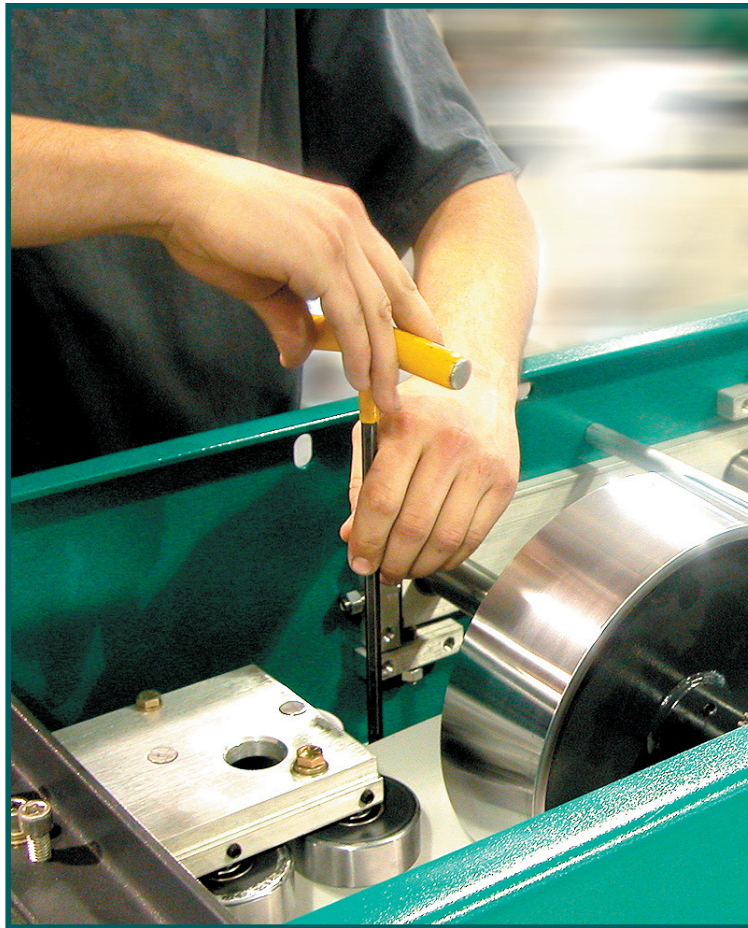


# JS5 & JS6

## Adjustment & Training Manual



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## SAFETY & RECOMMENDATIONS

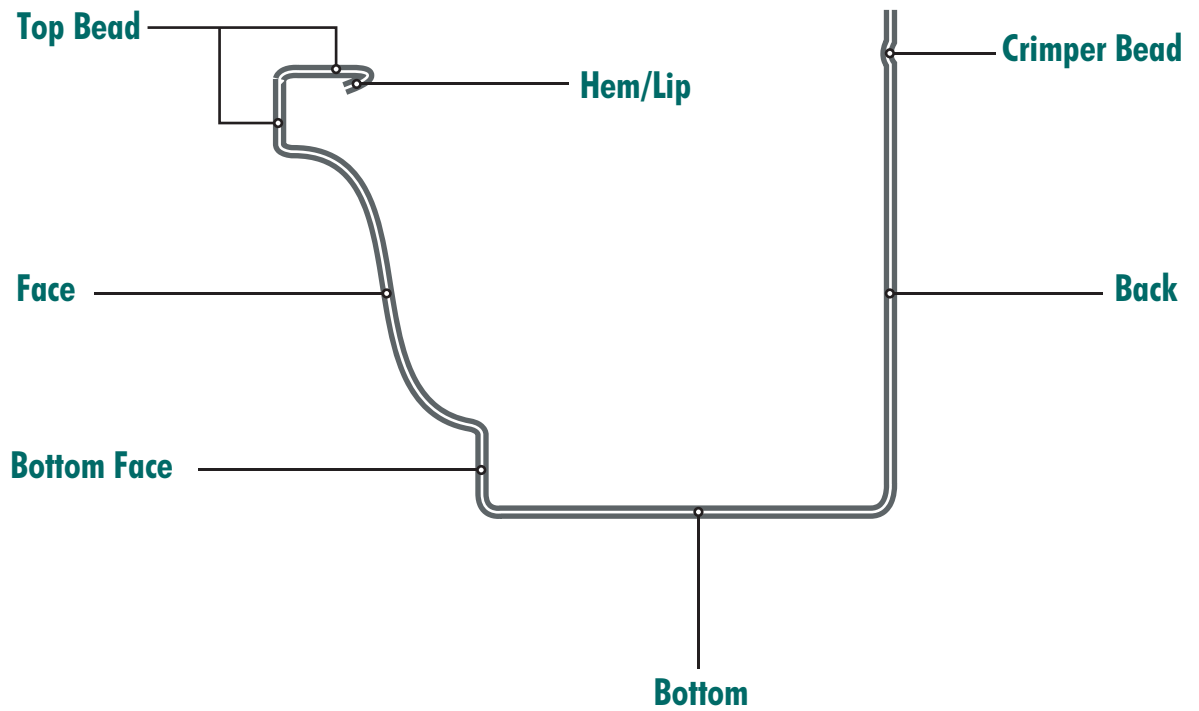
### GENERAL SAFETY AND RECOMMENDED TIPS

1. Read this manual before attempting to operate the machine.
2. Observe all safety signs and do not operate machine with any safety covers removed.
3. Stop the machine and disconnect power to the machine before making any adjustments.
4. Always conform to all local, and national safety codes concerning operating and lifting equipment that is used in conjunction with this machine.
5. Do not wear loose clothing, or jewelry when operating this machine.
6. Be aware that any foreign objects dropped on the coil will be carried through the machine and may cause damage.
7. Always keep lids on during storage and operation.
8. Avoid storing your machine outdoors for a long period of time. Cover your machine with a tarp for storage, but provide good ventilation to combat condensation and rust.
9. Keep your machine clean. This will increase the life of the machine, and make adjustments easier.
10. Keep components such as the shear and chains lubricated.
11. It is very important that all set screws, bolts, nuts, etc are constantly checked for tightness. This helps keep the machine in adjustment, and lessens the danger of a piece of hardware falling into the machine and causing serious damage to the rollers.
12. **Do not store, or transport the machine without gutter material running the full length of the machine.** The main forming rollers are set in close proximity to one another to create traction. Because of this fact, the rollers could be damaged during transport. Material in the machine also helps maintain adjustment.

## GUTTER TERMINOLOGY

### K-STYLE GUTTER PROFILE

These are the terms that Jobsite, Inc. used to describe the profile of a gutter.



## DRIVE SYSTEM

### POWER

The drive system is driven by a 1 HP single phase motor mounted on a C-face gear box. The gear box contains GL90 gear oil in its reservoir. This should be checked yearly to ensure proper oil level. The level should be between the center line of the upper shaft and the top of the reservoir cavity.

### CHAIN TENSION

The chain from the gear box to the main drive shaft should be checked periodically for tension and wear. To adjust tension, loosen the four bolts on reducer base plate and slide the unit towards the exit end of the machine to tighten chain.

**CAUTION: DO NOT OVER TIGHTEN.**

This will not only cause excessive wear, but will cause the #1 bottom roller to run out of round and cause oil canning in your gutter.

### LUBRICATION

Power is transmitted from one forming station to another by either chain and sprocket or gear. Lubricate chain weekly or every 20 hours of use. It is preferable to use a dry lubricant such as is used on motorcycle chains. Grease all gears after 20 hours with a waterproof grease.

**RECOMMENDED GREASE:**

Synco Chemical Corp.  
24 Davinci Drive  
Bohemia, New York 11716  
Super Luber PTFE Grease

**The characteristics of this grease are:**

- A heavy-duty grease 100% synthetic, totally compatible with other lubricants.
- Non-toxic, clean and clear, will not stain.
- Guaranteed to work from -45° Fahrenheit to +450° Fahrenheit. Will not melt, freeze, or separate. Prevents ice build-up.
- Impervious to salt water and road salt.

### FORMING ROLLERS

Power is transmitted to the gutter material by pinching the gutter material between the drive / forming rollers. Ideally it is desired to exert minimum pressure on the gutter material to drive it through the machine. To do this, in most cases will prevent twisting, oil canning, and erratic control of the gutter being formed.

