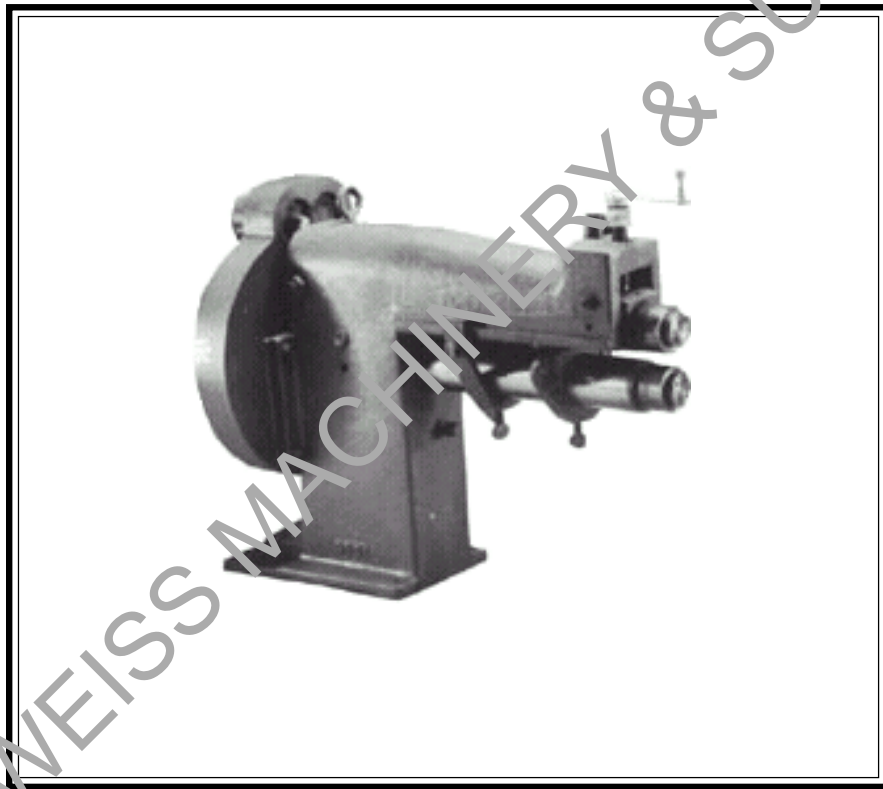


NO. 0617 BEADING MACHINE

OPERATING INSTRUCTIONS AND PARTS IDENTIFICATION



ROPER WHITNEY

2833 HUFFMAN BLVD., ROCKFORD, ILLINOIS 61103-3990 * 815/962-3011 * FAX 815/962-2227

Website: www.roperswhitney.com * Email: info@roperswhitney.com

NO. 0617 BEADING MACHINE

The No. 0617 Beading Machine is a deep throat design that is shipped with standard spacing collars and gauges for all operations except flanging. Rolls are ordered separately.

SPECIFICATIONS:

Capacity Mild Steel.....18 Gauge

Throat Depth.....13 Inches

Shipping Weight.....216 lbs

SAFETY RULES:

1. Never place any part of the body including loose clothing near or onto the rotating rolls. (KEEP HANDS AWAY). Failure to comply will lead to personal body injury.
2. Never clean forming rolls while rolls are rotating.
3. Do not exceed material capacity of the machine.
4. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operators Manual.
5. Never operate machine with any guard removed.
6. Do not use machine if servicing is required.
7. Use safety glasses and required protective tools.
8. Keep work areas clean and in proper order.

INSTALLATION

RECEIVING:

Immediately upon receiving the crimping and beading machine, check it very carefully for damage or loss of parts in transit. Since all equipment is sold F.O.B., the Roper Whitney Company plant, our responsibility for transit damage ceases when the transportation company signs the bill of lading indicating that it has received all of the items listed on the bill of lading in good condition. Report any loss or damage to the delivering carrier promptly to insure proper handling of your claim.

Question -- Distributor or Roper Whitney -- Shortages not appearing on the bill of lading or discrepancies between equipment received and the order should be reported to Roper Whitney Company immediately.

INSTALLATION -- (CAUTION!):

Be sure beading machine is solid and reasonably level on all four points so there is no camber or twist to the machine.

If machine is shipped on a pallet, be sure to remove from pallet and place directly on a bench.

Machine must be securely bolted to a bench and bench bolted to the floor. Bolt holes are provided in base of machine.

CLEANING:

In spite of precautions taken in preparing the beading machine for shipment, dirt and foreign material may accumulate during transit, and can cause damage unless thoroughly cleaned. It is extremely important to inspect and thoroughly clean off any dirt and foreign material that may have accumulated. DO NOT attempt to blow dirt out with an air hose as this may force some foreign material into undesirable areas. Remove any rust-proofing compound with an acceptable solvent.

