

SIPTM
SIMPLEX IDEAL PEERLESS



SIMPLEX 5000
ROTARY BLADE MILL
MANUAL

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PART NUMBER 20095-01

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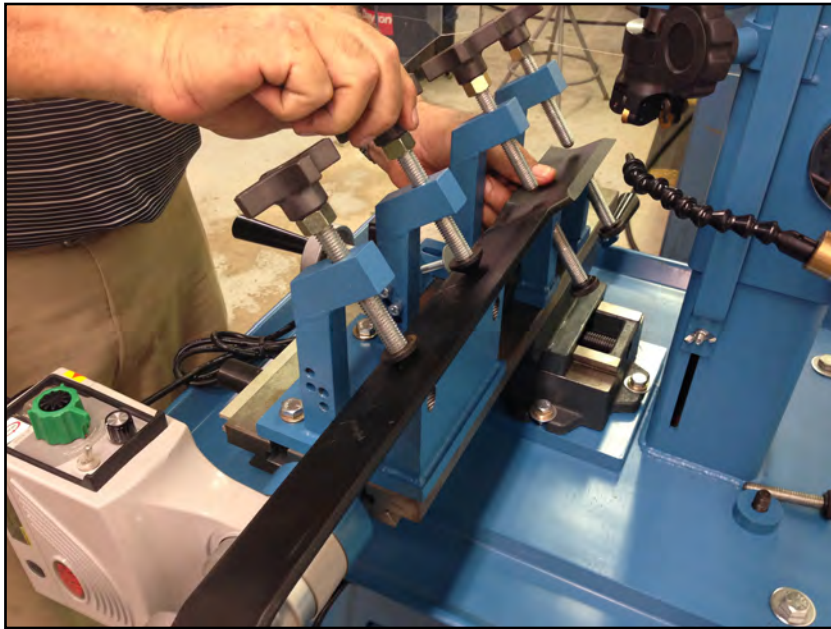
INSTRUCTIONS



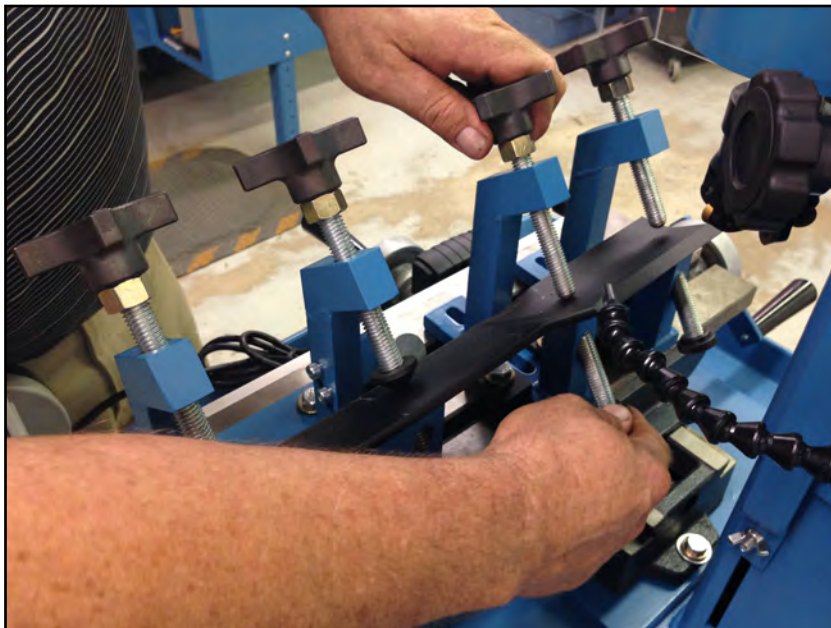
Place the rotary blade in the fixture and tighten the cone tipped clamp into the mounting hole of the rotary blade.



Adjust the support bolt so the rotary blade cutting edge is parallel to the milling table travel. Then lock it in place with the wing nut.



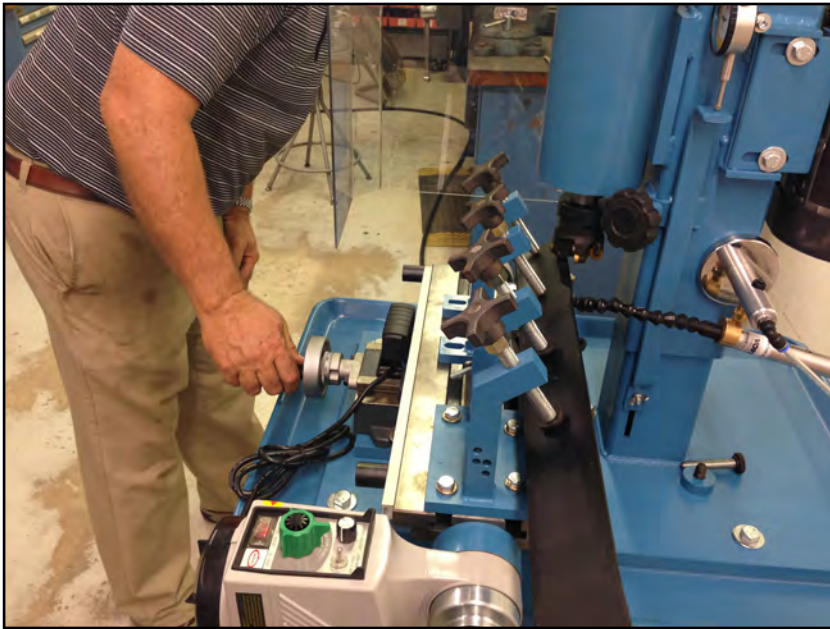
Then tighten the second cone tipped clamp on to the rotary blade. Make sure the blade stays in contact with the locating stop.



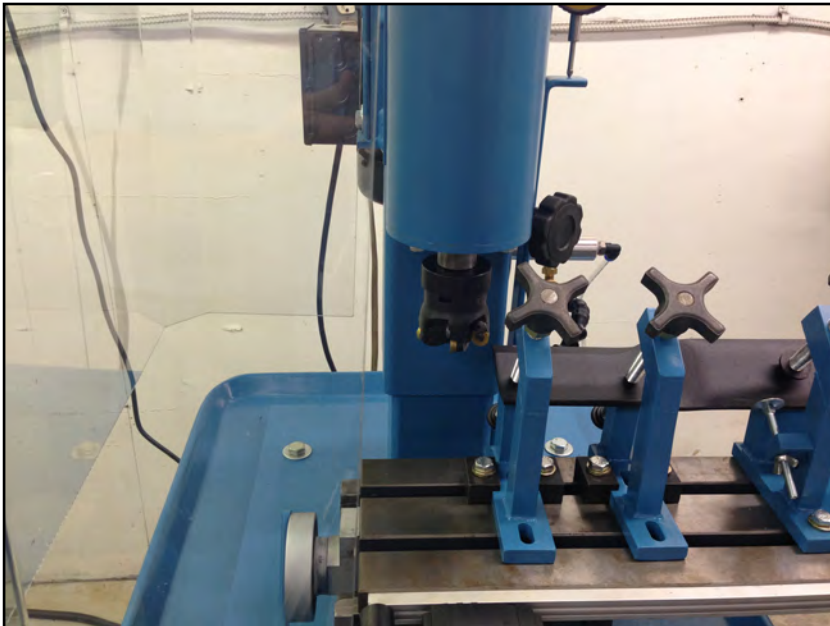
Adjust the support screws up to the bottom of the blade until they just touch, then tighten the top clamp screws.