## DRIVE SYSTEM

### ALIGNMENT

With the exception of the bottom #1, the entire bottom keel assembly is factory set for proper alignment and squareness of the bottom drive. If the bottom keel is suspected of being the source of the problem, take your gutter machine to your nearest Jobsite representative for service. It should be noted, however, that the bottom keel does not get out of alignment very easy unless the machine is dropped or involved in an accident.

The Jobsite Gutter Machine is designed to drive the coil straight through the machine. Only with a few exceptions, all top and bottom rollers will be aligned straight to the break lines of the gutter. The main top drive rollers should always be centered directly over the bottom.

### RECOMMENDED SETTING FOR DRIVE STATION CLEARANCE

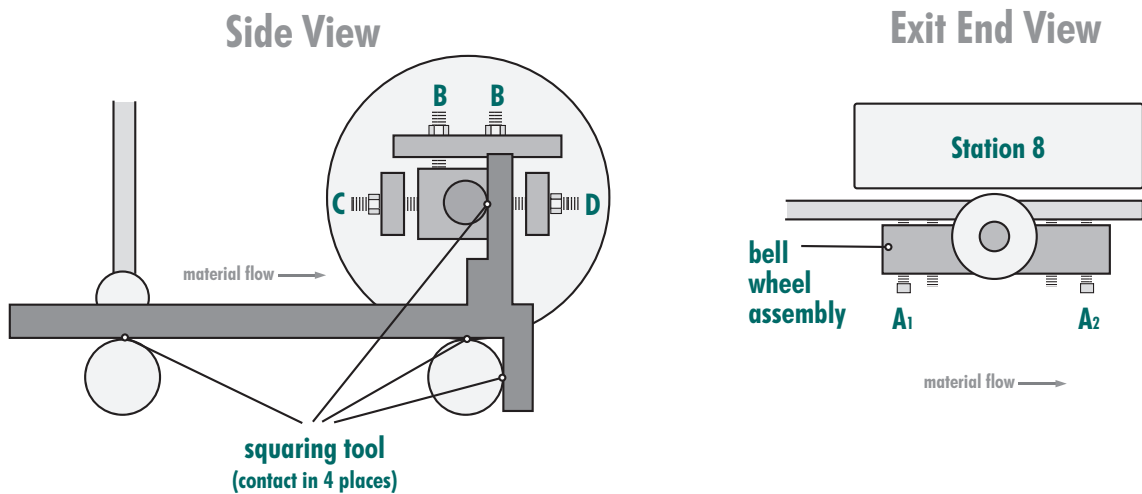
Station	JS5	JS6
#1 Bullet Roller	0.013 (0.33 MM)	0.013 (0.33 MM)
#2 Top Driver Roller	0.010 (0.254 MM)	0.010 (0.254 MM)
#2 Floater (Hub)	0.054 (1.372 MM)	0.060 (1.524 MM)
#3 Top Driver Roller	0.010 (0.254 MM)	0.010 (0.254 MM)
#4 Top Driver Roller	0.010 (0.254 MM)	0.010 (0.254 MM)
#5 Top Driver Roller	0.010 (0.254 MM)	0.010 (0.254 MM)
#6 & 7 Skate Roller	Material Thickness	Material Thickness
#8 Top Driver Roller	Touching	Touching
#8 Back Side	Material Thickness	Material Thickness
#8 Bell Wheel (Face Side)	0.032 (0.813 MM)	0.032 (0.813 MM)
#8 Bell Wheel (Bottom)	0.010 (0.254 MM)	0.010 (0.254 MM)

## ADJUSTING STATION #8

### ALIGNING STATION #8

(Station 8 must be aligned before Stations 2, 3, and 5 are adjusted.)

- A.** Remove bell wheel assembly by loosening screws A1 and A2. Loosen locknuts and screws C and D. Adjust #8 roller down until lying flat on bottom roller by loosening screws B.
- B.** Start with squaring tool on right side of #8 roller. Using screws C and D, adjust until the four points on the squaring tool are touching as shown below. Loosen the set screws on the #8 top roller locking collar and move the roller to the right until there is enough room to place the squaring tool on the left side. Repeat the same procedure for adjustment that was done on the right side. Re-check each side and tighten locknuts.



## ADJUSTING STATION #8

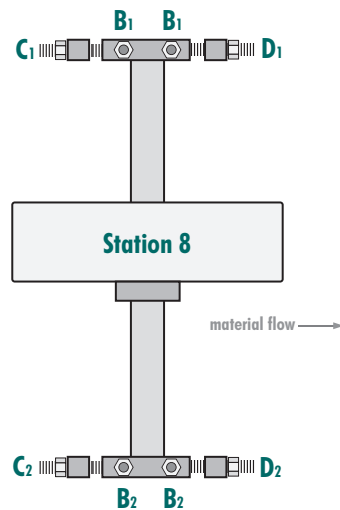
## ADJUSTING #8 DRIVE ROLLER CLEARANCE

**A.** Loosen locknuts and screws C1 and C2. Screws D1 and D2 should stay tight to maintain square. Use screw B1 and B2 to raise and lower top roller flush to bottom roller. Re-tighten screws C1 and C2 until snug and re-tighten all locknuts.

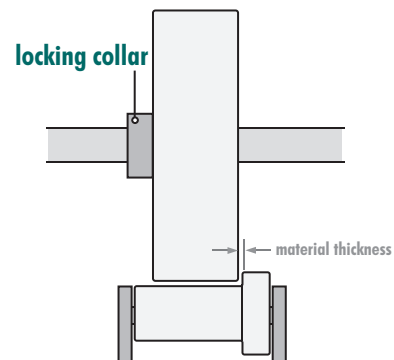
**B.** Loosen set screws on locking collar and move #8 roller left or right until a gap clearance of the material thickness is acquired as show below. Re-tighten set screws.

**CAUTION:** The rollers can become damaged if adjustment B is set too close. Be assured that the rollers are not touching and re-adjust if necessary.

Top View



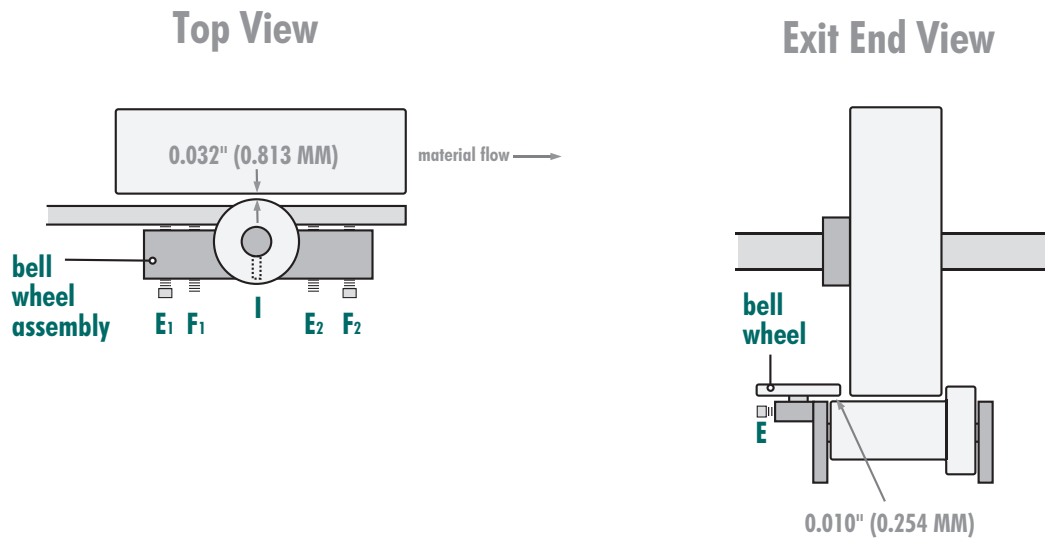
Exit End View



## ADJUSTING STATION #8

## ADJUSTING #8 BELL WHEEL CLEARANCE

- A.** Re-attach bell wheel assembly. Tighten screws E1 and E2 until a 0.032" (0.813 MM) clearance is acquired between the bell wheel and face side of roller #8. Tighten screws F1 and F2 snug.
- B.** Loosen set screw I. Raise or lower the bell wheel until a 0.010" (0.254 MM) gap is acquired between the bottom of the bell wheel and the #8 bottom roller as shown below.



