

Nos. 544LR, 1544, 2544, 3544, 4544, 5544, 6544, 7544 Combination Rotary Machines



This one machine with interchangeable rolls (see roll chart) will perform turning, burring, wiring, elbow edging, flanging and flattening operations. A truly universal machine with provision for reversing direction of arbors, with normal clockwise handle rotation. Furnished with No. 975 offset standard. Heavy, enclosed frame, solid steel, machine-cut, quiet gears. Finest construction throughout. See Roll Chart for rolls available.



Capacity mild steel	gauge	22
Distance between shaft centers	ins.	2
Shipping weight—less rolls	approx. lbs.	27
Shipping weight—rolls per pair	approx. lbs.	1

INSTRUCTIONS

CAUTION! Be certain that the machine is securely bolted into Bench Standard (2) and that Bench Standard is securely clamped to work bench. Also, work bench must be bolted to floor.

This machine may be used for Burring, Elbow Edging, Flanging, Turning, and Wiring as needed.

1. The Hand Crank (4) provided with this machine is (as shown) mounted on the Upper Arbor (17) for Burring and Wiring.
2. The Hand Crank (4) is to be mounted on the Lower Arbor (18) for Turning, Flanging, and other operations.
3. To change the Hand Crank (4) from the Upper Arbor (17) to the Lower Arbor (18), loosen the inboard Set Screw (24) in the Crank Rod Holder (6), place Crank Rod Holder (6) on Lower Arbor (18) and tighten the Set Screw (24).
4. The Adjusting Screw Handle (3) is used to raise or lower the Upper Arbor assembly into and away from the work.
5. The Upper Arbor (17) is adjustable forward or backward by backing off Set Screw (27) in Adjusting Nut (21) and turning the Adjusting Nut (21) left or right, as needed, until desired alignment of Rolls is obtained. After adjustment is made, tighten Set Screw (27) to secure Adjusting Nut (21).
6. Place proper Rolls on the Upper and Lower Arbors, fitted snugly on their respective keys.
7. Rolls are secured to the Upper and Lower Arbors by the Roll Nuts (29) which are tightened with the Spanner Wrench (12) provided. Rolls must be tight to prevent slippage.
8. Rear Rocking Box Pivot Screws (23) are used to align Rolls sideways. To adjust Rolls, loosen Check Nuts (28) and turn Pivot Screws towards or away from operator as needed.
9. The Gauge can now be set to suit the work piece, and to the proper depth by loosening the Hand Knob (32) and turning the knurled Gauge Adjusting Nut (20). When proper Gauge adjustment is obtained, secure Hand Knob (32). An identical Gauge Adjusting Nut (20) is provided on the off side of the machine. To change Gauge from near to off side, loosen Hand Knob (32), turn Gauge Adjusting Nut (20) away from operator until Gauge becomes loose, relocate Gauge, Hand Knob (32), and Gauge Locking Screw (31) to the desired side and turn Gauge Adjusting Nut (20) towards the operator until Gauge Stake is pulled in to give the desired Gauge adjustment. Tighten the Hand Knob (32).
10. "X" points should be lubricated daily with a good grade machine oil.

MODELS

No. 544LR Combination Rotary Machine Is Furnished With:
10727 Standard Gauge
975 Bench Standard

No. 1544 Combination Rotary Machine Is Furnished With:
10118 A Turning Roll
10119 A Turning Roll
15037 B Turning Roll
15038 B Turning Roll
10120 C Burring Roll
10121 C Burring Roll
10122 D Wiring Roll
10123 D Wiring Roll
10727 Standard Gauge
975 Bench Standard

No. 2544 Turning Machine Is Furnished With:
10118 A Turning Roll
10119 A Turning Roll
15037 B Turning Roll
15038 B Turning Roll
10727 Standard Gauge
975 Bench Standard

No. 3544 Burring Machine Is Furnished With:
10120 C Burring Roll
10121 C Burring Roll
10727 Standard Gauge
975 Bench Standard

No. 4544 Wiring Machine Is Furnished With:
10122 D Wiring Roll
10123 D Wiring Roll
10727 Standard Gauge
975 Bench Standard

No. 5544 Elbow Edging Machine Is Furnished With:
15039 Elbow Edging Roll
15040 Elbow Edging Roll
10727 Standard Gauge
975 Bench Standard

No. 6544 Flanging Machine Is Furnished With:
15053 L Flanging Roll
15054 L Flanging Roll
~~14637 Special Curved Gauge~~ *obsolete*
975 Bench Standard

No. 7544 Flattening Machine Is Furnished With:
15055 M Flattening Roll
15056 M Flattening Roll
15057 Roll Nut
975 Bench Standard



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Parts List For Models 544LR, 1544, 2544, 3544, 4544, 5544, 6544, 7544

