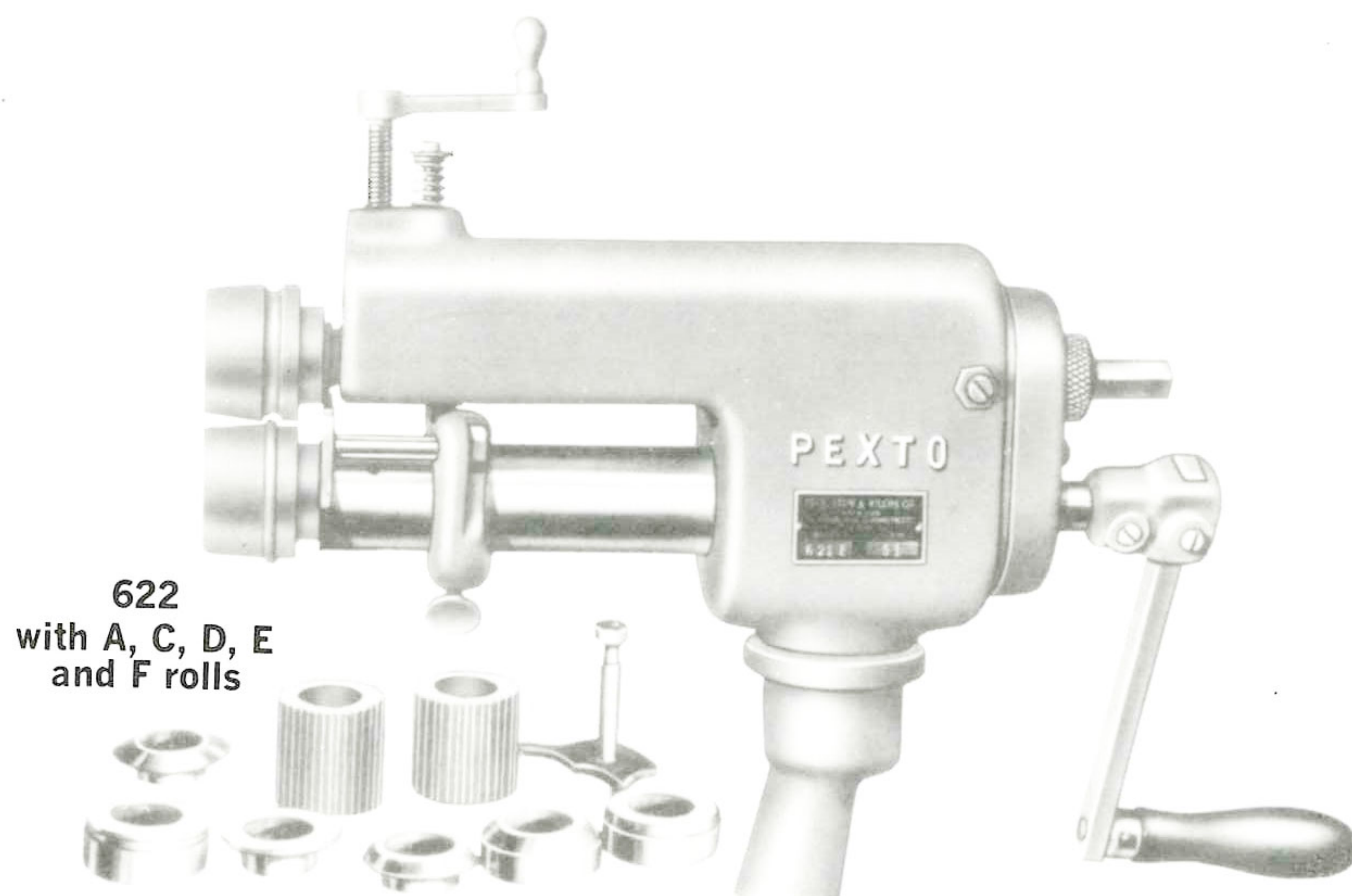
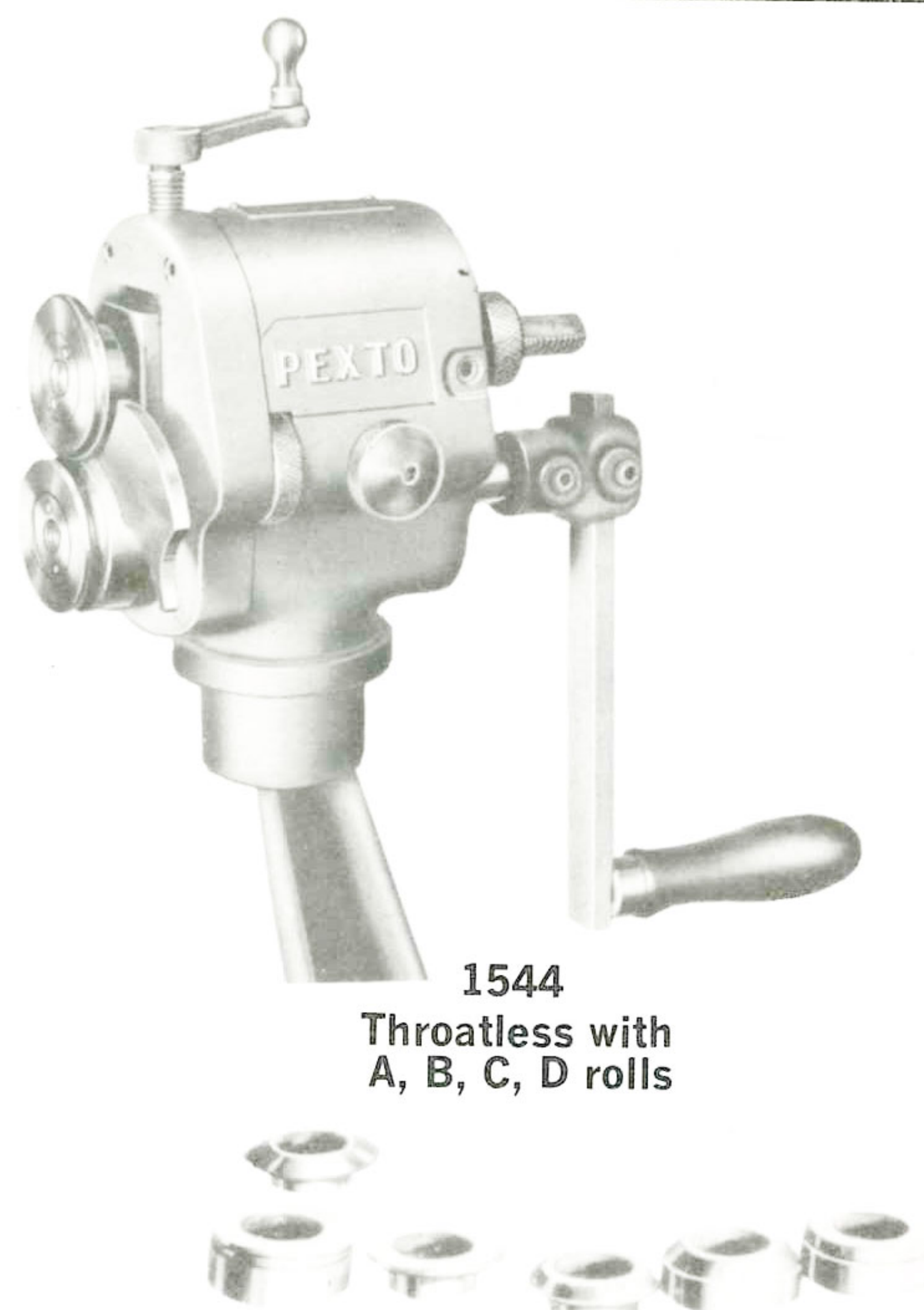