## ADJUSTING BOX FORMING ASSEMBLY

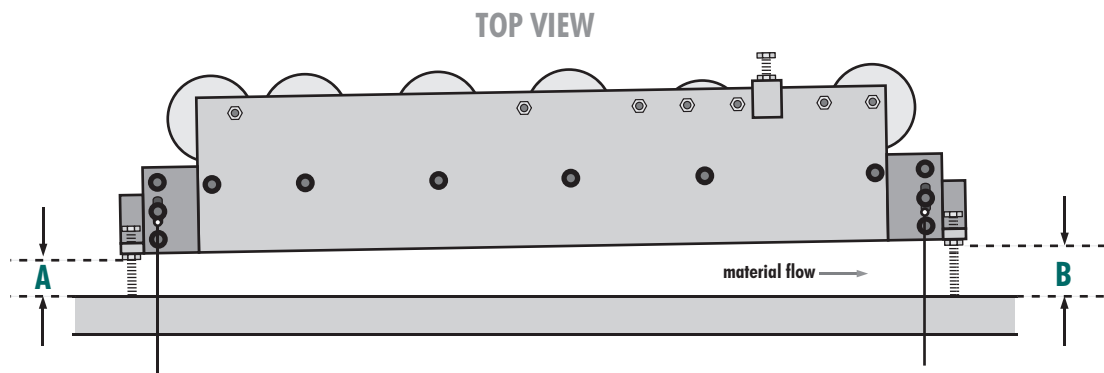
### BOX FORMING ASSEMBLY

The box assembly is a roll forming machine all by itself. Proper positioning is critical and any minor adjustment or realignment of the forming stations can adversely affect the performance of the machine. Each station in the box has been factory aligned and should not need re-adjustment. However if adjustment is needed contact your Jobsite representative for support.

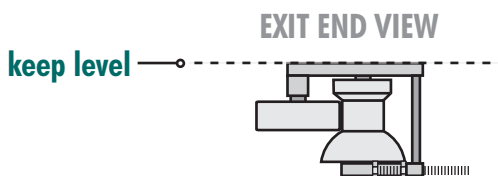
The box roller assembly must be positioned as specified below.

**JS5 Only** - Make sure the entry end of the assembly or dimension A is set 2 1/2" (6.35 CM) from the right side panel and the exit end or dimension B is set 2 3/4" (7 CM) from the right side panel. Initial factory setting may differ from these recommended settings.

**JS6 Only** - Make sure the entry end of the assembly or dimension A is set 2 3/4" (6.99 CM) from the right side panel and the exit end or dimension B is set 3 1/8" (7.94 CM) from the right side panel. Initial factory setting may differ from these recommended settings.



**To adjust box up and down loosen center set screw and use outside screws for adjustment.**



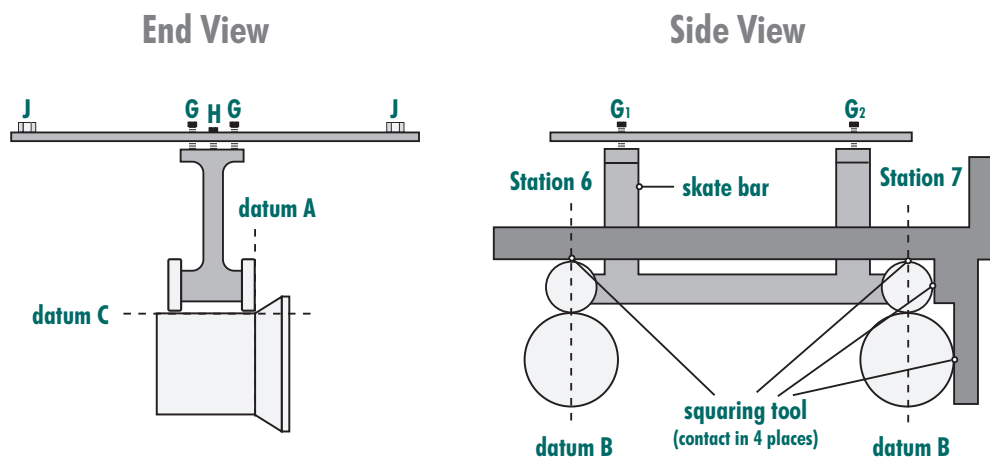
## ADJUSTING STATION #6 &amp; 7

## ALIGNING AND ADJUSTING STATIONS 6 &amp; 7

**A.** Loosen screws H on stations 6 and 7. Adjust clearance of top and bottom roller (Datum C) to zero using screws G. Make sure zero clearance is set across entire width of skate.

**B.** Datum B is adjusted with a squaring tool. Loosen screws G1 and G2 to hold skate assembly in place, but allow movement with a small rubber mallet. Place squaring tool as shown below. Gently strike skate casting with mallet to move assembly in contact with squaring tool in four places as shown below. Re-tighten screws G. Repeat same procedure for the right side.

**C.** Loosen screws J on both stations 6 and 7. Align the side of the skate bearing with Datum A as shown below. Re-tighten screws J.



**CAUTION:** Do not force skate bearing to ride on roller. This will cause damage to rollers.

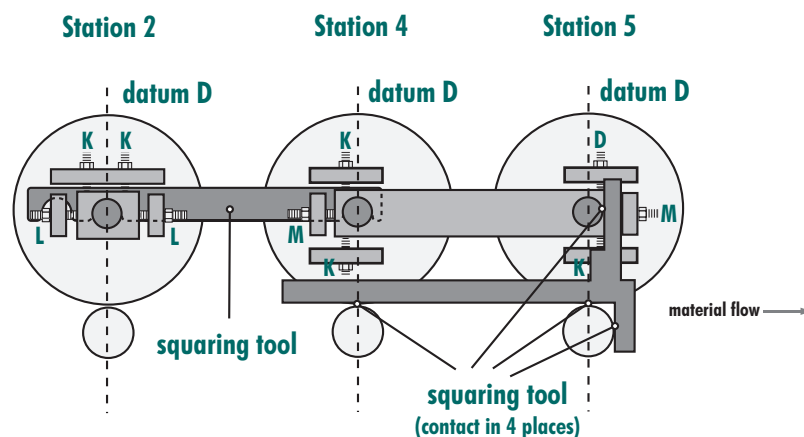
## JS5 - ADJUSTING STATION #2, 4, & 5

### JS5 - STATION #2, 4, & 5 ALIGNMENT

**A.** The top roller must be aligned directly over the bottom roller along Datum Plane D. Starting with stations 4 and 5 only, loosen locknuts and screws M. Set square on left side as shown below. Note square must be perpendicular to rollers shafts to work properly. Use adjustment screws M to move shaft back or forward until the four contact points make contact as shown below. Re-tighten locknuts M. Move squaring tool to the right side and repeat same procedure.

**B.** After station 4 and 5 have been aligned and tightened, loosen the locknuts and screws L. Station 2 is aligned by using a different squaring tool shown below. Set the notch in the squaring tool on the shaft of station 4 and adjust screws L until the other notch falls in place on the shaft of station 2. Re-tighten screws and locknuts L and repeat on opposite side.

### JS5 Side View



**NOTE:** The squaring tool to adjust station 2 has a notch for squaring the JS5 and a notch for squaring the JS6. Be sure to use the correct notch.

