

"Ring Roll"

by Art Miller, Riverside, California

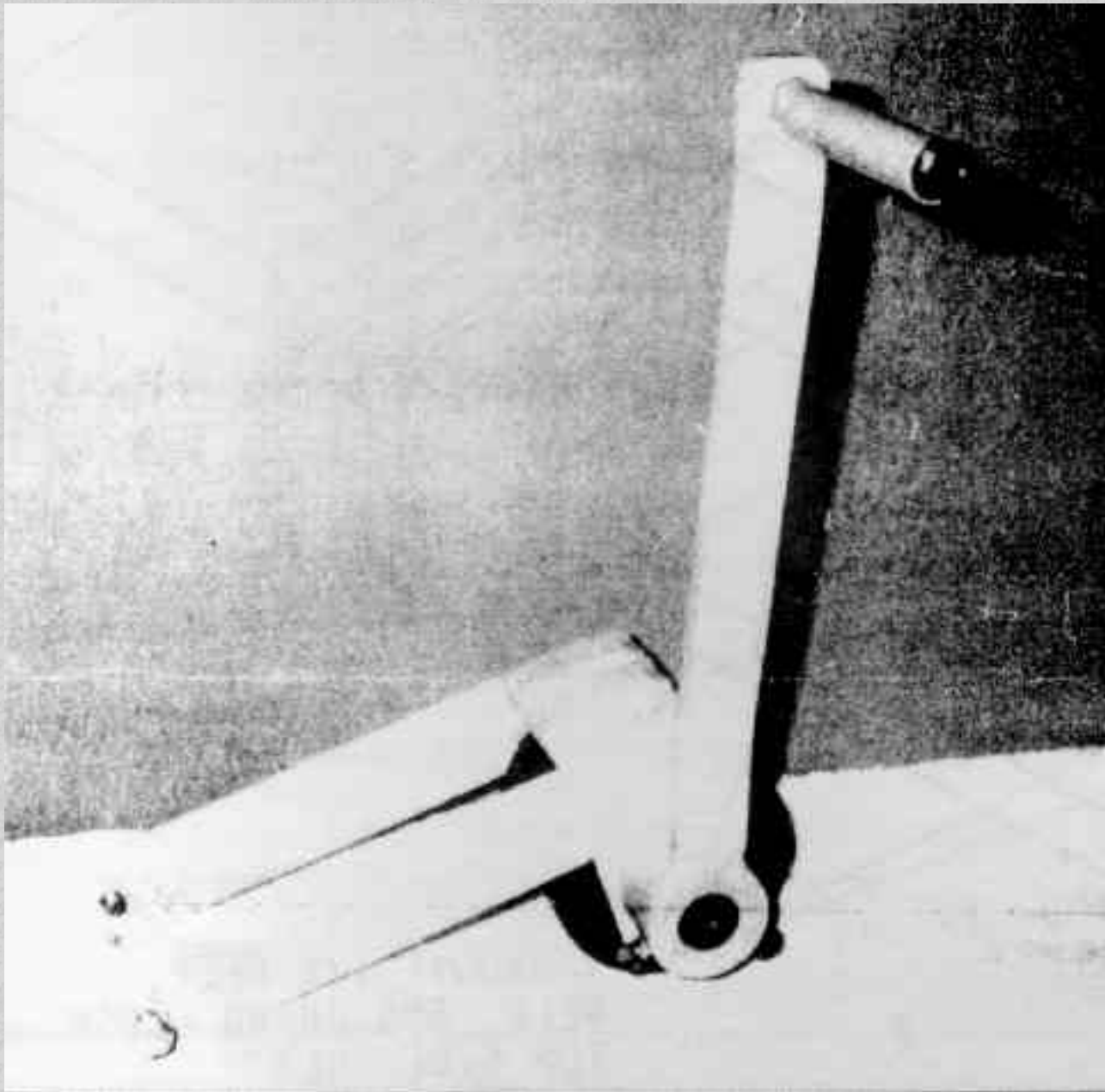
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In the need for a ring roller, I copied and scaled down a ring roll used at a local fabrication shop. It is made from miscellaneous cutoff and was fabricated with a cutting torch, cutoff saw, drill press, hand grinder and arch welder.

