

power combination rotary machines

CIRCLE CUTTING
AND FLANGING ATTACHMENT



Combination circle and flanging attachment for cutting circles 4" to 24" from square blanks—flanging 3½" to 36".

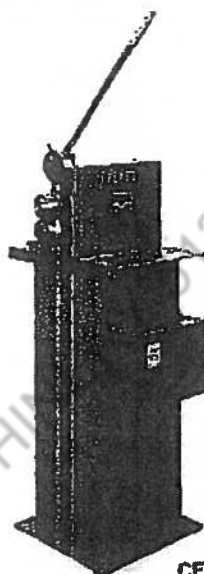


CM-250

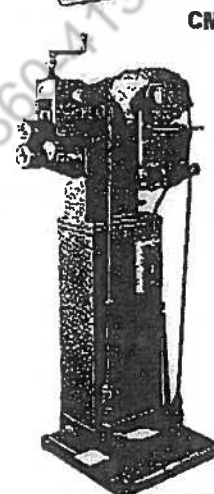
No. CE-300 Spin Collar Machine

Provides the easiest, fastest method available for connecting round pipe to rectangular duct. Eliminates unnecessary time spent fitting and closing collar edges formed by other methods. Complete with tooling, ready to form spin edge in one operation on 22 to 30 gauge galvanized steel. Minimum diameter of five inches. Floor mounted complete with magnetic starter and automatic roll start and stop. (Pat. 3,648,503.)

Number	CE-300
Roll speed.....r.p.m.	78
Capacity.....gauge	22 to 30
Minimum diameter.....ins.	5
Diameter of rolls.....ins.	3
Standard electrics.....115 volt, single phase, 60 hertz	
Motor.....h.p.	½
Shipping weight, crated.....approx. lbs.	330
Length.....ins.	21
Height.....ins.	17
Width.....ins.	50



CE-300



1627

CM-250 Power Combination Rotary Machine 2½" DIAMETER ROLLS

Designed for crimping, beading, turning, burring, wiring and edging. Combined crimping and beading—exclusively PEXTO—can be accomplished.

CLUTCH—Multiple disc Maxitorq Clutch—with hand and foot control.

DRIVE—"V" belt drive—Standard machine furnished with sheaves for roll speed of 26 r.p.m. Sheave and pulley combination supplied for various speeds.

POWER—Powered with ½ h.p. 1800 r.p.m. motor to power source requirements. Reversing switch extra.

ROLLS—Standard rolls and gauges as illustrated on roll chart.

Number	CM-250
Crimping and beading.....gauge	22
Crimping only.....gauge	18
Beading only.....gauge	18
Turning, burring, wiring, edging, flanging.....gauge	18
Sitting and circle cutting.....gauge	16
Maximum height of flange*.....gauge	½ in 18
Flanging.....ins.	3½ to 36
Circle cutting (from square blanks).....ins.	4 to 24
Arbor diameter in bearings.....ins.	1¼
Roll speed (standard).....r.p.m.	26
Depth of throat from end of arbors to frame.....	7½
Motor (1800 r.p.m.).....h.p.	½
Shipping weight:	
machine.....approx. lbs.	450
flanging attachment.....approx. lbs.	195
Length.....ins.	23
Height.....ins.	50
Width.....ins.	18

*Height of flange, without distortion, will be less in lighter gauges.