LOCKING SCREW #10389
GAUGES #14637 & #15825

HAND KNOB #10956 — 2 REQ'D FOR
GAUGES #14637 & #15825

GAUGE #15825 FOR USE WITH #5544

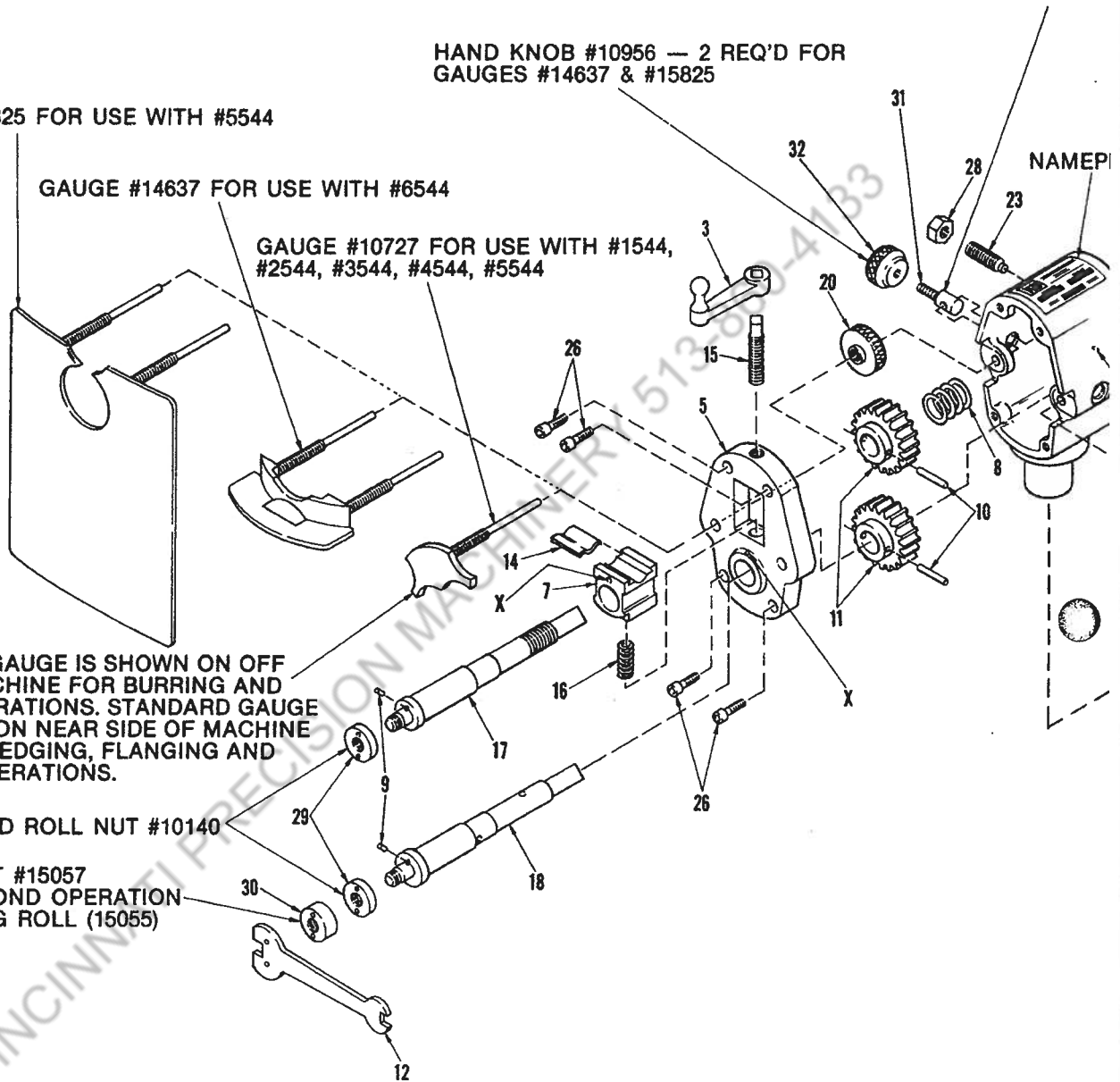
GAUGE #14637 FOR USE WITH #6544

GAUGE #10727 FOR USE WITH #1544,
#2544, #3544, #4544, #5544

STANDARD GAUGE IS SHOWN ON OFF
SIDE OF MACHINE FOR BURRING AND
WIRING OPERATIONS. STANDARD GAUGE
SHOULD BE ON NEAR SIDE OF MACHINE
FOR ELBOW EDGING, FLANGING AND
TURNING OPERATIONS.

STANDARD ROLL NUT #10140

ROLL NUT #15057
FOR SECOND OPERATION
FLANGING ROLL (15055)
1 ONLY



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ROLL CHART

NAME	ROLL NUMBER	CATALOG NUMBER	GAUGE REQ'D	ROLL DIAGRAM
"A" Turning Roll 1/8"	10118 10119	350000001 350000002	259700028	
"B" Turning Roll 3/16"	15037 15038	350000049 350000050	259700028	
"C" Burring Roll	10120 10121	350000003 350000004	259700028	
"D" Wiring Roll	10122 10123	350000005 350000006	259700028	
No. 1 Elbow Edging Roll	15039 15040	350000051 350000052	259700028 or 259700046	
"L" Flange Roll	15053 15054	350000053 350000054	259700028 <i>obsolete</i>	
"M" Flat- tening Roll	15055 15056	350000055 350000056	None	

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