

ROPER WHITNEY.



MODEL NO. 0581 CRIMPING AND BEADING MACHINE OPERATION, PARTS & MAINTENANCE MANUAL

Model:	Purchased From:
Serial #:	Date Received:

USA  MADE



Trick-Tools.com

80 Truman Road

Pella, IA 50219

Phone: 1-877-VAN-SANT

E-mail: sales@trick-tools.com



FOREWORD

This manual has been prepared for the owner and operators of Roper Whitney No. 0581 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:

SAFETY

Do not operate the No. 0581 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.



CAUTION: Be certain that the machine is securely bolted into the bench standard (1) and that the bench standard is securely clamped to the work bench. Also, the work bench must be bolted to the floor.

SPECIFICATIONS

Capacity Mild Steel.....24 ga.
Weight.....30 lbs. approx.
Nominal Center Distance.....1 3/4"

The 0581 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. This machine is adjustable for deep or shallow bead and for "fade-away" crimp. The 0581 comes complete with #975 Bench Standard and Spanner Wrench.

Model No. 0581 Crimping and Beading Machine is furnished with:

350000017	Ogee Bead Roll	350000018	Ogee Bead Roll
350000015	Crimping Roll	350000016	Crimping Roll
381700082	Spacing Collars	259700013	Standard Gauge
239009750	975 Bench Standard		

Optional extended ogee bead rolls are also available to configure the machine solely for beading.

350000153 Extended upper ogee bead roll
350000154 Extended lower ogee bead roll

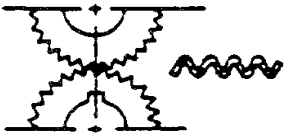
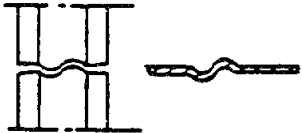
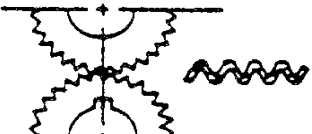
INSTRUCTIONS

Mount Lower Crimping Roll (11) on driving lugs of Lower Gear (16). Note key slots for mating with lugs of the Lower Gear. The Gear (16) is keyed to the Lower Arbor (9), thus becoming the driver. To mesh Upper Crimping Roll (10) with Lower Crimping Roll (11); rotate Upper Gear (15) until its lugs will accommodate slots in Upper Crimping Roll in proper mesh. Upper Gear slides on Upper Arbor (8), acting as idler and is driven by mating with Lower Gear.

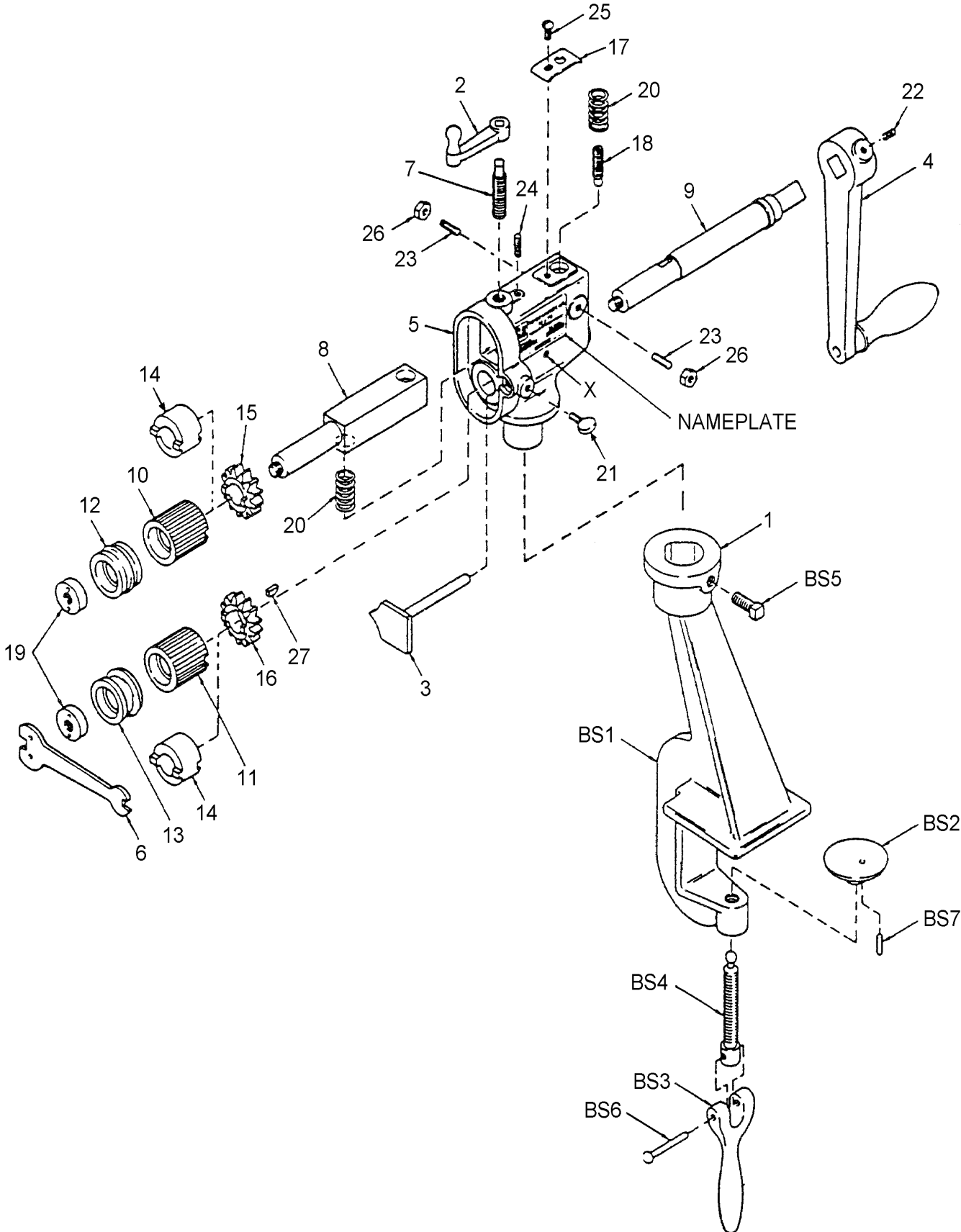
TO ADJUST MACHINE:

