

TIN KNOCKER

TK 724 COMBINATION MACHINE

INSTRUCTIONS AND PARTS DIAGRAMS



Sheet Metal Equipment Sales Inc.
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**TIN KNOCKER
SAFETY RULES
TK 724 COMBINATION MACHINE**

1. Never use a machine or tool for anything other than its intended purpose. Use the proper tool and equipment for the task.
2. Do not operate the machine in excess of its rated capacity.
3. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.

WARRANTY

All new SME machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. SME at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. SME 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 contact SME, 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 SME. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Readjustment can easily be done by following the procedures described within. 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.

Note: The forming rolls are a consumable 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 tooling 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 tool roll with lower tool roll, rotate upper gear until it will accommodate in upper tool 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 tool rolls as noted above.
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. Keep machine arbors, screws, rocking box, journal bearings and gears lubricated with medium motor oil.

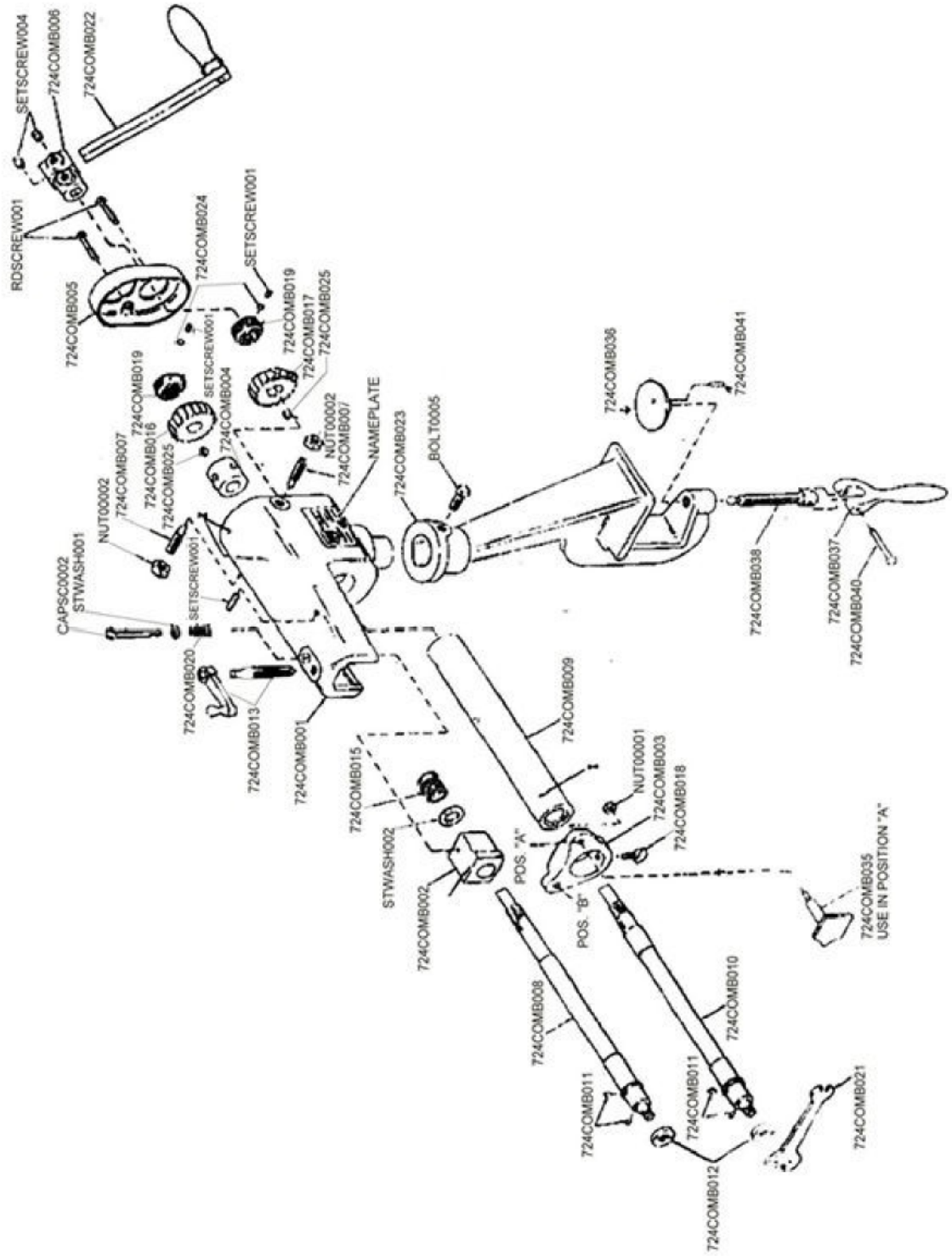
SPECIFICATIONS

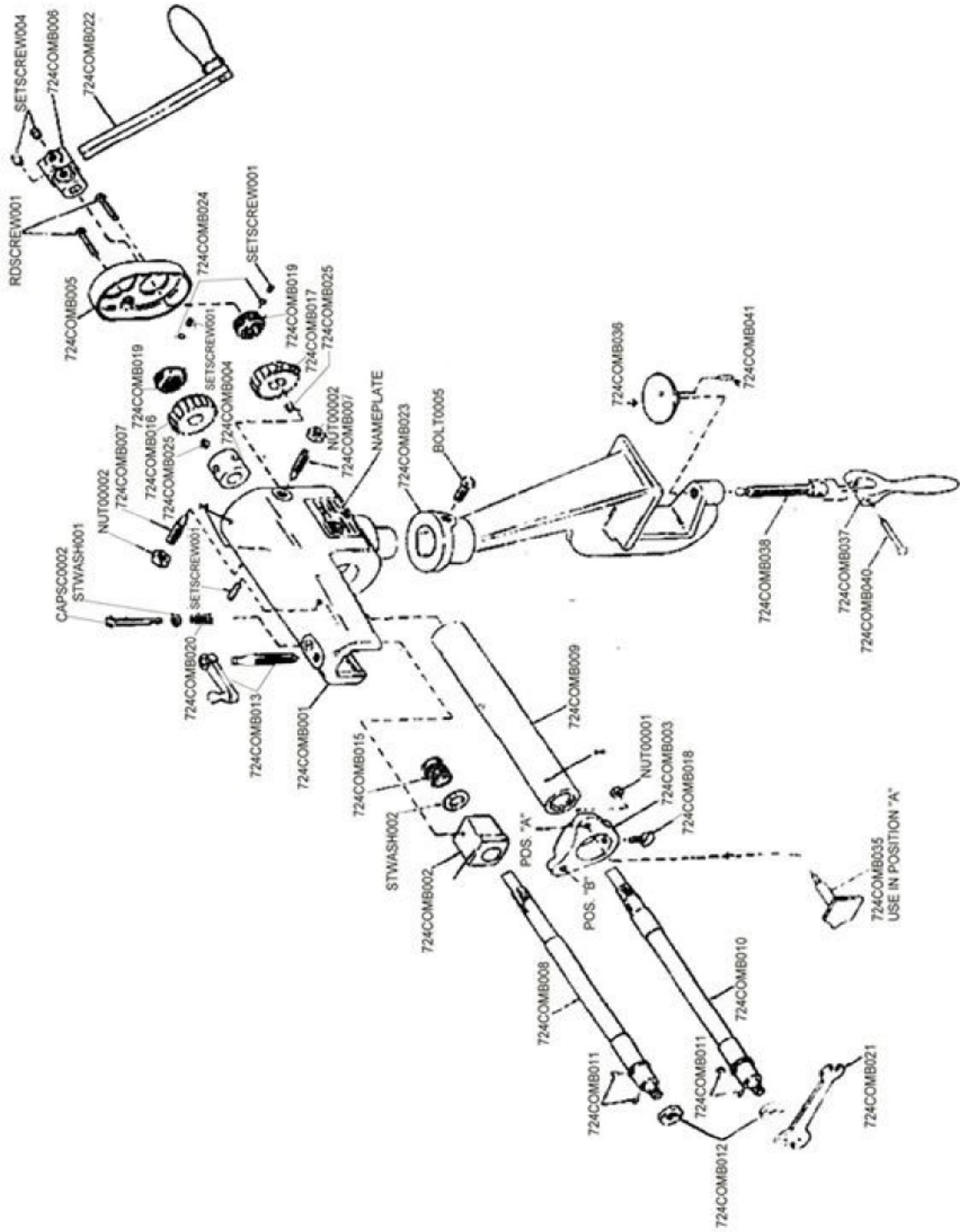
General: Crimp or bead

24 Ga. and lighter. Comes with Ogee bead
and crimping tooling, depth gauge, and base

CAPACITY; 24 Ga. Mild Steel

WEIGHT: Approx. 32 lb (15 kg)





TK 724 COMBINATION MACHINE DRAWING

Parts For 724 COMBO			
Fine No.	Part No.	Description	No. REQ "D."
1	724COM B001	FRAME	1
2	724COM B002	FRONT UPPER BOX	1
3	724COM B003	GAUGE	1
4	724COM B004	ROCKING BOX	1
5	724COM B005	GEAR GUARD	1
6	724COM B006	CRANK ROD HOLDER	1
7	724COM B007	PIVOT SCREW	2
8	724COM B008	UPPER SHAFT	1
9	724COM B009	HORN ASSEM BLY	1
10	724COM B010	SHAFT, LOWER	1
11	724COM B011	ROLL PIN FOR SHAFT	4
12	724COM B012	ROLL NUT	2
13	724COM B013	ADJUSTMENT SCREW & HANDLE	1
15	724COM B015	SPRING	1
16	724COM B016	UPPER COUN. GEAR	1
17	724COM B017	LOWER COUN GEAR	1
18	724COM B018	THUM B SCREW	1
