



SECTION-ZZ
FOR 8" FM.

WHEN ORDERING REPLACEMENTS STATE SIZE AND SERIAL NUMBER STAMPED ON NAME PLATE OF MACHINE AND DESIGNATE PART BY BOTH NAME AND NUMBER

- 322 H. SLIDE, CAM SLIDE, DIE SLIDE COVER PLATE.
- 501 DIE SLIDE.
- 503 DIE SLIDE R.H. LIP LINER.
- 504 DIE SLIDE L.H. LIP LINER.
- 505 BED LINER FOR DIE SLIDE R. H. LIP.
- 506 BED LINER FOR DIE SLIDE L. H. LIP.
- 507 DIE SLIDE SIDE LINER.
- 508 FLOATING PLATE REAR BACKING LINER.
- 509 FLOATING PLATE FRONT BACKING LINER.
- 510 STATIONARY DIE THRUST BLOCK.
- 511 DIE SLIDE EXTENSION TOP LINER.
- 512 DIE SLIDE EXTENSION BACK SIDE LINER.
- 513 DIE SLIDE EXTENSION FRONT SIDE LINER.
- 514 DIE SLIDE EXTENSION BOTTOM LINER.

- 516 MOVING DIE SIDE LINER.
- 517 STATIONARY DIE SIDE LINER.
- 518 MOVING DIE BOTTOM LINER.
- 519 STATIONARY DIE BOTTOM LINER.
- 520 DIE CLAMPS.
- 521 DIE SLIDE FRONT COVER PLATE.
- 522 FILLER PLATE-H. SL. C. SL, DIE SLIDE COVER PLATE.
- 523 PLUG WASHERS FOR FILLER PLATE.
- 524 DIE SLIDE FLOATING PLATE.
- 525 FLOATING PLATE BACK UP LINER.
- 526 FLOATING PLATE RETAINER BLOCK.
- 527 DIE SLIDE BRONZE SIDE LINER.
- 528 DIE SLIDE EXT. BRONZE LINER.

ADJUSTMENT FOR SIDE WEAR

- 1 - WITH DIE SLIDE OPEN, REMOVE FLOATING PLATE FRONT BACKING LINER (509).
- 2 - FORCE DIE SLIDE AWAY FROM SIDE LINER (507) AND WITH FEELER GAUGE FEEL BETWEEN SIDE LINER (507) AND SLIDE (501) TO DETERMINE THICKNESS OF SHIMS TO BE INSTALLED, ALLOWING APPROXIMATELY .001 INCH PER INCH OF DIE SLIDE WIDTH FOR OPERATING CLEARANCE.
- 3 - REMOVE SIDE LINER (507) HOLDING SCREWS, WITH DRAW LINER (507), FIT SHIMS OF SUITABLE THICKNESS ON THE BED SIDE OF THE LINER, CUT HOLES FOR SCREWS, AND BEND EDGE OF SHIMS OVER BACK END OF THE LINER TO PREVENT SHIFTING.
- 4 - SLIDE SIDE LINER (507) WITH SHIMS INTO PLACE, REPLACE SCREWS, AND CHECK CORRECT OPERATING CLEARANCE WITH FEELER GAUGES, AND BY MANUALLY TURNING OVER THE MACHINE.
- 5 - SQUARE UP MOVING DIE SEAT WITH STATIONARY DIE SEAT BY SHIMMING OR MACHINING EXTENSION BEARING SIDE LINERS (512, 513).
- 6 - AFTER MACHINING FLOATING PLATE FRONT BACKING LINER (509), INSTALL IN PLACE, SHIMMING BEHIND LINER (509) FOR CORRECT OPERATING CLEARANCE.
- 7 - LINE UP STATIONARY DIE THRUST BLOCK (510) WITH FLOATING PLATE (524) BY MACHINING OR SHIMMING BLOCK (510).

ADJUSTMENT FOR VERTICAL WEAR

- 8 - TO TAKE UP THE GREATER WEAR ON DIE SLIDE L. HAND LIP LINER (504), REMOVE PLUG WASHERS (523), SLIDE FILLER PLATE (522) OUT FROM UNDER COVER PLATE (322). REMOVE SOCKET HEAD SCREWS THRU PLUG WASHER HOLES IN COVER PLATE (322). SLIDE L. HAND LIP LINER (504) OUT FROM UNDER DIE SLIDE, FIT WITH SUITABLE SHIMS AND RETURN TO PLACE.
- 9 - TO COMPENSATE FOR WEAR ON BOTH LIPS, REMOVE SHIMS FROM UNDER COVER PLATE (521) AND SHIM BETWEEN FILLER PLATE (522) AND COVER PLATE (322).
- 10 - WITH SLIDE SET ABSOLUTELY SQUARE, CORRECT EXTENSION BEARINGS BY SUITABLE SHIMMING OR BY MACHINING OF TOP LINER (511) AND BOTTOM LINER (514).

DISASSEMBLY OF DIE SLIDE FROM MACHINE

- 11 - REMOVE COVER PLATES (521) AND (322). REMOVE CONNECTING LINK (403) AND TOGGLES (401, 402). REMOVE FLOATING PLATE BACK UP LINER (525) AND CAP SCREWS HOLDING FLOATING PLATE (524) TO DIE SLIDE. REMOVE DIE SLIDE EXTENSION BOTTOM LINER (514), MOVING DIE SIDE LINER (516), AND MOVING DIE BOTTOM LINER (518) AND ALSO FLOATING PLATE RETAINER BLOCK (526).
- 12 - DROP ENDS OF A CHAIN THRU HOLES "A" IN DIE SLIDE, ANCHOR ENDS OF THE CHAIN BY SLIPPING SHORT BARS THROUGH THE LINKS.
- 13 - LIFT THE DIE SLIDE FROM MACHINE ON AN ANGLE, BEARING TO THE LEFT TO ALLOW THE DIE SLIDE EXTENSION TO CLEAR BED FRAME.

STOP FOR BACK STROKE

THE STOP (G) SERVES TO PREVENT THE DIE SLIDE FROM OVERTRAVELING EXCESSIVELY WHEN THE GRIP SAFETY THROWS OUT. IT SHOULD NORMALLY CLEAR THE END OF THE SLIDE BY 1/16" OR 1/8", NOT MORE.