



Tri-Roller Swaging Tool Instructions

Setup instructions

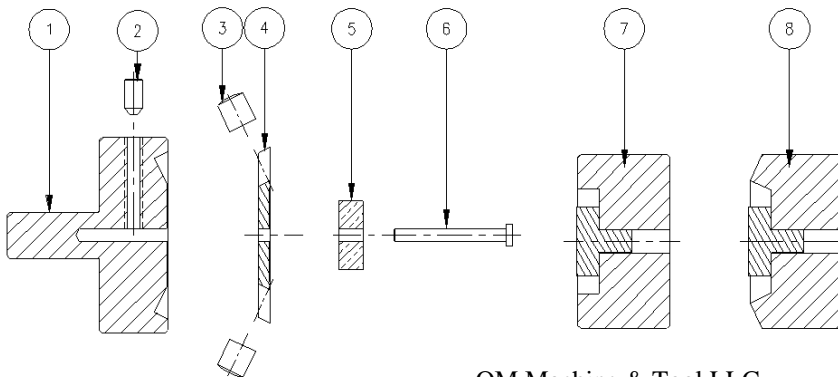
- A) Install tri-roller swaging tool (1) into drill press chuck or vertical milling machine.
- B) Adjust spindle speed - recommend approximately 50 rpm for initial pieces.
(Note: This can later be increased up to 250 rpm, once operator proficiency has been developed).
- C) Install bearing into housing per the drawing specification.

Operating instructions

- A) Position part (sub-assembly – bearing & housing) on the flat surfaced locating fixture (7) in bearing bore.
- B) With part resting on locating fixture slowly lower the spindle — ensuring roller fixture bushing is piloted into the bearing bore.
- C) Start spindle and apply light pressure for initial revolutions to allow rollers to center in bearing groove.
- D) Repeat 1-2 times applying normal arm pressure and maintain swaging tool engagement for approximately 5 seconds
- E) Release pressure and withdraw tool from bearing/housing sub-assembly.
- F) Inspect swage per the requirements of the drawing or swaging specification.
- G) Repeat steps D through F until swage is complete.
- H) Turn sub-assembly over and repeat steps A thru G to complete swaging on opposite side except use angled (conical) surfaced locating fixture (8) for this operation.

Note:

- Do not grease rollers or bearing lip - Use light machine oil only.
- Clean debris from tool rollers frequently using an air gun.
- If application requires installation with sealant or primer, remove excess from bearing groove prior to swaging.



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