Adjust the head up or down until the milling inserts just touch the milled surface of the rotary blade.



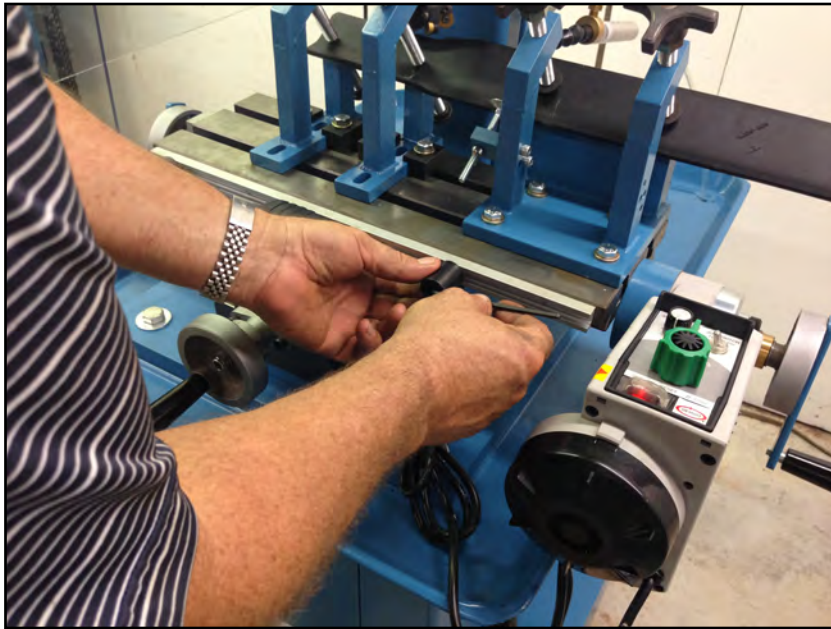
Feed the mill table in or out until the milling cutter overlaps the surface on the rotary blade to be milled.



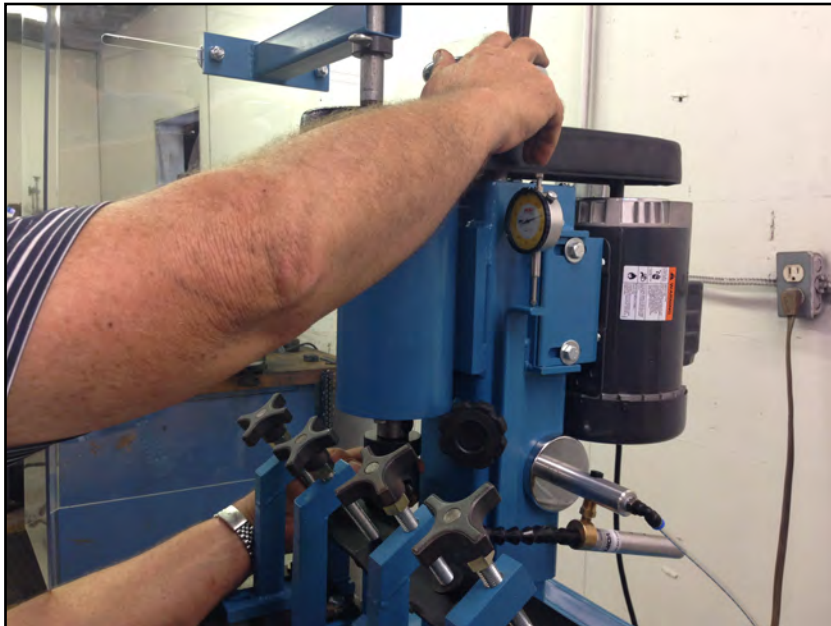
Feed the milling table so the rotary blade is just off the end of the milling cutter.



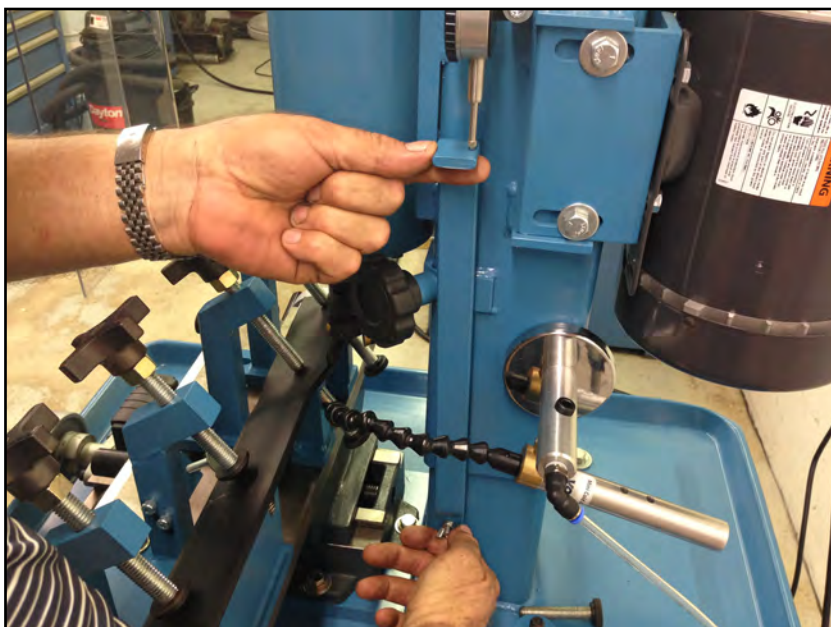
Set the first travel stop.



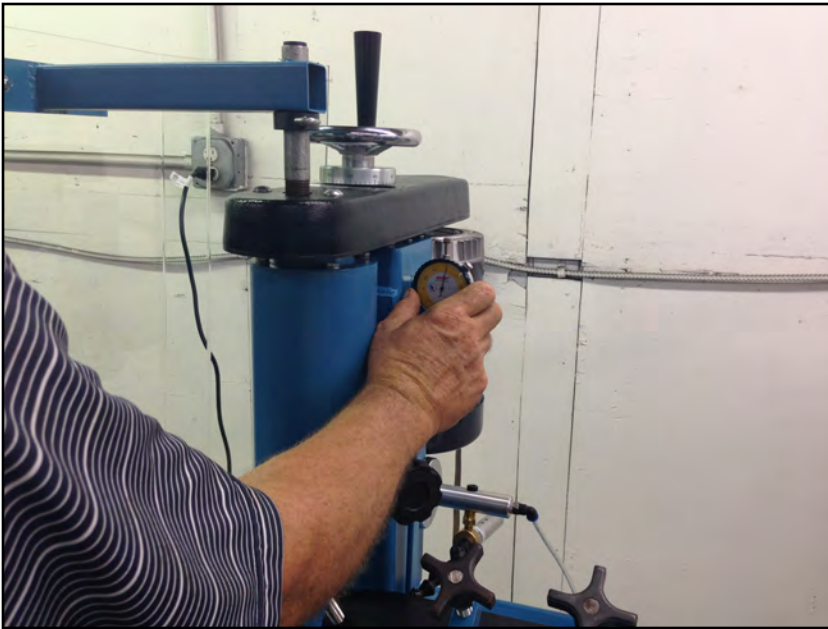
With the milling table positioned at the end of the milled section of the rotary blade, set the second travel stop.