combination rotary machines



622
with A, C, D, E
and F rolls



1544
Throatless with
A, B, C, D rolls

No. 544 Series

This ONE machine with interchangeable rolls (see roll chart) will perform turning, burring, wiring, elbow edging, flanging and flattening operations. A truly UNIVERSAL machine with provision for reversing direction of arbors, with normal clockwise handle rotation. Furnished with No. 975 offset standard. Heavy, enclosed frame, solid steel, machine-cut, quiet gears. Finest construction throughout. See Roll Chart 2" center for rolls available.

Number	544 Series
Capacity mild steel.....gauge	22
Distance between shaft centers.....ins.	2
Shipping weight—less rolls.....approx. lbs.	27
Shipping weight—rolls per pair.....approx. lbs.	1

544LR —Less rolls and gauges.

1544 —Combination machine with A, B, C, D rolls.

2544 —Turning machine with A rolls (11 gauge wire) and B rolls (7 gauge wire).

3544 —Burring machine with C rolls. Max. 1/4" flange.

4544 —Wiring machine with D rolls (up to 7 gauge wire).

5544 —Elbow edger with No. 1 E.E. rolls.

6544 —1st operation.

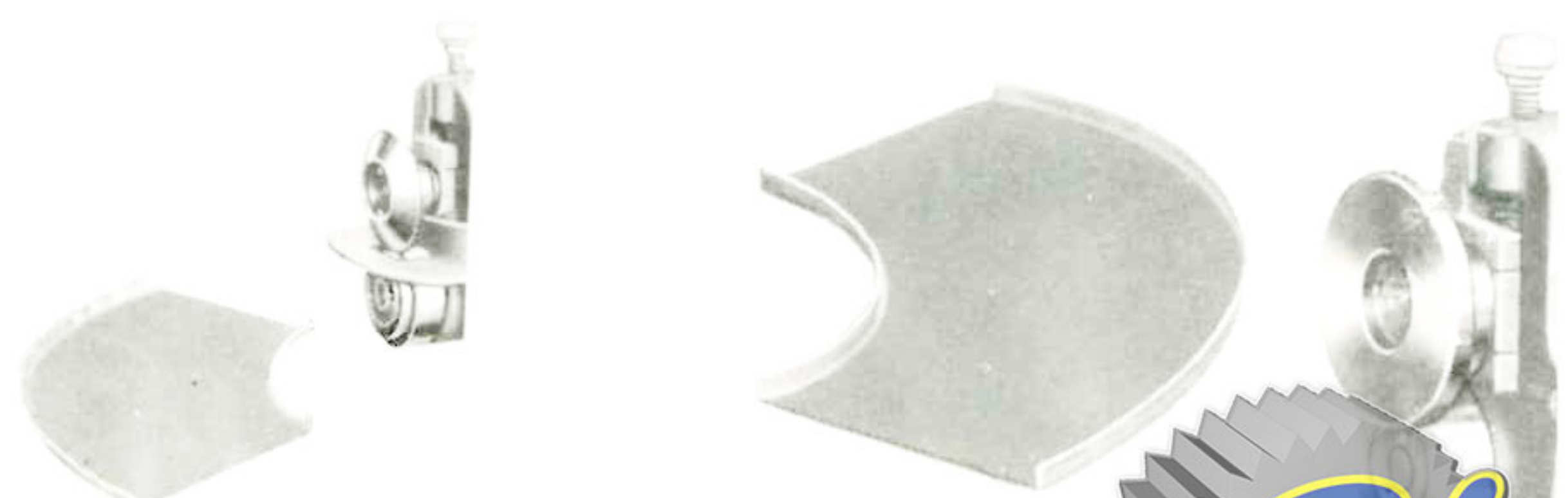
Flanging machine with L rolls. (Max. 3/8" flange).

7544 —2nd operation.

Flanging machine with M rolls.

"L" Flanging rolls with curved gauge.

"M" Flattening rolls.

