OPERATING INSTRUCTIONS
FOR
PEXTO #CM-250 ELECTRIC COMBINATION ROTARY MACHINE

The production of quality work on this machine depends upon accurate set-up and adjustment, regardless of type of work to be done.

To adjust this machine, proceed as follows:

Back off CRANK LEVER to move ROLL SHAFTS apart. Place work rolls on shafts and tighten ROLL NUTS securely, using wrench provided with the machine.

Insert work between rolls and set gauge for position desired. Bolt special gauge (if used) to GAUGE HOLDER. Adjust by loosening set screws and moving GAUGE HOLDER, which can also be used as a Universal Gauge.

Turn down CRANK LEVER until contact is made with work. If proper roll positioning is not obtained, UPPER SHAFT can be adjusted in several ways with relation to LOWER SHAFT:

1. Tilting (or Vertical adjustment) is made through the VERTICAL ADJUSTING BOLT and its ADJUSTING SCREW.

2. In-and-out position is adjusted by the HORIZONTAL ADJUSTING BOLT and its ADJUSTING SCREW.

3. Side-to-side adjustment of shafts is held through GIBS bearing on the ROCKING BOX and is changed through the GIB ADJUSTING SCREW. This adjustment may be necessary in crimping only. When properly set and in working position, rolls will show uniform all-around clearance equal to metal gauge.

After work rolls are set, operate machine as follows:

1. Make sure HAND LEVER is in “up” position, and that rolls are not fully engaged with work.

2. Start motor (starter located on right-hand side of base).

3. Engage CLUTCH by—(a) Rotating HAND LEVER toward back of machine or (b) depressing FOOT CLUTCH LEVER. (If motor runs but Shafts do not turn, CLUTCH should be adjusted according to plate attached to FRAME. The CLUTCH YOKE may be adjusted by means of lock nuts on the SHIFTER ROD). NOTE—CLUTCH SHIFTER SHOES must be loose and free-fitting with the clutch in any position.

4. Slowly bring work rolls together by (a) Turning CRANK LEVER, or (b) depressing FOOT TREADLE. CAUTION—Until TREADLE STOP IS SET, do not exert heavy pressure on FOOT TREADLE as damage may result.

(CONTINUED ON BACK PAGE)
5. When work rolls are fully engaged, set stops as follows:—(a) Run check nuts on crank screw down to FRAME and tighten together. (b) Adjust TREADLE STOP to bear against floor plate when proper roll engagement is reached.

After the above adjustments have been made, the machine is set for a production run. Clutch engagement and work roll engagement can be made by using any combinations of hand or foot controls (as described in #3 and 4 above).

The following internal adjustments are available:
Spring tension on the FOOT CLUTCH LEVER can be changed by adjusting the SPRING STUD up or down through its lock nuts.

FOOT TREADLE spring tension can be changed by adjusting the ROD COLLAR up or down.

For belt take-up, loosen lock nuts on MOTOR BRACKET ADJUSTING SCREW. Tighten belt just enough to prevent slippage. Too tight a belt will damage bearings in motor and DRIVE SHAFT, as well as hasten belt wear.

LUBRICATION:—
"A" Indicates oil points:—Use SAE-30 motor oil.
"B" Indicates grease points:—Use a good grade of automobile chassis lubricant.
Lubricate every 8 hours' operating time.

FOR ORDERING PARTS:—
Give Model No. and Serial No. of machine as well as part name shown on this card.
power combination rotary machines

No. CE-300 Spin Collar Machine

Provides the easiest, fastest method available for connecting round pipe to rectangular duct. Eliminates unnecessary time spent fitting and closing collar edges formed by other methods. Complete with tooling, ready to form spin edge in one operation on 22 to 30 gauge galvanized steel. Minimum diameter of five inches. Floor mounted complete with magnetic starter and automatic roll start and stop. (Pat. 3,648,503.)