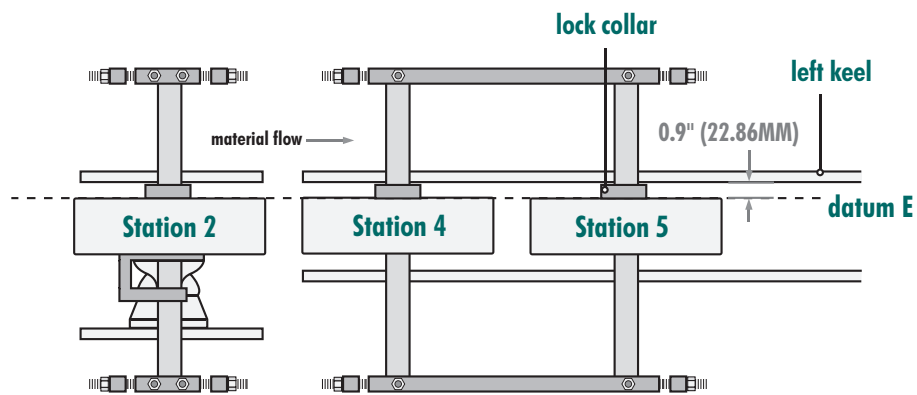


## JS5 - ADJUSTING STATION #2, 4, & 5

### JS5 - STATION #2, 4, & 5 ALIGNMENT CONT...

C. With Datum D now set, each roller must be aligned according to Datum Plane E. Loosen the set screw on each roller lock collar. Move each station 0.9" (22.86 MM) from the left keel as shown below. Re-tighten lock collar set screw.

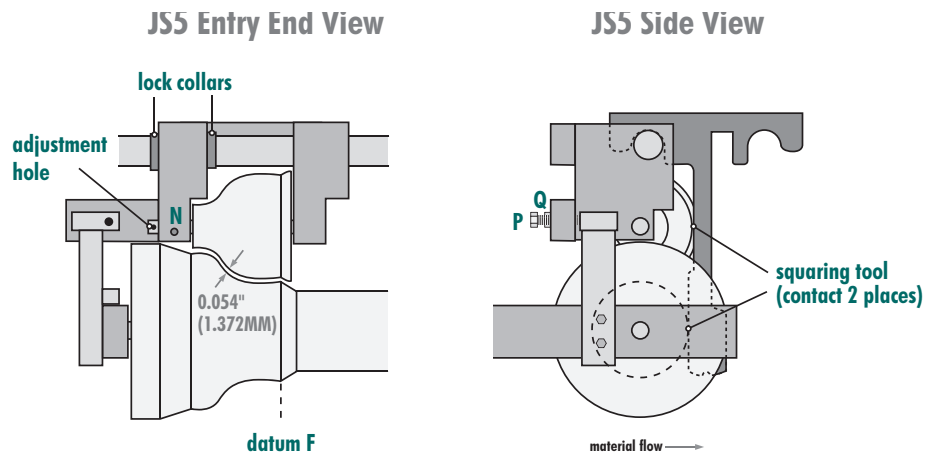
#### JS5 Top View



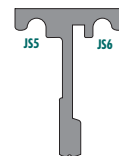
## JS5 - ADJUSTING STATION #2, 4, & 5

### JS5 - STATION #2 HUB ROLLERS ALIGNMENT

- A.** Loosen set screws on lock collars. Move roller along shaft to align top hub roller over bottom hub roller from left to right. A mirror might be needed to match the roller profiles.
- B.** Loosen set screw N. The top hub roller is on an eccentric shaft for adjusting. Insert allen wrench into adjustment hole and rotate until a gap of 0.054" (1.372 MM) is set on the flattest point of the top and bottom rollers. Re-tighten set screw N.
- C.** Place squaring tool on station 2 shaft aligned with datum F. Tighten or loosen screw P until rollers contact square in 2 places shown in side view below. If screw P runs out of play then screw Q can be used for adjusting.
- D.** Re-check gap setting between rollers and re-adjust as necessary.



**NOTE:** The squaring tool to adjust station 2 hub has a notch on each side for squaring the JS5 and JS6. Be sure to use the correct side.

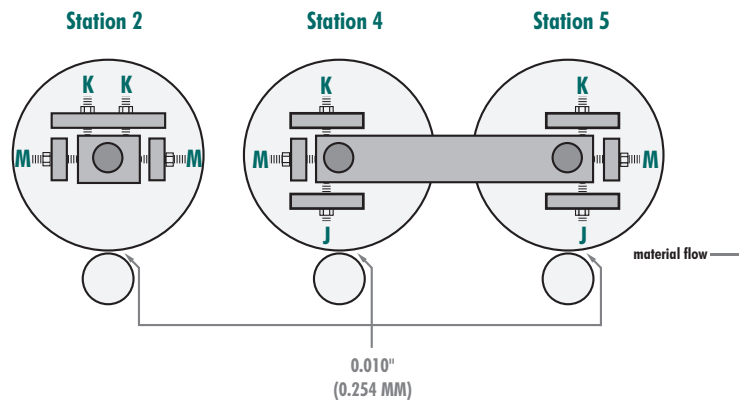


## JS5 - ADJUSTING STATION #2, 4, & 5

### JS5 - STATION #2, 4, & 5 TOP DRIVE ROLLER CLEARANCE

**A.** Each station needs to be aligned properly before setting drive roller clearance. Loosen lock nuts on screws K, J, and M. Loosen screws K and tighten screws J to increase gap or loosen screws J and tighten screws K to decrease gap. Adjust until a 0.010" (0.254 MM) gap is acquired between the top and bottom roller. Repeat on both side to assure gap is equal across the entire width of roller on all three rollers. Re-tighten screws K snug and re-tighten lock nuts.

JS5 Side View



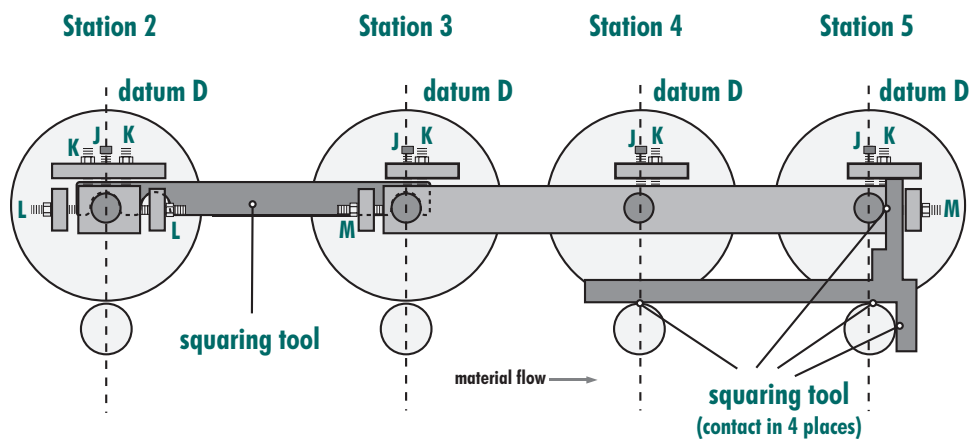
## JS6 - ADJUSTING STATION #2, 3, 4, & 5

### JS6 - STATION #2, 3, 4, & 5 ALIGNMENT

**A.** The top roller must be aligned directly over the bottom roller along Datum Plane D. Starting with stations 4 and 5 only, loosen locknut and screws M. Set square on left side as shown below. Note square must be perpendicular to rollers shafts to work properly. Use adjustment screws M to move shaft back or forward until the four contact points make contact as shown below. Re-tighten locknuts M. Move squaring tool to the right side and repeat same procedure.

**B.** After station 3, 4 and 5 have been aligned and tightened, loosen the locknuts and screws L. Station 2 is aligned by using a different squaring tool shown below. Set the notch in the squaring tool on the shaft of station 4 and adjust screws L until the other notch falls in place on the shaft of station 2. Re-tighten screws and locknuts L and repeat on opposite side.

### JS6 Side View



**NOTE:** The squaring tool to adjust station 2 is has a notch for squaring the JS5 and a notch for squaring the JS6. Be sure to use the correct notch.