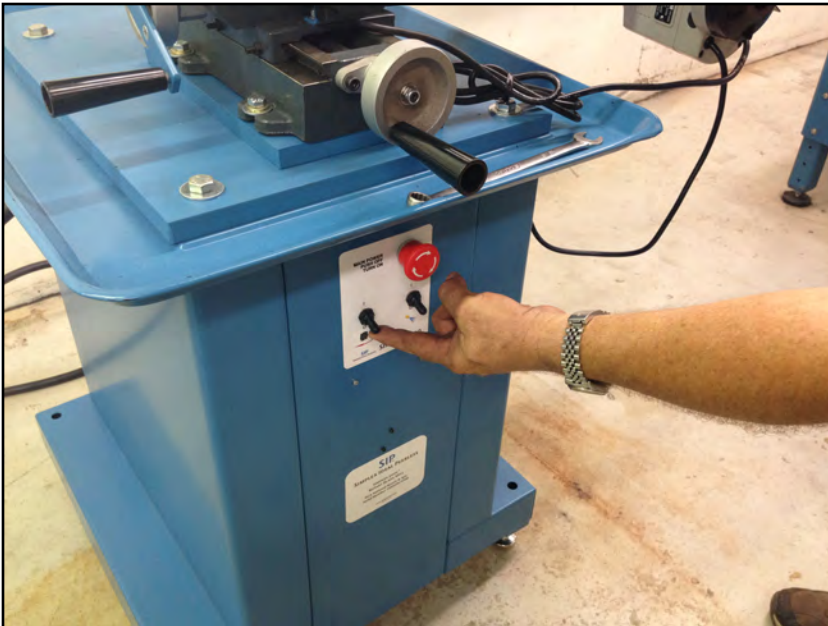
Adjust the head so the milling cutter is just touching the rotary blade.



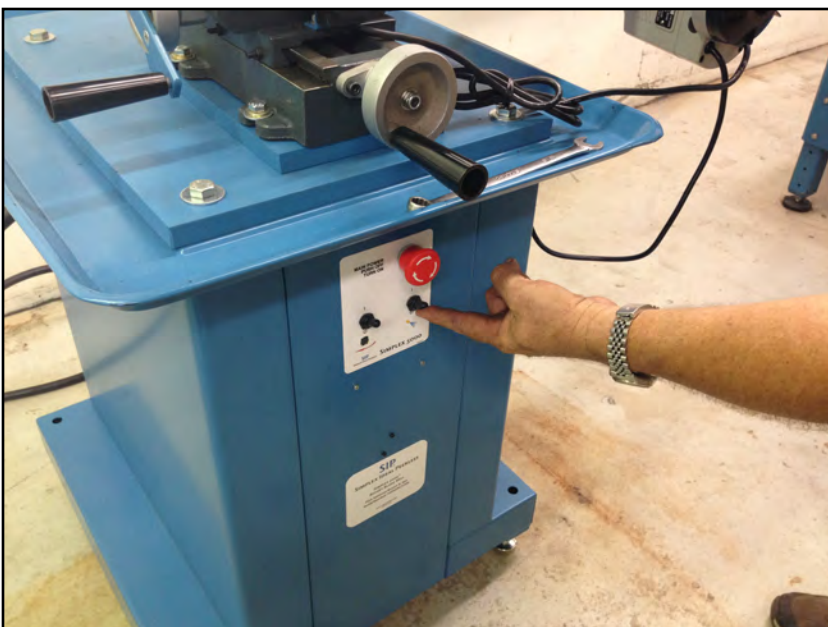
Adjust the dial indicator stop so the dial indicator reads close to zero.



Set the dial indicator so it reads exactly zero.



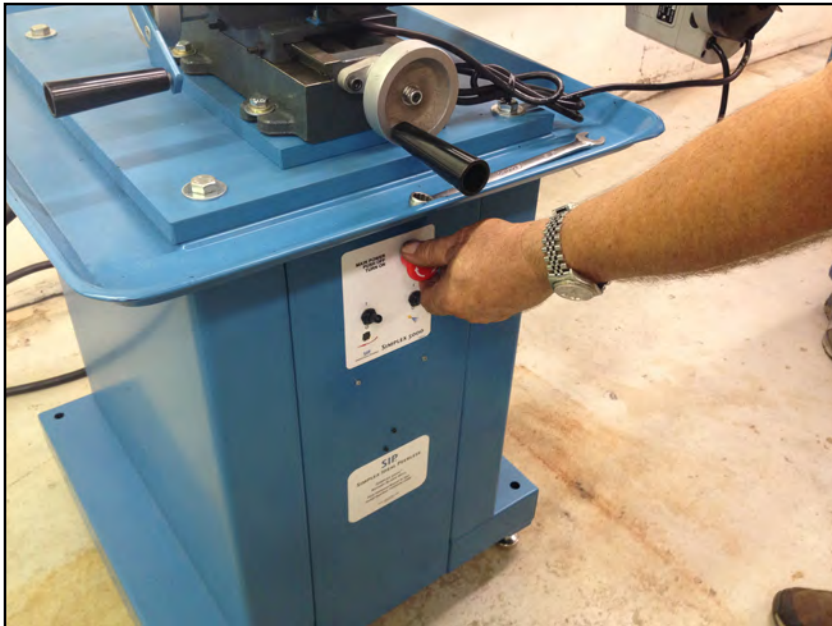
Set the milling motor switch to on.



Set the air cooling switch to on.



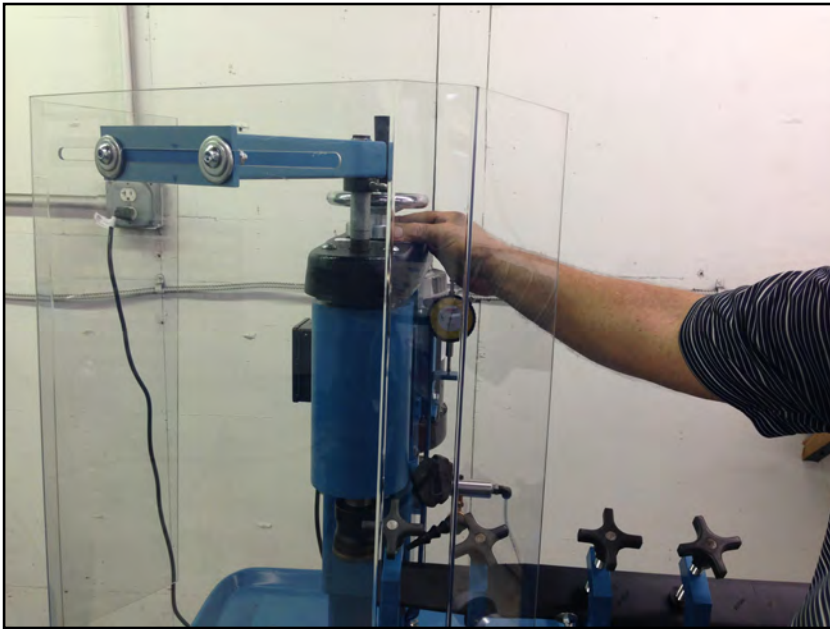
Close the shield.



Turn on the main power.



