



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

- 501 DIE SLIDE
- 503 DIE SLIDE LONG LIP LINER
- 504 DIE SLIDE SHORT LIP LINER
- 505 BED LINER FOR DIE SLIDE LONG LIP
- 506 BED LINER FOR DIE SLIDE SHORT LIP
- 507 DIE SLIDE WEDGE SIDE LINER
- 508 DIE SLIDE BACKING PLATE
- 508^A DIE SLIDE BACKING PLATE BRONZE LINER
- 509 MOVING DIE THRUST PLATE
- 509^A MOVING DIE THRUST PLATE BRONZE LINER
- 510 STATIONARY DIE THRUST BLOCK
- 511 DIE SLIDE EXTENSION TOP LINER
- 512 DIE SLIDE EXTENSION WEDGE SIDE LINER
- 513 DIE SLIDE EXTENSION 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 COVER PLATE
- 322 HEADERSLIDE, CAM SLIDE, & DIE SLIDE COVER PLATE
- 522 FILLER PLATE FOR H. SL., C. SL., & DIE SL. 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 BOTTOM LINER

ADJUSTMENT FOR SIDE WEAR.

- 1 - WITH DIE SLIDE OPEN, REMOVE DIE THRUST PLATE (509) AND (509^A).
- 2 - FORCE DIE SLIDE AWAY FROM WEDGE (507), AND WITH FEELER GAGE, FEEL BETWEEN WEDGE AND SLIDE TO DETERMINE THICKNESS OF SHIMS TO BE INSTALLED, ALLOWING APPROXIMATELY .001 PER INCH OF WIDTH OF DIE SLIDE FOR OPERATING CLEARANCE.
- 3 - REMOVE WEDGE HOLDING SCREWS, WITHDRAW WEDGE (507), FIT SHIMS OF SUITABLE THICKNESS ON THE SIDE OF WEDGE TOWARD BED FRAME, CUT HOLES FOR BOLTS AND BEND EDGE OF SHIMS OVER SMALL END OF WEDGE TO PREVENT SHIFTING.
- 4 - SLIDE WEDGE WITH SHIMS INTO PLACE, REPLACE SCREWS, AND CHECK CORRECT OPERATING CLEARANCE WITH FEELERS AND BY TURNING MACHINE OVER BY HAND.
- 5 - SQUARE UP MOVING DIE SEAT WITH STATIONARY DIE SEAT BY SHIMMING OR MACHINING EXTENSION BEARING LINERS (512) AND (513).
- 6 - AFTER MACHINING BRONZE LINER (509^A) ON MOVING DIE THRUST PLATE (509), INSTALL IN PLACE, SHIMMING BEHIND (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 SHORT LIP LINER (504), REMOVE PLUG WASHERS (523), SLIDE FILLER PLATE (522) OUT FROM UNDER COVER (322). REMOVE ALLEN HEAD SCREWS THRU PLUG WASHER HOLES IN COVER PLATE (322). SLIDE 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 AND MACHINING OF TOP AND BOTTOM LINERS (511) AND (514).

DISASSEMBLY OF DIE SLIDE FROM MACHINE

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

STOP FOR BACK STROKE

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