

# ROPER WHITNEY.®



## MODEL NO. 0585 CRIMPING AND BEADING MACHINE OPERATION, PARTS & MAINTENANCE MANUAL

Model:	Purchased From:
Serial #:	Date Received:



**Trick-Tools.com**

75 Truman Road

Pella, IA 50219

Phone: 1-877-VAN-SANT

E-mail: [sales@trick-tools.com](mailto:sales@trick-tools.com)



## FOREWORD

This manual has been prepared for the owner and operators of Roper Whitney No. 0585 crimping and beading machine. Its purpose, aside from operations instructions, is to promote safety through the use of accepted operating procedures. Read all instructions thoroughly before operating the machine.

Also contained in this manual is the parts list for your machine. It is recommended that only Roper Whitney or factory authorized parts be used as replacements.



Warranty Statement:

### **3 YEAR LIMITED WARRANTY**

Roper Whitney ("Manufacturer") warrants, commencing with the date of shipment to first end-user ("Customer") and for a period of thirty-six (36) months thereafter, all machinery and parts manufactured by Manufacturer to be free of defects in workmanship and material. **This warranty remains in force for the above time period only if all of Manufacturer's operational procedures are followed and recommended maintenance is performed.** If, within such warranty period, any machinery or parts manufactured by Manufacturer shall be proved to Manufacturer's satisfaction to be defective, such machinery or parts shall be repaired or replaced, at Manufacturer's option. All warranty claims are made F.O.B Manufacturer's plant, providing such machinery or parts are returned freight prepaid to Manufacturer's plant or designated service center for Manufacturer's inspection. All failed parts or components must be returned to Manufacturer prepaid for inspection before credit will be issued for new parts or components. Manufacturer's obligation hereunder shall be confined to such repair or replacement and does not include any charges, direct or indirect, for removing or replacing defective machinery or parts. No warranty shall apply to machinery, or parts or accessories, which have been furnished, repaired, or altered by others so as, in Manufacturer's judgment, to affect the same adversely or which shall have been subject to negligence, accident or improper care, installation, maintenance, storage, or other than normal use or service, during or after shipment. No warranty shall apply to the cost of repairs made or attempted outside of Manufacturer's plant or designated service center without Manufacturer's authorization. No warranty shall apply with respect to machinery or part not manufactured by Manufacturer, including but not limited to motors, accessories, electrical and hydraulic components, if such machinery or part is subject to warranty by the manufacturer of such machinery or part. No warranty claims by Customer will be honored with respect to any machinery or part from which the name and date plate has been removed or is otherwise no longer located or exhibited on such machinery or part. **THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY AND IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. MANUFACTURER SHALL NOT BE SUBJECT TO ANY OTHER OBLIGATIONS OR LIABILITIES WHATSOEVER WITH RESPECT TO MACHINERY, PARTS, ACCESSORIES, OR SERVICES MANUFACTURED OR FURNISHED BY IT OR ANY UNDERTAKINGS, ACTS, OR OMISSIONS RELATING THERETO. UNDER NO CIRCUMSTANCES SHALL MANUFACTURER BE LIABLE FOR ANY CONSEQUENTIAL OR OTHER DAMAGES, EXPENSES, LOSSES, OR DELAYS HOW SO EVER CAUSED.**

**THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.**

**Note: Consumable tooling is not covered under the 3 year manufacturer's warranty.**

RETURN OF THE PRODUCT REGISTRATION CARD FURNISHED WITH THE PRODUCT IS NECESSARY TO OBTAIN WARRANTY COVERAGE THEREON. CARD MUST BE FULLY COMPLETED, SIGNED BY THE PURCHASER, AND IF APPLICABLE, SIGNED BY THE DISTRIBUTOR. RETURN REGISTRATION CARD TO:

Roper Whitney 2833 Huffman Blvd. Rockford, IL 61103  
815-962-3011 / Fax 815-962-2227  
[www.roperswhitney.com](http://www.roperswhitney.com)

## SAFETY

**Do not operate the No. 0585 machine without the proper safety label in place.** If your machine is missing the following label please contact Roper Whitney Co. or your authorized Roper Whitney distributor to order.



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:

