

TIN KNOCKER TK POWER CRIMPER BEADER



INSTRUCTIONS & PARTS DIAGRAM

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WARRANTY

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE:

1. This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you. Call us at: (800) 640-0746.
2. Opening rolls (for Philipsburg Lock) are consumable items and not subject to warranty

SPECIFICATIONS

Maximum Capacity mild steel or equivalent	18 gauge mild steel
Throat to Frame Depth	13"
Throat to gauge depth	12.25"
Distance between shaft centers	3"
Shipping weight	340 lbs
Motor	1 hp, 230V, 3 phase
Dimensions	L 39" x H 52" x W 14.5"

SAFETY PRECAUTIONS

1. Keep the work area well-lit and uncluttered to avoid accidents.
2. Turn off machine to clean. Do not use compressed air for cleaning debris from yourself or the machine. Remove debris and grit from machine with a rake or brush – not your hands.
3. Only authorized and trained personnel should operate the machine.
4. Thoroughly read and understand the Operator's Manual as well as the warnings and instructions mounted on the machine.
5. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.
6. Report all injuries or illness, regardless of severity, to your supervisor.
7. Do not place speed above safety.
8. Never use this machine for anything other than its intended purpose. Use the proper tool and equipment for the task.
9. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
10. Do not operate the machine more than its rated capacity.
11. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.
12. Do not override the safety features of the equipment or remove any guarding.
13. Use proper Personal Protective Equipment (PPE) while operating machine.

RECEIVING THE MACHINE

- Upon receipt and before signing the Bill of Lading carefully examine the machine for damage that may have occurred during shipping.
- Be certain you have two handles.
- Any loss or damage should be noted in detail on the delivery receipt and reported to your distributor immediately.
- Free replacement from TK International is dependent upon the notation and the Bill of Lading on delivery slip.

ROLL TYPES



INSTALLING THE MACHINE

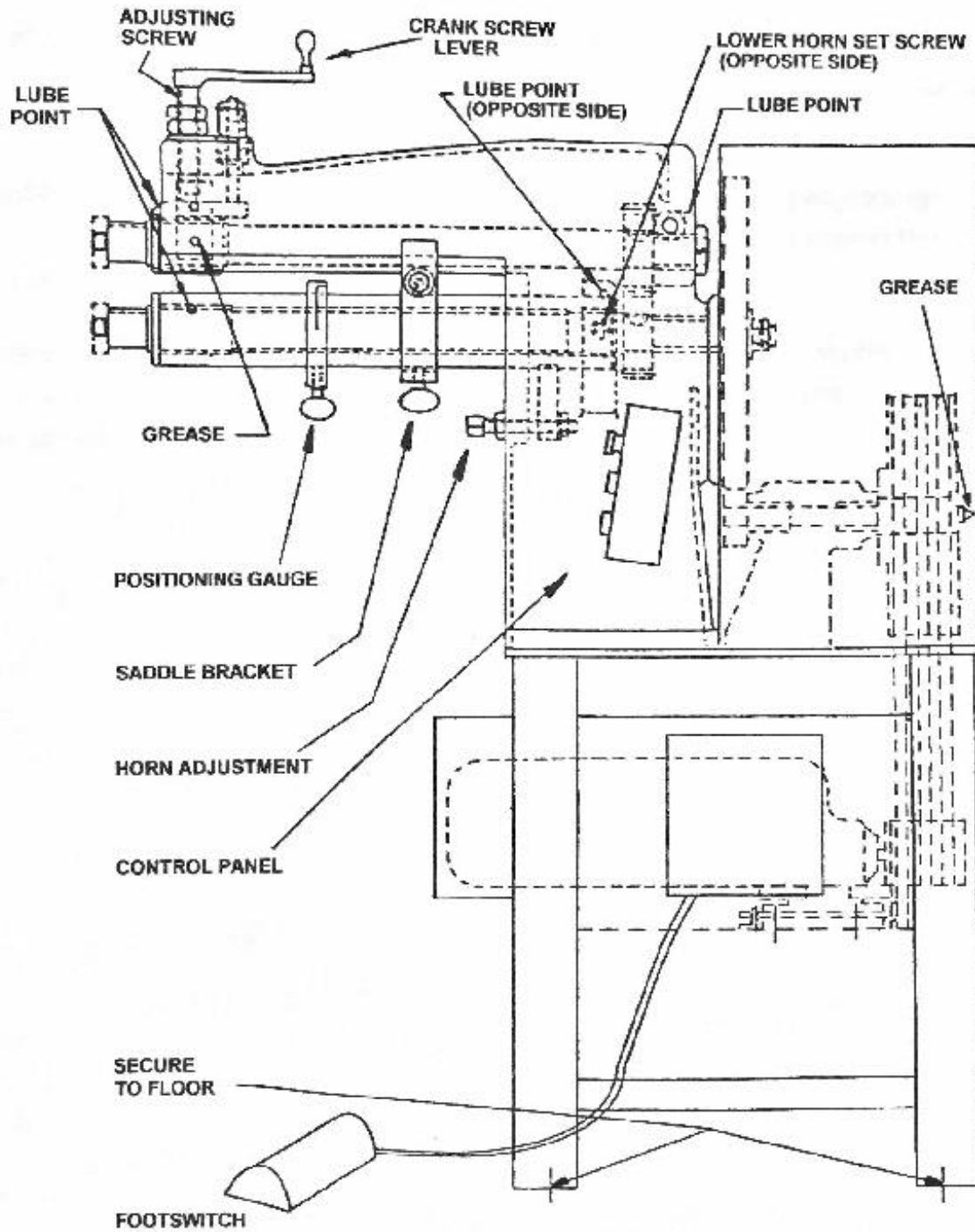
- If the machine is shipped on a pallet, remove the machine from the pallet.
- Ensure that machine is reasonably level between all four mounting points.
- Machine must be securely mounted to the ground with bolts.

