

Instructions for No. 0581 Crimping and Beading Machine

INSTRUCTIONS

CAUTION! Be certain that the machine is securely bolted into Bench Standard (1) and that Bench Standard is securely clamped to work bench. Also, work bench must be bolted to floor.

Mount Lower Crimping Roll (11) on driving lugs of Lower Gear (16). Note key slots for mating with lugs of the Lower Gear. The Gear (16) Is keyed to the Lower Arbor (9), thus becoming the driver.

To mesh Upper Crimping Roll (10) with Lower Crimping Roll (11): rotate Upper Gear (15) until its lugs will accommodate slots in Upper Crimping Roll in proper mesh. Upper Gear slides on Upper Arbor (8), acting as idler and is driven by mating with Lower Gear.

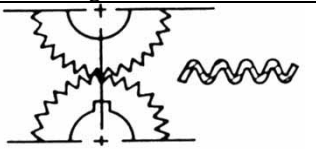
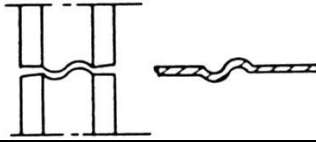
To adjust machine:

1. Mount Crimping Rolls as noted above. Mount Upper Ogee Beading Roll (12) and Lower Ogee Beading Roll (13) and secure with Roll Nuts (19).
2. Use Adjusting Screw Handle (2) to raise or lower the Upper Rolls into and away from the work.
3. Use Setscrew (24) to limit movement of Upper Rolls to setting required for given operation.
4. Use Pivot Screw (18) to tip (or tilt) Upper Arbor and Rolls in order to obtain a "fade-away" or straight crimp as desired. Pivot Screw (18) is reached by opening Spring Cover (17).
5. If only crimp is desired, remove Ogee Bead Rolls and Crimping Rolls. Mount Spacers (14) on Arbors to mate with Gear lugs. Mount Crimping Rolls to mate with Spacer lugs and rotate to proper mesh as described above. Lock securely with Roll Nuts (19).
6. Keep machine Arbors, Screws, Rocking Box, Journal Bearings and Gears lubricated with a medium (SAE 30) motor oil. "X" points should be lubricated daily with a good grade machine oil.

Model No. 0581 Crimping And Beading Machine Is Furnished With:

350000017	10570 Ogee Bead Roll
350000018	10571 Ogee Bead Roll
350000015	10568 Crimping Roll
350000016	10569 Crimping Roll
381700082	10572 Spacing Collars
259700013	BM 10580 Standard Gauge
239009750	975 Bench Standard

ITEM No.	PART No.	DESCRIPTION	No. REQ'D
1 *	239009750	#975 Bench Standard, Complete	1
2	764670214	Adj. Screw Handle (With Adj. Screw)	1
3	259700013	Gauge	1
4	230700008	Crank Assembly, Hand	1
5	764140114	Frame	1
6	764480016	Spanner Wrench	1
7	See Item 2	Adj. Screw	1
8	764680115	Upper Arbor	1
9	764680116	Lower Arbor	1
10	350000015	Upper Crimping Roll	1
11	350000016	Lower Crimping Roll	1
12	350000017	Upper Beading Roll	1
13	350000018	Lower Beading Roll	1
14	381700082	Spacing Collar	2
15	764380117	Upper Conn. Gear	1
16	764380118	Lower Conn. Gear	1
17	764220119	Cover	1
18	764650120	Pivot Screw	1
19	764560121	Roll Nut	2
20	664184542	Spring	2
21	641012131	Thumb Screw	1
22	621012132	5/16-18 x 7/8 Socket S. S.	1
23	600325907	5/16-18 x 3/4 Headless S.S.	2
24	600325912	1/4-20 x 3/4 Headless S.S.	1
25	615012086	1/4-20 x 1/2 Btn. Head Capscrew	1
26	649023004	5/16-18 Check Nut	2
27	764530122	Lower Arbor Key	1
BS1*	746060001	Standard	1
BS2*	746010002	Swivel Cap	1
BS3*	746030003	Lever for Clamping Screw	1
BS4*	746650004	Clamping Screw	1
BS5*	633012227	7/16-14 x 1-1/2 Sq. Hd. C.P.S.S.	1
BS6*	600063472	3/16 x 2 Btn. Hd. Sti. Rivet	1
BS7*	600063442	5/32 x 3/4 Roll Pin	1

Name	Roll Number	Catalog Number	Gauge Req'd	Roll Diagram
Crimping Roll	10568 10569	350000015 350000016	BM10580	
Ogee Bead Roll	10570 10571	350000017 350000018	BM10580	
Spiral Crimp Roll	10776 10777	350000019 350000020	BM10580	