



RAPID-AIR

OPERATING INSTRUCTIONS FOR S0, S1, W0, W1, W2 NON-POWERED STRAIGHTENERS

RAPID-AIR
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TABLE OF CONTENTS

PAGE

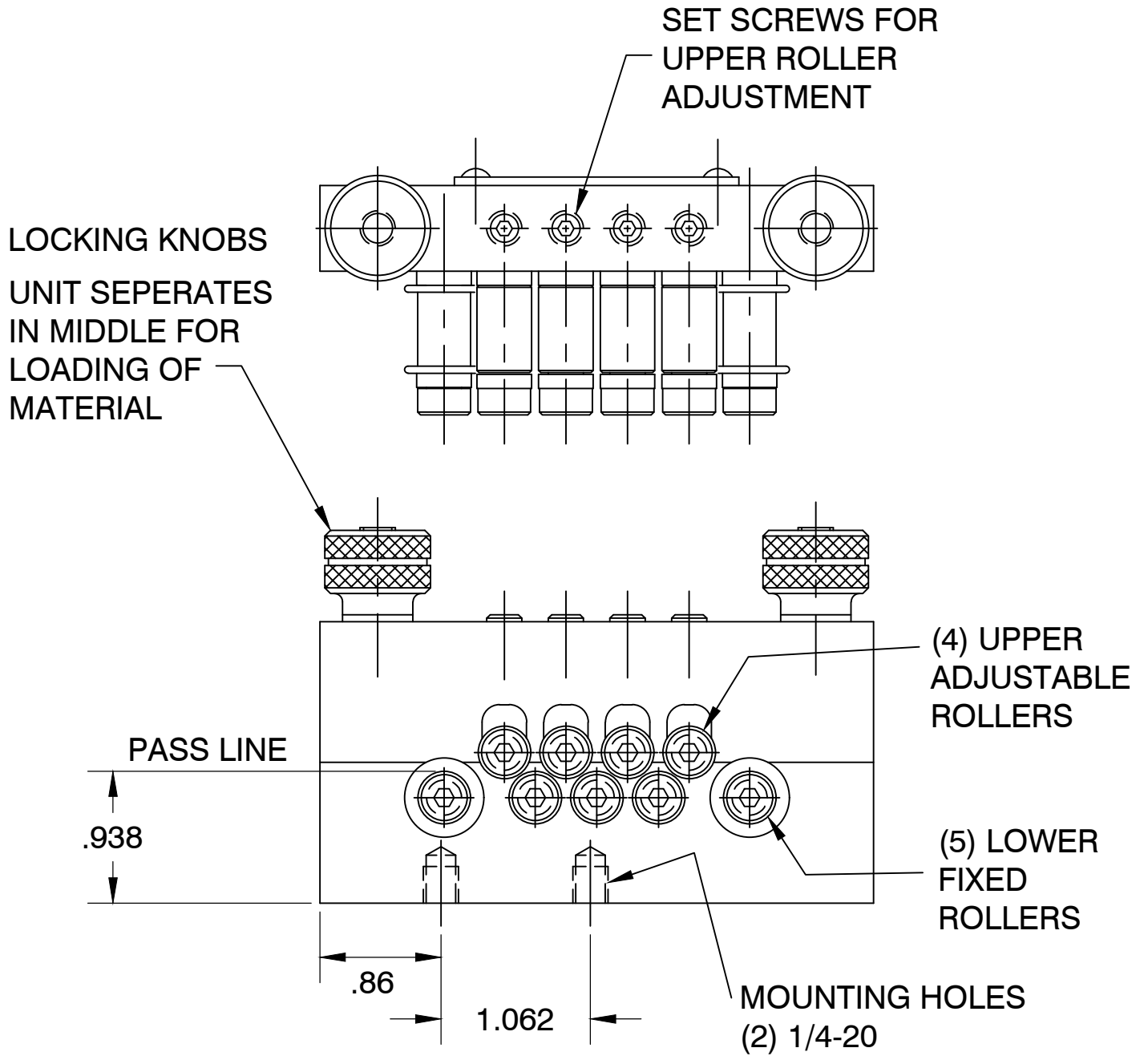
1. SETUP INSRUCTIONS & CAPACITIES
2. MODEL "S0" DIAGRAM
3. MODEL "S1" DIAGRAM
4. MODEL "W0" DIAGRAM
5. MODELS "W1" & "W2" DIAGRAM
6. MODEL "S0" ASSEMBLY DRAWING
7. MODEL "S1" ASSEMBLY DRAWING
8. MODEL "W0" ASSEMBLY DRAWING
9. MODEL "W1" ASSEMBLY DRAWING
10. MODEL "W2" ASSEMBLY DRAWING