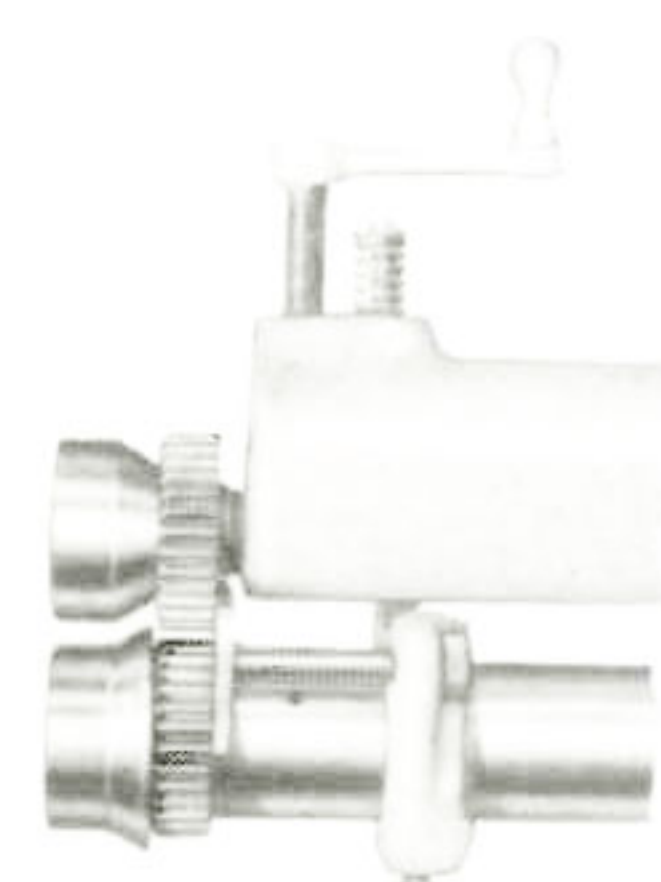
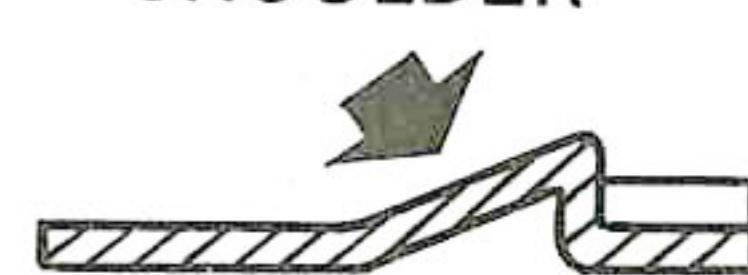


No. 622 Series

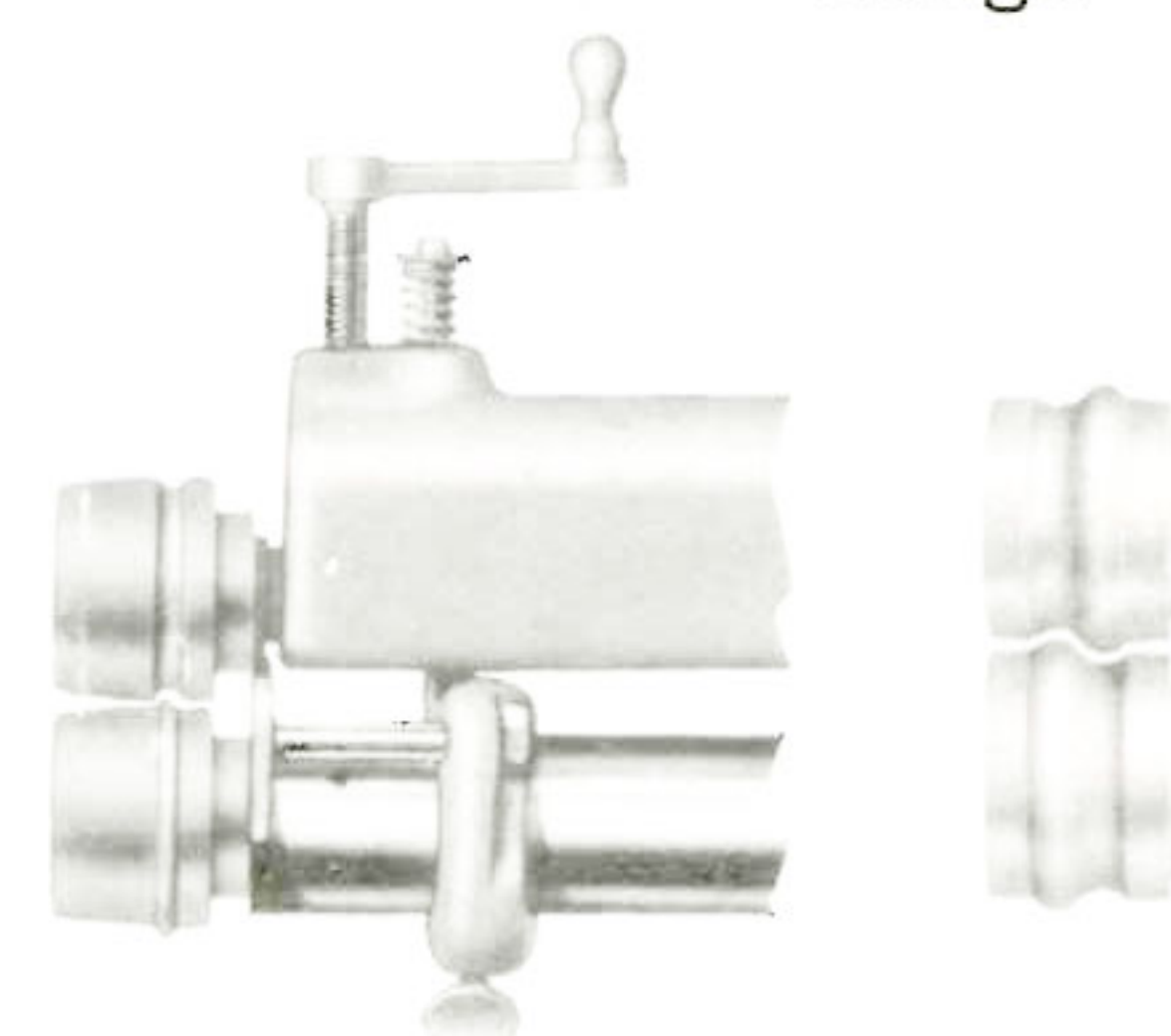
A combination Rotary Machine embodying all the features of the Throatless Machine with the added features of a 7" throat, and arbors designed to utilize crimping, beading, furnace collar edging and offset rolls. Furnished with A, C, D, E and F rolls. See Roll Chart 2" centers for rolls available.