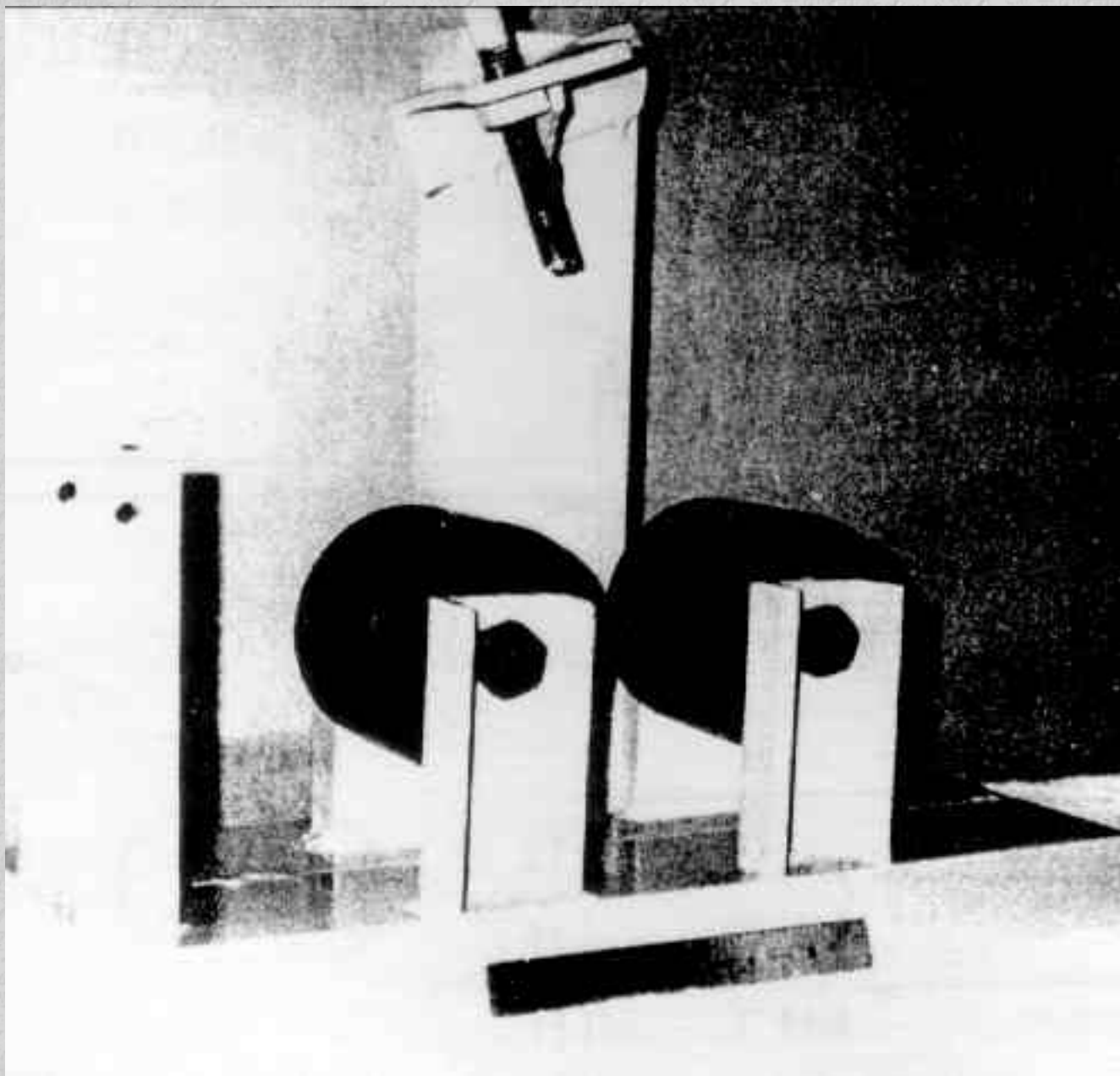
the fixed roller (tied to the crank) and crank assembly is removable from the base to allow installation and removal of welded rings.

The 2.5 inch wide rollers are made from sch. 40 pipe (3.5" OD) with 1/4 plate end caps. 5/8" bolts were used for axels. The fixed drive roll has a 3/4" diameter shaft with the fixed roll pin through this shaft and pipe roller with 5/16" dia rod 3.5" long. Braze the pin to the pipe roller OD.