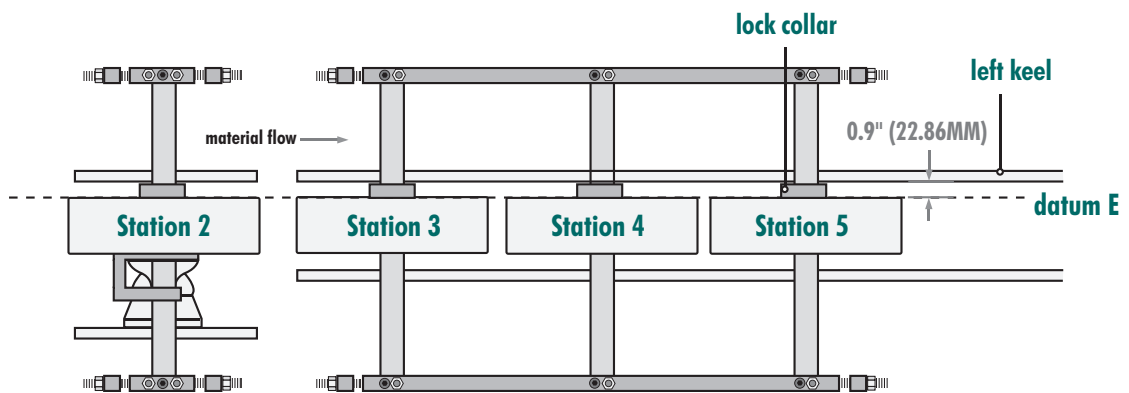


## JS6 - ADJUSTING STATION #2, 3, 4, & 5

### JS6 - STATION #2, 3, 4, & 5 ALIGNMENT CONT...

C. With Datum D now set, each roller must be aligned according to Datum Plane E. Loosen the set screw on each roller lock collar. Move each station 0.9" (22.86 MM) from the left keel as shown below. Re-tighten lock collar set screw.

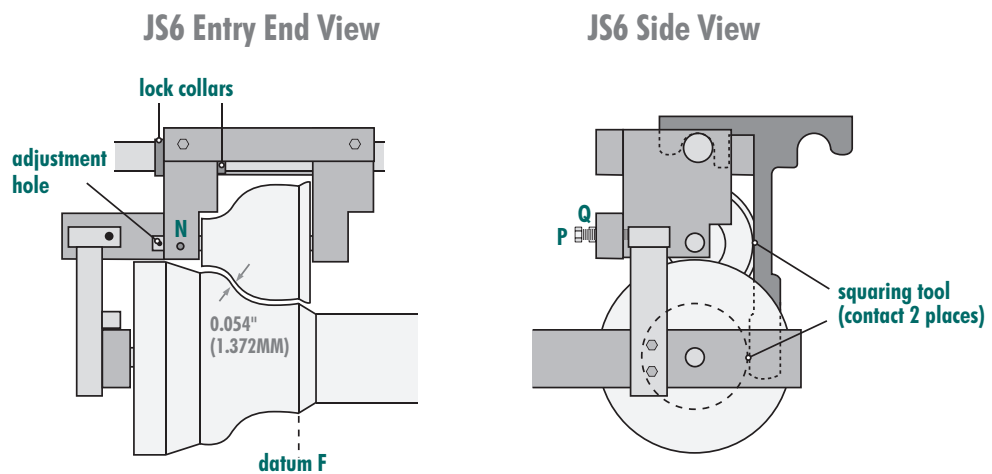
JS6 Top View



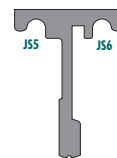
## JS6 - ADJUSTING STATION #2, 3, 4, & 5

### JS6 - STATION #2 HUB ROLLERS ALIGNMENT

- A.** Loosen set screws on lock collars. Move roller along shaft to align top hub roller over bottom hub roller from left to right. A mirror might be needed to match the roller profiles.
- B.** Loosen set screw N. The top hub roller is on an eccentric shaft for adjusting. Insert allen wrench into adjustment hole and rotate until a gap of 0.054" (1.372 MM) is set on the flattest point of the top and bottom rollers. Re-tighten set screw N.
- C.** Place squaring tool on station 2 shaft aligned with datum F. Tighten or loosen screw P until rollers contact square in 2 places shown in side view below. If screw P runs out of play then screw Q can be used for adjusting.
- D.** Re-check gap setting between rollers and re-adjust as necessary.



**NOTE:** The squaring tool to adjust station 2 hub has a notch on each side for squaring the JS5 and JS6. Be sure to use the correct side.

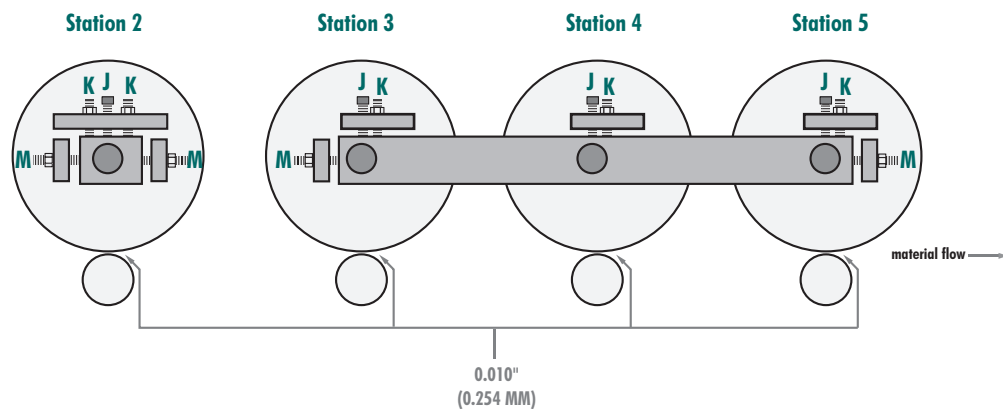


## JS6 - ADJUSTING STATION #2, 3, 4, & 5

### JS6 - STATION #2, 3, 4, & 5 TOP DRIVE ROLLER CLEARANCE

**A.** Each station needs to be aligned properly before setting drive roller clearance. Loosen lock nuts and screws K. Loosen screw M on one side only to allow up or down movement. To adjust up tighten screws J and loosen screws K and vice versa for adjusting down. Adjust until a 0.010" (0.254 MM) gap is acquired between the top and bottom roller. Repeat on both side to assure gap is equal across the entire width of roller on all four rollers. Re-tighten screws M snug and re-tighten all lock nuts.

JS6 Side View

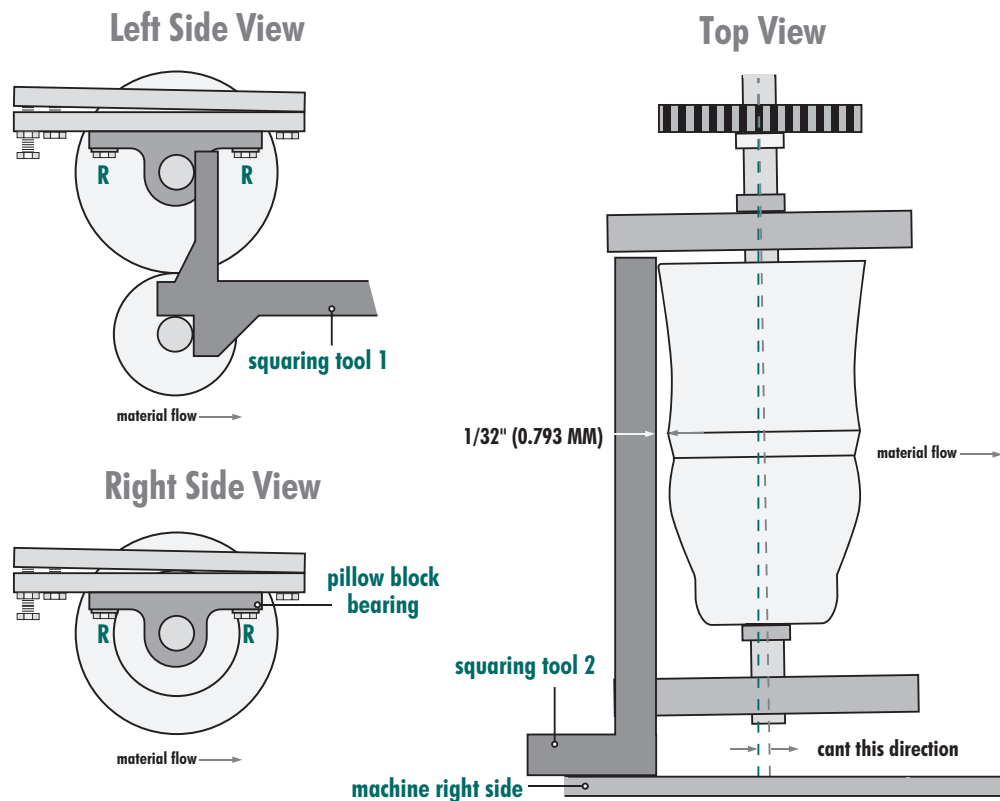


## ADJUSTING STATION #1

## STATION #1 BULLET ROLLER ALIGNMENT

**A.** To adjust loosen screws R on both sides. While keeping the left side square as shown below, place square 2 against right side of machine as shown below. Move the right side pillow block bearing forward until a  $1/32"$  (0.793MM) gap is acquired shown below. Retighten screws R.