Number	620	621	622
Capacity.....gauge	24	24	24
Capacity crimping only.....gauge			26
Depth of throat to frame.....ins.	7	7	7
Distance between shaft centers....ins.	2	2	2
Shipping weight, boxed....approx. lbs.	48	48	50

NOTE HIGH FLAT
SHOULDER



No. 621



No. 620

No. 621 Furnace Collar Edging Machine (Furnished with Furnace Collar Edging Rolls and crimping gauge.)

No. 620 Beading Machine (Furnished with 1/4" single bead and 3/4" Ogee Bead Rolls.)

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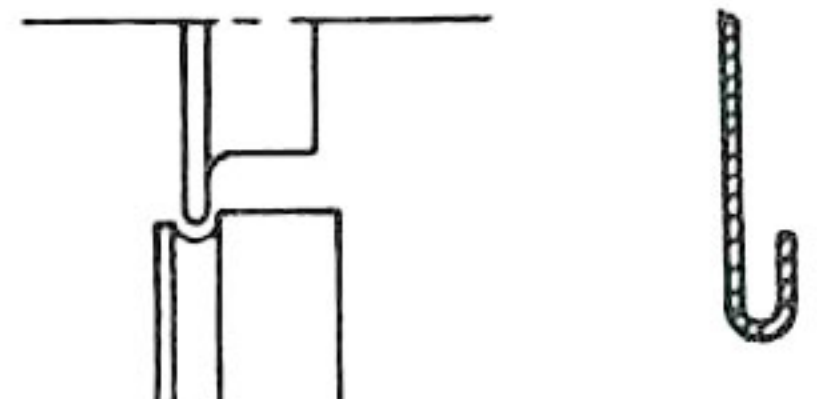
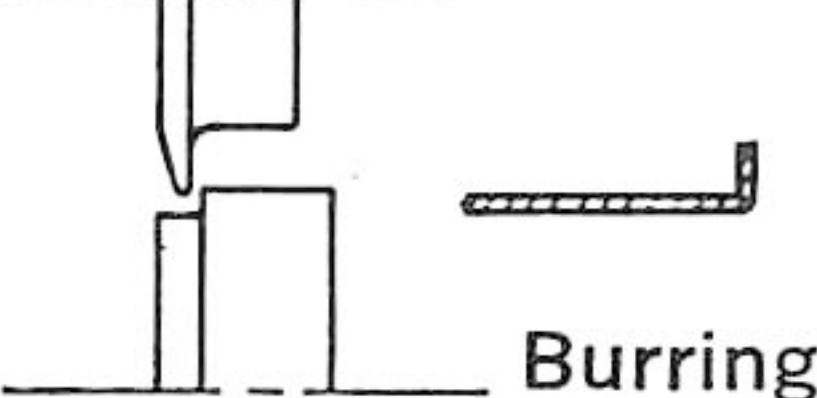
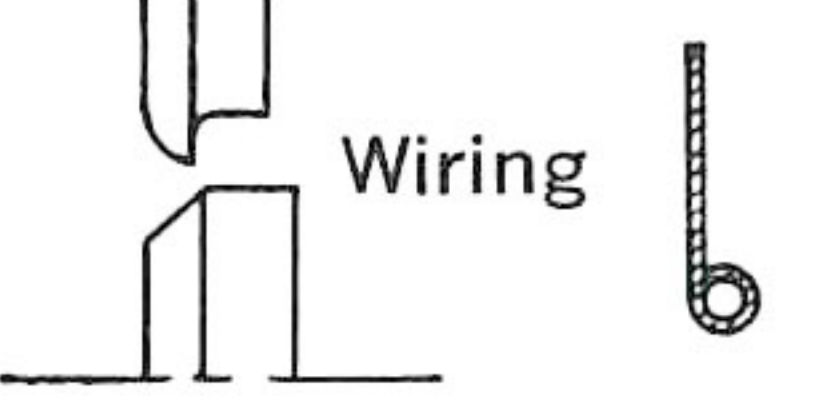
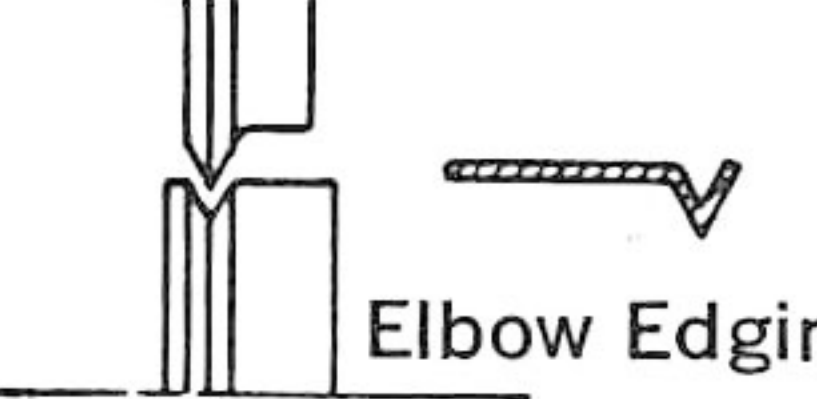
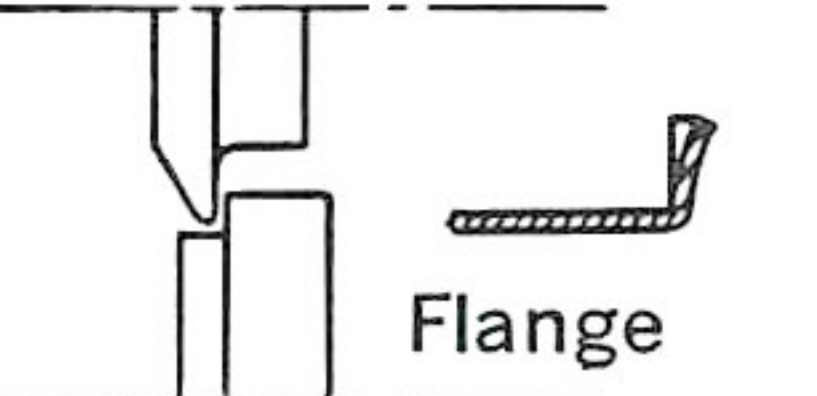
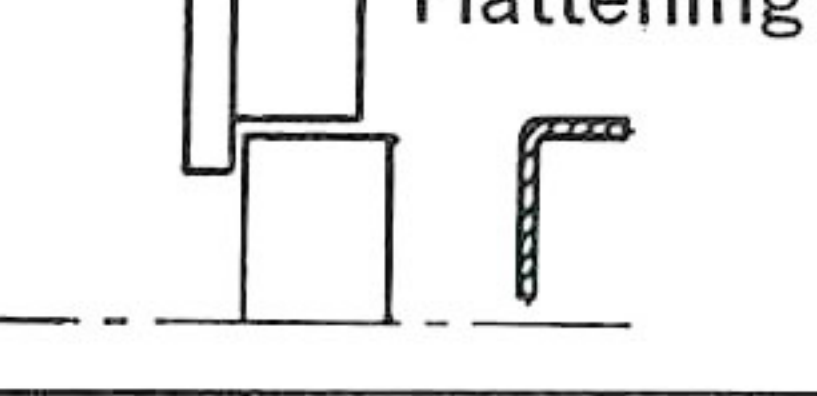
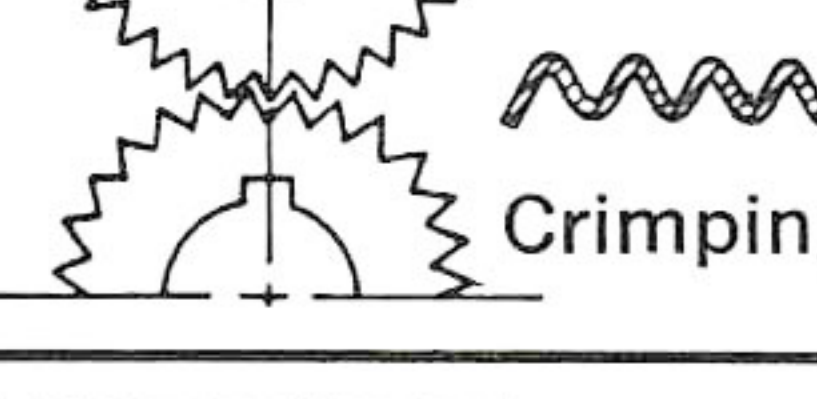
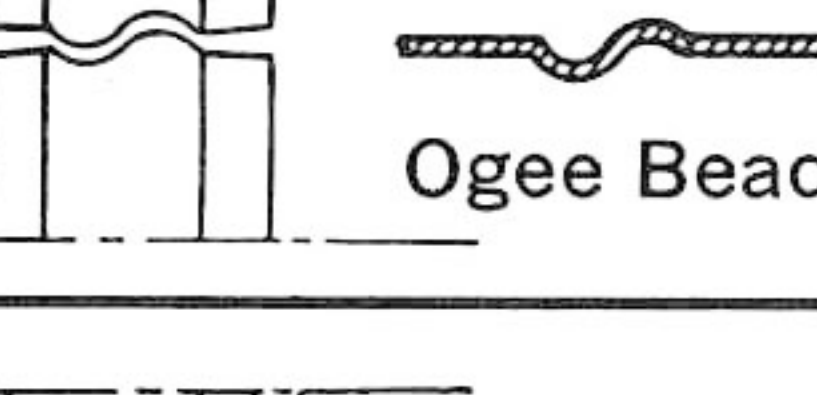
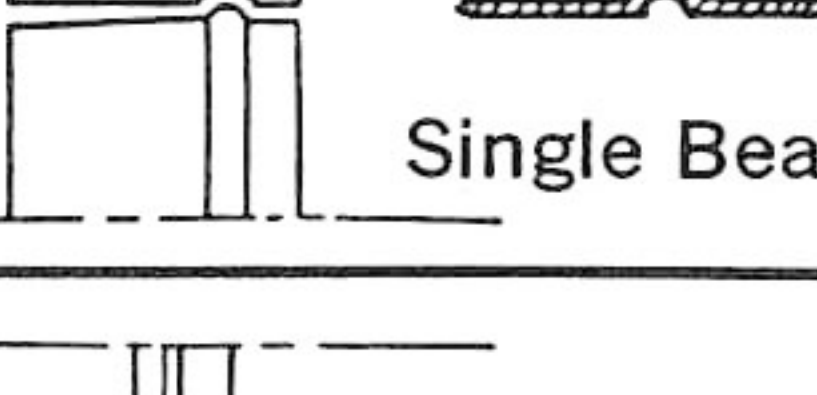
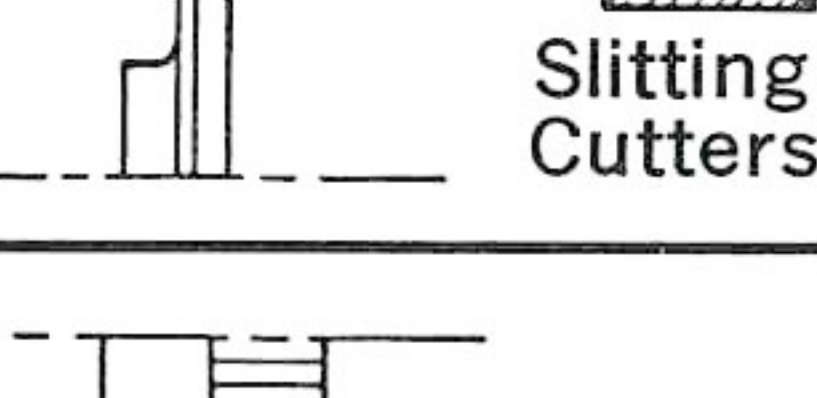