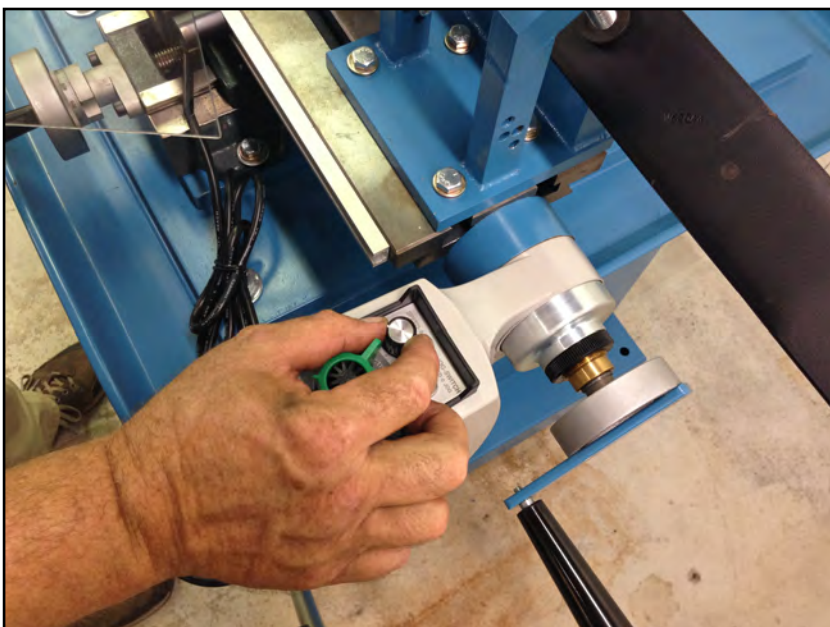
Turn on the power to the power feed.



Infeed the milling head the desired amount.



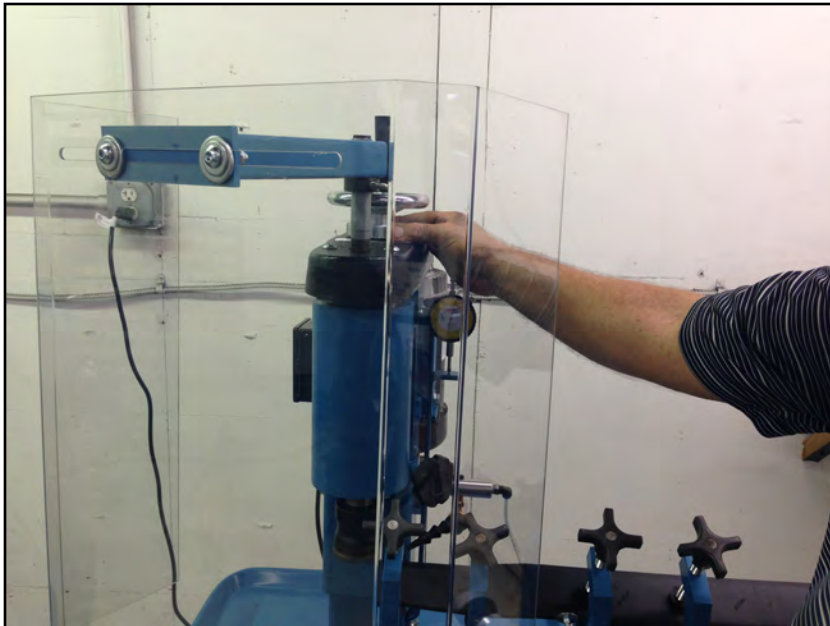
Turn the travel direction on.



Set the travel speed.



When the milling table has stopped, reverse the power feed until the milling cutter clears the rotary blade.



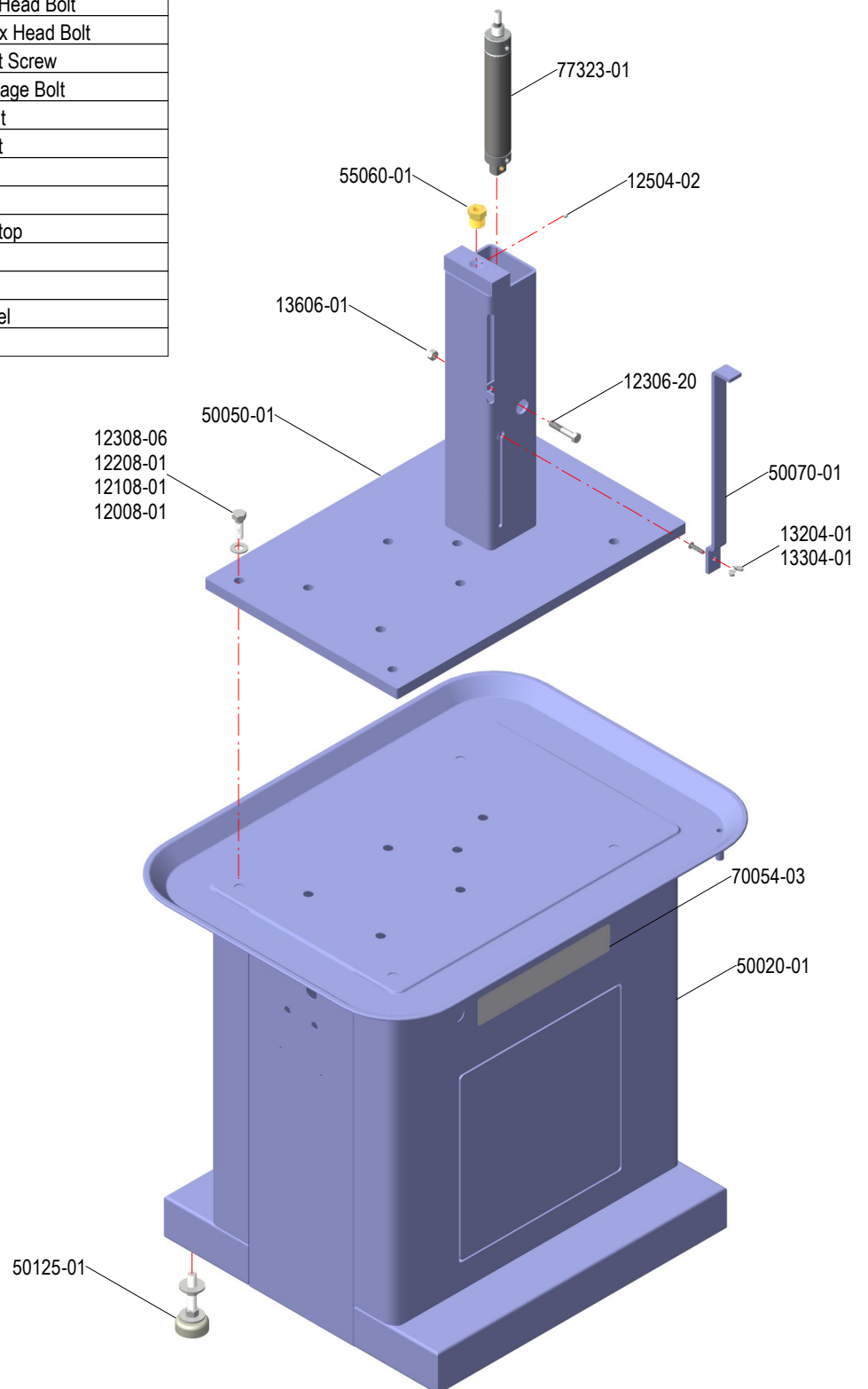
In feed the milling head and repeat until the rotary blade is sharp.



Push the power button to turn the mill off. Remove the blade and remount it for the other end and repeat.