SETUP INSTRUCTIONS & CAPACITIES

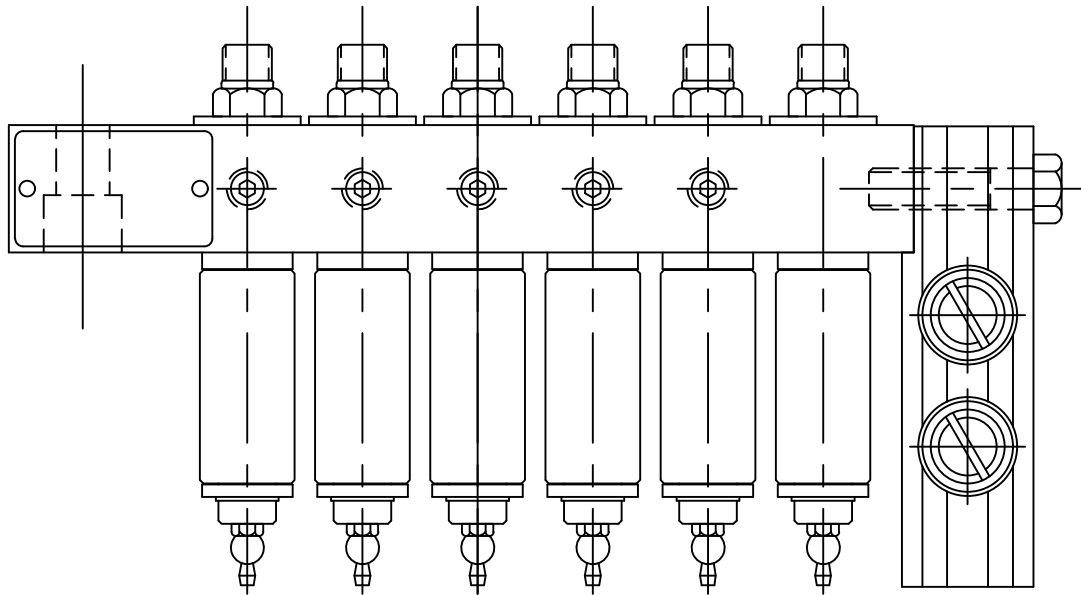
1. Your non-powered straightener is fully assembled and ready to be put into position. Visually inspect unit for damaged or loose parts due to shipment. If there is physical damage contact carrier.
2. Your non-powered straightener can be bolted directly to a Rapid-Air Power Roll or your pulling device. Make sure the non powered straightener pass line is in line with the pass line of the pulling device.
3. Your "S0" & "S1" model non-powered straighteners are designed to remove coil set from flat stock in one plane. Your "W0", "W1" and "W2" model non-powered straighteners are designed to remove coil set from wire in two planes. Most of the coil set should be removed with the rollers closest to the entrance end of the straightener with declining adjustment as the material passes through the rollers closest to the exit end of the straightener. Never over-work the material to the point where opposite coil set is established. All rollers must rotate as material is pulled through.
4. Note: The above instructions are only a guide from which to establish a standard starting point. Final adjustments on any or all of the rollers will vary with differing stock conditions.

MODEL	ROLL DIAMETER	MAXIMUM MATERIAL WIDTH	RECOMMENDED OPERATING RANGE
S0	.375" (9.53mm)	.50" flat stock (12.70mm)	.003"-.020" thickness (.076-.51mm)
S1	.718" (18.24mm)	1.50" flat stock (38.00mm)	.005"-.035" thickness (.127-.89mm)
W0	.375" (9.53mm)	wire	.003"-.030" diameter (.076-.76mm)
W1	.900" (22.86mm)	wire	.015"-.060" diameter (.38-1.52mm)
W2	1.000" (25.40mm)	wire	.050"-.150" diameter (.127-3.81mm)