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PEXTO

Roll Chart for Rotary Machines

Roll Chart for Rotary Machines—(2" Centers)

CM 250—(2½" Centers) & 1627—(3" Centers)

NAME	PART NUMBER	GAUGE REQUIRED— FOR USE ON SERIES		ROLL DIAGRAM	PART NUMBERS		GAUGE REQUIRED		SPACING COLLARS	
		544	620-1-2		CM250	1627	CM250	1627	CM250	1627
"A" ⅛"	10118 10119	10727	10126	 Turning	⅜" SP-2562 & 63	SP-2473 & 74	Spec. 2252	Spec. 1498	SP 2578	SP 2489
					¼" SP-2564 & 65	SP-2475 & 76	Spec. 2252	Spec. 1498	SP 2578	SP 2489
					⅝" SP-2566 & 67	SP-2477 & 78	Spec. 2252	Spec. 1498	SP 2578	SP 2489
"B" ⅜"	15037 15038	10727	10126							
"C"	10120 10121	10727	10126	 Burring	SP-2568 SP-2569	SP-2479 SP-2480	Spec. 2252	Spec. 1498	SP 2578	SP 2489
"D"	10122 10123	10727	10126	 Wiring	SP-2570 SP-2571	SP-2481 SP-2482	Spec. 2252	Spec. 1498	SP 2578	SP 2489
"No. 1"	15039 15040	10727 or 15825	10126	 Elbow Edging	SP-2595 SP-2596	SP-2606 SP-2607	Spec. 1352	Spec. 1497	SP 2578	SP 2489
"L"	15053 15054	14637	Spec. 1541	 Flange	3B-15271 3B-15272	3B-15045 3B-15046	Spec. 2263	Spec. 2186	SP 2578	SP 2489
"M"	15055 15056	None	None	 Flattening	3B-15273 3B-15274	3B-15047 3B-15048	None	None	SP 2578	SP 2489
"E"	10124 10125	Not Avail.	10127	 Crimping	¼" SP-2572 SP-2573 ⅝" SP-2574 SP-2575	¼" SP-2485 SP-2486 ⅝" SP-2483 SP-2484	Spec. 2253	Spec. 1498 & 1499	SP 2579	SP 2490
"F" ¾"	10152 10153	Not Avail.	10130	 Ogee Bead	⅝" SP-2576 SP-2577	⅝" SP-2487 SP-2488	Spec. 2252	Spec. 1498	SP 2578	SP 2489
"G" ¼"	11106 11107	Not Avail.	10130	 Single Bead	⅜" SP-2603 SP-2604 ½" 3B-13160 3B-13161	⅝" SP-2614 SP-2615	Spec. 2252	Spec. 1498	SP 2579	SP 2490
"H"	SP2445 SP2446	Not Avail.	10126	 Slitting Cutters	SP-2583	SP-2495	Spec. 2252	Spec. 1498	SP 2584	SP 2496
"N"	A-51258 A-51259 A-51260 (2 Req'd)	Not Avail.	10127	 Furnace Collar Edging	A-51253 A-51554 A-51255 A-51256	A-5230 A-5231 A-5232 A-5233	Spec. 2253	Spec. 1498 & 1499	SP 2579	SP 2490
"P"	A-6512 A-6513	Not Avail.	10127	 Offset	A-6514 A-6515	A-6377 A-6378	Spec. 2251	Spec. 2250	SP 2579	SP 2490

