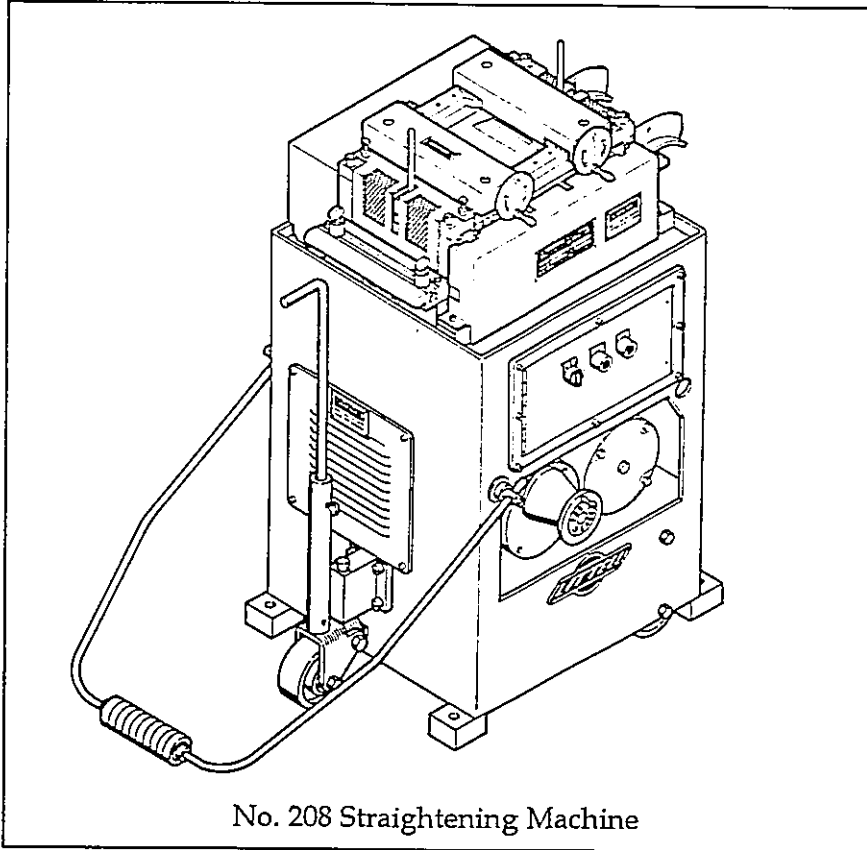


No. 208-17PD STRAIGHTENING MACHINE

SERVICE BULLETIN
NUMBER SD-181

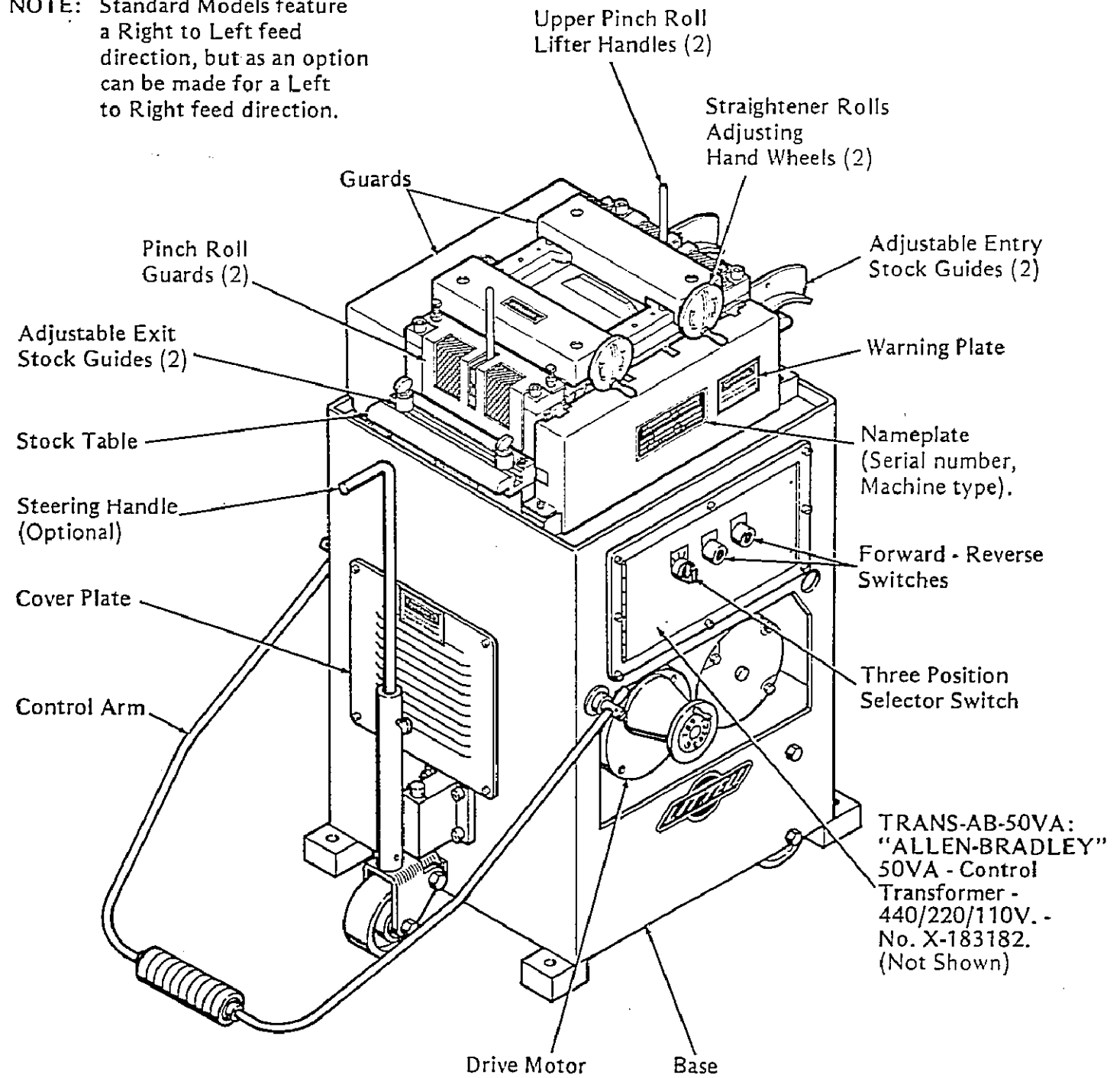


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No. 208 Straightening Machine:
Description - General.

NOTE: Standard Models feature a Right to Left feed direction, but as an option can be made for a Left to Right feed direction.