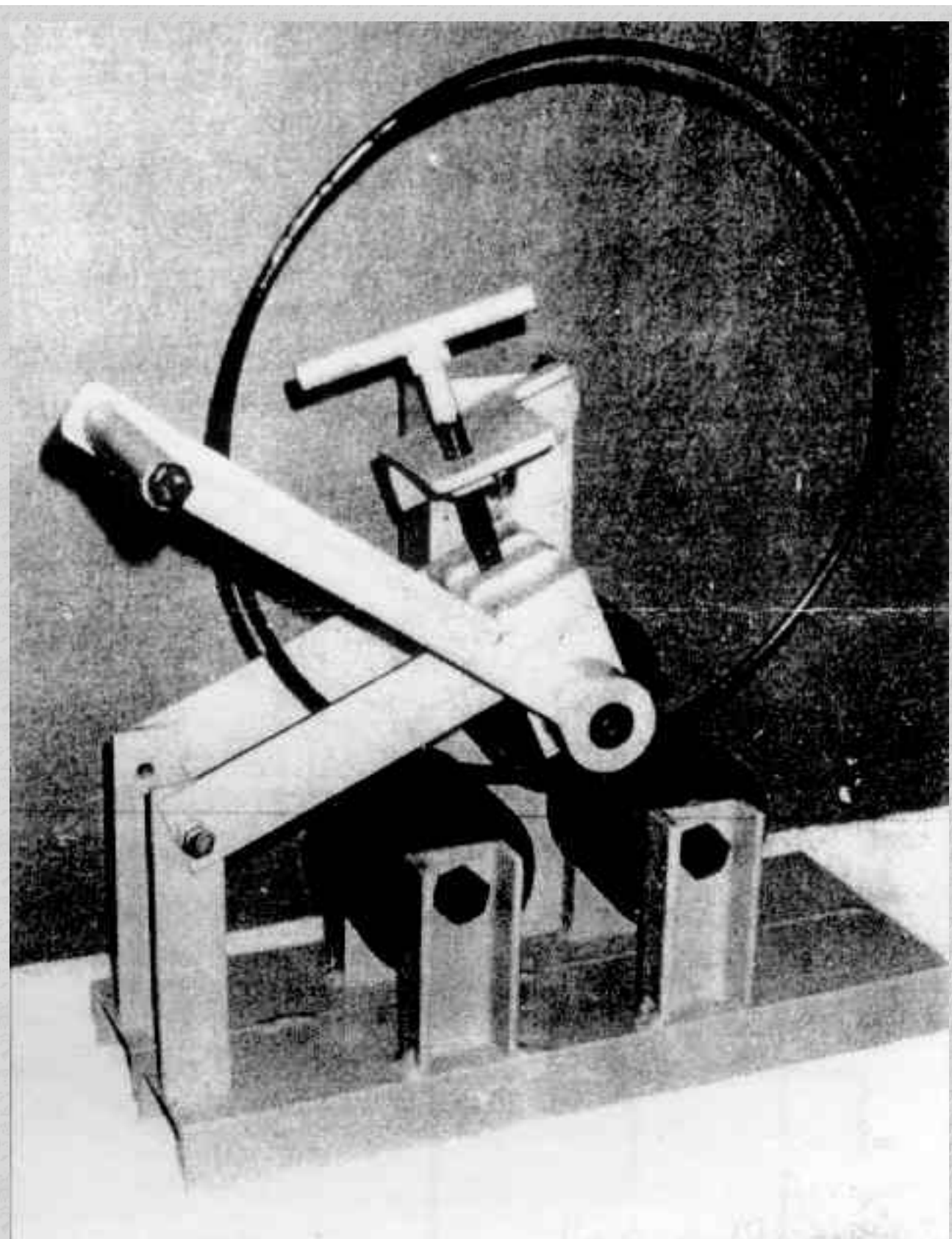
TIP: The roller will not bend the ends of the material. the length of this straight section will depend on your roller spacing. Mine leaves a little less than 2" straight on each end. So I calculate the ring material length ($C = \pi \times \text{mean diameter}$) and add 4". Cut stock and prick punch 2" from the end of the stock lay out ring length and prick punch at the other end of the material. Roll ring and cut off at punch marks.



Top assembly



base assembly



machine with ring being formed