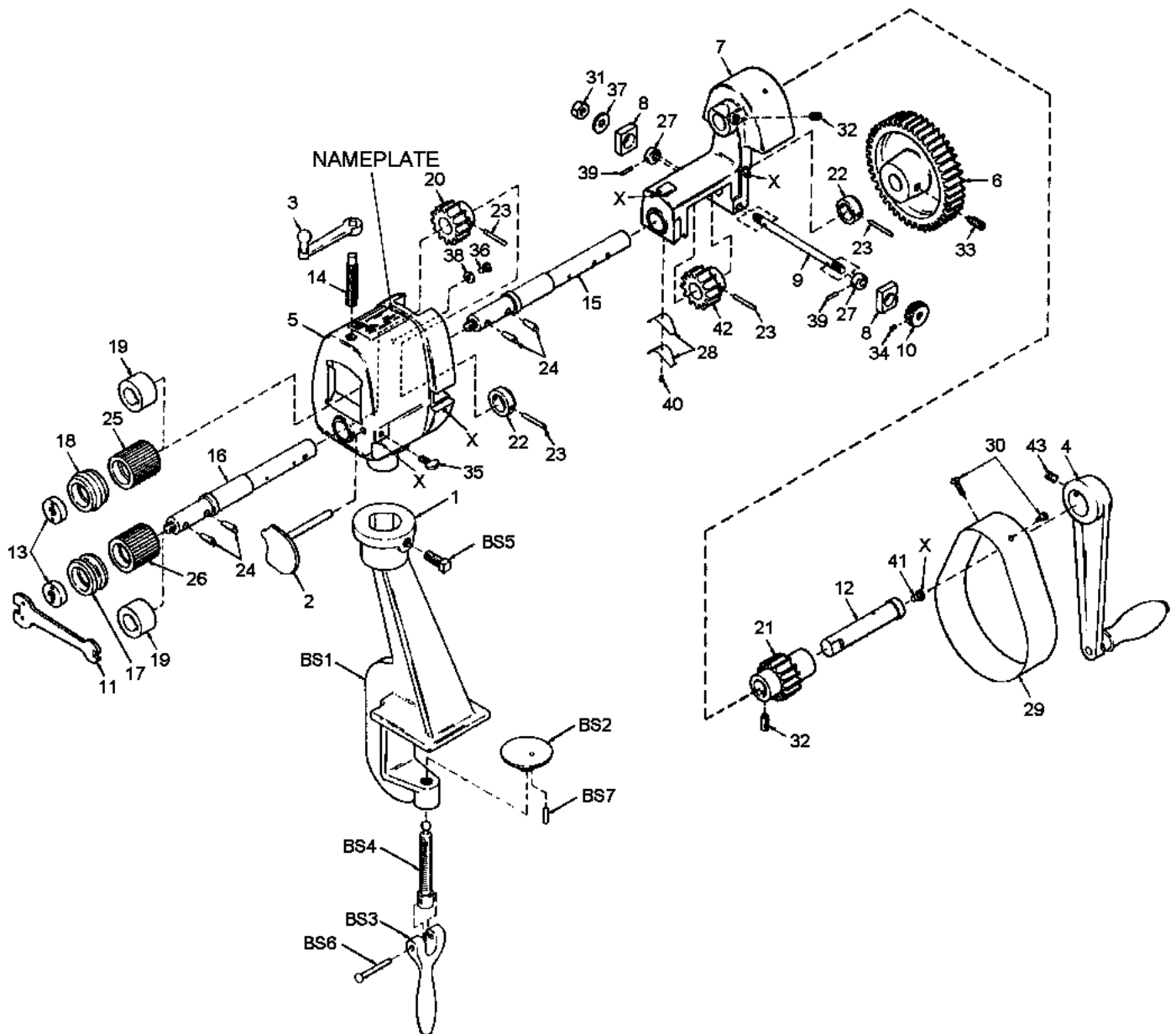
350000033	Ogee Bead Roll	381700083	Spacing Collars
350000034	Ogee Bead Roll	259700015	Standard Gauge
350000035	Crimping Roll	239009750	Bench Standard
350000036	Crimping Roll		

## 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.

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 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.
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 Rolls either backward or forward as required. After adjustment is made, tighten Hex Nut.
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, 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.

## MODEL 0585 PARTS IDENTIFICATION



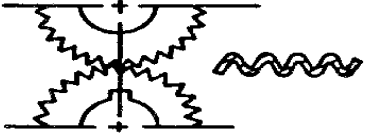
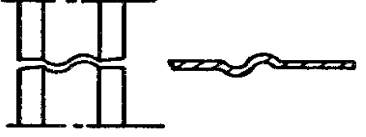

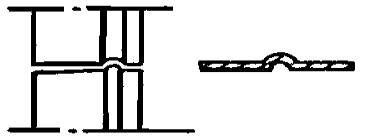
ITEM NO.	PART NO.	DESCRIPTION	QTY.
*1	239009750	#975 Bench Standard, Complete	1
*BS1	746060001	Standard	1
*BS2	746010002	Swivel Cap	1
*BS3	746030003	Lever for Clamping Screw	1
*BS4	746650004	Clamping Screw	1
*BS5	633012227	SHSCP Screw 7/16-14 x 1 1/2	1
*BS6	600063472	Roll Pin 1/4 Dia x 1 3/4	1
*BS7	600063442	Roll Pin 5/32 x 11/16	1

\* Part of the #975 Complete Bench Standard Assembly

# MODEL 0585 PARTS LIST

ITEM NO.	PART NO.	DESCRIPTION	QTY.
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 Arbor	1
16	764680132	Lower Arbor	1
17	350000033	Lower Beading Roll	1
18	350000034	Upper Beading Roll	1
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	664184543	Spring	2
29	764440138	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

## 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)	