OPERATION AND ADJUSTMENT

CAUTION! Do not operate beading machine without proper instructions. Become familiar with the intended operation before using. Machine to be operated by qualified personnel only.

This PEXTO beading machine is intended for deep throat beading, crimping and other roll operations on 18 gauge maximum mild steel sheet material. The positioning gauge is adjustable within it's 12" range.

Rolls are secured to the shafts by roll nuts and keys. The lower shaft horn adjustment will provide lateral adjustment for alignment of the rolls. An adjustable "saddle" bracket will provide additional support for the lower shaft horn when required. The pivoting upper shaft is spring loaded in the open position. Amount of the opening is controlled by the adjusting screw and crank screw lever.

Depth of bead can be limited by the check nuts on the adjusting screw. The positioning gauge is adjustable to locate the bead in relation to the end of the material being worked.

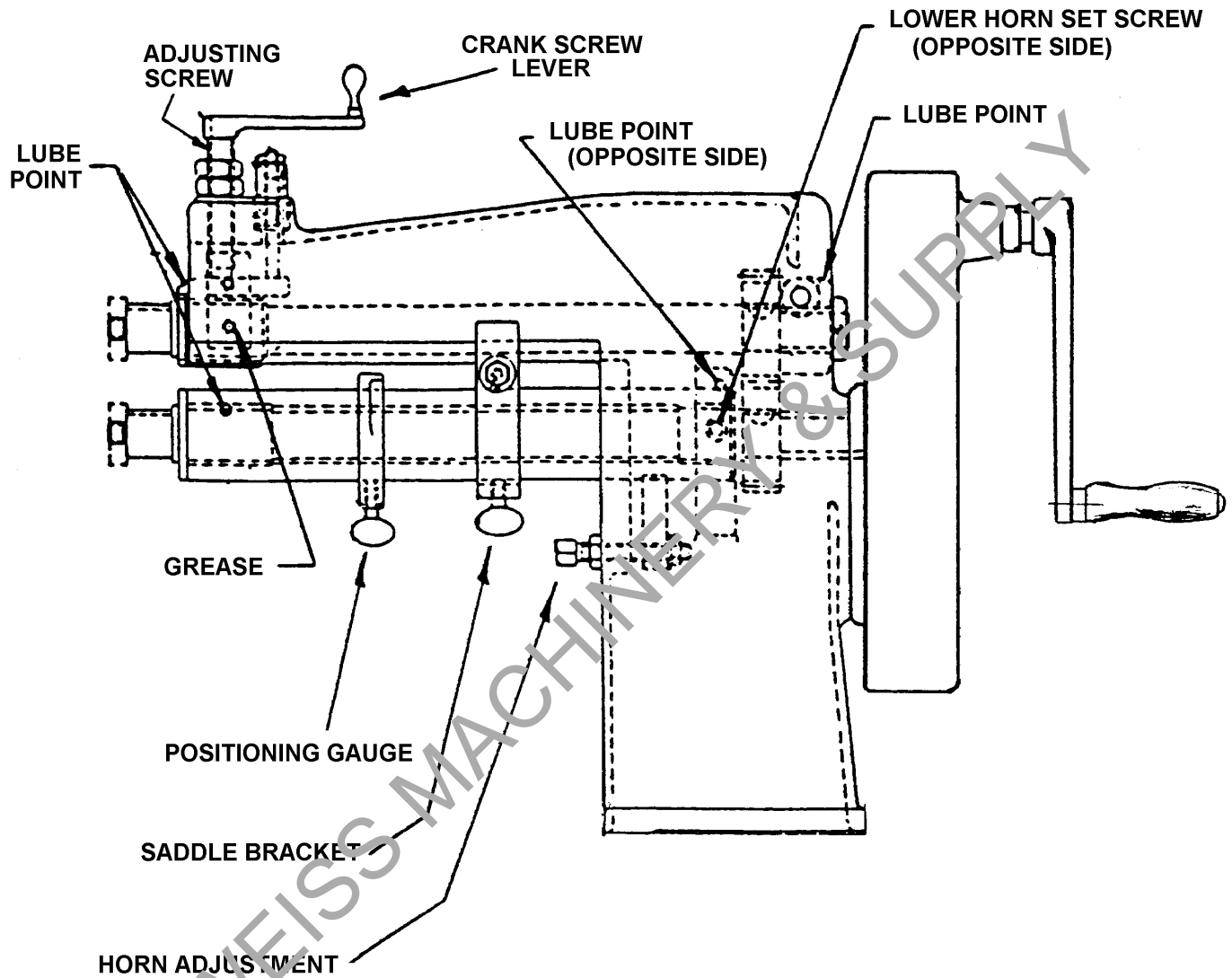
LOWER HORN ADJUSTMENT:

To adjust lower horn the lower horn set screw, which is located directly below oil hole on back side of machine, must be loosened FIRST. Then loosen lock nut on horn adjustment screw. Adjust horn to desired position, tighten locknut and retighten set screw.

