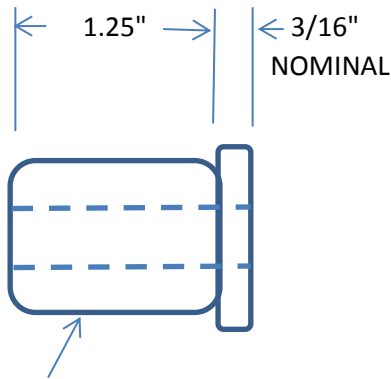
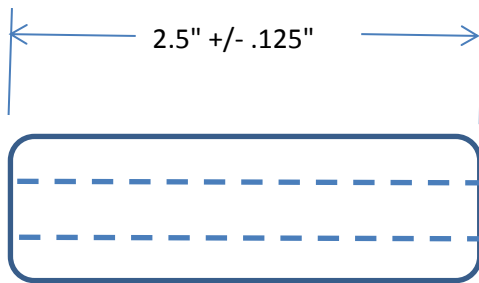


TURN O.D. TO .872" / .874"  
 SLIP FIT IN ARMATURE  
 EACH END



TURN OD .874" / .875"  
 PRESS FIT INTO BLOCK  
 LEAVE END AS FURNISHED  
 DIAMETER



TURN OD .872" / .874"  
 SLIP FIT IN ARMATURE

DRILL ID HOLES AS PER TABLE  
 ENDS SMALL TAPER OR ROUND EDGES  
 DO NOT TAPER ENDS, SAW CUT ENDS.  
 MATERIAL, EXTRUDED VIRGIN UHMW  
 1.0" NOMINAL AS FURNISHED DIAMETER.  
 BUSHING SET CONSISTS OF ONE OF EACH SIZE

MATERIAL SIZE	DRILL HOLE SIZE
.500"	17/32 .531"
.472"	1/2 .500"
.394"	27/64 .422"
.375"	#Y .404"
.313" / .315"	#R .339"
.276"	19/64 .2969"
.250"	#I .272"
.236"	#I .272"
.216"	15/64 .234"
.197"	#4 .209"
.185" / .188"	#4 .209"
.177"	#8 .199"
.156"	#16 .177"
.118" / .125"	#27 .144"
.092" / .094"	#33 .113"
.079"	#43 .089"
.059" / .062"	#45 .082"

REVISION: 0 ORIGINAL ISSUE

IDAHO LABORATORIES CORPORATION  
 2101 HEMMERT AVENUE  
 IDAHO FALLS, IDAHO 83401  
 PH: 208-522-0055 FX: 208-522-4522

DRAWING: D130517-08 REVISION: 0  
 STRAIGHTENER BUSHINGS RS-500 MODEL 4

DRAWN BY: GLENN N. HARKER

CHECKED BY: \_\_\_\_\_

APPROVED BY: \_\_\_\_\_

**IDAHO LABORATORIES CORPORATION**

2101 HEMMERT AVENUE.

IDAHO FALLS IDAHO 83401

PHONE: 208-522-0055 FASMILE: 208-522-4522

CAPACITY: ROUND MATERIAL .059" TO .500" ( 1.5MM TO 12.7MM )

STRAIGHTENING SPEED 10 TO 50 FEET PER MINUTE ( 3m TO 15m MINUTE )

ELECTRICAL REQUIREMENTS: 120 VAC, SINGLE PHASE, 60 HZ, 15 AMPS.

SPECIAL ORDER 220 VAC, 50 HZ.

WEIGHT: INCLUDING WOOD BOX 150 POUNDS.

DIMENSIONS: 16" WIDE, 24" DEEP ( 406mm X 610mm )

SPECIFICATIONS: BUSHING 7/8" IN DIAMETER ( 22.22mm ) SPINDLE SPEED 1000 RPM.

FURNISHED SIX SETS OF BUSHING: .500" ( 12.7mm) .375" (9.5mm) .313" ( 8mm) .250" (6.4mm)

.188" (4.8mm) .125" ( 3.2mm)

FOB POINT: IDAHO FALLS, IDAHO 83401

**OPERATING INSTRUCTIONS AND TIPS:**

1. Keep the material being straightened moving through the bushings at all times. This will prevent over heating of the bushings and over work hardening of the material being straightened.
2. Use bushings of the correct size holes. The hole must be .010" (0.25mm) to .040" ( 1.0mm) larger than the material being straightened.
3. Worn bushings may be re drilled for use with larger material. Use UHMW plastic for the bushings Other plastics will not provide the same operating life. Bushings may be purchased from ILC or manufactured by most machine shops.
4. End bushing sets must fit freely inside the rotating armature as they are held in place with set screws. The center bushing is press fit into the bushing holder. Additional bushing holders may be purchased from ILC. Having a set of bushing holders with UHMW bushing already installed will speed up changing times when switching material diameters.
- 5.0 Keep material being straightened clean of dirt or chips they may cause scratches or accelerate wear of the bushings.
- 6.0 Use as small of an offset on the center bushing as possible while giving acceptable results to reduce work hardening of the material being straightened
- 7.0 Pull material through straightener with a uniform speed. To fast may produce ripples in the material.
- 8.0 Use locking pliers held at a right angle that clamp on the material being straightened to prevent rotation or whipping of the material. Whipping of the material can cause damage or injury of personel.
- 9.0 Always wear eye protection when operation this machine. Bolt or clamp the machine to a solid work surface when in use.

**WARRANTY:** Machine is covered for one year on labor or parts less consumable items like bushings or drive belts.

Idaho Laboratories Corporation is not liable for injury or damage resulting from use or missuse of this machine. Operator or owner assumes all liability for use of this machine.