

TIN KNOCKER

TK 724 COMBINATION MACHINE

INSTRUCTIONS & PARTS DIAGRAMS



TAAG INDUSTRIES CORP.
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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 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 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.

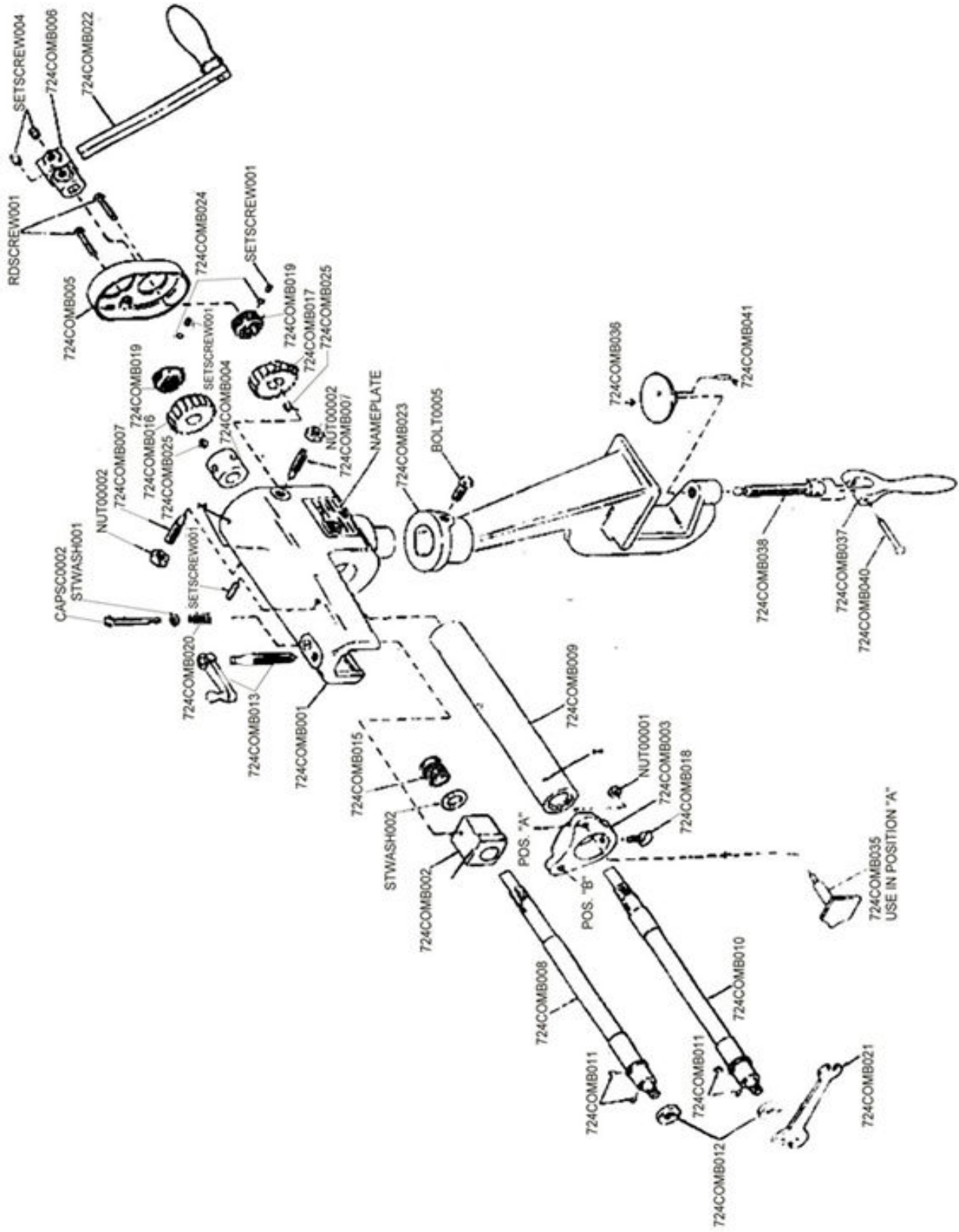
SPECIFICATIONS

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	724COMB001	Frame	1
2	724COMB002	FRONT UPPER BOX	1
3	724COMB003	GAUGE	1
4	724COMB004	ROCKING BOX	1
5	724COMB005	GEAR GUARD	1
6	724COMB006	CRANK ROD HOLDER	1
7	724COMB007	PIVOT SCREW	2
8	724COMB008	UPPER SHAFT	1
9	724COMB009	HORN ASSEMBLY	1
10	724COMB010	SHAFT, LOWER	1
11	724COMB011	ROLL PIN FOR SHAFT	4
12	724COMB012	ROLL NUT	2
13	724COMB013	ADJUSTMENT SCREW & HANDLE	1
15	724COMB015	SPRING	1
16	724COMB016	UPPER COUN. GEAR	1
17	724COMB017	LOWER COUN GEAR	1
18	724COMB018	THUMB SCREW	1
19	724COMB019	ADJUSTMENT NUT	2
20	724COMB020	FRONT BOX SPRING	1
21	724COMB021	COMB. WRENCH	1
22	724COMB022	CRANK ASSEMBLY, HAND	1
23	724COMB023	BENCH STANDARD	1
24	724COMB024	PLUG	1
25	724COMB025	# 3 WOODRUFF KEY	2
26	724CAPSC0002	CAPSCREW M6 X 65	1
27	724STWASH001	M6 STANDARD WASHER	1
28	724STWASH002	M12 STANDARD WASHER	1
29	724NUT00002	CHECK NUT M12	2
30	724SETSCREW001	SETSCREW M6	1
31	724RDSCREW001	RD. HEAD SCREW M6 X 40	2
32	724SETSCREW004	SET SCREW M6 X 15	2
33	724NUT00001	NUT M8	2
35	724COMB035	EXTENSION GAUGE	1
36	724COMB036	SWIVEL CAP	1
37	724COMB037	LEVER FOR CLAMPING SCREW	1
38	724COMB038	CLAMPING SCREW	1
39	724BOLT0005	BOLT SQ M10 X 41	1
40	724COMB040	BTN. HD. STL. RIVET	1
41	724COMB041	ROLL PIN	1
42	724COMBR01	TURNING ROLL, UPPER	1
43	724COMBR02	TURNING ROLL, LOWER	1
44	724COMBR03	BURRING ROLL, UPPER	1
45	724COMBR04	BURRING ROLL, LOWER	1
46	724COMBR05	"D" WIRING ROLL, UPPER	1
47	724COMBR06	"D" WIRING ROLL, LOWER	1
48	724COMBR07	CRIMPING ROLL, UPPER	1
49	724COMBR08	CRIMPING ROLL, LOWER	1
50	724COMBR09	OGEE BEAD ROLL ¾ UPPER	1
51	724COMBR10	OGEE BEAD ROLL, LOWER	1
52	724COMBR11	UPPER BEAD ROLL	1
53	724COMBR12	LOWER BEAD ROLL	1