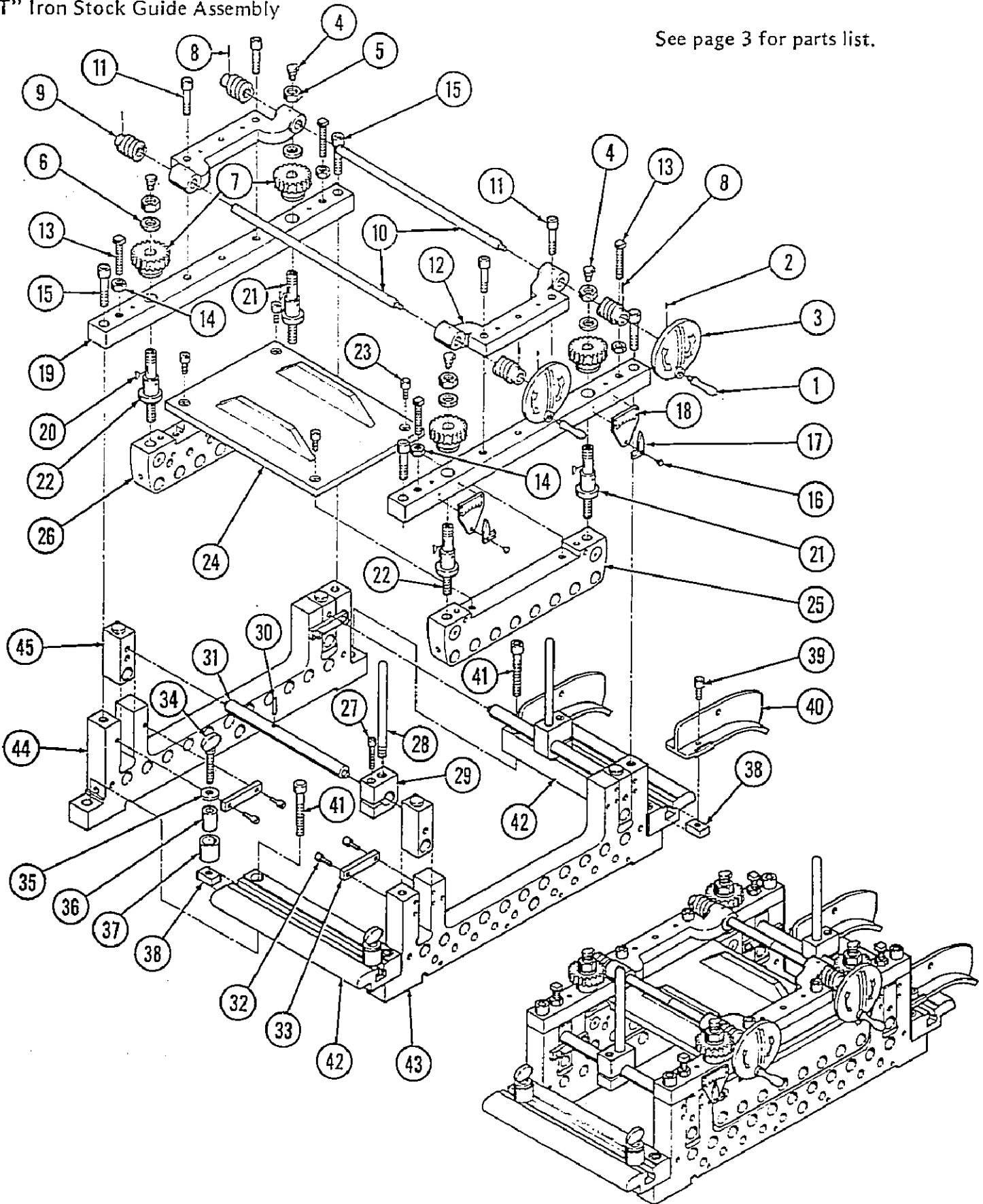
No. 208 Straightening Machine:
 Adjusting Screw, Roller Guide, and "T" Iron
 Stock Guide Assembly Parts List.

Note: See page 4 for exploded view of parts.

