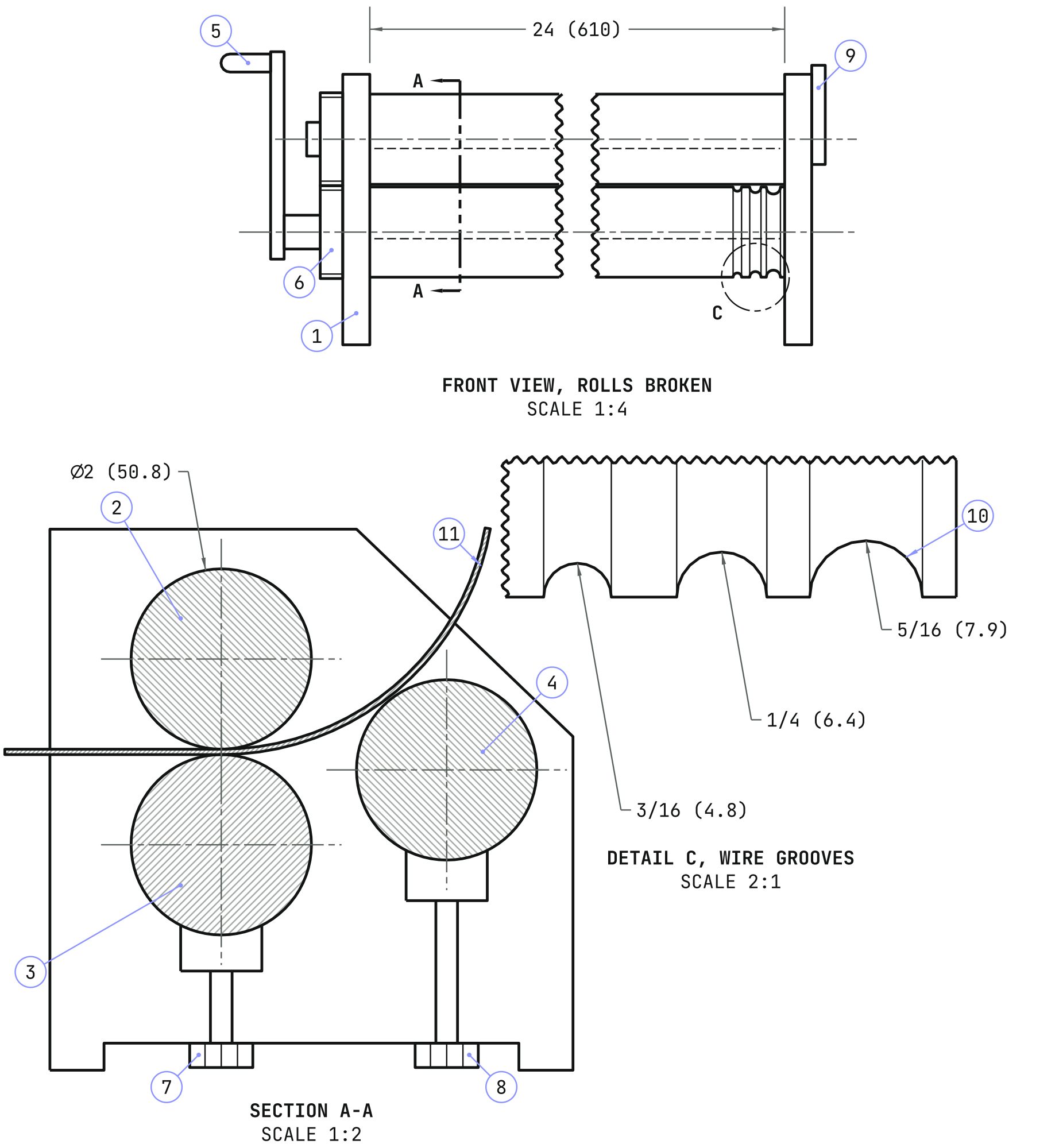
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Slip Rolls

A slip roll curves flat sheet into cylinders, tubes and gentle skin contours.



CAPACITY, MILD STEEL	
WIDTH IN	GAUGE (IN)
24	20 GA (0.036)
36	22 GA (0.030)
50	16 GA (0.060)

ROLL DIAMETER	
WIDTH IN	ROLLS IN
24-36	Ø2 (50.8)
50	Ø3 (76.2)

NOTES

1. DIMENSIONS IN INCHES (MM).
2. FRONT ROLLS FEED THE SHEET, REAR ROLL SETS THE CURVE.
3. SET THE LOWER FRONT ROLL TO THE SHEET THICKNESS.
4. RATED CAPACITY IS FOR MILD STEEL.
5. WIRE GROOVES 3/16, 1/4, 5/16 ON 24 IN ROLLS.
6. KEEP THE ROLLS CLEAN FOR ALUMINUM.

ITEM	DESCRIPTION
11	SHEET
10	WIRE GROOVE
9	UPPER ROLL RELEASE
8	ADJUSTING SCREW, REAR
7	ADJUSTING SCREW, LOWER
6	DRIVE GEARS
5	HANDLE
4	REAR ROLL
3	LOWER FRONT ROLL
2	UPPER FRONT ROLL
1	END FRAME

SLIP ROLL, HAND	
SHEET 1 OF 1	
DWG TAP-TG-098	REV A
SCALE 1:2	

Types and sizes

Type	Width, capacity, rolls	Use
Hand slip roll, 24 in	24 in (610 mm); 20 gauge, 0.036 in (0.91 mm) mild steel; ⌀2 in (50.8 mm) rolls	Tubes, ducts, fairings and patches in thin sheet
Hand slip roll, 36 in	36 in (914 mm); 22 gauge, 0.030 in (0.76 mm) mild steel; ⌀2 in (50.8 mm) rolls	Longer skins and wraps in thin sheet
Hand slip roll, 50 in	50 in (1270 mm); 16 gauge, 0.060 in (1.52 mm) mild steel; ⌀3 in (76.2 mm) rolls	Long panels and heavier sheet
Power slip roll	Same three-roll layout with a motor drive	Repeated parts and long runs
Shear, brake and roll combination	Three machines on one bench frame	Shops that need all three in one place

What to check when buying

Check	What to look for
Width and capacity	Forming width and gauge for mild steel on the plate; with the same rolls, a wider machine is rated for thinner sheet
Roll diameter	The sheet wraps around the upper roll, so that roll sets the tightest curve; larger rolls bend less across the width
Roll finish	Ground, smooth and free of nicks or rust; any mark on a roll prints on the sheet
Wire grooves	Sizes that match the wire you use, commonly 3/16, 1/4 and 5/16 in on 24 in machines
Adjustment	Screws at both ends of the lower and rear rolls, so the rolls set parallel for a cylinder or angled for a cone
Upper roll release	Opens without tools and closes square, so a closed cylinder slides off
Mounting	Holes to bolt the frames to a bench or stand that does not move when you crank

Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.

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Accessories

Item	What it is for
Radius gauges or a template	Checking the curve between passes
Stand	Holds the machine at working height and leaves room for the sheet to come round
Clean lint-free cloth and solvent	Wiping the rolls before aluminum
Light machine oil	Gears, journals and adjusting screws
Protective film	Covers clad sheet where the rolls would mark it

SCAN · OPEN THIS GUIDE
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