<table>
<thead>
<tr>
<th>Number</th>
<th>Roll speed</th>
<th>Capacity</th>
<th>Minimum diameter</th>
<th>Diameter of rolls</th>
<th>Standard electrics</th>
<th>Motor</th>
<th>Shipping weight</th>
<th>Length</th>
<th>Height</th>
<th>Width</th>
</tr>
</thead>
<tbody>
<tr>
<td>CE-300</td>
<td>r.p.m.</td>
<td>gauge</td>
<td>ins.</td>
<td>ins.</td>
<td>115 volt, single phase, 60 hertz</td>
<td>h.p.</td>
<td>approx. lbs.</td>
<td>ins.</td>
<td>ins.</td>
<td>ins.</td>
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<td></td>
<td>78</td>
<td>22 to 30</td>
<td>6</td>
<td>3</td>
<td>90</td>
<td>85</td>
<td>330</td>
<td>21</td>
<td>17</td>
<td>50</td>
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</tbody>
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CM-250 Power Combination Rotary Machine

2¾" DIAMETER ROLLS

Designed for crimping, beading, turning, burring, wiring and edging. Combined crimping and beading—exclusively PEXTO—can be accomplished.

CLUTCH—Multiple disc Maxtorq Clutch—with hand and foot control.

DRIVE—"V" belt drive—Standard machine furnished with sheaves for roll speed of 26 r.p.m. Sheave and pulley combination supplied for various speeds.

POWER—Powered with ½ h.p. 1800 r.p.m. motor to power source requirements. Reversing switch extra.

ROLLS—Standard rolls and gauges as illustrated on roll chart.

| Number  | Crimping and beading gauge | Crimping only gauge | Beading only gauge | Turning, burring, wiring, edging, flanging gauge | Sitting and circle cutting gauge | Maximum height of flange ins. ¾" in 15 | Flanging ins. 3½ to 36 | Circle cutting (from square blanks) ins. 4 to 24 | Arbor diameter in bearings ins. 1¼ | Roll speed (standard) r.p.m. | Depth of throat from end of arbors to frame ¾" | Motor (1800 r.p.m.) h.p. | Shipping weight machine approx. lbs. 450 | Length ins. 195 | Height ins. 50 | Width ins. 18 |
|---------|---------------------------|---------------------|-------------------|-------------------------------------------------|--------------------------------|----------------------------------------|-----------------------|------------------------------------------|-----------------------------|----------------------|----------------------------------|----------------------|----------------|------------|------------|
| CM-250  | 22                        | 18                  | 18                | 18                                              | 18                            | 16                                     | 18                    | 18                                        | 1½                          | 26                   | 7½                  | ½                     |

No. 1627 Power Combination Rotary Machine

3" DIAMETER ROLLS

For all kinds of roll operations such as burring, turning, wiring, beading, crimping, combined crimping and ogee beading, elbow edging, slitting, flanging, offsetting and for the cutting and flanging of circular discs when furnished with circle attachment.

Silent chain drive, optional speeds, foot and hand lever operated friction clutch control and hand crank for depressing top roll arbor. Foot treadle for depressing top roll arbor suitable for single operations on light gauge work. Can also be furnished with control for reversing drive. Regularly furnished with one drive sprocket for minimum standard speed.

| Number  | Capacity crimping and beading gauge | Capacity crimping only or beading only gauge | Capacity, turning, burring, wiring, elbow edging gauge | Capacity crimping and beading gauge | Capacity crimping only or beading only gauge | Capacity, turning, burring, wiring, elbow edging gauge | With circular cutting and flanging attachment will cut from square blanks ins. 8 to 13½ | Will flange circular disc up to diameter ins. 8 to 26 | Distance between shaft centers ins. 3 | Speed of rolls with standard sprockets r.p.m. 23-38-47 | Depth of throat from end of arbors to frame ins. 6½ | Motor—1800 r.p.m. h.p. ½ | Shipping weight, crated approx. lbs. 550 | Length ins. 27 | Height ins. 57 | Width ins. 22 |
|---------|-----------------------------------|---------------------------------------------|-----------------------------------------------------|-----------------------------------|---------------------------------------------|-----------------------------------------------------|------------------------------------------|------------------------------------------|----------------------------------------|----------------------------------------|----------------------|----------------|------------|------------|
| 1627    | 18                                | 16                                          | 16                                                  | 18                                | 16                                          | 16                                                  | 14                                      | 14                                      | 3                        | 23-38-47                | 6½                   | ½            | 550        | 27          |

*Height of flange, without distortion, will be less in lighter gauges.

*By cutting four corners of square blanks circles can be cut up to 26 inch diameter.