

NO. 0585 CRIMPING AND BEADING MACHINE

INSTRUCTIONS AND PARTS LIST



The 0585 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. 3/8" or 1/2" Single Bead Rolls are available for beading only. This machine is adjustable for deep or shallow bead and for "fade-away" crimp. The 0585 comes complete with #975 Bench Standard and Spanner Wrench.

Capacity Mild Steel.....20 Ga.
Ratio Back Gearing.....3:1
Shipping Weight Boxed.....51 lbs. approx.
Nominal Center Distance.....1 3/4"

Model No. 0585 Crimping & Beading Machine is Furnished With:

350000033	11450 Ogee Bead Roll	381700083	11452 Spacing Collars
350000034	11451 Ogee Bead Roll	259700015	EM 15111 Standard Gauge
350000035	11466 Crimping Roll	239009750	975 Bench Standard
350000036	11467 Crimping Roll		

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.

- 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.
- 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 Roll Pin (33) in Large Gear (6) and pull Large Gear off of the Upper Arbor (15), slide Pinion (21) onto Upper Arbor (15) and tighten Roll Pin (33) on Pinion (21), reattach Hand Crank Assembly (4) to Pinion (21) and tighten Soc. S.S. (43) in Hand Crank Assembly.
- 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 Rolls either backward or forward as required. After adjustment is made, tighten Hex Nut.
- The Eccentric is used to obtain a straight or fade-away crimp.
 - For a straight crimp, the Upper Arbor (15) and the Lower Arbor (16) must be parallel.
 - 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.
- 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.
- 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).
- Keep machine Arbors, Screw, Cap, Journal Bearings and Gears lubricated with a medium (SAE30) motor oil. "X" points should be lubricated daily with a good grade machine oil.