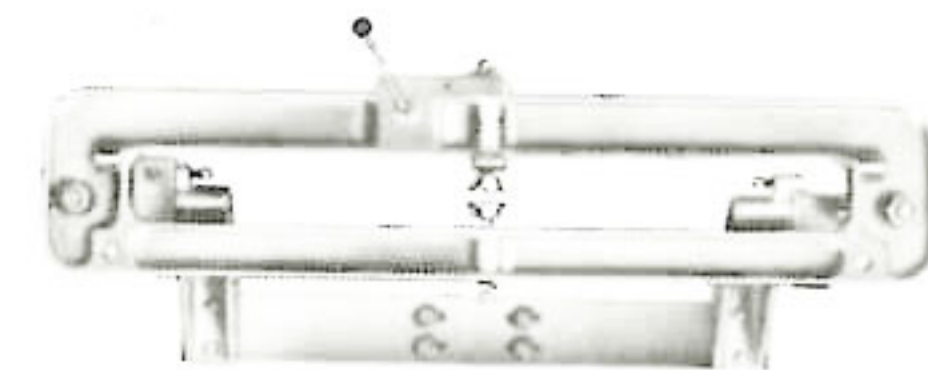
power combination rotary machines

No. CE-300 Spin Collar Machine

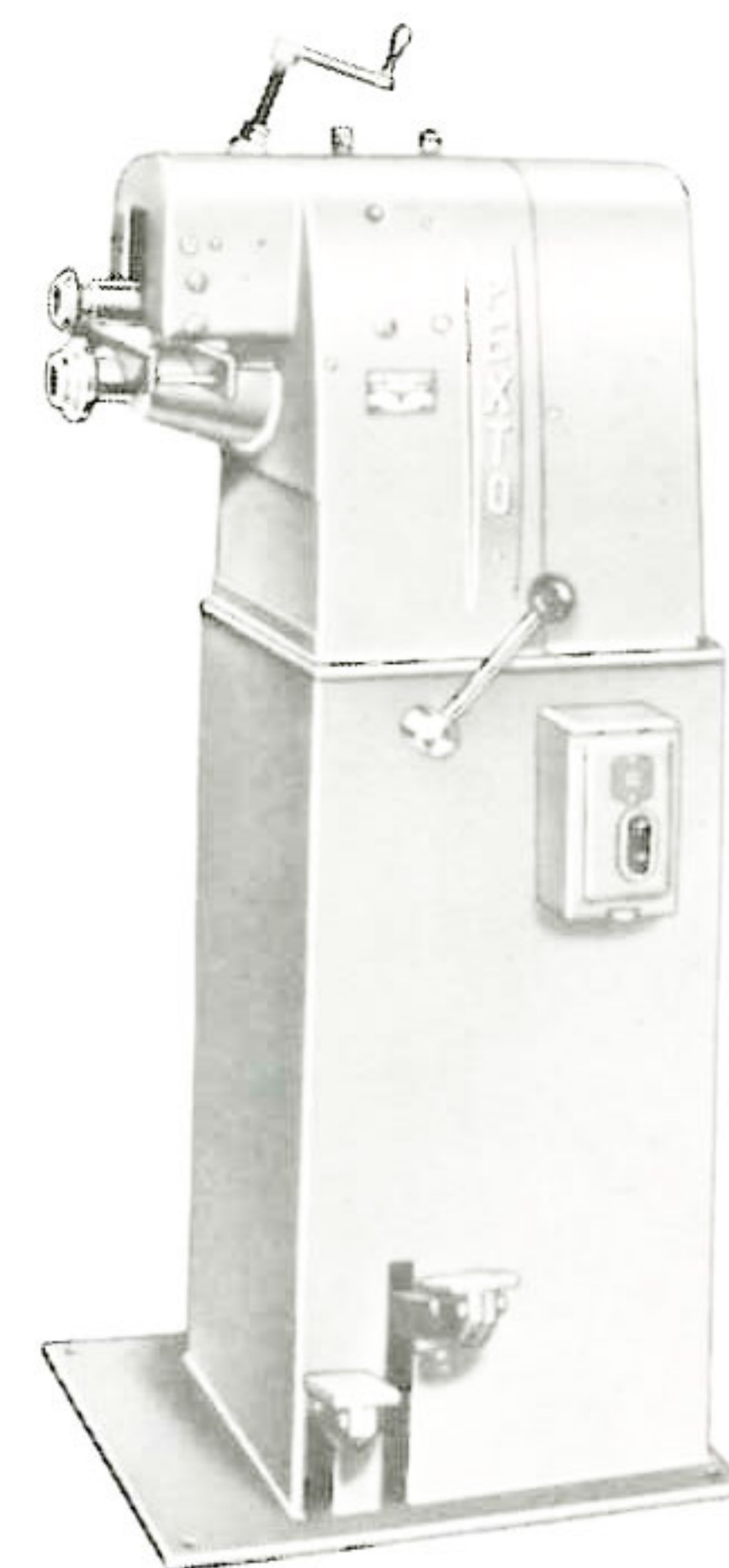
Provides the easiest, fastest method available for connecting round pipe to rectangular duct. Eliminates unnecessary time spent fitting and closing collar edges formed by other methods. Complete with tooling, ready to form spin edge in one operation on 22 to 30 gauge galvanized steel. Minimum diameter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

Number	CE-300
Roll speed.....r.p.m.	78
Capacity.....gauge	22 to 30
Minimum diameter.....ins.	5
Diameter of rolls.....ins.	3
Standard electrics.....115 volt, single phase, 60 hertz	
Motor.....h.p.	1/2
Shipping weight, crated.....approx. lbs.	330
Length.....ins.	21
Height.....ins.	17
Width.....ins.	50