Additional adjusting can help counteract pressure against right entry guide as well as controlling the lip of the gutter while feeding gutter material into the machine. The lip on the leading end of the gutter material will generally be heavy for the first two feet of gutter. This could jam in the box forming assembly or in the shear. **However, do not move more than  $1/32"$  at a time.** Exceeding  $1/8"$  can cause gutter to go away from the house.

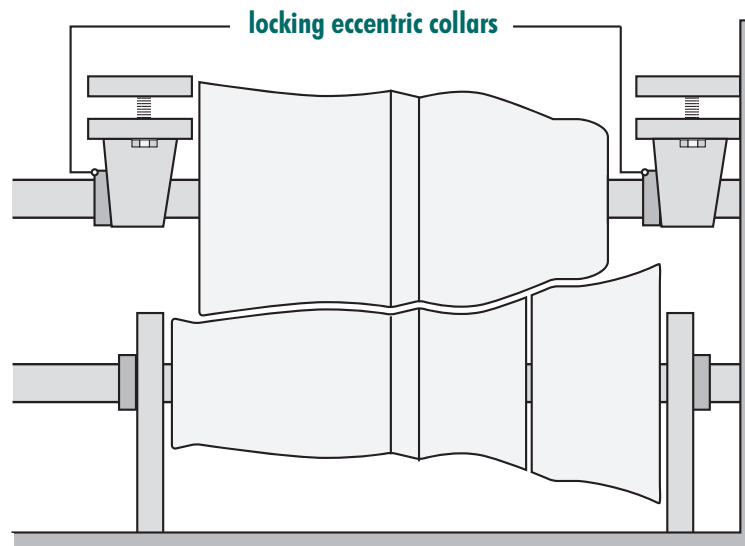


## ADJUSTING STATION #1

**STATION #1 BULLET ROLLER ALIGNMENT CONT...**

**B.** Align the bullet profile over the bottom roller profile. Use an allen wrench to loosen set screw on eccentric collars. Rotate collar either direction to unlock. Move the bullet roller left to right to desired position. Re-lock collar and re-tighten set screw.

Failure to center roller will cause excessive wear on rollers and possibly introduce stress into the gutter, making the gutter difficult to adjust by normal means.

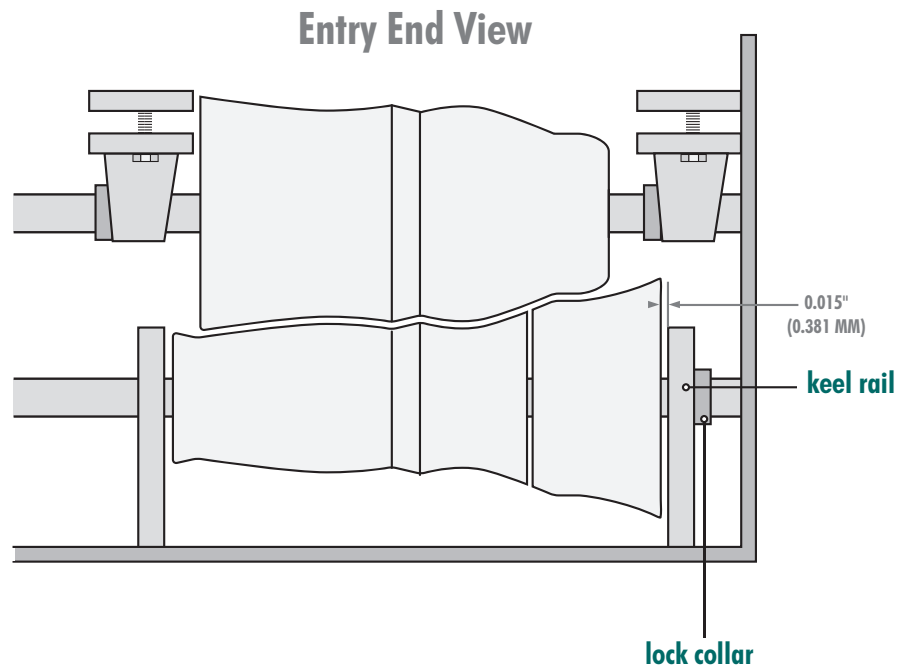


**Entry End View**

## ADJUSTING STATION #1

**STATION #1 BOTTOM ROLLER ALIGNMENT**

**A.** The bottom roller can be moved left or right to align the critical radius with the station forming rollers. Adjust the right side of the bottom roller 0.015" (0.381 MM) to the left of the right keel rail as shown below. To move the bottom roller, loosen the lock collar on the right and the sprocket on the left, and by using a screw driver, move the bottom roller left or right as needed.

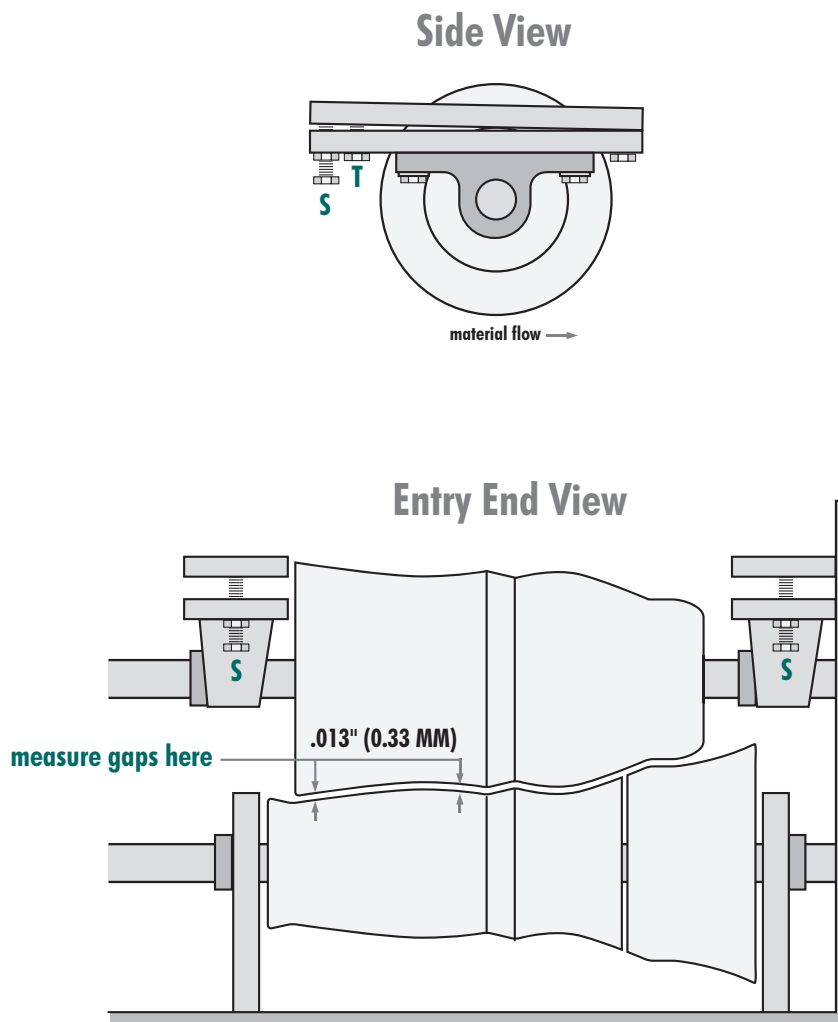


**CAUTION:** Do not force roller, bottom roller will interfere with top roller if roller is moved far enough. Attempting to force roller can damage rollers, you may have to move the bullet at the same time to avoid damage. Do not pry directly against roller.