ITEM NO.	DESCRIPTION	QTY. REQ.	ITEM NO.	DESCRIPTION	QTY. REQ.
1.	Handle - ("BALCRANK" No. H-3302)	2	24.	Plate - Bridge	1
2.	Set Screw - Soc. Hd. (No. 10-32 x .375" Lg.)	2	25.	Frame - Upper Bearing - Front (Sub Assembly Reference)	1
3.	Handwheel - Adjusting	2	26.	Frame - Upper Bearing - Rear (Sub Assembly Reference)	1
4.	Cup - Oil ("GITS") (Four are shown.)	8	27.	Screw - (Soc. Hd. Cap .312" - .18 x 1.500" Lg.)	2
5.	Nut - Hex. (1/2" - 20 Th'd.)	4	28.	Handle - Lifter	2
6.	Washer - Steel (.50" x 1.00" x .12")	4	29.	Clamp - Lifter Handle	2
7.	Gear - Worm ("B.G.W." No. G1050-RH 12 D.P. - 20 T - 1.666" P.D. - .500" Bore - .125" x .062" Keyway)	4	30.	Pin - Dowel (.250" x 1.000" Lg.)	2
8.	Pin - Taper (No. 0)	4	31.	Shaft - Lifter	2
9.	Worm - ("B.G.W." No. GH1056-RH 12 D.P. - 1.00" P.D. - Single Thd. - .500" Bore - 1.12" Face No Keyway)	4	32.	Screw - (Soc. Hd. Cap .250" - 20 x .625" Lg.)	8
10.	Shaft - Adjusting Screw	2	33.	Shim - Lifter Shaft Support	4
11.	Screw - (Soc. Hd. Cap 3/8" - 16 x 1-5/8" Lg.)	4	34.	Thumb Screw	2
12.	Screw - Adjusting Cap	2	35.	Washer - Thumb Screw	2
13.	Screw - Sq. Hd. Set - Flat Pt. (.375" - 16 Thd. x 2.0" Lg.)	4	36.	Roller - Hub	2
14.	Nut - Hex. Full (.375" - 16 Thd.)	4	37.	Roller - Stock Guide	2
15.	Screw - (Soc. Hd. Cap .500" - 13 x 1-3/8" Lg.)	4	38.	Nut - Stock Guide.	4
16.	Pin - Pivot	2	39.	Screw - (Soc. Hd. Cap .375" - 16 x .750" Lg.)	2
17.	Pointer - Indicator	2	40.	Guide - Stock - "T" Iron	2
18.	Plate - Indicator Dial	2	41.	Screw - (Soc. Hd. Cap .500" - 13 x 2.875" Lg.)	4
19.	Cap - Bearing	2	42.	Table - Stock	2
20.	Key - Woodruff (No. 3)	4	43.	Frame - Bearing - Front (Reference)	1
21.	Screw - Adjusting - R.H.	2	44.	Frame - Bearing - Rear (Reference)	1
22.	Screw - Adjusting - L.H.	2	45.	Box - Upper Roll (Sub Assembly Reference)	4
23.	Screw - (Soc. Hd. Cap .375" - 16 x .500" Lg.)	4			

No. 208 Straightening Machine:
Adjusting Screw, Roller Guide and
"T" Iron Stock Guide Assembly

See page 3 for parts list.



No. 208 Straightening Machine:
Upper Roll and Gear Assembly
Parts List.