REPAIR PARTS

Keep work area clear and in proper order. Parts list are included with these instructions. For repair parts, when needed, give complete Model No. and Serial No. as listed on the machine nameplate. Identify parts by description and reference to parts list and drawings with this manual.

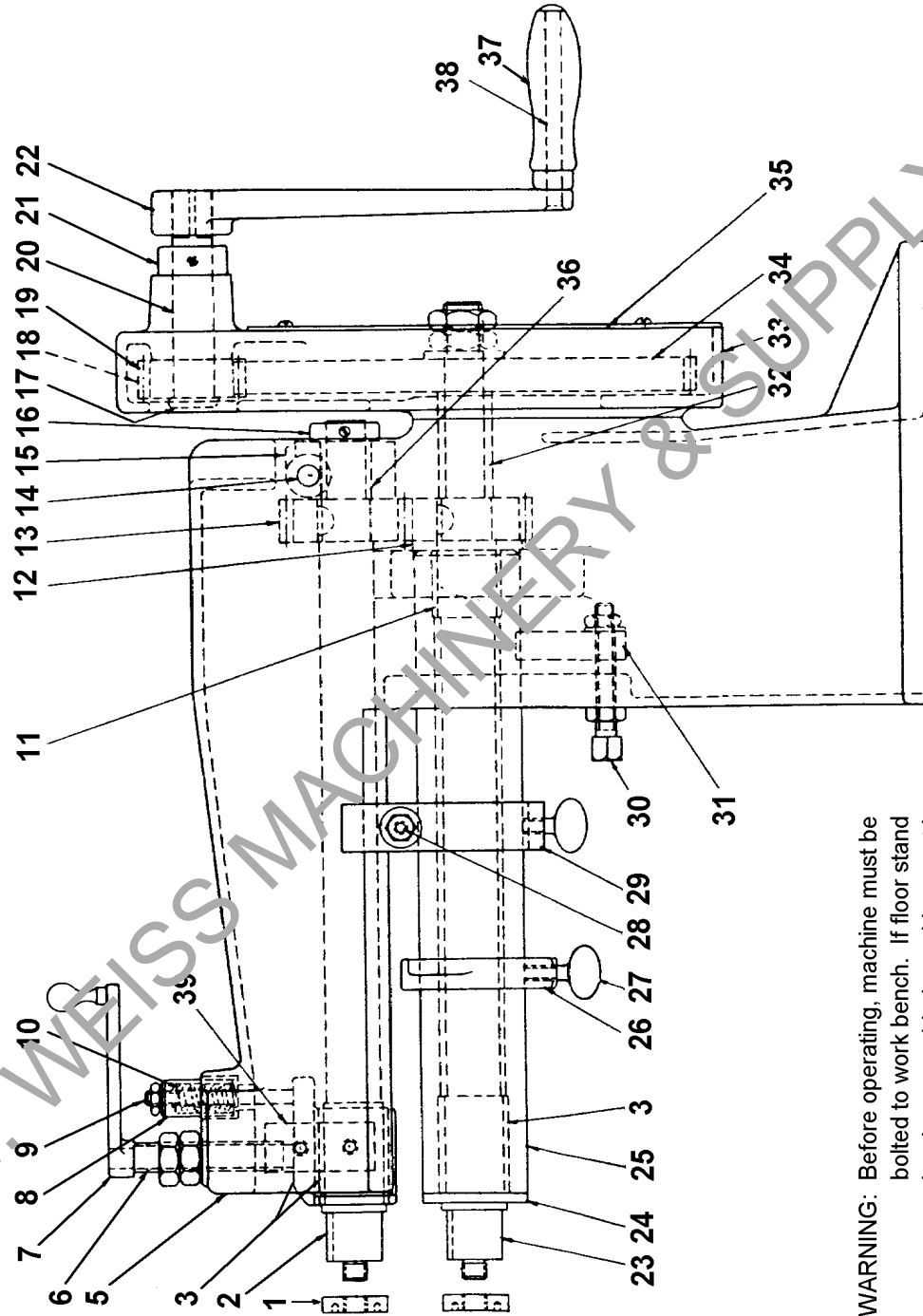
**NO. 0617
BEADING MACHINE**



LUBRICATION

1. Use any standard lubrication industrial oil.
2. Use any standard machine bearing grease, such as Mobil Grease Special or Texclad 2.

PARTS IDENTIFICATION CHART – BEADING MACHINE – 0617








WARNING: Before operating, machine must be bolted to work bench. If floor stand has been provided, machine must be bolted to floor stand with bolts provided. Stand must be securely lagged to floor.