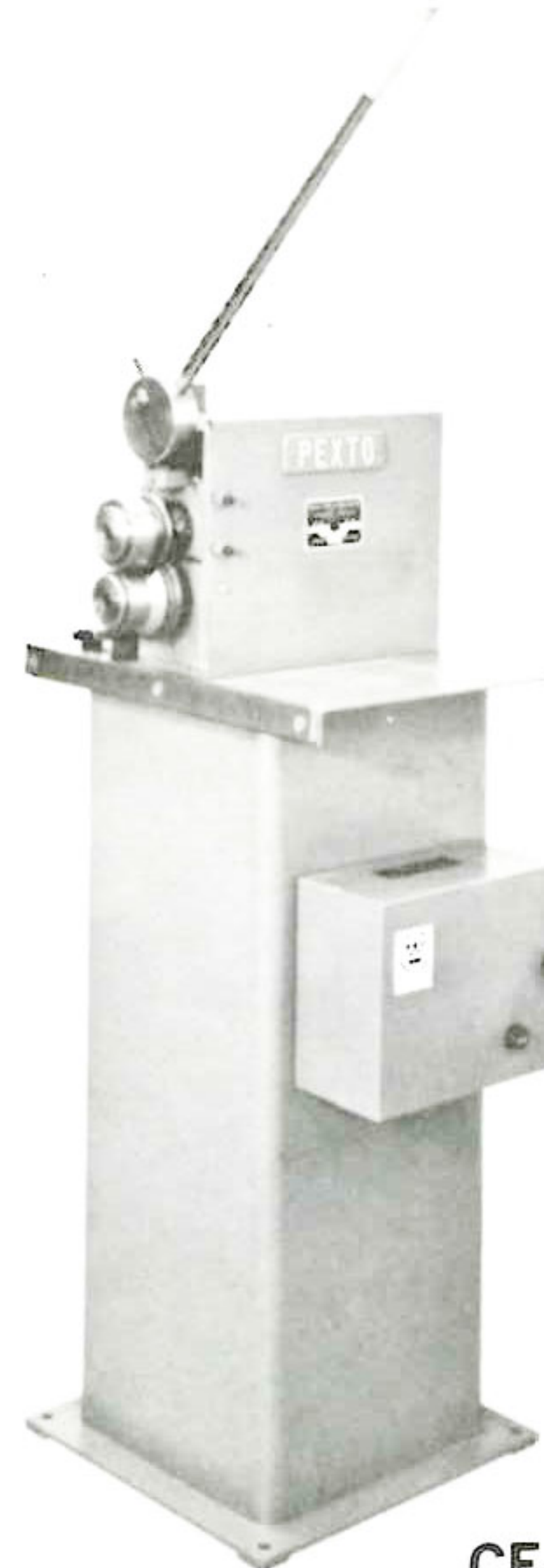
CIRCLE CUTTING AND FLANGING ATTACHMENT



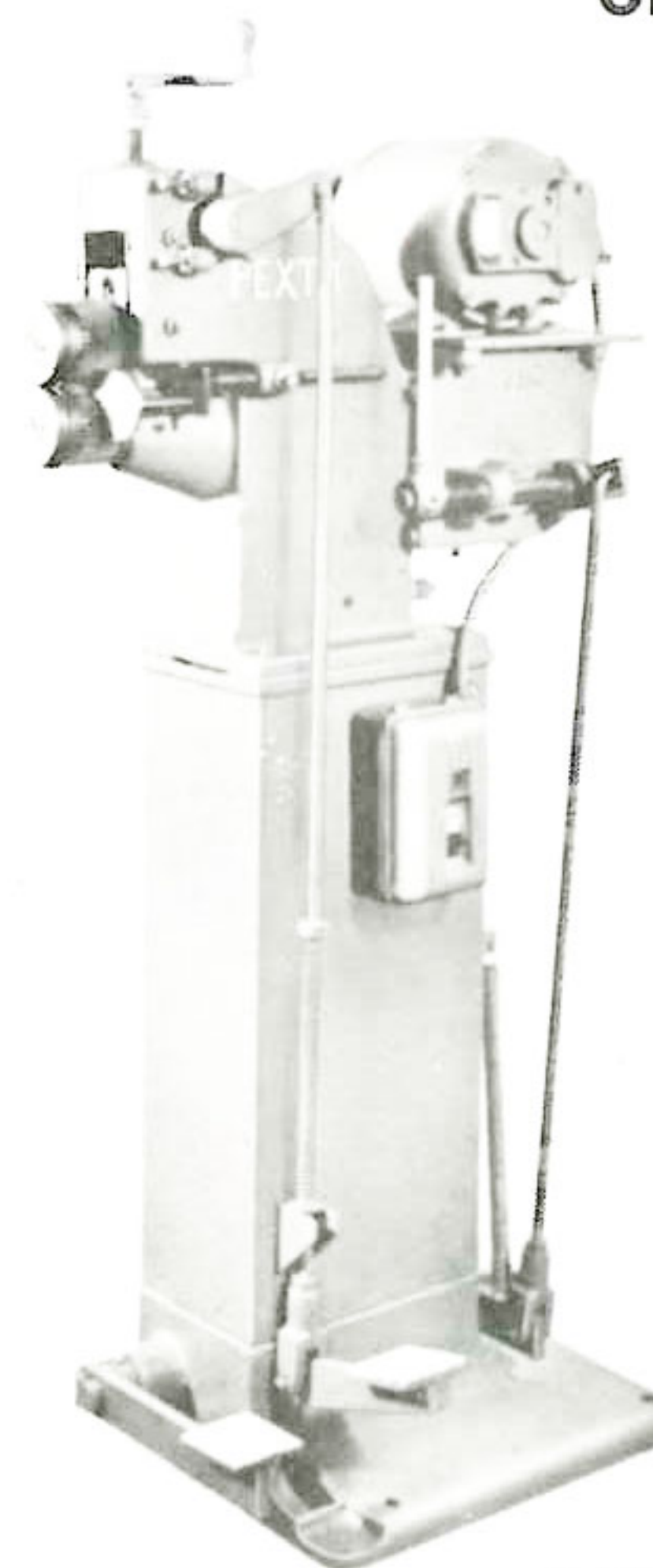
Combination circle and flanging attachment for cutting circles 4" to 24" from square blanks—flanging 3 1/2" to 36".



CM-250



CE-300



1627

CM-250 Power Combination Rotary Machine 2 1/2" DIAMETER ROLLS

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

CLUTCH—Multiple disc Maxitorq 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 1/2 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	CM-250
Crimping and beading.....gauge	22
Crimping only.....gauge	18
Beading only.....gauge	18
Turning, burring, wiring, edging, flanging.....gauge	18
Slitting and circle cutting.....gauge	16
Maximum height of flange*.....gauge	1 1/2" in 18
Flanging.....ins.	3 1/2 to 36
Circle cutting (from square blanks).....ins.	4 to 24
Arbor diameter in bearings.....ins.	1 1/4
Roll speed (standard).....r.p.m.	26
Depth of throat from end of arbors to frame.....ins.	7 1/2
Motor (1800 r.p.m.).....h.p.	1/2
Shipping weight:	
machine.....approx. lbs.	450
flanging attachment.....approx. lbs.	195
Length.....ins.	23
Height.....ins.	50
Width.....ins.	18

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

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	1627
Capacity crimping and beading.....gauge	18
Capacity crimping only or beading only.....gauge	16
Capacity, turning, burring, wiring, elbow edging.....gauge	16
Capacity slitting.....gauge	14
With circular cutting and flanging attachment will cut from square blanks*.....ins.	8 to 13 1/2
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.	6 1/2
Motor—1800 r.p.m.....h.p.	3/4
Shipping weight, crated.....approx. lbs.	550
Length.....ins.	27
Height.....ins.	57
Width.....ins.	22

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

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