OPERATION

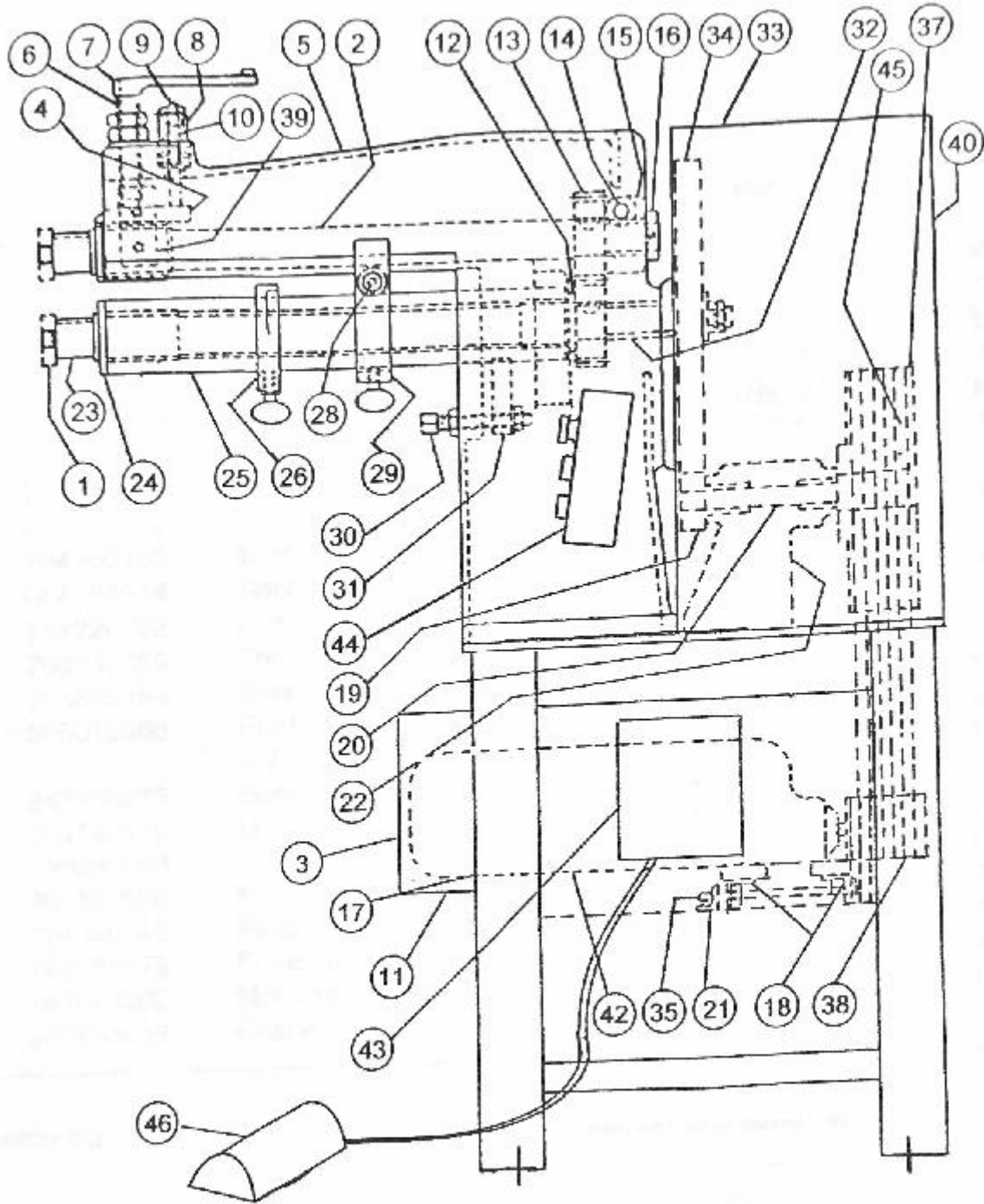
- The power crimper/bender comes with a speed and power controller and two foot pedals.
- Turn machine on
- Set the speed controller to the desired rotational speed (in RPMs).
- Depress proper foot pedal for desired rotational direction.