MODEL "S0" FLAT STOCK NON-POWERED STRAIGHTENER

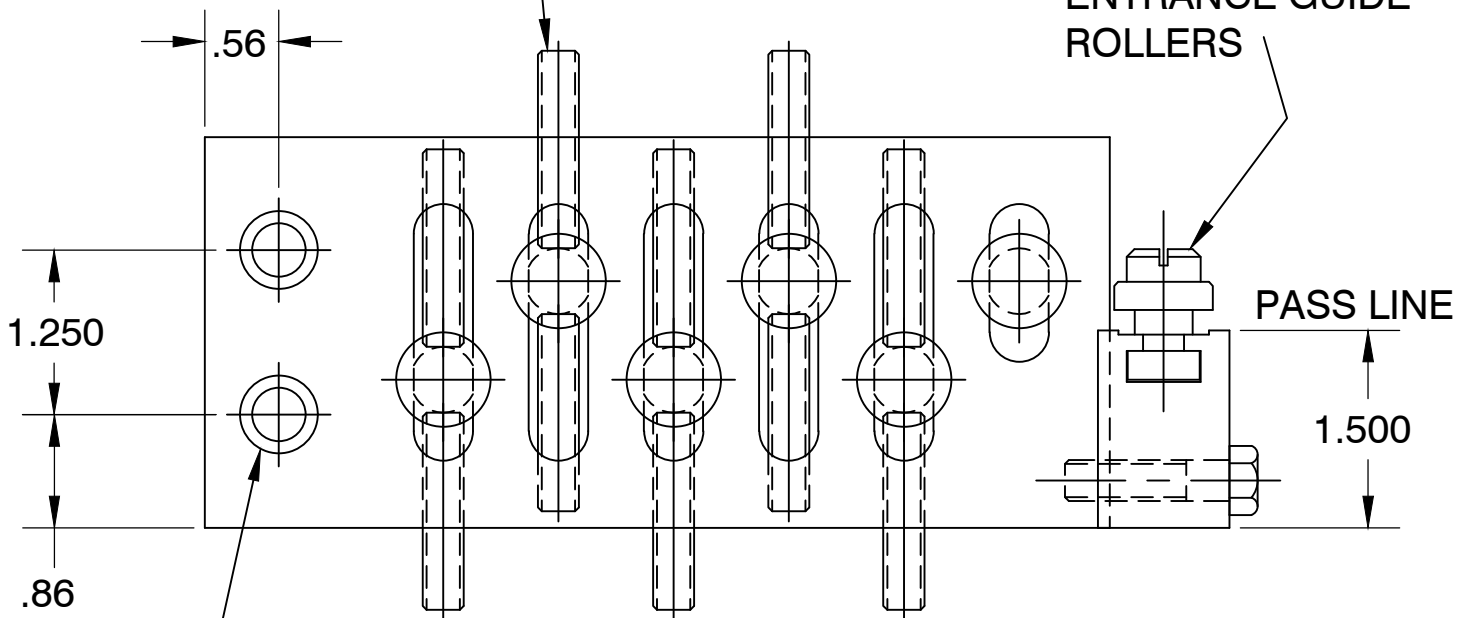


MODEL "S1" FLAT STOCK NON-POWERED STRAIGHTENER