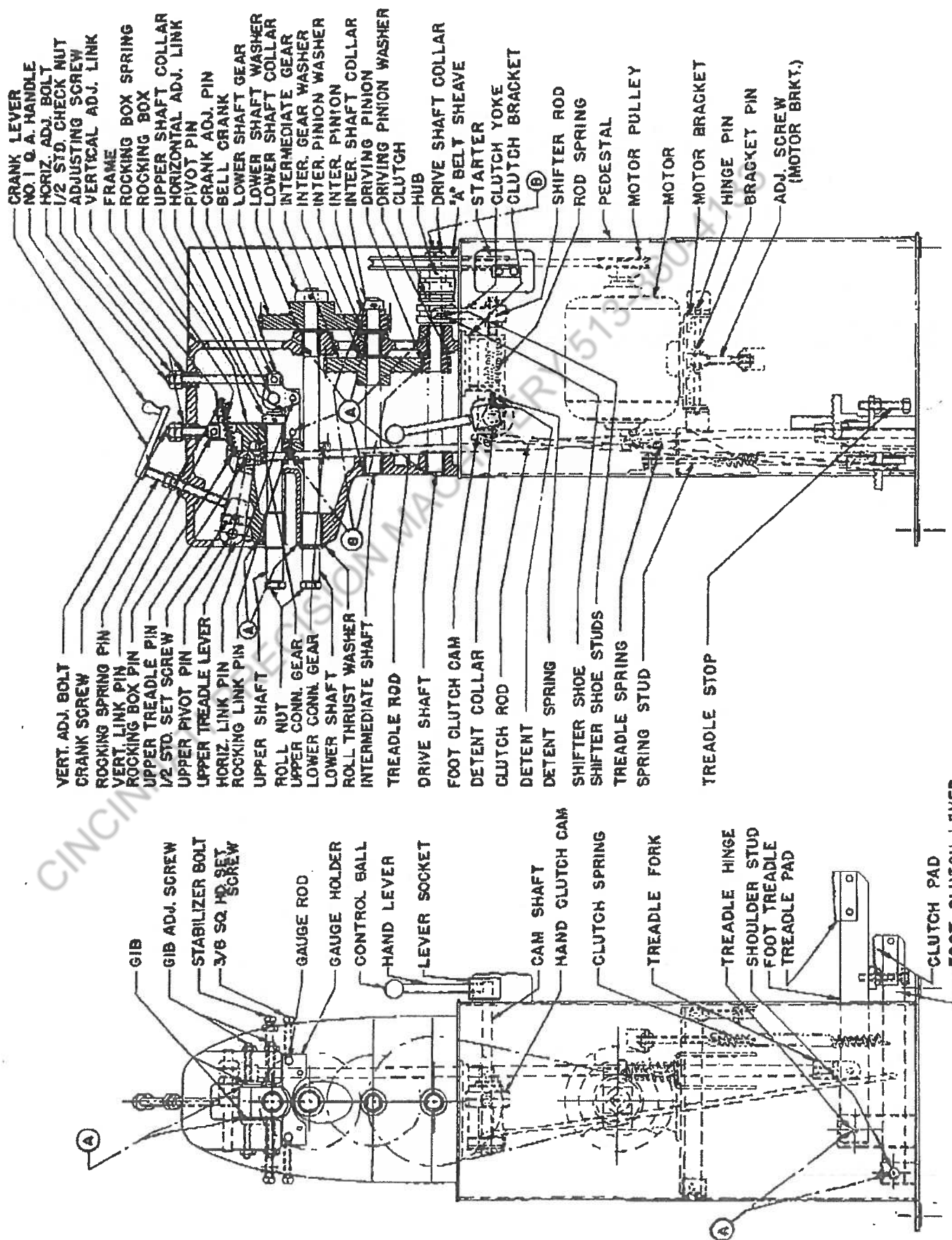
No. 1627 Power Combination Rotary Machine 3" DIAMETER ROLLS

For all kinds of roll operations such as burring, turning, wiring, beading, crimping, combined crimping and ogee beading, elbow edging, slitting, flanging, offsetting and for the cutting and flanging of circular discs when furnished with circle attachment.

Silent chain drive, optional speeds, foot and hand lever operated friction clutch control and hand crank for depressing top roll arbor. Foot treadle for depressing top roll arbor suitable for single operations on light gauge work. Can also be furnished with control for reversing drive. Regularly furnished with one drive sprocket for minimum standard speed.

Number	1627
Capacity crimping and beading.....gauge	18
Capacity crimping only or beading only.....gauge	16
Capacity, turning, burring, wiring, elbow edging.....gauge	16
Capacity slitting.....gauge	14
With circular cutting and flanging attachment will cut from square blanks*.....ins.	8 to 13½
Will flange circular disc up to diameter.....ins.	8 to 26
Distance between shaft centers.....ins.	3
Speed of rolls with standard sprockets....r.p.m.	23-38-47
Depth of throat from end of arbors to frame.....ins.	6½
Motor—1800 r.p.m.....h.p.	¾
Shipping weight, crated.....approx. lbs.	550
Length.....ins.	27
Height.....ins.	57
Width.....ins.	22

*By cutting four corners of square blanks circles can be cut up to 26 inch diameter.



