

Five-Roll Straightener User Instructions

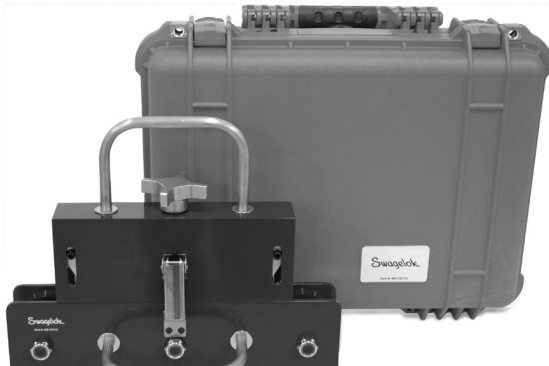
These instructions contain information necessary for the proper operation of the Swagelok® Five-Roll Straightener, Model MS-TST12.

Read and understand these instructions before using the five-roll straightener.

Overview

The five-roll straightener is designed for either hand-held operation or it can be mounted to a spool stand for more automated tube straightening. The five-roll straightener kit

- accommodates both bare tubing and single-jacketed tubing
- accommodates tubing sizes ranging from 1/8 to 1/2 in. and 3 to 12 mm
- weighs approximately 16.3 lb (7.4 kg)
- includes five-roll straightener tool and heavy-duty, plastic storage case.



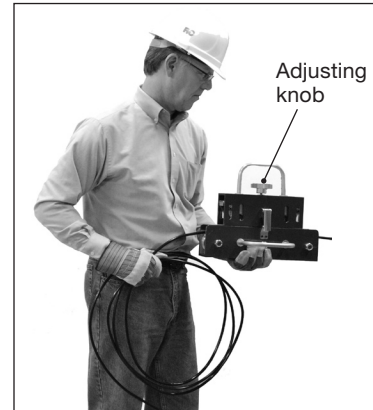
Operation

These instructions cover the hand-held operation of the tube straightener.

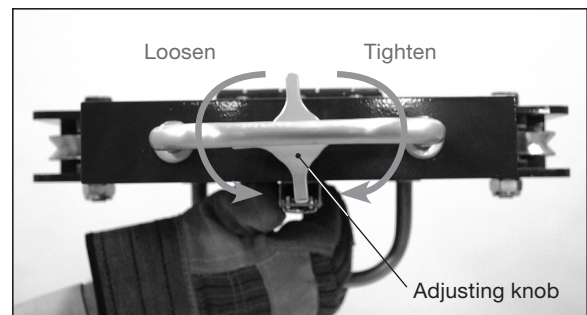
1. Straighten the beginning of the coil by hand.



2. Adjust the roller height by turning the adjusting knob clockwise for smaller tubing and counter-clockwise for larger tubing. Start feeding the tube through the straightener.



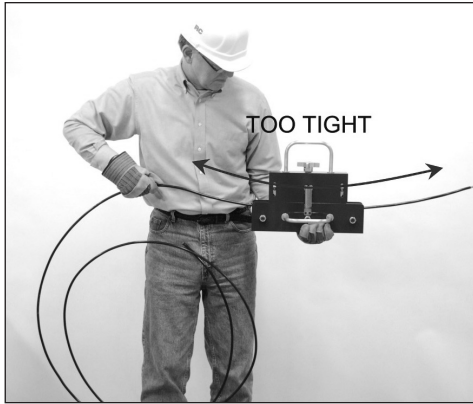
3. Pull / push the tube back and forth through the straightener and adjust the roller height using the adjusting knob so the tubing is coming out straight.



Top View



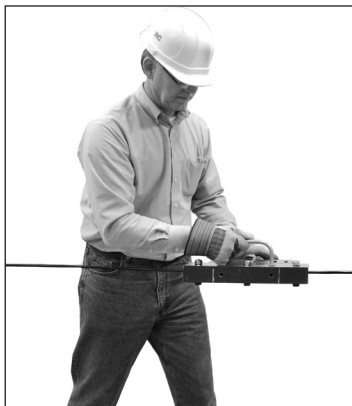
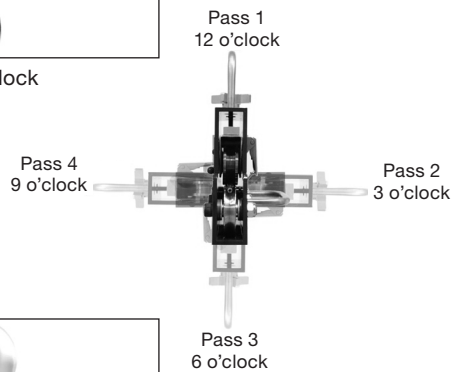
4. If the tube curves up, loosen the adjusting knob.
If the tube continues to curve down, tighten the adjusting knob.



5. After the initial pass, additional straightening may be necessary. If so, work the straightener along the length of tubing rotating the straightener to the 3, 6, and 9 o'clock positions until desired straightening is achieved.



Initial pass at 12 o'clock



Final pass at 9 o'clock