For proper operation and safety, this tool must be mounted in a 5” or larger heavy-duty bench vise.

Running sheet stock through the three slip rolls will cause it to curve. The two front rolls drive the material, via the hand crank, into the slip roll mechanism; the rear roller is positioned to produce the desired curve in the workpiece.

Set the vertical spacing of the two front rolls by turning the knobs located on the top of each end plate (B). Start with the two rollers touching evenly along their length, and then turn the screws equally (you can add a small dot of paint for reference) until the workpiece will just fit between, and be driven by, the rollers.

Adjust the position of the rear roller by turning the two knobs pointing down on the back of the machine (C). Tightening the knobs brings the rear roller closer to the two drive rollers, producing a tighter-radius curve. Adjusting the rear roller at an angle produces a conical shape.

Cylinders may be formed with the slip rolls. To extricate the finished object from the rollers, loosen the top knobs and remove the top roller… handle-side first.

The grooves located in the end of the rollers are for bending tubing and round stock. Sizes, from left to right, are: 3/64”, 5/64”, 1/8”, 5/32” and 3/16”

Note: If a straight section of stock protrudes from one end of the curve, reverse the material and feed it again through the rollers.