## ADJUSTING STATION #1

**STATION #1 BULLET ROLLER CLEARANCE**

**A.** Loosen lock down screws T on the left side and T on the right side of the machine. Loosen lock nut on S and turn screw counterclockwise to increase gap and turn clockwise to decrease gap between the drive roller. Re-tighten lock nut on S and screw T. Measure gap in both corners to .013" (0.33 MM) as shown below.

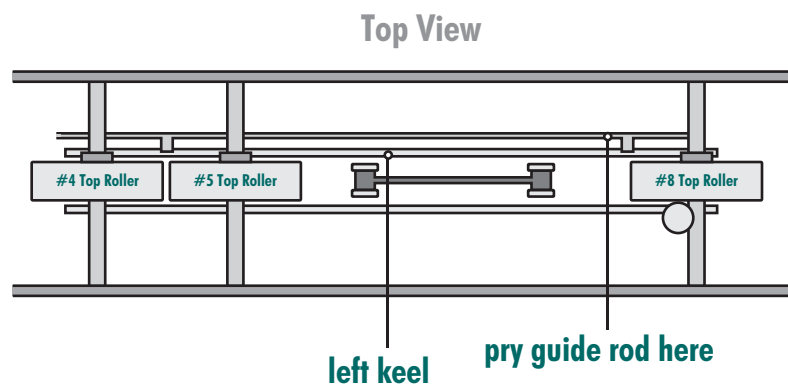


## ADJUSTING GUIDE RODS

The guide rods are factory set and should not need adjustment. However if adjustment is needed follow the process below.

### ADJUSTING GUIDE RODS

- A.** Run out a piece of gutter and check the angle between the back face and the bottom is set at 90°.
- B.** Use a mini pry bar or other leverage device to pry against the guide rod and the keel rail close to the attachment area shown below. Pry to the right to decrease the angle and pry to the left to increase the angle. Be very careful to pry small amounts at a time and do not pry against any rollers. Run-out gutter, check angle and re-adjust if necessary.



## FREQUENTLY ASKED QUESTIONS

### 1. WHY IS PAINT PEELING OFF MY GUTTER?

- A. Try running a different color coil (make sure it did not come from the same lot run of coil). If paint does not come off 2nd coil, the paint on the 1st coil is most likely bad.
- B. Check rollers for damage or build-up of foreign product (i.e., paint, tape, plastic, etc.).
- C. Check clearance of rollers (See page 4).

### 2. WHY AM I LOOSING HEM OR LIP AFTER 10-15 FEET?

- A. Lower entrance end of box assembly 1/16" (See page 8). And/or, move entry guides 1/16" towards the face side panel.

### 3. WHY ARE THERE RIPPLES (OIL CANNING) IN THE BOTTOM OF MY GUTTER WHILE RUNNING COPPER?

- A. Check to see if rollers are damaged or if roller have accumulated build-up.
- B. Check roller clearances (See page 4).
- C. Release pressure off of the face side of Station 8 top roller.

### 4. WHY IS MY GUTTER NOT STRAIGHT?

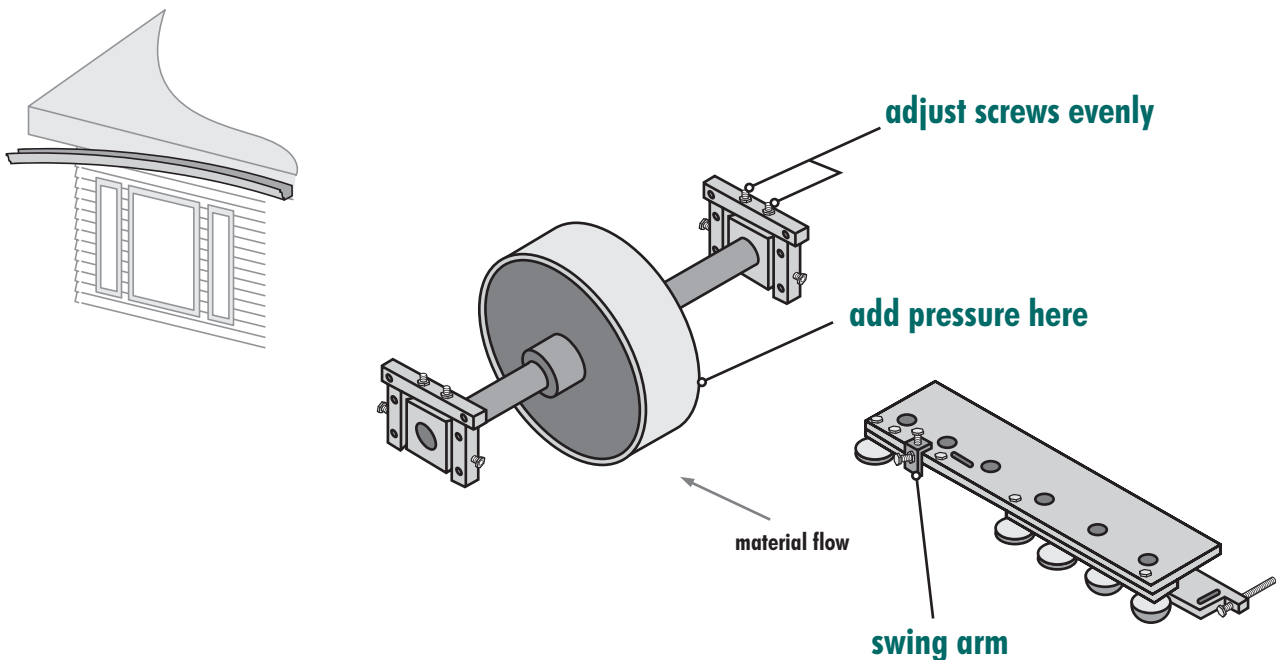
- A. Refer to the Troubleshooting section (See page 24 through 27).

## TROUBLESHOOTING

**GUTTER IS RUNNING AWAY FROM THE HOUSE**

When the gutter is curving away from the house, there are two adjustments that can be made to correct this problem. Always disconnect power before adjusting.

- A. Add more pressure to the right side of the #8 top roller by adjusting the screws clockwise shown below. Make sure that the locknuts are secured after adjustment.
- B. Unlock the swing arm bolt at the box assembly and rotate clockwise shown as below. This will only effect the top bead of the gutter. Lowering the box 1/2 turn will also help, but will cause gutter to run uphill. Make sure the locknuts and bolts are secured after adjustment.



**Note:** When making adjustments, it is a good idea to write down how many turns are made to each adjusting screw. Then you can always reset the adjusting screws back to their original positions.

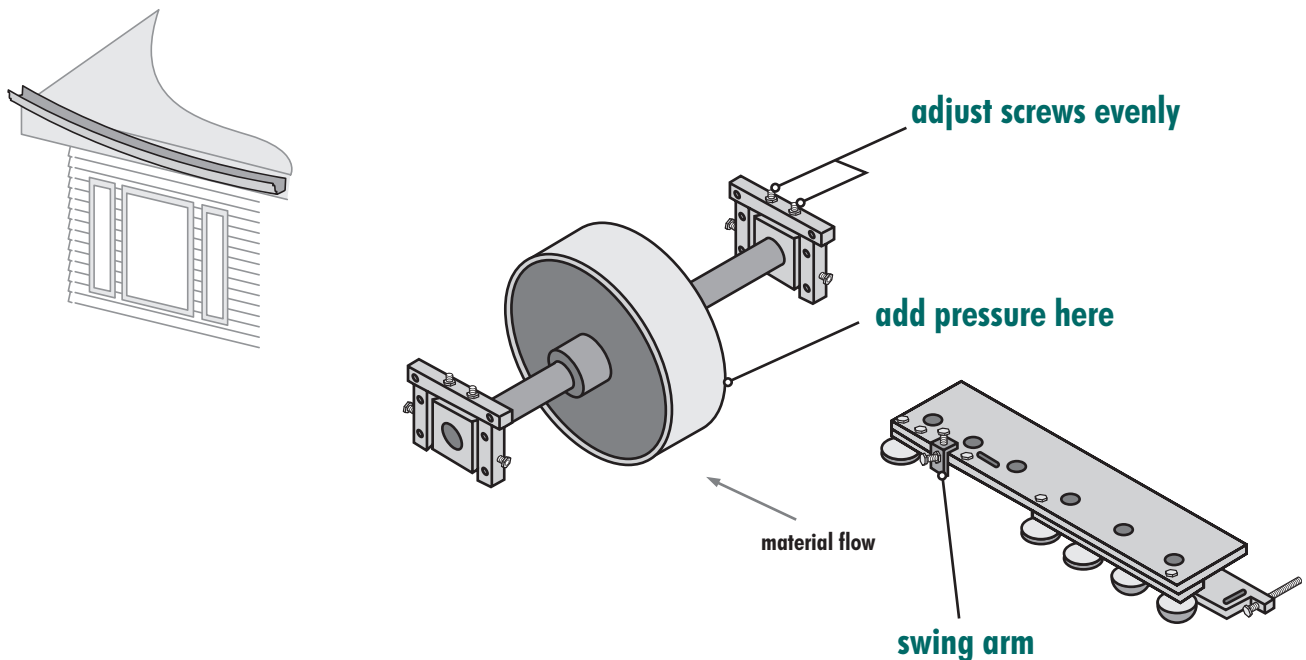
Small adjustments greatly affect the gutter path! Take care to slowly change each setting.