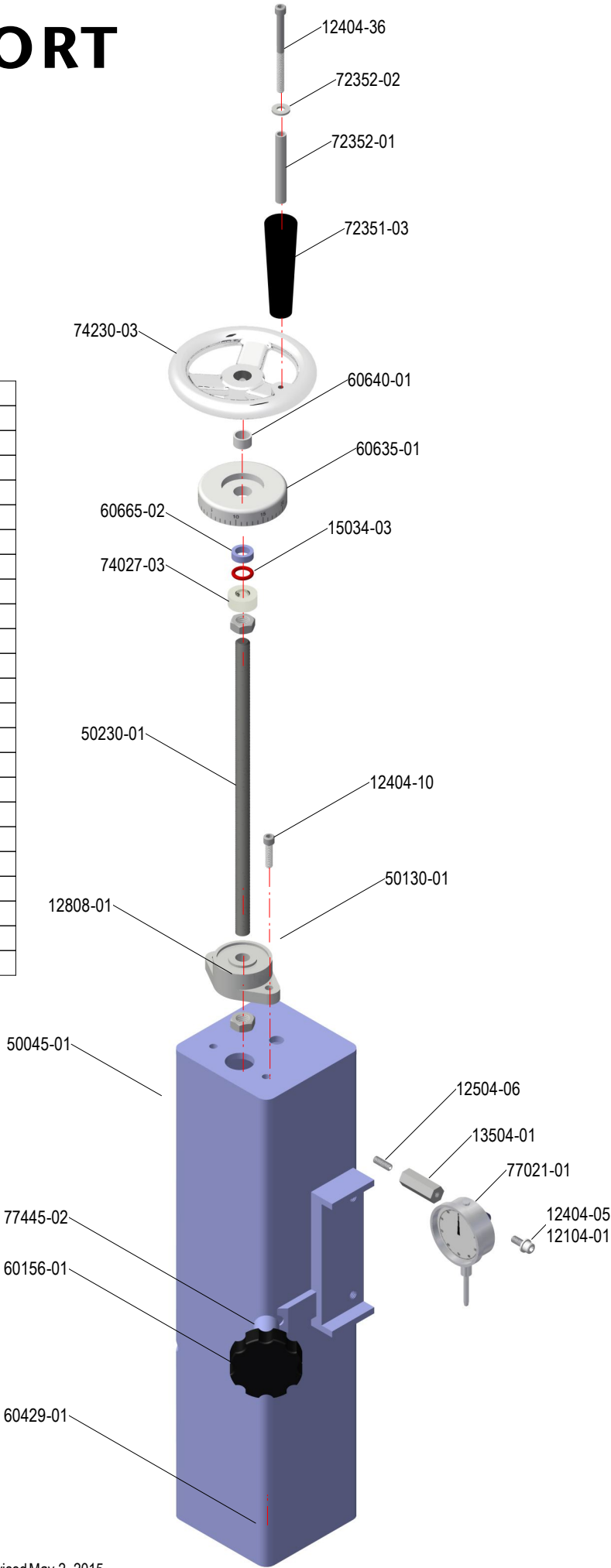
BASE

Part Number	Quantity	Description
12008-01	1 each	1/2-13 Nut
12108-01	4 each	1/2 Lock Washer
12208-01	8 each	1/2 Washer
12306-20	1 each	3/8-16 x 2 Hex Head Bolt
12308-06	4 each	1/2-13 x 3/4 Hex Head Bolt
12504-02	1 each	1/4-20 x 1/4 Set Screw
13204-01	1 each	1/4-20 x 1 Carriage Bolt
13304-01	1 each	1/4-20 Wing Nut
13606-01	1 each	3/8-16 Lock Nut
50020-01	1 each	Table
50050-01	1 each	Base
50070-01	1 each	Dial Indicator Stop </td
50125-01	4 each	Foot Pad
55060-01	1 each	Feed Nut
70054-03	2 each	Face Plate Label
77323-01	1 each	Air Cylinder