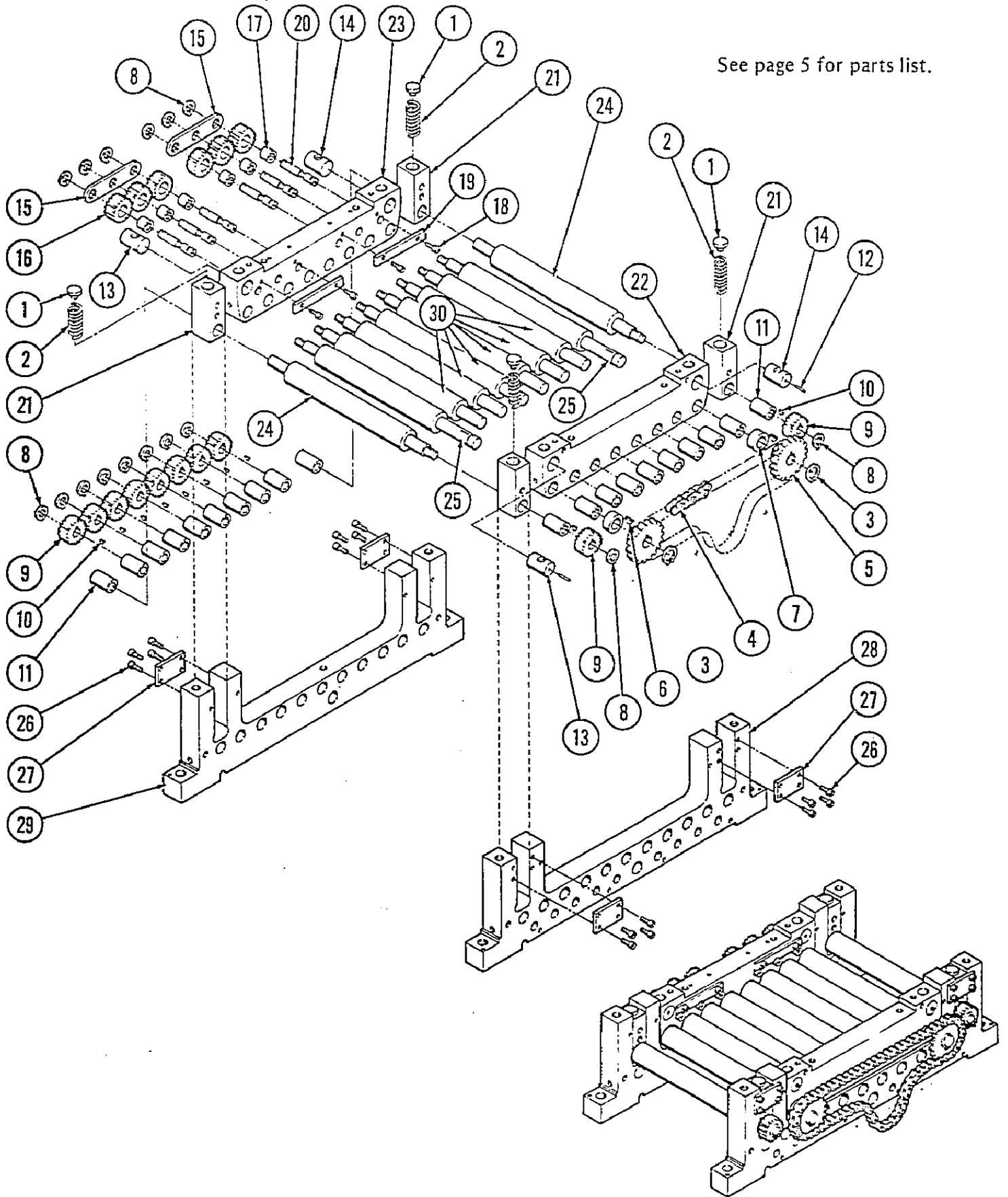
Note: See page 6 for exploded view of parts.

ITEM NO.	DESCRIPTION	QTY. REQ.
1.	Button - Spring	4
2.	Spring - ("DANLY" No. 9-1206-11 .38" x .75" x 1.50" Lg.)	4
3.	Ring - Ret. ("WALDES" No. 5100-62)	2
4.	Chain - Roller - Upper Straightener Roll Drive ("MFGRS STD" No. 35 - .38" Pitch)	33"
5.	Sprocket - Drive (No. 35B19)	2
6.	Key - Woodruff (No. 6)	2
7.	Spacer - Sprocket (.62" x 1.00" x .50")	2
8.	Ring - Ret. ("WALDES" No. 5100-50)	16
9.	Gear - Roll (20 T)	10
10.	Key - Woodruff (No. 3)	10
11.	Bushing - ("OILITE" No. AA-811-2 .627" x .815" x 1.25" Lg.)	20
12.	Pin - Roll (.125" x .750" Lg.)	2
13.	Nut - Adjusting Screw - L.H.	2
14.	Nut - Adjusting Screw - R.H.	2
15.	Retainer - Gear 3-Hole.	2
16.	Gear - Idler (20 T)	6
17.	Bushing - ("OILITE" No. AA-628-10 .500" x .625" x .500" Lg.)	6
18.	Screw - (Soc. Hd. Cap .250" - 20 x .500" Lg.)	4
19.	Retainer - Idler Pin (3.5" Lg.)	2
20.	Pin - Idler Gear	6
21.	Box - Upper Roll	4
22.	Frame - Upper Bearing - Front	1
23.	Frame - Upper Bearing - Rear	1
24.	Roll - Pinch (Upper - w/Gears Only.)	2
* 25.	Roll - (Upper Stra. - w/Gears and Sprockets Only.)	2
26.	Screw - (Soc. Hd. Cap .250" - 20 x .625" Lg.)	16
27.	Retainer - Roll Box	4
28.	Frame - Bearing - Front (Reference)	1
29.	Frame - Bearing - Rear (Reference)	1
30.	Roll - (Upper Stra. - w/Gears Only.)	6