19	724COM B019	ADJUSTM ENT NUT	2
20	724COM B020	FRONT BOX SPRING	1
21	724COM B021	COM B. WRENCH	1
22	724COM B022	CRANK ASSEM BLY, HAND	1
23	724COM B023	BENCH STANDARD	1
24	724COM B024	PLUG	1
25	724COM B025	# 3 WOODRUFF KEY	2
26	CAPSC0002	CAPSCREW M 6 X 65	1
27	STWASH001	M 6 STANDARD WASHER	1
28	STWASH002	M 12 STANDARD WASHER	1
29	NUT00002	CHECK NUT M 12	2
30	SETSCREW001	SETSCREW M 6	1
31	RDSCREW001	RD. HEAD SCREW M 6 X 40	2
32	SETSCREW004	SET SCREW M 6 X 15	2
33	NUT00001	NUT M 8	2
35	724COM B035	EXTENSION GAUGE	1
36	724COM B036	SWIVEL CAP	1
37	724COM B037	LEVER FOR CLAM PING SCREW	1
38	724COM B038	CLAM PING SCREW	1
39	BOLT0005	BOLT SQ M 10 X 41	1
40	724COM B040	BTN. HD. STL. RIVET	1
41	724COM B041	ROLL PIN	1
42	724COM BR01	TURNING ROLL, UPPER	1
43	724COM BR02	TURNING ROLL, LOWER	2
44	724COM BR03	BURRING ROLL, UPPER	1
45	724COM BR04	BURRING ROLL, LOWER	1
46	724COM BR05	"D" WIRING ROLL, UPPER	1
47	724COM BR06	"D" WIRING ROLL, LOWER	1
48	724COM BR07	CRIM PING ROLL, UPPER	1
49	724COM BR08	CRIM PING ROLL, LOWER	1
50	724COM BR09	OGEE BEAD ROLL ¾ UPPER	1
51	724COM BR10	OGEE BEAD ROLL, LOWER	2
52	724COM BR11	UPPER BEAD ROLL	1
53	724COM BR12	LOWER BEAD ROLL	1