CRANK LEVER
 NO. 1 Q. A. HANDLE
 HORIZ. ADJ. BOLT
 1/2 STD. CHECK NUT
 ADJUSTING SCREW
 VERTICAL ADJ. LINK
 FRAME
 ROCKING BOX SPRING
 ROCKING BOX
 UPPER SHAFT COLLAR
 HORIZONTAL ADJ. LINK
 PIVOT PIN
 CRANK ADJ. PIN
 BELL CRANK
 LOWER SHAFT GEAR
 LOWER SHAFT WASHER
 LOWER SHAFT COLLAR
 INTERMEDIATE GEAR
 INTER. GEAR WASHER
 INTER. PINION WASHER
 INTER. PINION COLLAR
 DRIVING PINION COLLAR
 DRIVING PINION WASHER
 CLUTCH
 HUB
 DRIVE SHAFT COLLAR
 'A' BELT SHEAVE
 STARTER
 CLUTCH YOKE
 CLUTCH BRACKET
 SHIFTER ROD
 ROD SPRING
 PEDESTAL
 MOTOR PULLEY
 MOTOR
 MOTOR BRACKET
 HINGE PIN
 BRACKET PIN
 ADJ. SCREW (MOTOR BRKT.)

VERT. ADJ. BOLT
 CRANK SCREW
 ROCKING SPRING PIN
 VERT. LINK PIN
 ROCKING BOX PIN
 UPPER TREADLE PIN
 1/2 STD. SET SCREW
 UPPER PIVOT PIN
 UPPER TREADLE LEVER
 HORIZ. LINK PIN
 ROCKING LINK PIN
 UPPER SHAFT
 ROLL NUT
 UPPER CONN. GEAR
 LOWER CONN. GEAR
 LOWER SHAFT
 ROLL THRUST WASHER
 INTERMEDIATE SHAFT
 TREADLE ROD
 DRIVE SHAFT
 FOOT CLUTCH CAM
 DETENT COLLAR
 CLUTCH ROD
 DETENT
 DETENT SPRING
 SHIFTER SHOE
 SHIFTER SHOE STUDS
 TREADLE SPRING
 SPRING STUD
 TREADLE STOP

GIB
 GIB ADJ. SCREW
 STABILIZER BOLT
 3/8 SQ HD SET SCREW
 GAUGE ROD
 GAUGE HOLDER
 CONTROL BALL
 HAND LEVER
 LEVER SOCKET
 CAM SHAFT
 HAND CLUTCH CAM
 CLUTCH SPRING
 TREADLE FORK
 TREADLE HINGE
 SHOULDER STUD
 FOOT TREADLE
 TREADLE PAD
 CLUTCH PAD
 FOOT CLUTCH LEVER

VERT. ADJ. BOLT
 CRANK SCREW
 ROCKING SPRING PIN
 VERT. LINK PIN
 ROCKING BOX PIN
 UPPER TREADLE PIN
 1/2 STD. SET SCREW
 UPPER PIVOT PIN
 UPPER TREADLE LEVER
 HORIZ. LINK PIN
 ROCKING LINK PIN
 UPPER SHAFT
 ROLL NUT
 UPPER CONN. GEAR
 LOWER CONN. GEAR
 LOWER SHAFT
 ROLL THRUST WASHER
 INTERMEDIATE SHAFT
 TREADLE ROD
 DRIVE SHAFT
 FOOT CLUTCH CAM
 DETENT COLLAR
 CLUTCH ROD
 DETENT
 DETENT SPRING
 SHIFTER SHOE
 SHIFTER SHOE STUDS
 TREADLE SPRING
 SPRING STUD
 TREADLE STOP

CRANK LEVER
 NO. 1 Q. A. HANDLE
 HORIZ. ADJ. BOLT
 1/2 STD. CHECK NUT
 ADJUSTING SCREW
 VERTICAL ADJ. LINK
 FRAME
 ROCKING BOX SPRING
 ROCKING BOX
 UPPER SHAFT COLLAR
 HORIZONTAL ADJ. LINK
 PIVOT PIN
 CRANK ADJ. PIN
 BELL CRANK
 LOWER SHAFT GEAR
 LOWER SHAFT WASHER
 LOWER SHAFT COLLAR
 INTERMEDIATE GEAR
 INTER. GEAR WASHER
 INTER. PINION WASHER
 INTER. PINION COLLAR
 DRIVING PINION COLLAR
 DRIVING PINION WASHER
 CLUTCH
 HUB
 DRIVE SHAFT COLLAR
 'A' BELT SHEAVE
 STARTER
 CLUTCH YOKE
 CLUTCH BRACKET
 SHIFTER ROD
 ROD SPRING
 PEDESTAL
 MOTOR PULLEY
 MOTOR
 MOTOR BRACKET
 HINGE PIN
 BRACKET PIN
 ADJ. SCREW (MOTOR BRKT.)