LUBRICATION

- Bearing blocks and pulley idler shaft should be lubricated every 40 hours



Full Assembly Parts Diagram



Parts List

Fine No.	Part No.	QTY	Part Name
1	PCBR001	2	Roll nut
2	PCBR002	1	upper shaft
3	PCBR003	1	motor cover
4	PCBR004	1	front box assembly
5	PCBR005	1	frame
6	PCBR006	1	adjusting screw
7	PCBR007	1	crank screw lever
8	PCBR008	1	spring cup
9	PCBR009	1	stud
10	PCBR010	1	spring cup
11	PCBR011	1	motor cover
12	PCBR012	1	rear thrust washer
13	PCBR013	2	connecting gear
14	PCBR014	1	full dog screw
15	PCBR015	1	rocking box assembly
16	PCBR016	1	lock nut
17	PCBR017	1	stand
18	PCBR018	1	motor bracket
19	PCBR019	1	pinion gear
20	PCBR020	1	drive shaft
21	PCBR021	1	motor hinge
22	PCBR022	1	bearing bracket assembly
23	PCBR023	1	lower shaft
24	PCBR024	1	front thrust washer
25	PCBR025	1	horn assembly
26	PCBR026	1	gauge assembly
28	PCBR027	1	tie bolt
29	PCBR028	1	saddle
30	PCBR029	1	adjusting screw
31	PCBR030	1	adjusting stud
32	PCBR031	1	pipe spacer
33	PCBR032	1	rear cover
34	PCBR033	1	gear
35	PCBR034	1	hinge pin
37	PCBR035	1	large sheave
38	PCBR036	1	small sheave
39	PCBR037	2	gib
40	PCBR038	1	belt guard

42	PCBR039	1	motor
43	PCBR040	1	starter
44	PCBR041	1	controller panel
45	PCBR042	1	V belts
46	PCBR043	1	Foot pedals
not shown	PCBR044-U	1	Crimp roll large tooth - upper
not shown	PCBR044-L	1	Crimp roll large tooth - lower
not shown	PCBR045-U	1	Crimp roll small tooth - upper
not shown	PCBR045-L	1	Crimp roll small tooth - lower
not shown	PCBR046-U	1	Offset roll - upper
not shown	PCBR046-L	1	Offset roll - lower
not shown	PCBR047-U	1	Oggee roll - upper
not shown	PCBR047-L	1	Oggee roll - lower
not shown	PCBR048-U	1	Single roll - upper
not shown	PCBR048-L	1	Single roll - lower
not shown	PCBR049-U	1	Turning roll - upper
not shown	PCBR049-L	1	Turning roll - lower
not shown	PCBR050-U	1	Wiring roll - upper
not shown	PCBR050-L	1	Wiring roll - lower