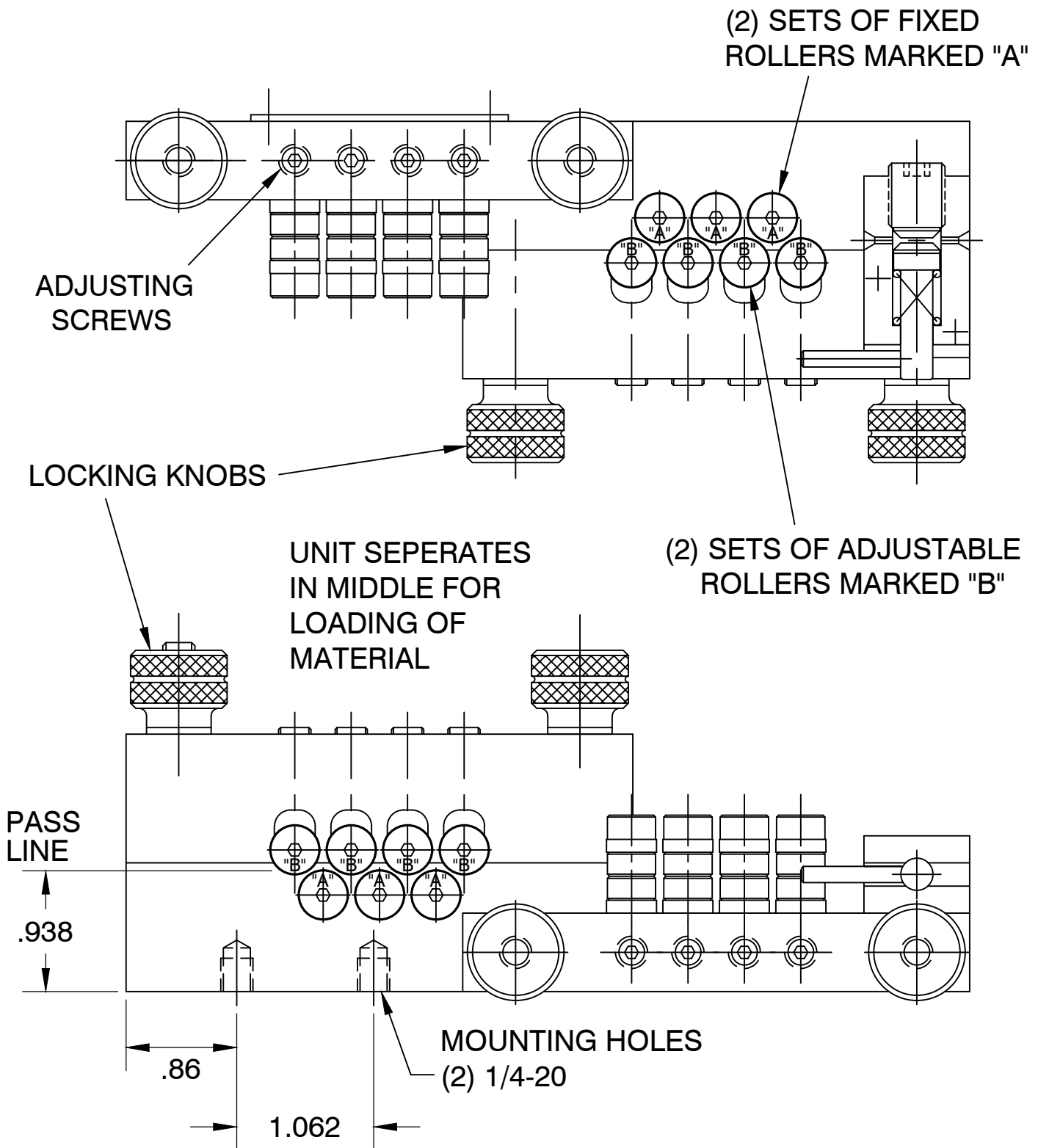
ADJUSTING SCREWS

ENTRANCE GUIDE ROLLERS

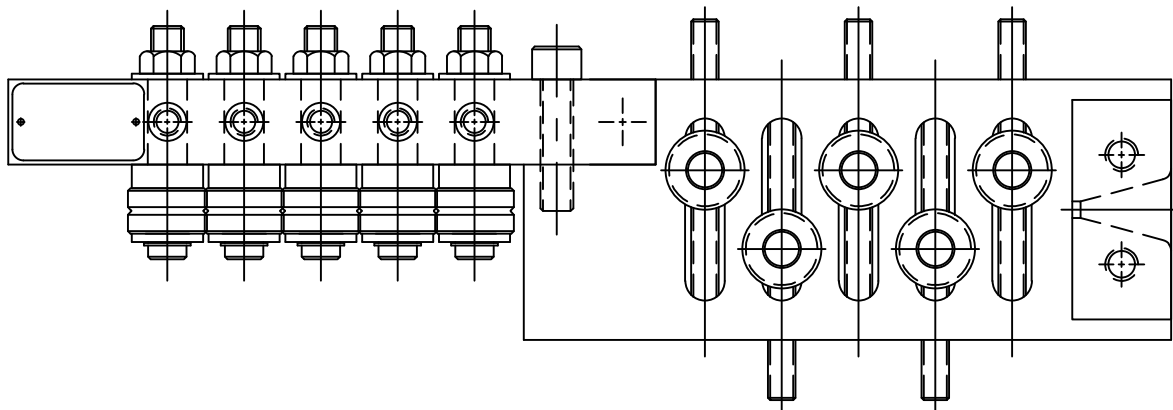


FOR 3/8-16
SCREWS

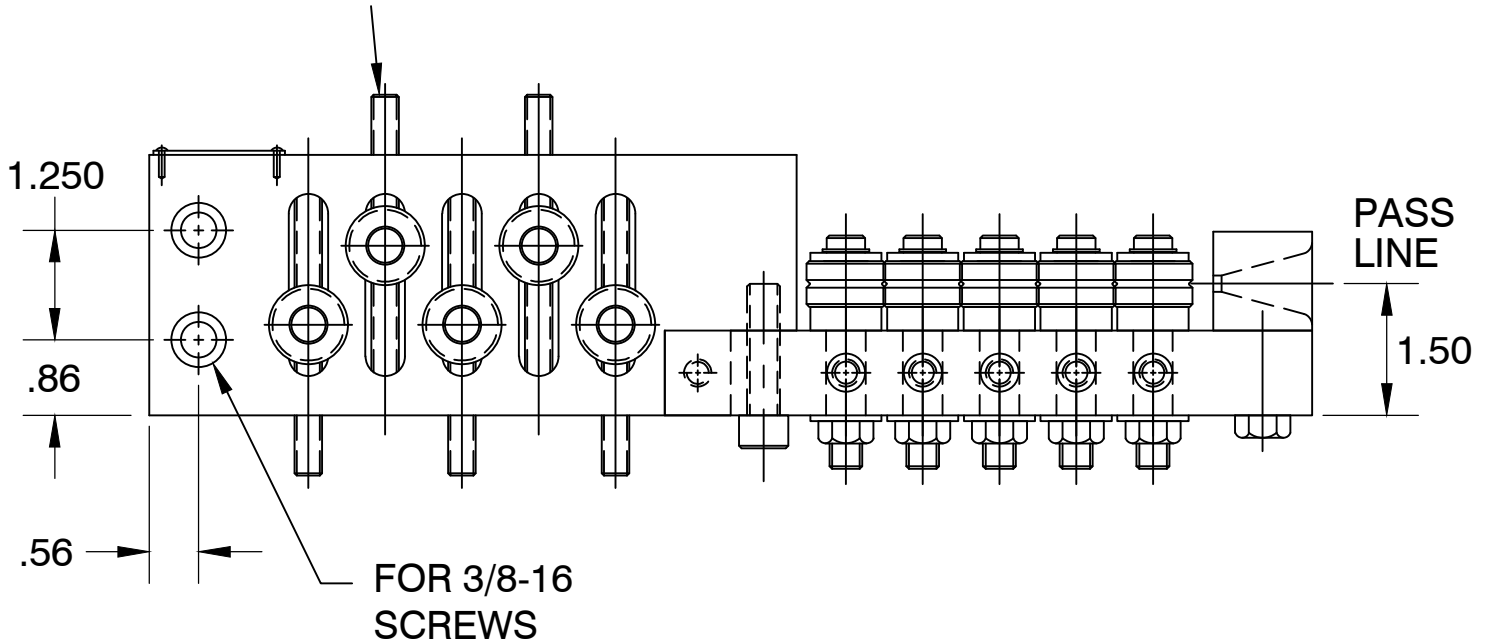
