

## Instructions for Combination Rotary Machines

### INSTRUCTIONS

**CAUTION!** Be certain that the machine is securely bolted into Bench Standard (23) and that Bench Standard is securely clamped to work bench. Also, work bench must be bolted to floor.

This machine may be used for Crimping, Beading, Furnace Collar Edging, Offsetting, Turning, Burring, Wiring, Elbow Edging, Flanging, Flattening and Slitting as needed. Crimping Rolls, Beading Rolls, Furnace Collar Rolls and Offset Rolls, when used, are mounted on the larger diameter of the Arbors (8 & 10), fitted snugly over the inner Roll Key Pins (11). All other Rolls are mounted on the smaller diameter of the Arbors, fitted snugly over the outer Roll Key Pins (11). Rolls are secured to Arbors with Roll Nuts (12).

1. The Hand Crank Assembly (22) provided with this machine is mounted on the Upper Arbor (B) for operations in Burring and Wiring.
2. Mount Crank Assembly (22) on Lower Arbor (10) for Crimping, Beading, Turning, etc.
3. Adjusting Screw (13), turned by rotating Adj. Screw Lever (14), is used to raise or lower the Front Upper Box (2) and Upper Arbor (B) with its Rolls, into and away from the work piece.
4. The Upper Arbor is laterally adjustable by backing off Set Screw (31) in Adjusting Nut (19) by turning the loosened Adjusting Nut (19) right or left in order to obtain alignment of Rolls. After Adjustment is made, tighten Set Screw (31) to secure Adjusting Nut (19).
5. Pivot Screws (7) for Rocking Box (4) are used to line up Crimping Rolls. To adjust Upper Crimping Roll, loosen Check Nuts (29) and turn Pivot Screws (7) toward or away from operator as necessary to align Crimping Rolls.
6. Secure Roll Nuts (12) with Spanner Wrench (21) before operating machine to prevent Roll slippage.
7. The Throat Gauge (3) can now be set to suit the work piece to the depth of the Horn (9) by loosening Thumb Screw (18) and moving Throat Gauge (3) to desired position and locking in place with Thumb Screw (18). (Throat Gauge is used alone for Beading only) See illustration.
8. End play in Lower Arbor (10) can be removed by loosening Set Screw (31) in Adjusting Nut (19) on Lower Arbor and turning Adjusting Nut (19) clockwise until all end play is removed. Tighten Set Screw (31) securely.
9. Keep machine Arbors, Screws, Rocking Box, Journal Bearings and Gears lubricated with a medium (SAE30) motor oil. Access to oil Gears may be found thru Gear Guard (5). "X" points should be lubricated daily with a good grade machine oil.

### MODELS

No. 620 Beading Machine Is Furnished With: 11 106 G Single Bead Roll  
11107 G Single Bead Roll  
10152 F Ogee Bead Roll  
10153 F Ogee Bead Roll  
10130 "Throat Gauge  
975 Bench Standard

No. 621 Furnace Collar Edger Is Furnished With:  
A51258 N Furnace Collar Edging Roll  
A51259 N Furnace Collar Edging Roll

A51260 N Furnace Collar Edging Roll  
BM7903 Extension Gauge  
10130 Throat Gauge  
975 Bench Standard

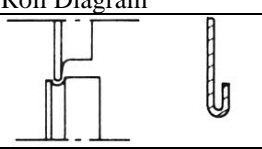
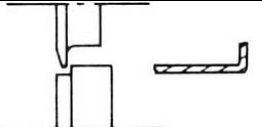
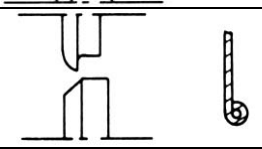
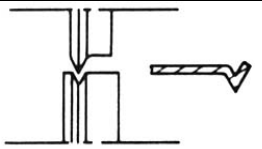
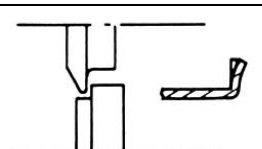
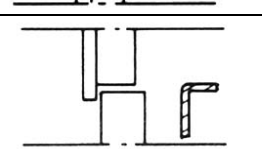
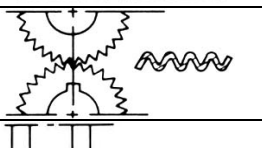
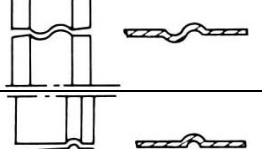
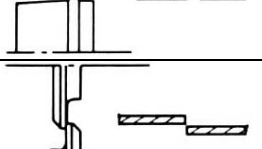
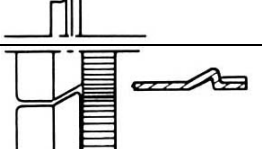
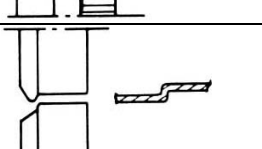
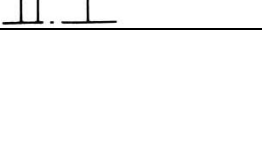

