



# USER ARTICLE PANEL - TWISTING



**Version 2026.1**

**SCOTTSDALE**

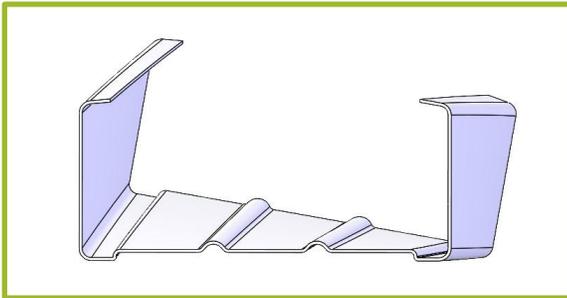
THE TRUSTED STEEL-FRAMING PARTNER

# PANEL - TWISTING

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## Problem/Question

Panel Machine is producing C-profile frames with a twist in the bottom horizontal section. The twist caused misalignment in production, leading to quality issues in the final frames.



## Possible Causes

- Roller misalignment in entry and mid-stations.
- Incorrect pressure setup.
- Worn bearings or rollers in Station 4.
- Different Lip lengths.

## Possible resolution

- Checked and re-aligned rollers at Stations 1–3, which set the direction of the profile.
- Checked and reset roller setup ensuring rollers are level with even pressure side to side.
- Replaced worn bearings or rollers at Station 4.
- Adjust infeed rollers to even out lip lengths.
- Verified machine setup for the steel thickness in use.

### Quick Tip

- Always perform a full roller setup when changing material thickness.
- Check station 1-3 for alignment.

### Reference Videos

Setting Gauge thickness

<https://www.youtube.com/watch?v=qO1gg-xpt64>

Setting Profile, lip length, Bow

<https://www.youtube.com/watch?v=fmxWVBIVS7w>