



When ordering replacements, State serial number and size, stamped on name plate of machine, and designate part by both name and number.

- 150 - Brake spring adjusting rod
- 151 - Spring adjusting nut
- 152 - Brake spring
- 153 - Brake spring rod washer
- 154 - Brake lining
- 155 - Brake band end
- 156 - Brake band
- 157 - Cam brake lever
- 158 - Brake cam roller
- 159 - Brake drum, cam and eccentric
- 160 - Brake band adjusting end
- 161 - Brake band adjusting clamp screw
- 162 - Timer trip lever
- 163 - Timer spring
- 164 - Valve bell crank
- 165 - Valve lever connecting link
- 166 - Brake lever connecting link
- 167 - Spring brake lever
- 616 - Clutch operating valve
- 715 - Valve operating lever

ADJUSTMENT  
CAUTION

Brake band length adjustment, by means of screw (150) is made only when distance "C" is less than 1/8".

If machine does not stop on back dead center, after operating sufficiently to warm up brake parts, the brake requires adjusting. This is probably due to a slight wear on brake lining (154) which can be compensated for by adjusting the length of the brake band (155). To secure proper band length, with the roller (158) on the high part of the cam (159) and the links (156) and valve bell crank (164) in line, release brake link clamp screw (161) and turn spring rod (150) until distance "C" between flange on washer (153) and boss of spring brake lever (167) is 3/16". Then clamp spring rod (150) by means of clamp screw (161). When making adjustment in this manner, the setting of the brake spring (152) is not disturbed.

If machine continues to coast beyond back dead center, when properly warmed up, the tension of the brake spring (152) must be increased. This is accomplished by tightening the spring adjusting nut (151) without permitting the spring rod (150) to turn, and change the adjustment of band length.

If the machine still coasts beyond back dead center, stop the machine with the brake roller (158) on the low part of the cam (159), block the timer trip lever (167) so that it cannot engage the valve bell crank (164) and by means of the spring studs of the clutch (16), see that the plates are releasing quickly. If release is slow, check clutch operating valve (616) to see that it is exhausting properly. If, after establishing this, the clutch continues to release sluggishly, investigate the clutch.

THE AJAX MANUFACTURING COMPANY  
Euclid Branch P.O.  
Cleveland 17, Ohio

CLUTCH AND BRAKE OPERATION

Loosen brake band adjusting clamp screw 161 then back off brake spring adjusting rod 150 until spring pressure is fully released. Turn screw in a clockwise direction to a point where spring pressure is picked up, then rotate an additional 360° which provides .100" gap for brake lining wear. "C" dimension will be at .100" greater than its minimum setting. Tighten clamp screw 161.

When foot treadle is depressed, brake is released 3/16" which is sufficient to completely release the brake. This same motion rocks over valve operating lever 715 shifting valve from "exhaust" to "air on" which operates clutch starting a machine cycle. In the first 30 to 40° degrees of rotation, brake cam roller 158 drops to low cam loosening brake an additional 1/4".

At 260° the timer cam trips lever 162 allowing valve bell crank lever 164 to rotate in a clockwise direction exhausting air from the clutch. At 312° the brake cam roller 158 reaches high cam, setting the brake. Brake spring 152 must be adjusted to stop the machine within the angle of the high cam. Brake release by foot treadle amounts to 3/16" at "C". Brake release by brake cam roller 158 amounts to 1/4" at "C".