## TROUBLESHOOTING

**GUTTER IS RUNNING TOWARDS THE HOUSE**

When the gutter is curving towards the house, there are two adjustments that can be made to correct this problem. Always disconnect power before adjusting.

- A. Reduce the pressure to the right side of the #8 top roller by adjusting the screws clockwise noted below. Make sure that the locknuts are secured after adjustment.
- B. Unlock the swing arm bolt at the box assembly and rotate counter-clockwise as shown below. This will only effect the top bead of the gutter. Raising the box 1/2 turn will also help, but will cause gutter to run downhill. Make sure the locknuts and bolts are secured after adjustment.



**Note:** When making adjustments, it is a good idea to write down how many turns are made to each adjusting screw. Then you can always reset the adjusting screws back to their original positions.

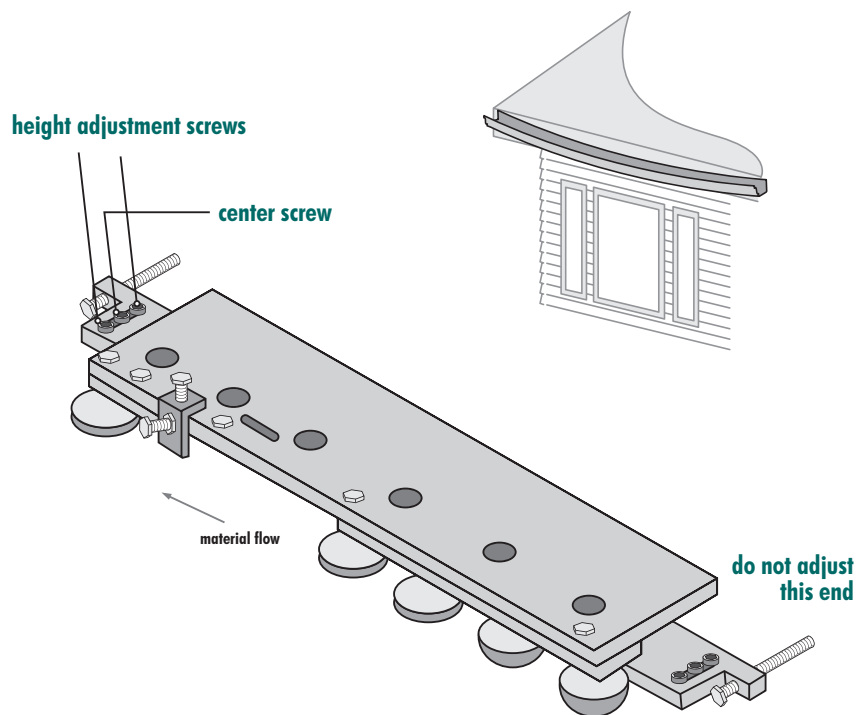
Small adjustments greatly affect the gutter path! Take care to slowly change each setting.

## TROUBLESHOOTING

**GUTTER IS RUNNING UPHILL**

When the gutter is curving uphill, there is one adjustment that can be made to correct this problem. Always disconnect power before adjusting.

- A.** Loosen center screw on exit end of Box Roller Assembly. Adjust end up with the two outside screws 1/2 turn at a time. Make sure the two height adjustment screws are set evenly. If they are not even, the box assembly will not be level, resulting in gutter being twisted. Re-tighten center bolt.



**Note:** When making adjustments, it is a good idea to write down how many turns are made to each adjusting screw. Then you can always reset the adjusting screws back to their original positions.

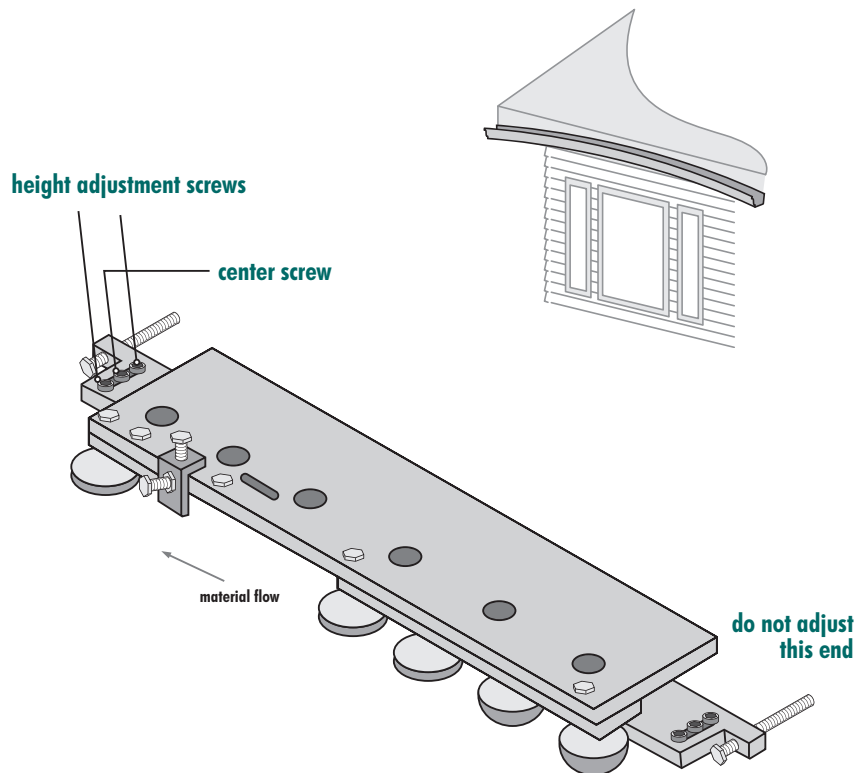
Small adjustments greatly affect the gutter path! Take care to slowly change each setting.

## TROUBLESHOOTING

**GUTTER IS RUNNING DOWNHILL**

When the gutter is curving downhill, there is one adjustment that can be made to correct this problem. Always disconnect power before adjusting.

- A. Loosen two outside screws then tighten center screw 1/2 turn at a time. Make sure the two height adjustment screws are set evenly. If they are not even, the box assembly will not be level; resulting in gutter being twisted. Re-tighten outside screws.



**Note:** When making adjustments, it is a good idea to write down how many turns are made to each adjusting screw. Then you can always reset the adjusting screws back to their original positions.

Small adjustments greatly affect the gutter path! Take care to slowly change each setting.

## CONTACT JOBSITE

Jobsite has put their best effort in designing, fabricating and manufacturing the highest quality machine on the market and hope you get many years of prosperity from this superior machine.

If you are having trouble with adjustments mentioned in this manual or any other adjustments contact your local dealer. You may also contact Jobsite below:

**Jobsite, Inc.**

841 21 1/2 Road

Grand Junction, CO 81505

Toll Free: (800) 992-8996

Phone: (970) 523-5885

Fax: (970) 523-5881

Email: [machinesales@jobsite-us.com](mailto:machinesales@jobsite-us.com)

Visit our website for more information on this machine and our other roll forming equipment and accessories at [www.jobsite-us.com](http://www.jobsite-us.com).