NO. 0617
PARTS IDENTIFICATION LIST

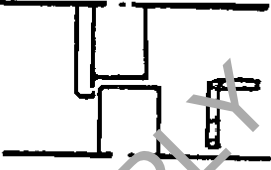
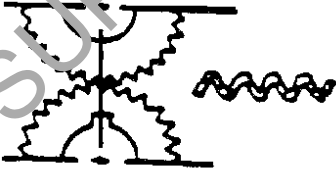
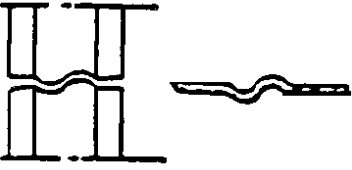
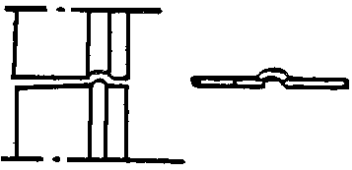
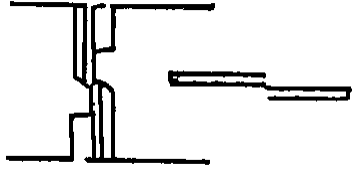
ITEM NO.	PART NO.	PART NAME
1	764560158	Roll Nut
2	764680164	Upper Shaft
3	243700017	Front Box Assembly (Consists of Front Box & Bunting Bushing which can only be purchased as assembly 243700017 above)
5	764140220	Frame
6	764650157	Adjusting Screw
7	230700011	Crank Screw Lever
8	764260162	Spring Cup
9	764160163	Front Box Stud
10	664184544	Spring
11	664194640	Bunting Bushing
12	764830169	Thrust Washer (Rear)
13	764380154	Connecting Gears
14	690012366	Pin
15	243700018	Rocking Box
16	764560170	Lock Nut
17	764680160	Idler Stud
18	764380147	Idler Pinion
19	764380146	Pinion Gear
20	764680150	Drive Shaft
21	600000462	Collar
22	767460096	Hand Crank
23	764680165	Lower Shaft
24	764830168	Thrust Washer (Front)
25	764510142	Horn
26	259700094-Assy	Gauge
27	259700024-Assy	Thumb Screw
28	764160151	Tie Bolt
29	764130149	Saddle
30	764650166	Adjusting Screw
31	764680167	Adjusting Stud
32	764630155	Pipe Spacer
33	764440144	Gear Guard
34	764380145	Gear
35	764220152	Gear Guard Cover
36	664194638	Bunting Bushing
37	640356309	Handle
38	767210097	Stale
39	764400148	Gib
40	764480161	Spanner Wrench

WHEN ORDERING REPLACEMENT PARTS, GIVE MODEL NUMBER, PART NAME & PART NUMBER.


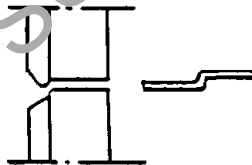
NO. 0617 ROLL CHART**3" CENTERS**

ROLL STYLE	ROLL CATALOG NO.		GAUGE REQ'D	SPACING COLLAR	ROLL DIAGRAM
A	3/16"	350000086 350000087	259700035	381700092	 TURNING
	1/4"	350000088 350000089	259700035	381700092	
B	5/16"	350000090 350000091	259700035	381700092	
C		350000092 350000093	259700035	381700092	 BURRING
D		350000094 350000095	259700035	381700092	 WIRING
NO.1		350000122 350000123	259700035	381700092	 ELBOW EDGING
L		350000137 350000138	259700037	381700092	 FLANGE

NO. 0617 ROLL CHART

3" CENTERS					
ROLL STYLE	ROLL CATALOG NO.		GAUGE REQ'D	SPACING COLLAR	ROLL DIAGRAM
M	3/16"	350000086 350000087	259700035	381700092	 FLATTENING
	1/4"	350000098 350000099	259700034	381700092	 CRIMPING
E	5/16"	350000096 350000097			
F	9/16"	350000100 350000101	259700035	NOT REQ'D	 OGEE BEAD
	1"	350000011 350000012		381700092	
G	5/8"	350000124 350000125	259700035	NOT REQ'D	 SINGLE BEAD
	3/8"	350000013 350000014			
H		350700070 CARBON (2 REQ'D) 350700067 HIGH SPEED (2 REQ'D)	259700035	381700085	 SLITTING CUTTERS

NO. 0617 ROLL CHART

3" CENTERS					
ROLL STYLE	ROLL CATALOG NO.		GAUGE REQ'D	SPACING COLLAR	ROLL DIAGRAM
N		350000070	259700034	381700092	 FURNACE COLLAR EDGING
		350000071			
		350000072			
		350000073			
P		350000074	259700034	381700092	 OFFSET
		350000075			