No. 622 Rotary Machine Is Furnished With:

10118 A Turning Roll  
 10119 A Turning Roll  
 10120 C Burring Roll  
 10121 C Burring Roll  
 10122 D Wiring Roll  
 10123 D Wiring Roll  
 10152 F Ogee Bead Roll  
 10153 F Ogee Bead Roll  
 10124 E Crimping Roll  
 10125 E Crimping Roll  
 10130 Throat Gauge  
 Spec. 10126 Standard Gauge  
 BM7903 Extension Gauge  
 975 Bench Standard

No. 622LR Rotary Machine Is Furnished With:

10130 Throat Gauge  
 975 Bench Standard

ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION	ITEM NO.	NO. REQ'D.	PART NO.	DESCRIPTION
1	1	10128	Frame	20	1	10193	Front Box Springs
2	1	10129	Front Upper Box	21	1	10154	Comb. Wrench
3	1	10130	Gauge	22	1	10150	Crank Assembly, Hand
4	1	10131	Rocking Box	23	1	10151	#975 Bench Standard, Complete
5	1	10132	Gear Guard	24	2	14308	Plug
6	1	10133	Crank Rod Holder	25	2	WS1980	#3 Woodruff Key
7	2	10134	Pivot Screw	26	1	WS207	1/4-20 x 2-1/2 Fil. Hd. Capscrew
8	1	10135	Upper Shaft	27	1	WS1 714	1/4 Standard Washer
9	1	10137	Horn Assembly	28	1	WS1 721	3/4 Standard Washer
10	1	B736	Shaft, Lower	29	2	WS1334	7/16-14 Check Nut
11	4	WS1531A	Roll Pin for Shaft	30	1	WS835	5/16-18 x 7/8 Soc. Setscrew
12	2	10140	Roll Nut	31	2	WS827	5/16-18 x 1/4 Soc. Setscrew
13	1	10141	Adj. Screw	32	2	WS1169	1/4-20 x 1-1/2 Rd. Hd. Screw
14	1	A7809	Adj. Screw Handle	33	2	WS845	3/8-16 x 1/2 Soc. Setscrew
15	1	10049	Spring	34	2	WS1332	5/16-18 Jam Hex Nut
16	1	10145	Upper Conn. Gear	BS1	1	10176	Standard
17	1	A7314	Lower Conn. Gear	BS2	1	10177	Swivel Cap
18	1	10147	Thumb Screw	BS3	1	10272	Lever for Clamping Screw
19	2	13461	Adj. Nut	BS4	1	10179	Clamping Screw
				BS5	1	WS644	7/16-14 x 1-1/2 Sq. Hd. C.P.S.S.
				BS6	1	WS2349	3/16 x 2 Btn. Hd. Stl. Rivet
				BS7	1	WS1544	A5/32 x 3/4 Roll Pin

Name	Roll Number	Catalog Number	Gauge Req'd	Roll Diagram
"A" Turning Roll 1/8"	10118	35000001	10126	
	10119	35000002		
"B" Turning Roll 3/16"	15037	35000049	10126	
	15038	35000050		
"C" Burring Roll	10120	35000003	10126	
	10121	35000004		
"D" Wiring roll	10122	35000005	10126	
	10123	35000006		
No. 1 Elbow Edging Roll	15039	35000050	10126	
	15040	35000052		
"L" Flange Roll	15053	35000053	Spec. 1541	
	15054	35000054		
"M" Flattening Roll	15055	35000055	None	
	15056	35000056		
"E" Crimping Roll	10124	35000007	BM7903	
	10125	35000008		
"F" Ogee Bead Roll 3/4"	10152	35000009	10130	
	10153	35000010		
"G" Single Bead Roll 1/4"	11106	35000029	10130	
	11107	35000030		
"H" Slitting Cutter Roll	SP2445	35070068	10126	
	SP2446	35070069		
"N" Furnace Collar Edging Roll	A51258	35000067	BM7903	
	A51259	35000068		
	A51260	35000069		
	(2 Req'd)			
"P" Offset Roll	A6512	35000076	BM7903	
	A6513	35000077		