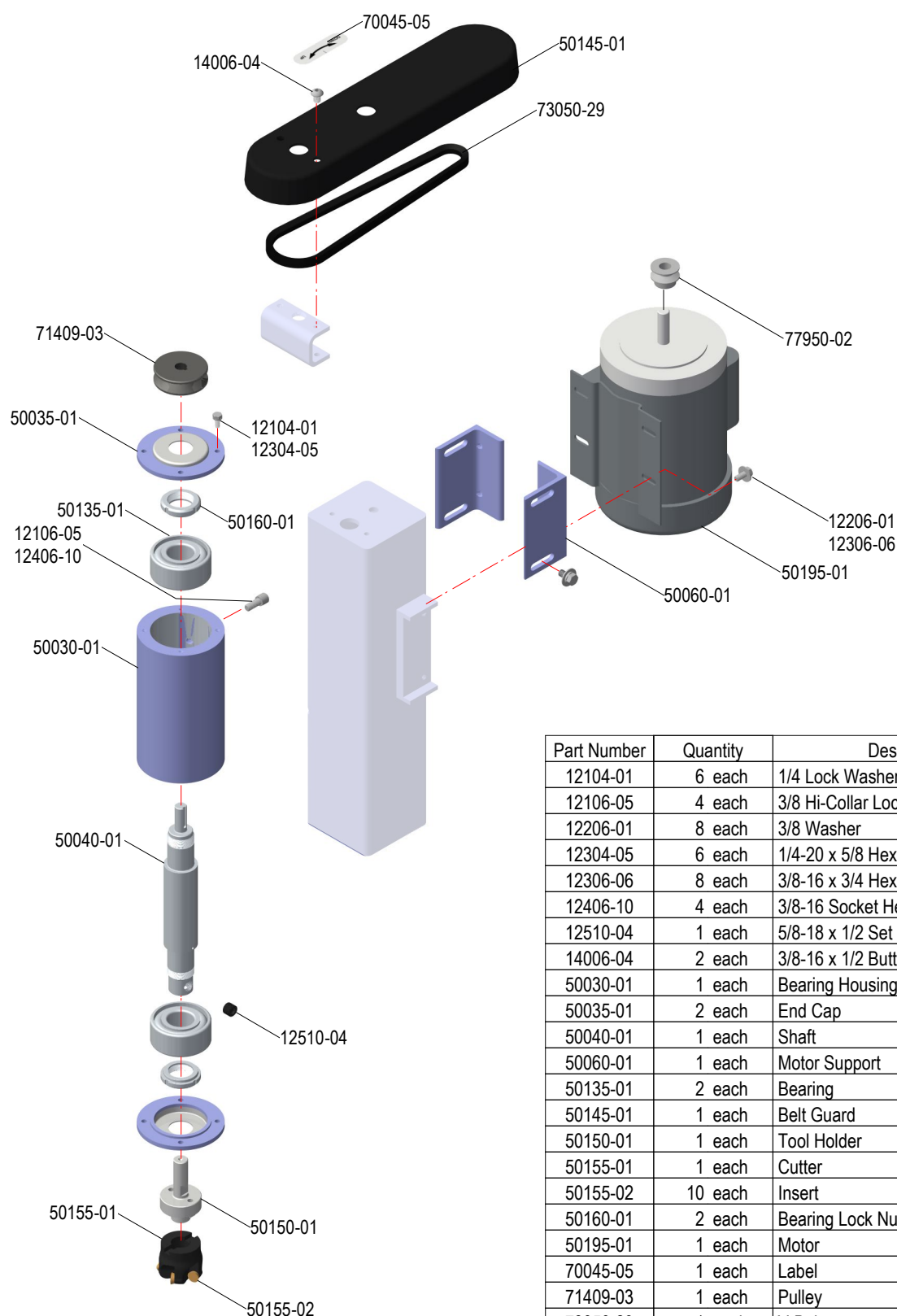


MILL HEAD SUPPORT

Part Number	Quantity	Description
12104-01	1 each	1/4 Lock Washer
12404-05	1 each	1/4-20 x 5/8 Socket Head Bolt
12404-10	2 each	1/4-20 x 1 Socket Head Bolt
12404-36	1 each	1/4-20 x 3-3/4 Socket Head Bolt
12504-06	1 each	1/4-20 x 3/4 Set Screw
12808-01	2 each	1/2-13 Hex Jam Nut
13504-01	1 each	1/4-20 Coupling Nut
15034-03	1 each	O-ring
50045-01	1 each	Ajustable Vertical Tube
50130-01	1 each	Flanged Bearing
50230-01	1 each	Feed Screw
60156-01	1 each	Clamp
60429-01	1 each	Clamp Nut
60635-01	1 each	Hand Wheel Dial
60640-01	1 each	Bushing
60665-02	1 each	Spacer
72351-03	1 each	Handle
72352-01	1 each	Tube
72352-02	1 each	Spacer
74027-03	1 each	Collar
74230-03	1 each	Hand Wheel
77021-01	1 each	Dial Indicator
77445-02	1 each	Spacer

