

TIN KNOCKER

TK MANUAL CRIMPER - BEADER

INSTRUCTIONS & PARTS DIAGRAMS



TAAG INDUSTRIES CORP.
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TIN KNOCKER SAFETY RULES MANUAL CRIMPER - BEADER

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush – not your hands.
2. 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 operator's Manual as well as any warnings and instructions that might be mounted on the machine.
3. Safety glasses are recommended with the use of this or any shop machine.

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.

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OPERATING INSTRUCTIONS

Be certain that the machine is securely bolted into Bench Stand and that Bench Stand is securely clamped to work bench. Mount lower crimping roll on driving lugs of lower gear. Key slots for mating with lugs of the lower gear. The gear is keyed to the lower arbor thus becoming the driver. To mesh upper crimping roll with lower crimping roll rotate upper gear until its lugs will accommodate slots in upper crimping roll in proper mesh. Upper gear slides on upper arbor, 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 and lower Ogee beading roll and secure with roll nuts
2. Use adjusting screw handle to raise or lower the upper rolls into and away from the work.
3. Use setscrew to limit movement of upper rolls to setting required for given operation.
4. Use pivot screw to tip upper arbor and rolls in order to obtain a fade-away or straight crimp as desired.
5. If only crimp is desired, remove ogee bead rolls and crimping rolls. Mount spacers on arbors to mate with gear lugs. Mount crimping rolls to mate with spacer lugs and rotate to proper mesh as described above. Lock securely with roll nuts.
6. Keep machine Arbors, screws, rocking box , journal bearings and gears lubricated with a medium motor oil.

SPECIFICATIONS

GENERAL: Crimp and bead in one pass of the metal,

24 ga and lighter. Comes with Ogee bead

and crimping tooling, depth gauge, and base.

CAPACITY: 24 Ga Mild Steel

WEIGHT: Approx. 32 lb

Parts For Manual Crimper - Beader			
Fine No.	Part No.	Description	No. REQ'D.
1	CRIMP0001	BENCH STANDARD	1
2	CRIMP0002	ADJ SCREW & HANDLE	1
3	CRIMP0003	GAUGE	1
4	CRIMP0004	CRANK ASSEMBLY, HAND	1
5	CRIMP0005	FRAME	1
6	CRIMP0006	SPANNER WRENCH	1
8	CRIMP0008	UPPER ARBOR	1
9	CRIMP0009	LOWER ARBOR	1
10	CRIMP0010	UPPER CRIMPING ROLL	1
11	CRIMP0011	LOWER CRIMPING ROLL	1
12	CRIMP0012	UPPER BEADING ROLL	1
13	CRIMP0013	LOWER BEADING ROLL	1
14	CRIMP0014	SPACING COLLAR	2
15	CRIMP0015	UPPER CONN. GEAR	1
16	CRIMP0016	LOWER CONN. GEAR	1
17	CRIMP0017	COVER	1
18	CRIMP0018	PIVOT SCREW	1
19	CRIMP0019	ROLL NUT	2
20	CRIMP0020	SPRING	2
21	CRIMP0021	THUMB SCREW	1
22	CRIMPBOLT0004	BOLT HEX M8 X 25	1
23	CRISSETSCREW002	SET SCREW M8 X 25	2
24	CRISSETSCREW003	SET SCREW M6 X 20	1
25	CRIMPCAPSC0001	CAP SCREW M6 X 15	1
26	CRIMPNUT0001	NUT M8	2
27	CRIMP0027	LOWER KEY ARBOR	1
28	CRIMP0028	SWIVEL CAP	1
29	CRIMP0029	LEVER FOR CLAMPING SCREW	1
30	CRIMP0030	CLAMPING SCREW	1
31	CRIMPBOLT0005	BOLT SQ M10 X 41	1
32	CRIMP0032	BTN. HD. STL. AIVET	1
33	CRIMP0033	ROLL PIN	1
34	CRIMP0034	DRIVEN BEAD ROLL-UPPER	1
35	CRIMP0035	DRUVEN BEAD ROLL - LOWER	1