MODEL "W0" WIRE NON-POWERED STRAIGHTENER



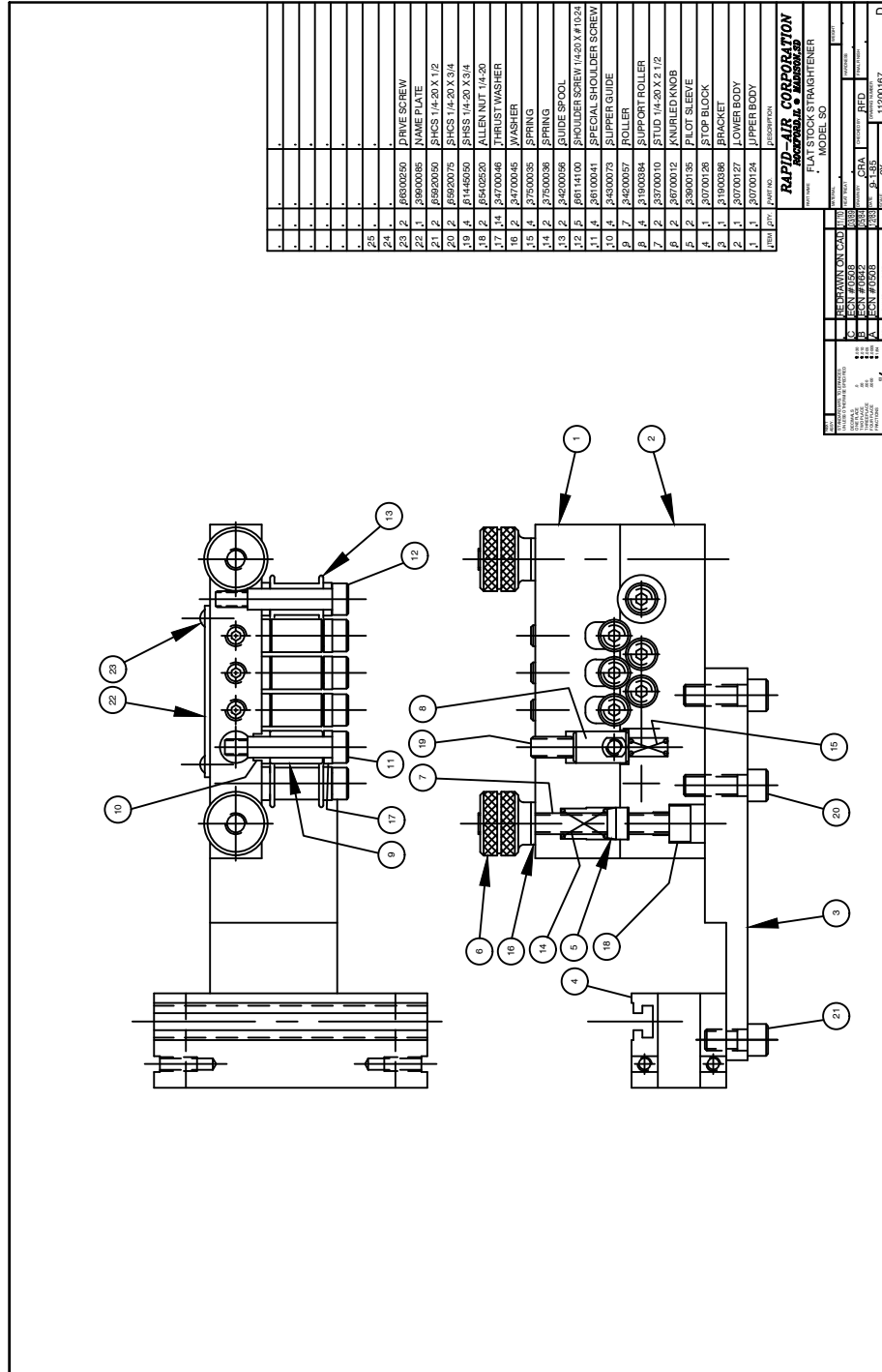
MODELS "W1" & "W2" WIRE NON-POWERED STRAIGHTENER