* - Power Driven Rolls Total Two.

No. 208 Straightening Machine:
Upper Roll and Gear Assembly.

See page 5 for parts list.



No. 208 Straightening Machine:
Lower Roll and Gear Assembly
Parts List.

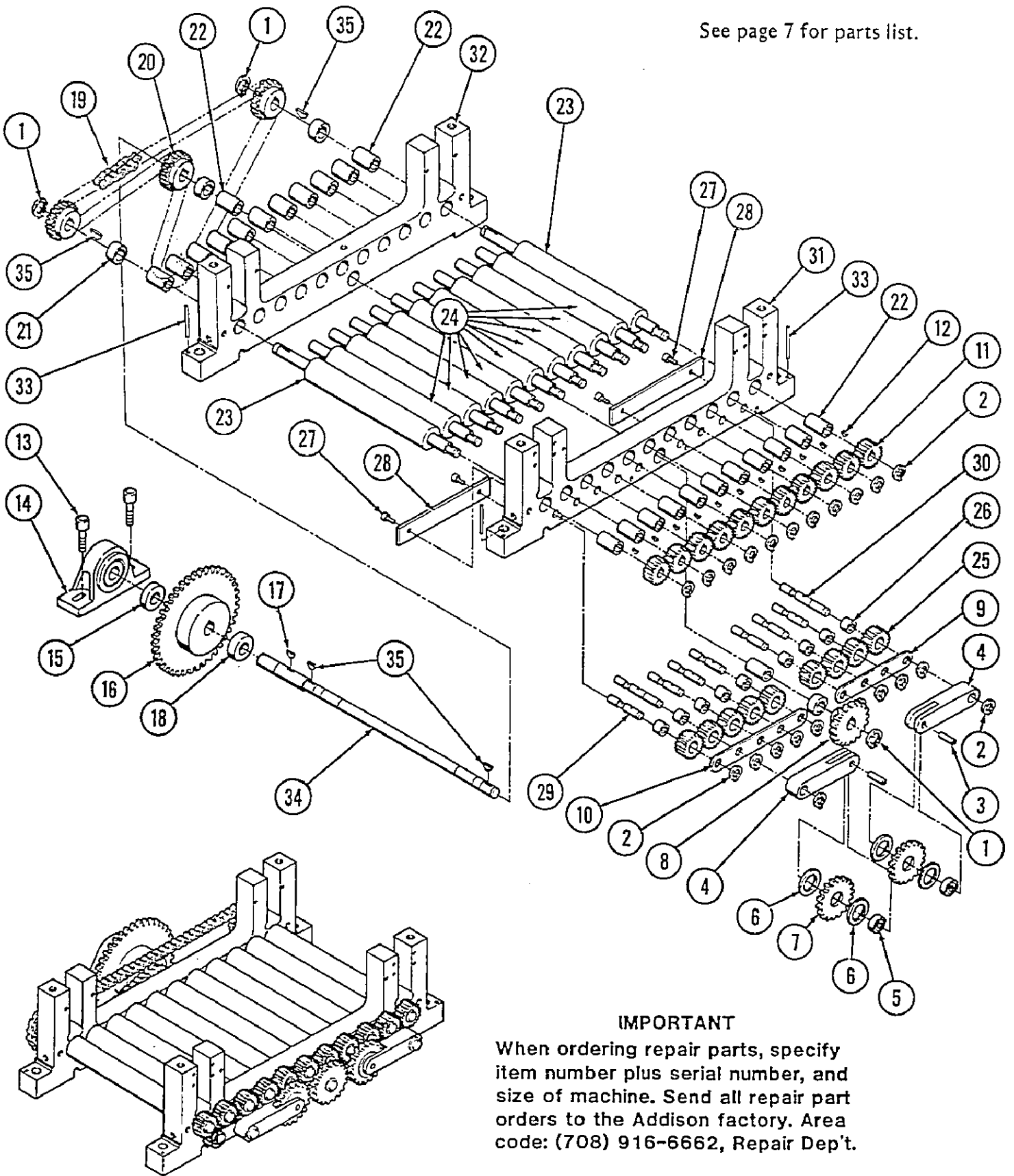
Note: See page 8 for exploded view of parts.