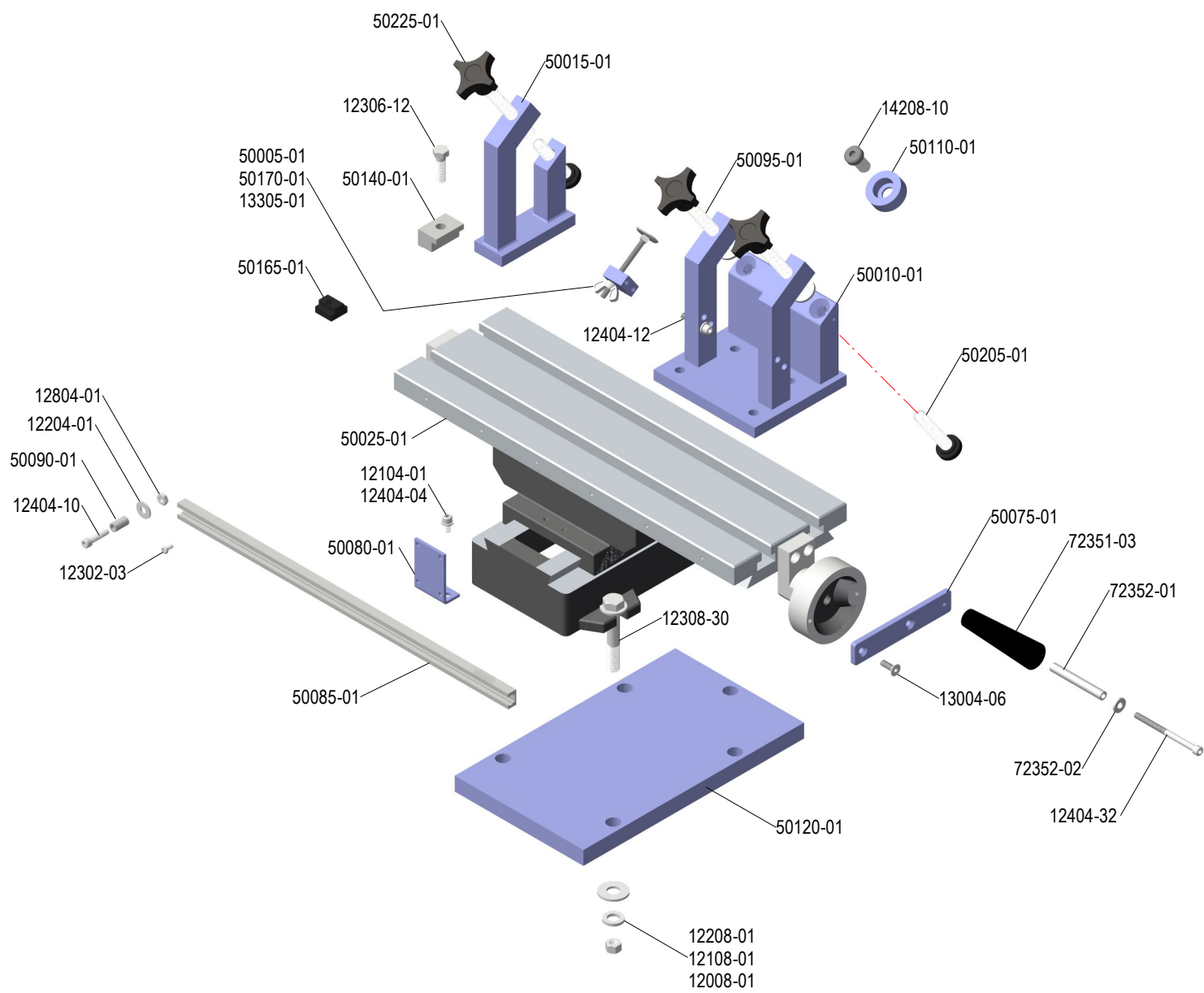


MILL HEAD



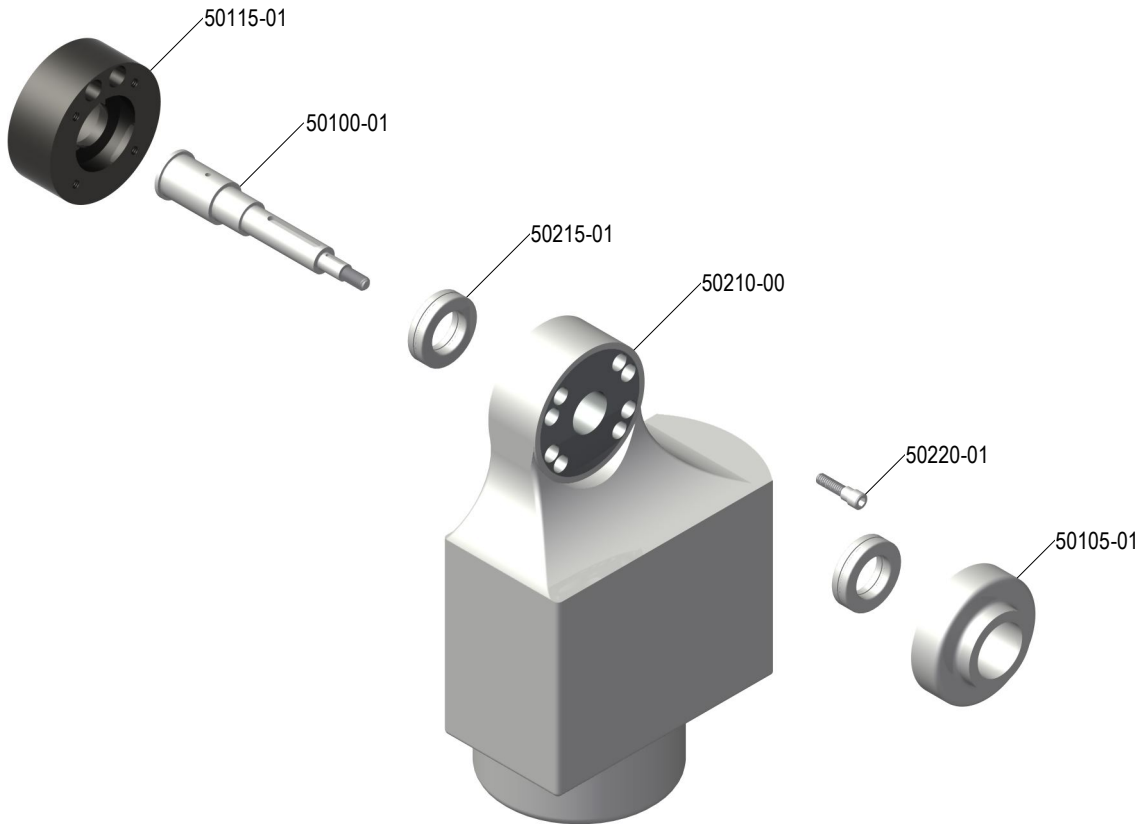
Part Number	Quantity	Description
12104-01	6 each	1/4 Lock Washer
12106-05	4 each	3/8 Hi-Collar Lock Washer
12206-01	8 each	3/8 Washer
12304-05	6 each	1/4-20 x 5/8 Hex Bolt
12306-06	8 each	3/8-16 x 3/4 Hex Head Bolt
12406-10	4 each	3/8-16 Socket Head Bolt
12510-04	1 each	5/8-18 x 1/2 Set Screw
14006-04	2 each	3/8-16 x 1/2 Button Head Cap Screw
50030-01	1 each	Bearing Housing
50035-01	2 each	End Cap
50040-01	1 each	Shaft
50060-01	1 each	Motor Support
50135-01	2 each	Bearing
50145-01	1 each	Belt Guard
50150-01	1 each	Tool Holder
50155-01	1 each	Cutter
50155-02	10 each	Insert
50160-01	2 each	Bearing Lock Nut
50195-01	1 each	Motor
70045-05	1 each	Label
71409-03	1 each	Pulley
73050-29	1 each	V-Belt
77950-02	1 each	Pulley

BLADE SUPPORT



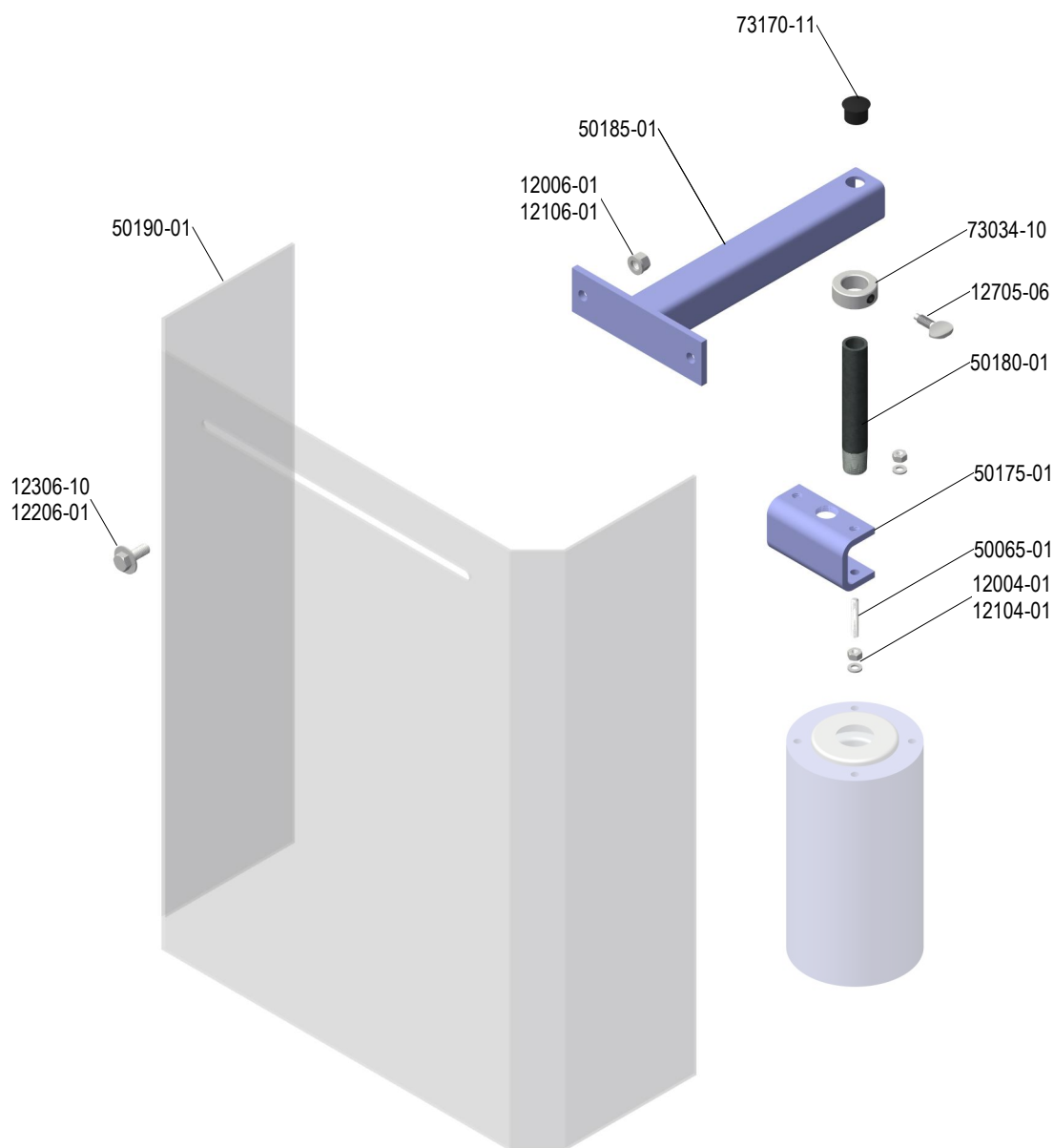
Part Number	Quantity	Description
12008-01	5 each	1/2-13 Nut
12104-01	2 each	1/4 Lock Washer
12108-01	5 each	1/2 Lock Washer
12204-01	4 each	1/4 Washer
12208-01	5 each	1/2 Washer
12302-03	6 each	#8-32 x 3/8 Pan Head Screw
12306-12	8 each	3/8-16 x 1-1/4 Hex Head Bolt
12308-30	5 each	1/2-13 x 3 Hex Head Bolt
12404-04	2 each	1/4-20 x 1/2 Socket Head Bolt
12404-10	2 each	1/4-20 x 1 Socket Head Bolt
12404-12	2 each	1/4-20 x 1-1/4 Socket Head Bot
12404-32	2 each	1/4-20 x 3-1/4 Socket Head Bolt
12804-01	2 each	1/4-20 Hex Jam Nut
13004-06	2 each	1/4-20 x 3/4 Flat Head Screw
13305-01	1 each	5/16-18 Wing Nut
14208-10	1 each	1/2-13 x 1 Low Head Bolt
50005-01	1 each	Stop Bracket
50010-01	1 each	Blade Support
50015-01	2 each	End Support
50025-01	1 each	XY Table
50075-01	2 each	Hand Crank
50080-01	1 each	Stop Bracket
50085-01	1 each	T-Slot
50090-01	2 each	Travel Stop
50095-01	2 each	Clamp Screw with Tip
50110-01	1 each	Blade Adaptor
50120-01	1 each	Spacer Plate
50140-01	4 each	Toe Clamp
50165-01	8 each	T-Slot Nut
50170-01	1 each	Elevator Bolt
50205-01	3 each	Clamp Screw
50225-01	2 each	Clamp Screw
72351-03	3 each	Handle
72352-01	3 each	Handle Spacer
72352-02	3 each	Washer

