

Slip Rollers for Sheet Metal

DT Workshop Equipment Reference — D&T / STEM resource for school workshops | Metalworking Machines



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Slip rollers (slip rolls) form smooth curves and cylinders in sheet metal by passing it between three adjustable rollers. They are the machine for making tubes, cones, hoppers and curved panels for cans, guards and art metalwork.

Key Features

- Roll lengths from 300 to 1300 mm
- Capacity 1-2.5 mm steel typical
- Adjustable rear roll for curve radius
- Quick-release top roll for tube removal
- Wire-forming and box-and-pan versions

Typical Uses in the Workshop

- Roll cylinders and cones from sheet
- Make hoppers, funnels and guards
- Form curved panels for sculpture and models
- Roll wire into rings and circles

Safe Operation

1. Adjust the rear roll for the radius needed
2. Feed the sheet square between the rollers
3. Crank steadily to draw the sheet through
4. Keep the sheet level to roll it square
5. Remove the top roll end to extract closed tubes

SAFETY NOTES

- Keep fingers away from the roller nip
- Roll short pieces with a helper or guard
- Do not force sharp-edged sheets through
- Check the rollers are clean of burrs
- Wear gloves to handle curved sheet edges

Maintenance & Consumables

- Oil the rollers and journals
- Clean the rollers of debris
- Check the adjustment threads
- Inspect the gears and handles
- Store with the rollers slightly apart

Specification & Buying Notes

Choose roller length and capacity for the project sheet sizes. A geared model with spring-loaded top roll eases tube removal. Choose steel rollers over cast iron for surface finish.