1. Mount Crimping Rolls as noted above. Mount Upper Ogee Beading Roll (12) and Lower Ogee Beading Roll (13) and secure with Roll Nuts (19).
2. Use Adjusting Screw Handle (2) to raise or lower the Upper Rolls into and away from the work.
3. Use Set Screw (24) to limit movement of Upper Rolls to setting required for given operation.
4. Use Pivot Screw (18) to tip (or tilt) Upper Arbor and Rolls in order to obtain a "fade-away" or straight crimp as desired. Pivot Screw (18) is reached by opening Spring Cover (17).
5. If only crimp is desired, remove Ogee Bead Rolls and Crimping Rolls. Mount Spacers (14) on Arbors to mate with Gear lugs. Mount Crimping Rolls to mate with Spacer lugs and rotate to mesh as described above. Lock securely with Roll Nuts (19).
6. Keep machine Arbors, Screws, Rocking Box, Journal Bearings and Gears lubricated with a medium (SAE 30) motor oil. "X" points should be lubricated daily with a good grade machine oil.

MODEL 0581 ROLL CHART

NAME	CATALOG NO.	GAUGE REQUIRED	ROLL DIAGRAM
Crimping Roll	350000015 350000016	259700013	
Ogee Bead Roll	350000017 350000018	259700013	
Spiral Crimp Roll	350000019 350000020	259700013	

MODEL 0581 PARTS IDENTIFICATION CHART



MODEL 0581 PARTS LIST

ITEM NO.	PART NO.	PART NAME	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 x 1 3/4	1
*BS7	600063442	Roll Pin 5/32 x 11/16	1
2	764670214	Adjusting Screw Handle (With Adj. Screw)	1
3	259700013	Gauge Assembly	1
4	230700008	Hand Crank Assembly	1
5	764140114	Frame	1
6	764480016	Spanner Wrench	1
7	See Item 2	Adjusting Screw	1
8	764680115	Upper Arbor	1
9	764680116	Lower Arbor	1
10	350000015	Upper Crimping Roll	1
11	350000016	Lower Crimping Roll	1
12	350000017	Upper Beading Roll	1
13	350000018	Lower Beading Roll	1
14	381700082	Spacing collar	2
15	764380117	Upper Connecting Gear	1
16	764380118	Lower Connecting Gear	1
17	764220119	Cover	1
18	764650120	Pivot Screw	1
19	764560121	Roll Nut	2
20	664184542	Spring	2
21	641012131	Thumb Screw	1
22	621012132	Socket Set Screw 5/16-18 x 7/8	1
23	600325907	Headless Set Screw 5/16-18 x 3/4	2
24	600325912	Headless Set Screw 1/4-20 x 3/4	1
25	615012086	Button Head Cap Screw 1/4-20 x 1/2	1
26	649023004	Check Nut 5/16-18	2
27	764530122	Lower Arbor Key	1

* Part of the #975 Complete Bench Standard Assembly