POWER FEED OPTION



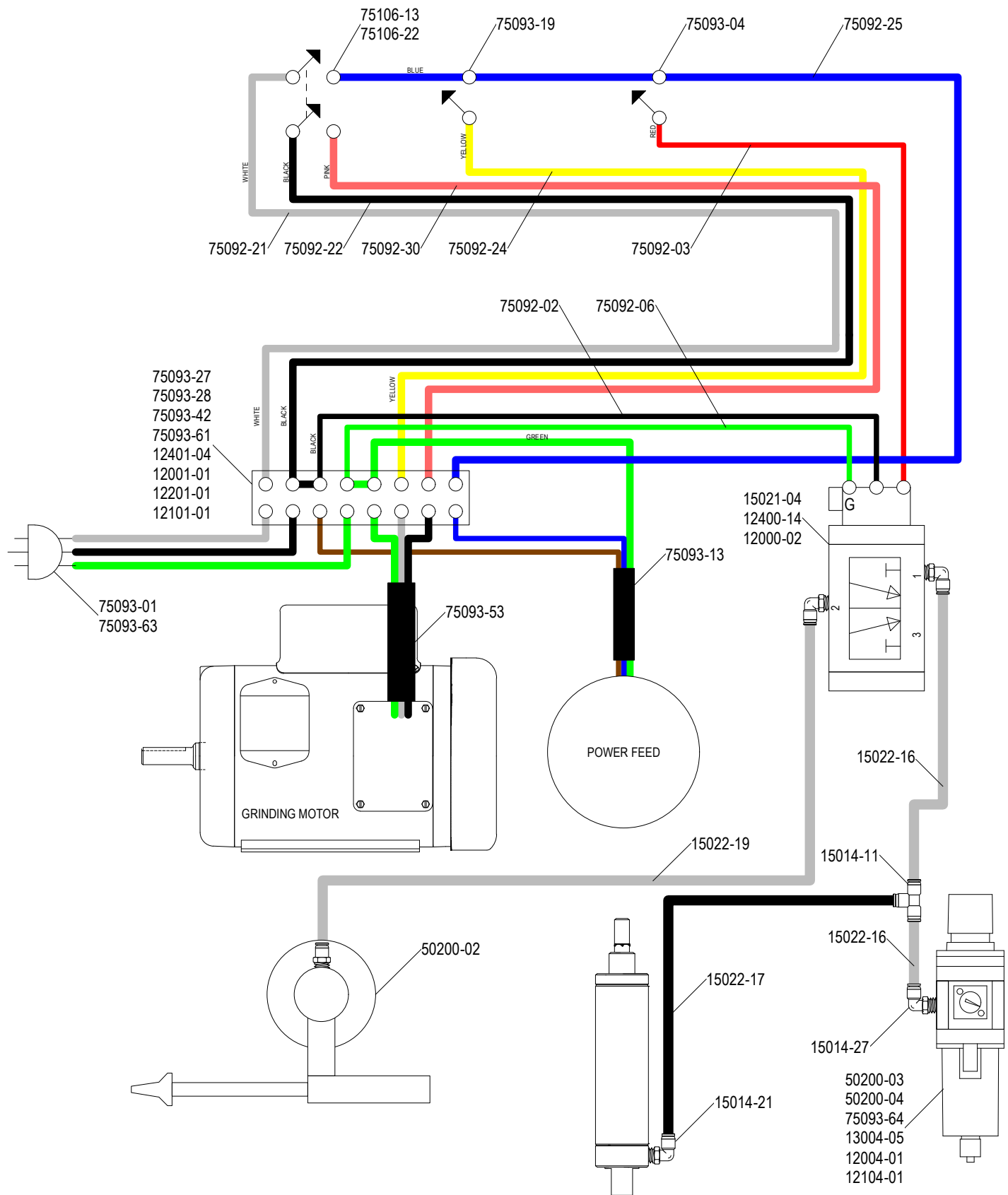
Part Number	Quantity	Description
50100-01	1 each	Powerfeed Adaptor Shaft
50105-01	1 each	Hand Wheel Dial
50115-01	1 each	Powerfeed Adaptor
50210-00	1 each	Powerfeed
50215-01	2 each	Thrust Bearing
50220-01	4 each	Mounting Bolt

SHIELD



Part Number	Quantity	Description
12004-01	4 each	1/4-20 Nut
12006-01	2 each	3/8-16 Nut
12104-01	1 each	1/4 Lock Washer
12106-01	2 each	3/8 Washer
12206-01	2 each	3/8 Washer
12306-10	2 each	3/8-16 x 1 Hex Head Bolt
12705-06	1 each	Thumb Screw
50065-01	2 each	1/4-20 x 1-1/2 Stud
50175-01	1 each	Shield Mount
50180-01	1 each	Shield Mount Pin
50185-01	1 each	Shield Mount Arm
50190-01	1 each	Shield
73034-10	1 each	Collar
73170-11	1 each	Plug

WIRING AND PNEUMATICS



Part Number	Quantity	Description
12000-02	2 each	#5-40 Nut
12001-01	2 each	#6-32 Nut
12004-01	1 each	1/4-20 Nut
12101-01	4 each	#6 Lock Washer
12104-01	1 each	1/4 Lock Washer
12201-01	4 each	#6 Washer
12400-14	2 each	#5-40 x 1- 1/2 Screw
12401-04	2 each	#6-32 x 1/2 Screw
13004-05	1 each	1/4-20 x 5/8 Flat Head Screw
15014-11	1 each	1/4 Union Tee
15014-21	3 each	1/4 x 1/8 NPT Male Swivel Elbow
15014-27	1 each	1/4 x 3/8 NPT Male Swivel Elbow
15021-04	1 each	Electric Valve 120V
15022-16	12 inches	Tubing, Gray
15022-16	6 inches	Tubing, Gray
15022-17	18 inches	Tubing, Black
15022-19	18 inches	Tubing, White
50200-02	1 each	Vortec Cold Air Gun
50200-03	1 each	Regulator
50200-04	1 each	Quick Clamp
75092-02	10 inches	20 Gauge Wire Black
75092-03	40 inches	20 Gauge Wire Red
75092-06	10 inches	20 Gauge Wire Green
75092-21	40 inches	14 Gauge Wire White
75092-22	40 inches	14 Gauge Wire Black
75092-24	40 inches	14 Gauge Wire Yellow
75092-25	40 inches	14 Gauge Wire Blue
75092-30	40 inches	14 Gauge Wire Pink
75093-01	1 each	Power Cord
75093-04	1 each	Toggle Switch
75093-13	1 each	Strain Relief
75093-19	1 each	Toggle Switch
75093-27	1 each	Terminal Block
75093-28	2 each	Jumper
75093-42	13 each	Locking Fork Terminal
75093-53	36 inches	Power Cord
75093-61	3 each	Locking Fork Terminal
75093-63	1 each	Strain Relief
75093-64	1 each	Strain Relief
75106-13	1 each	Mushroom Push Button
75106-22	1 each	NO Contact Block