

Instructions for No. 0585 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.

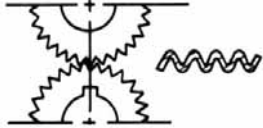
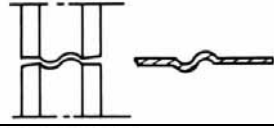



1. The Adjusting Screw Handle (3) is used to raise or lower the Cap (7) and Upper Arbor with its Roll, into and away from the work.
2. Two speeds are provided for: back geared for heavy gauge material and direct drive for light gauge material. For direct drive: loosen Soc. S.S. (43) in Hand Crank Assembly (4), remove Hand Crank Assembly, take out Screws (30) and remove Guard (29), loosen Soc. S.S. (32) and remove Pinion Gear Stud (12) and Pinion (21), slide Pinion from Pinion Gear Stud, loosen Soc. S.S. (33) in Large Gear (6) and pull Large Gear off of the Upper Arbor (15), slide Pinion (21) onto Upper Arbor (15) and tighten Soc. S.S. (33) on Pinion (21), reattach Hand Crank Assembly (4) to Pinion (21) and tighten Soc. S.S. (43) in Hand Crank Assembly.
3. The Upper Arbor (15) is adjustable in and out to line up the Rolls. To do this, loosen Hex Nut (31) and move Upper Arbor and Roll Is either backward or forward as required. After adjustment is made, tighten Hex Nut (31).
4. The Eccentric is used to obtain a straight or fade-away crimp.
 - (a) For a straight crimp, the Upper Arbor (15) and the Lower Arbor (16) must be parallel.
 - (b) For a fade-away crimp, the rear of the Upper Arbor (15) must be lowered. This is accomplished by loosening the Hex Nut (31) and turning the Eccentric Knob (10). When proper fade is obtained, tighten Hex Nut (31) to secure the Upper Arbor (15) in its proper location.
5. When changing from a straight crimp to a fade-away crimp, or vice-versa, the Crimping Rolls must be re-aligned. This is accomplished by removing the Upper Crimping Roll (25) and adjusting the Upper Arbor Eccentric Pins (24) with a screw driver.
6. The Gauge (2) can be adjusted to suit the work by loosening Thumb Screw (35), moving Gauge (2) to the desired position, and tightening the Thumb Screw (35).
7. Keep machine Arbors, Screws, Cap, Journal Bearings and Gears lubricated with a medium (SAE30) motor oil. "X" points should be lubricated daily with a good grade machine oil.

Model No. 0585 Crimping And Beading Machine Is Furnished With:

350000033	11450 Ogee Bead Roll
350000034	11451 Ogee Bead Roll
350000035	11466 Crimping Roll
350000036	11467 Crimping Roll
381700083	11452 Spacing Collars
259700015	BM15111 Standard Gauge
239009750	975 Bench Standard

ITEM NO.	NO. REQ'D.	PART NO.	CATALOG NO.	DESCRIPTION
1	1	BM10151	239009750	#975 Bench Standard, Complete
2	1	BM15111	259700015	Gauge
3	1	spec2154		Adj. Screw Handle
4	1	BM6844		Crank Assembly, Hand
5	1	5015		Frame
6	1	11444	764380125	Large Gear
7	1	15104	764170126	Cap
8	2	50219	764130127	Eccentric Block
9	1	50220	764030128	Eccentric Rod
10	1	50221	764550129	Eccentric Knob
11	1	10154	764480016	Spanner Wrench
12	1	10258	764680081	Stud, Pinion Gear
13	2	10578	764560121	Roll Nut
14	1	11445	764650130	Adj. Screw
15	1	11446	764680131	Upper Arbor
16	1	11447	764680132	Lower Arbor
17	1	11450	350000033	Lower Beading Roll
18	1	11451	350000034	Upper Beading Roll
19	2	11452	381700083	Spacing Collar
20	1	11453	764380133	Lower Conn. Gear
21	1	11454	764380134	Pinion
22	2	11455	764260135	Collar
23	4	11456		Pin
24	4	11458	764160136	Eccentric Pin
25	1	11466	350000035	Upper Crimping Roll
26	1	11467	350000036	Lower Crimping Roll
27	2	15108	764210137	Eccentric
28	2	15113	664184543	Spring
29	1	7709		Guard
30	2	WS1141	609012049	#10-24 x 3/8 Rnd. Hd. Screw
31	1	WS13544	643023005	3/8-16 Hex Nut
32	1	WS845	621012170	3/8-16 x 1/2 Soc. S.S.
33	2	WS847B		3/8-16 x 5/8 1/2 Dog Point Soc. S.S.
34	1	WS802	621012048	#10-24 x 5/16 Soc. S.S.
35	1	WS1962	641012133	5/16-18 x 1 Thumb Screw
36	1	WS1163	609012084	1/4-20 x 3/8 Rnd. Hd. Screw
37	1	WS1704	678033105	3/8 Std. Washer
38	1	WS1714	678033103	1/4 Std. Washer
39	2	WS1564A		Roll Pin
40	1	WS1904	600113812	#2 x 3/16 Drive Screw
41	1	WS1999	600134011	5/16 Spring Oiler
42	1	7854	764380139	Upper Conn. Gear
43	1	WS829	621012126	5/16-18 x 318 Cup Point Soc. S.S.
Bsi	1	10176	746060001	Standard
BS2	1	10177	746010002	Swivel Cap
BS3	1	10272	746030003	Lever for Clamping Screw
BS4	1	10179	746650004	Clamping screw
BS5	1	WS644	633012227	7/16-14 x 1-1/2 Sq. Hd. C.P.S.S.
BS6	1	WS2349		3/16 x 2 Btn. Hd. Std. Rivet
BS7	1	WS 1544A		5/32 x 3/4 Poll Pin

Name	Roll Number	Catalog Number	Gauge Req'd	Roll Diagram
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Crimping Roll	11466 11467	350000035 350000036	BM15111	
Ogee Bead Roll	11450 11451	350000033 350000034	BM15111	
Single Bead Roll 3/8"	16803 16804	350000057 350000058	BM15111	
Single Bead Roll 1/2"	AO5156 AO5157	350000061 350000062	BM15111	
Spiral Crimp Roll	11448 11449	350000031 350000032	BM15111	

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