VERT. ADJ. BOLT
 CRANK SCREW
 ROCKING SPRING PIN
 VERT. LINK PIN
 ROCKING BOX PIN
 UPPER TREADLE PIN
 1/2 STD. SET SCREW
 UPPER PIVOT PIN
 UPPER TREADLE LEVER
 HORIZ. LINK PIN
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 DETENT SPRING
 SHIFTER SHOE
 SHIFTER SHOE STUDS
 TREADLE SPRING
 SPRING STUD
 TREADLE STOP

CINCINNATI
 513-500-7575

OPERATING INSTRUCTIONS

FOR

PEXTO #CM-250 ELECTRIC COMBINATION ROTARY MACHINE

The production of quality work on this machine depends upon accurate set up and adjustment, regardless of type of work to be done.

To adjust this machine, proceed as follows:—

Back off CRANK LEVER to move ROLL SHAFTS apart. Place work rolls on shafts and tighten ROLL NUTS securely, using wrench provided with the machine.

Insert work between rolls and set gauge for position desired. Bolt special gauge (if used) to GAUGE HOLDER. Adjust by loosening set screws and moving GAUGE HOLDER, which can also be used as a Universal Gauge.

Turn down CRANK LEVER until contact is made with work. If proper roll positioning is not obtained, UPPER SHAFT can be adjusted in several ways with relation to LOWER SHAFT:

1. Tilting (or Vertical adjustment) is made through the VERTICAL ADJUSTING BOLT and its ADJUSTING SCREW.
2. In-and-out position is adjusted by the HORIZONTAL ADJUSTING BOLT and its ADJUSTING SCREW.
3. Side-to-side adjustment of shafts is held through GIBS bearing on the ROCKING BOX and is changed through the GIB ADJUSTING SCREW. This adjustment may be necessary in crimping only. When properly set and in working position, rolls will show uniform all-around clearance equal to metal gauge.

After work rolls are set, operate machine as follows:—

1. Make sure HAND LEVER is in "up" position, and that rolls are not fully engaged with work.
2. Start motor (starter located on right-hand side of base).
3. Engage CLUTCH by:—(a) Rotating HAND LEVER toward back of machine or (b) depressing FOOT CLUTCH LEVER. (If motor runs but Shafts do not turn, CLUTCH should be adjusted according to plate attached to FRAME. The CLUTCH YOKÉ may be adjusted by means of lock nuts on the SHIFTER ROD). NOTE:—CLUTCH SHIFTER SHOES must be loose and free-fitting with the clutch in any position.
4. Slowly bring work rolls together by (a) Turning CRANK LEVER, or (b) depressing FOOT TREADLE. **CAUTION:**—Until TREADLE STOP IS SET, do not exert heavy pressure on FOOT TREADLE as damage may result.

WARNING: Before operating, machine must be bolted to work bench. If floor stands are provided, machine must be bolted to floor stands, which must be securely lagged to floor.

5. When work rolls are fully engaged, set stops as follows:— (a) Run check nuts on crank screw down to FRAME and tighten together. (b) Adjust TREADLE STOP to bear against floor plate when proper roll engagement is reached.

After the above adjustments have been made, the machine is set for a production run. Clutch engagement and work roll engagement can be made by using any combinations of hand or foot controls (as described in #3 and 4 above).

The following internal adjustments are available:

Spring tension on the FOOT CLUTCH LEVER can be changed by adjusting the SPRING STUD up or down through its lock nuts.

FOOT TREADLE spring tension can be changed by adjusting the ROD COLLAR up or down.

For belt take-up, loosen lock nuts on MOTOR BRACKET ADJUSTING SCREW. Tighten belt just enough to prevent slippage. Too tight a belt will damage bearings in motor and DRIVE SHAFT, as well as hasten belt wear.

LUBRICATION:—

"A" Indicates oil points:—Use SAE-30 motor oil.

"B" Indicates grease points:—Use a good grade of automobile chassis lubricant. Lubricate every 8 hours' operating time.

FOR ORDERING PARTS:—

Give Model No. and Serial No. of machine as well as part name shown on this card.

T1