

NO. 0581 CRIMPING AND BEADING MACHINE INSTRUCTIONS AND PARTS LIST



The 0581 is furnished with Ogee Bead Rolls and Crimping Rolls for combined crimping and beading operation. By replacing Beading Rolls with Spacing Collars (regularly furnished) the machine can be used for crimping only. This machine is adjustable for deep or shallow bead and for "fade-away" crimp. The 0581 comes complete with #975 Bench Standard and Spanner Wrench.

Capacity Mild Steel.....24 ga.
Shipping Weight Boxed.....30 lbs. approx.
Nominal Center Distance.....1 3/4"

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		

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 Set Screw (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 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.

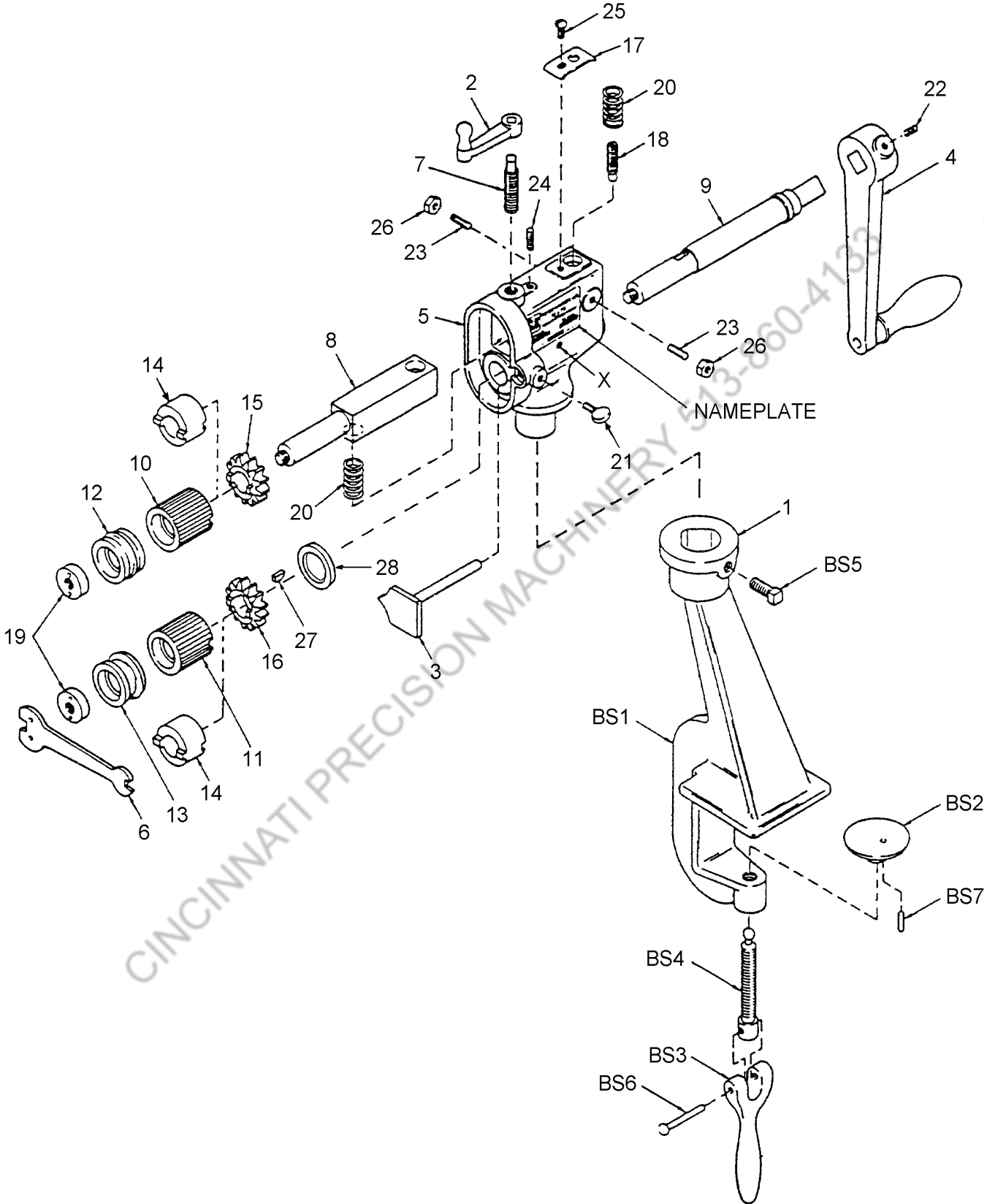


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MODEL 0581 PARTS IDENTIFICATION CHART



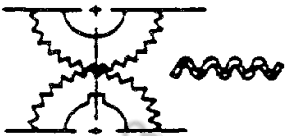
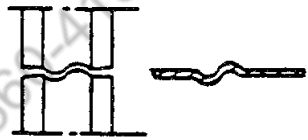
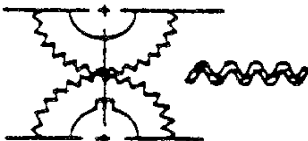
MODEL 0581 PARTS LIST

ITEM NO.	PART NO.	PART NAME	NO. REQ'D
1	239009750	#975 Bench Standard, Complete	1
*BS1	746060001	Standard	1
*BS2	746010002	Swivel Cap	1
*BS3	746030003	Lever for Clamping Screw	1
*BS4	746650004	Clamping Screw	1
*BS5	633012227	SHSCP Screw 7/16-14 X 1 1/2	1
*BS6	600063472	Roll Pin 1/4 x 1 3/4	1
*BS7	600063442	Roll Pin 5/32 x 11/16	1
2	764670214	Adjusting Screw Handle (With Adj. Screw)	1
3	259700013	Gauge Assembly	1
4	230700008	Hand Crank Assembly	1
5	764140114	Frame	1
6	764480016	Spanner Wrench	1
7	See Item 2	Adjusting 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 Connecting Gear	1
16	764380118	Lower Connecting 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	Socket Set Screw 5/16-18 x 7/8	1
23	600325907	Headless Set Screw 5/16-18 x 3/4	2
24	600325912	Headless Set Screw 1/4-20 x 3/4	1
25	615012086	Button Head Cap Screw 1/4-20 x 1/2	1
26	649023004	Check Nut 5/16-18	2
27	764530122	Lower Arbor Key	1
28	764630211	Spacer	1

* Part of the #975 Complete Bench Standard Assembly

When ordering replacement parts, give model, letter, and serial number shown on machine nameplate, and part description shown on parts list.

MODEL 0581 ROLL CHART

NAME	OLD ROLL NUMBER	CATALOG NUMBER	GAUGE REQ'D	ROLL DIAGRAM
Crimping Roll	10568 10569	35000015 35000016	259700013 (BM10580)	
Ogee Bead Roll	10570 10571	35000017 35000018	259700013 (BM10580)	
Spiral Crimp Roll	10776 10777	35000019 35000020	259700013 (BM10580)	

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