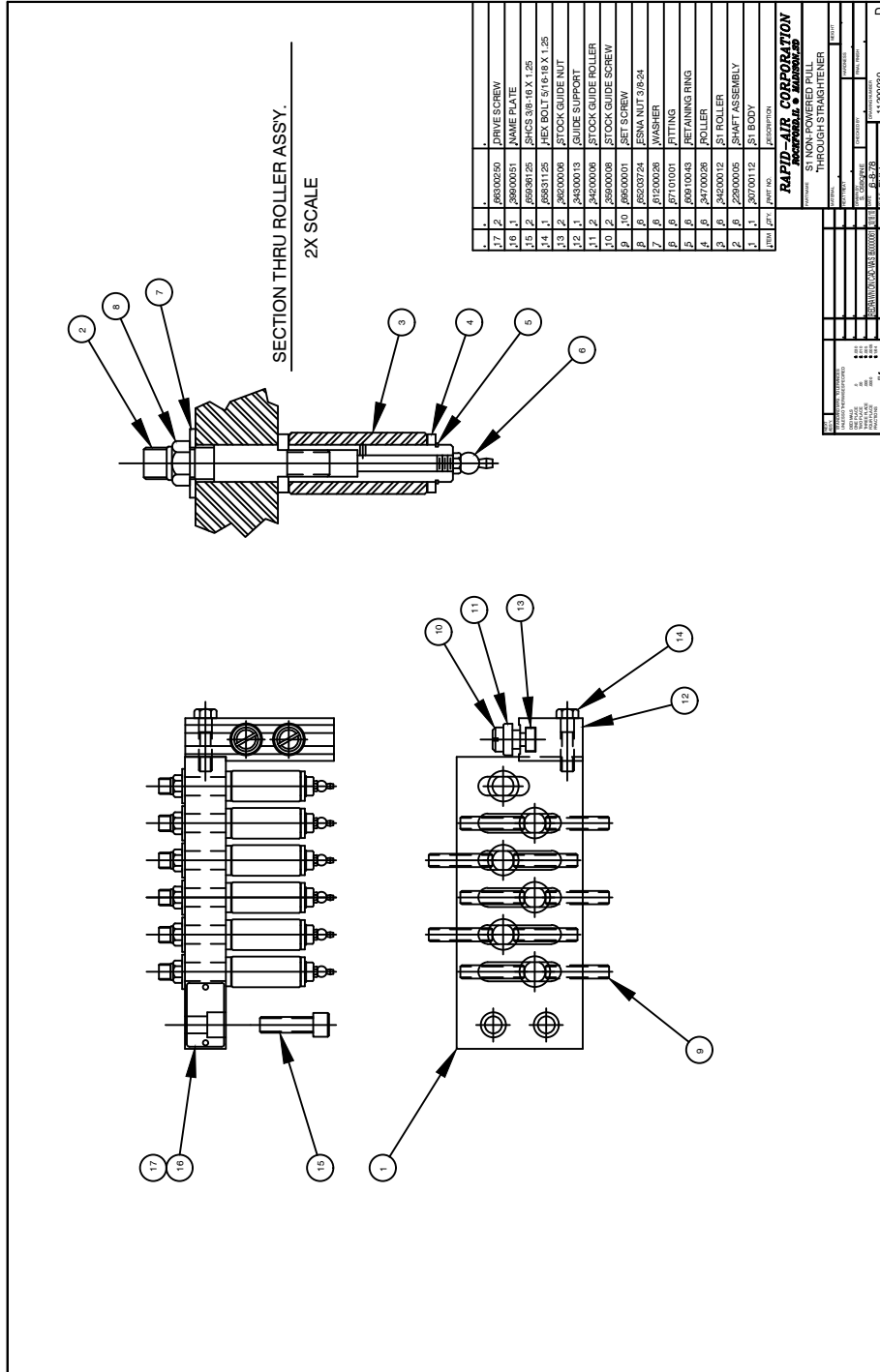
ADJUSTING SCREWS



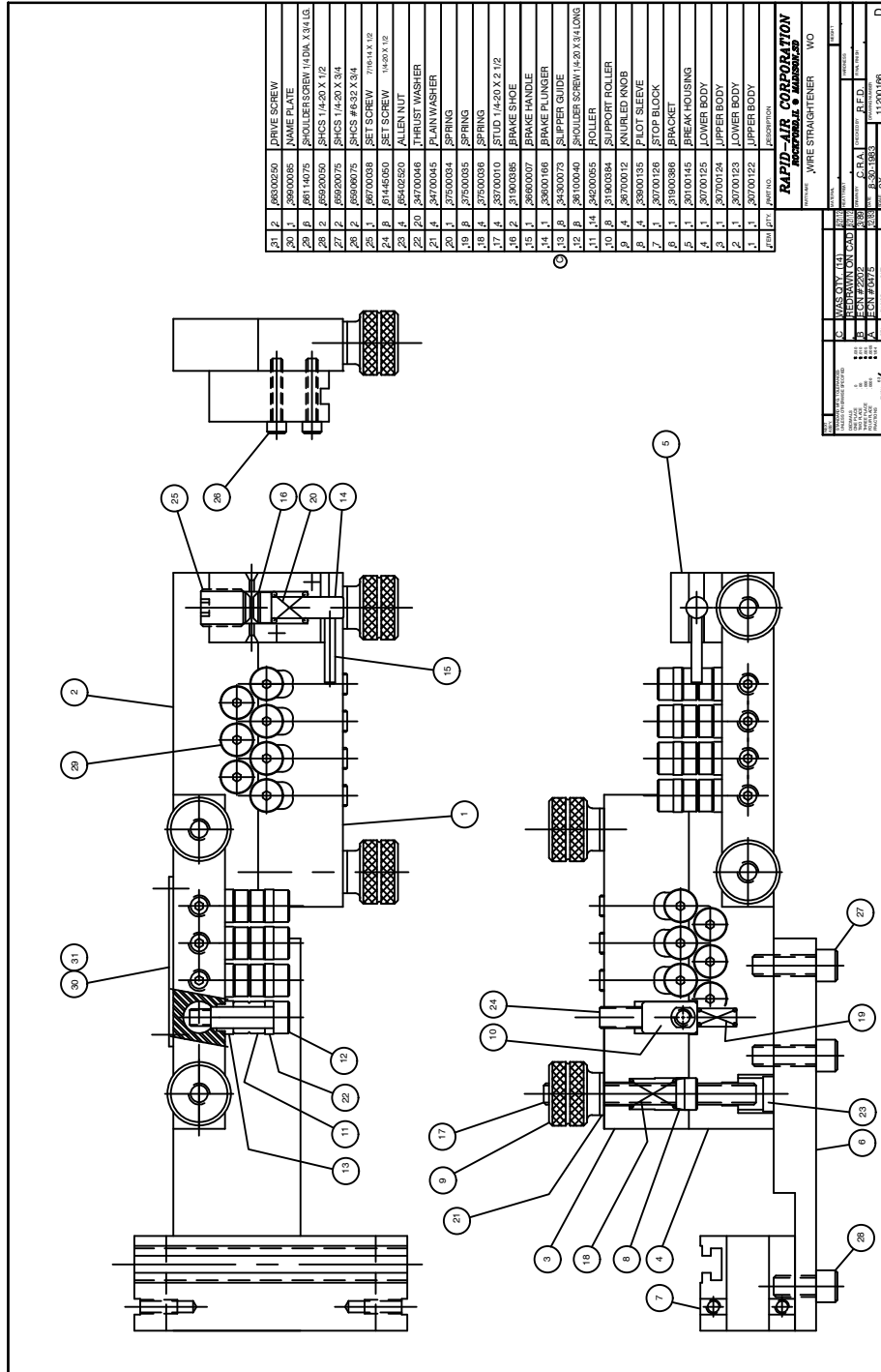
MODEL "S0" ASSEMBLY DRAWING



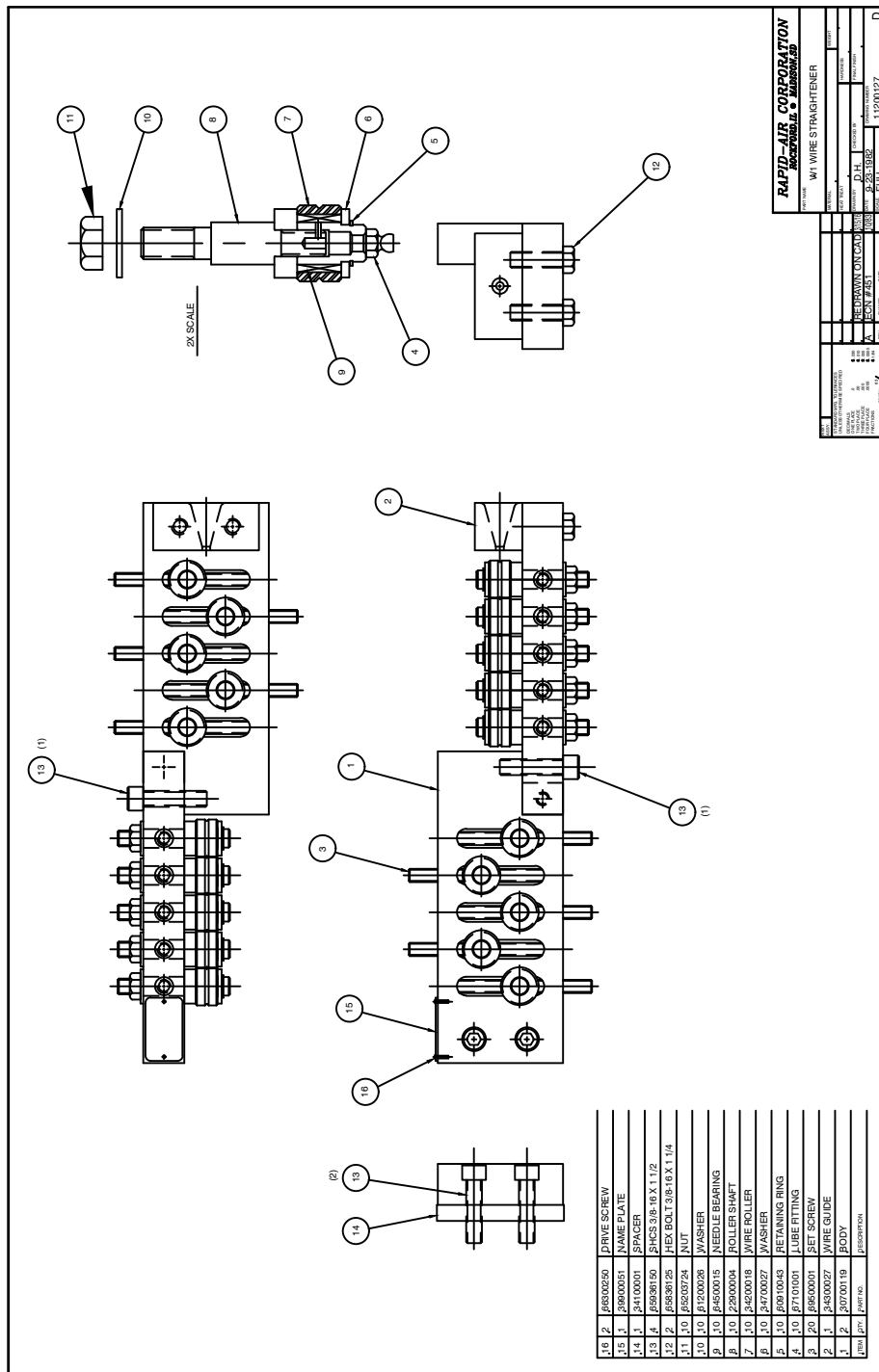
MODEL "S1" ASSEMBLY DRAWING



MODEL "W0" ASSEMBLY DRAWING



MODEL "W1" ASSEMBLY DRAWING



RAPID AIR CORPORATION MACHINE DIVISION	
NAME	W1 WIRE STRAIGHTENER
ITEM NO.	
DATE	
REVISED	
DESIGNED BY	D.H.
CHECKED BY	P.S. BUR
APPROVED BY	
DATE	J. 1200127
DRAWING NO.	
SCALE	
SIZE	D

MODEL "W2" ASSEMBLY DRAWING