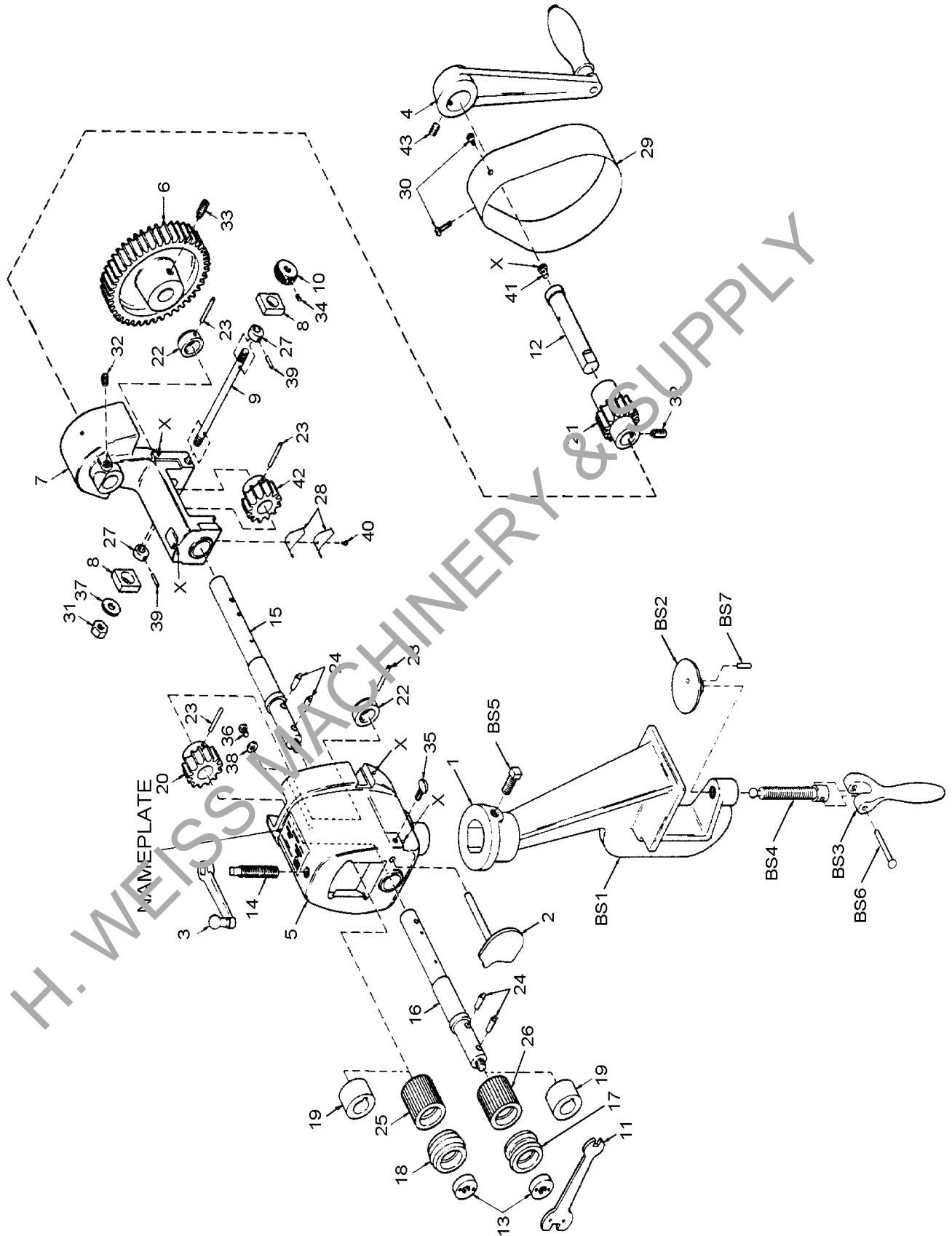


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MODEL 0585 PARTS IDENTIFICATION CHART



MODEL 0585 PARTS LIST

ITEM NO.	PART NO.	DESCRIPTION	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 Dia. x 1 3/4	1
*BS7	600063442	Roll Pin 5/32 x 11/16	1
2	259700015	Gauge	1
3	764670214	Adjusting Screw Handle	1
4	230700009	Hand Crank Assembly	1
5	764140124	Frame	1
6	764380125	Large Gear	1
7	764170126	Rocking Cap Box	1
8	764130127	Eccentric Block	2
9	764030128	Eccentric Rod	1
10	764550129	Eccentric Knob	1
11	764480016	Spanner Wrench	1
12	764680081	Pinion Gear Stud	1
13	764560121	Roll Nut	2
14	Included in Item 3	Adjusting Screw	1
15	764680131	Upper Anvil	1
16	764680132	Lower Anvil	1
17	350000033	Lower Beading Roll	1
18	350000034	Upper Beading Roll	1

ITEM NO.	PART NO.	DESCRIPTION	NO. REQ'D
19	381700083	Spacing Collar	2
20	764380133	Lower Connecting Gear	1
21	764380134	Pinion	1
22	764260135	Collar	2
23	600063457	Pin	4
24	764160136	Eccentric Pin	4
25	350000035	Upper Crimping Roll	1
26	350000036	Lower Crimping Roll	1
27	764210137	Eccentric	2
28	664184043	Spring	2
29	764440139	Guard	1
30	609012049	RHM Screw #10-24 x 3/8	2
31	643023005	Hex Nut 3/8-16	1
32	621012170	SSCP Screw 3/8-16 x 1/2	1
33	600063473	Roll Pin 1/4 x 2	1
34	621012048	SSCP Screw #10-24 x 5/16	1
35	641012133	Thumb Screw 5/16-18 x 1	1
36	609012084	RHM Screw 1/4-20 x 3/8	1
37	678033106	Flat Washer 7/16	1
38	678033104	Flat Washer 5/16	1
39	600063434	Roll Pin 1/8 x 11/16	2
40	600113812	Drive Screw #2 x 3/16	1
41	600134011	Spring Oiler 5/16	1
42	764380139	Upper Connecting Gear	1
43	621012126	SSCP Screw 5/16-18 x 3/8	1

* Part of the #975 Complete Bench Standard Assembly

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

MODEL 0585 ROLL CHART

NAME	OLD ROLL NUMBER	CATALOG NUMBER	GAUGE REQ'D	ROLL DIAGRAM
Crimping Roll	11466 11467	350000035 350000036	259700015 (BM15111)	
Ogee Bead Roll	11450 11451	350000033 350000034	259700015 (BM15111)	
Single Bead Roll 3/8"	16803 16804	350000057 350000058	259700015 (BM15111)	
Single Bead Roll 1/2"	AO5156 AO5157	350000061 350000062	259700015 (BM15111)	
Spiral Crimp Roll	11448 11449	350000031 350000032	259700015 (BM15111)	

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