ITEM NO.	DESCRIPTION	QTY. REQ.	ITEM NO.	DESCRIPTION	QTY. REQ.
1.	Ring - Ret. ("WALDES" No. 5100-62)	3	17.	Key - Woodruff (No. 11)	1
2.	Ring - Ret. ("WALDES" No. 5100-50)	22	18.	Spacer - Driven Sprocket - (.50" Lg.)	1
3.	Pin - Roll ("ESNA" No. 59-062-312- 1000 .312" Dia. x 1.00" Lg.)	2	19.	Chain - Roller - Pinch Roll Drive ("MFGRS STD" No. 35 - .38" Pitch)	49"
4.	Arm - Idler	2	20.	Sprocket - Drive (No. 35B16)	3
5.	Bearing - ("NICE" No. 1605DS .312" x .906" x .31")	2	21.	Spacer - Sprocket (.62" x 1.00" x .50")	4
6.	Spacer - Idler Sprkt. (.906" x 1.50" x .062")	4	22.	Bushing - ("OILITE" No. AA-811-2 .627" x .815" x 1.25" Lg.)	24
7.	Sprocket - Idler ("CULLMAN" No. 35A19 - .905"/.906" Bore - No Keyway.)	2	* 23.	Roll - Pinch - (Lower - Power Driven.)	2
8.	Sprocket - Drive (No. 35B19)	1	24.	Roll - (Lower Rolls - w/Gears Only.)	9
9.	Retainer - Gear 4-Hole	1	25.	Gear - Idler (20 T)	9
10.	Retainer - Gear 5-Hole	1	26.	Bushing - ("OILITE" No. AA-628-10 .500" x .625" x .500" Lg.)	9
11.	Gear - Roll (20 T)	11	27.	Screw - (Soc. Hd. Cap .250" - 20 x .375" Lg.)	4
12.	Key - Woodruff (No. 3)	11	28.	Retainer - Idler Pin (6.5" Lg.)	2
13.	Screw - (Soc. Hd. Cap .500" - 13 x 1.375" Lg.)	2	29.	Pin - Idler Gear	7
14.	Bearing - Pillow Block - ("SEAL- MASTER" No. NP-12 .75" x 1.31" x 5.0")	1	30.	Pin - Idler Gear - Long	2
15.	Spacer - Driven Sprocket - (.38" Lg.)	1	31.	Frame - Bearing - Front (Reference)	1
16.	Sprocket - Driven - ("CULLMAN" No. 41B-35 - .749"/.750" Bore - 3/16" x 3/32" Keyway.)	1	32.	Frame - Bearing - Rear (Reference)	1
			33.	Pin - Dowel (.187" x .88" Lg.)	4
			34.	Shaft - Drive	1
			35.	Key - Woodruff (No. 6)	4

* - Power Driven Rolls Total Two.

No. 208 Straightening Machine:
Lower Roll and Gear Assembly.

See page 7 for parts list.



IMPORTANT

When ordering repair parts, specify item number plus serial number, and size of machine. Send all repair part orders to the Addison factory. Area code: (708) 916-6662, Repair Dep't.