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

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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.

<table>
<thead>
<tr>
<th>MODEL</th>
<th>ROLL DIAMETER</th>
<th>MAXIMUM MATERIAL WIDTH</th>
<th>RECOMMENDED OPERATING RANGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>S0</td>
<td>.375&quot; (9.53mm)</td>
<td>.50&quot; flat stock (12.70mm)</td>
<td>.003&quot;-.020&quot; (.076-.51mm) thickness</td>
</tr>
<tr>
<td>S1</td>
<td>.718&quot; (18.24mm)</td>
<td>1.50&quot; flat stock (38.00mm)</td>
<td>.005&quot;-.035&quot; (.127-.89mm) thickness</td>
</tr>
<tr>
<td>W0</td>
<td>.375&quot; (9.53mm)</td>
<td>wire</td>
<td>.003&quot;-.030&quot; (.076-.76mm) diameter</td>
</tr>
<tr>
<td>W1</td>
<td>.900&quot; (22.86mm)</td>
<td>wire</td>
<td>.015&quot;-.060&quot; (.38-1.52mm) diameter</td>
</tr>
<tr>
<td>W2</td>
<td>1.000&quot; (25.40mm)</td>
<td>wire</td>
<td>.050&quot;-.150&quot; (.127-3.81mm) diameter</td>
</tr>
</tbody>
</table>
MODEL "S0" FLAT STOCK NON-POWERED STRAIGHTENER

LOCKING KNOBS
UNIT SEPERATES IN MIDDLE FOR LOADING OF MATERIAL

PASS LINE

.938

MOUNTING HOLES
(2) 1/4-20

.86

1.062

SET SCREWS FOR UPPER ROLLER ADJUSTMENT

(4) UPPER ADJUSTABLE ROLLERS

(5) LOWER FIXED ROLLERS

UNIT SEPERATES IN MIDDLE FOR LOADING OF MATERIAL
MODEL "S1" FLAT STOCK NON-POWERED STRAIGHTENER

ADJUSTING SCREWS

FOR 3/8-16 SCREWS

ENTRANCE GUIDE ROLLERS

PASS LINE

1.500

1.250

.86

.56
MODEL "W0" WIRE NON-POWERED STRAIGHTENER

- (2) SETS OF FIXED ROLLERS MARKED "A"
- (2) SETS OF ADJUSTABLE ROLLERS MARKED "B"
- ADJUSTING SCREWS
- LOCKING KNOBS
- UNIT SEPERATES IN MIDDLE FOR LOADING OF MATERIAL
- MOUNTING HOLES (2) 1/4-20
- PASS LINE 0.938
- PASS LINE 0.86
- PASS LINE 1.062
MODEL "W0" ASSEMBLY DRAWING
MODEL "W1" ASSEMBLY DRAWING