



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

322 HEADER SLIDE, CAM SLIDE & DIE SLIDE COVER PLATE	516 MOVING DIE SIDE LINER
501 DIE SLIDE	517 STATIONARY DIE SIDE LINER
503 DIE SLIDE R.H. LIPLINER	518 MOVING DIE BOTTOM LINER
504 DIE SLIDE L.H. LIPLINER	519 STATIONARY DIE BOTTOM LINER
505 BED LINER FOR DIE SLIDE R.H. LIP	520 DIE CLAMP
506 BED LINER FOR DIE SLIDE L.H. LIP	521 DIE SLIDE COVER PLATE
507 DIE SLIDE L.H. BED LINER	522 FILLER PLATE FOR HDR. SL, CAM SL, & DIE SL. COVER PL.
508 REAR BACKING PLATE	523 PLUG WASHERS FOR FILLER PLATE
508A REAR BACKING PLATE LINER	524 DIE SLIDE FLOATING PLATE
509 FRONT BACKING PLATE	527 DIE SLIDE L.H. SIDE LINER
509A FRONT BACKING PLATE LINER	528 DIE SLIDE EXTENSION BRONZE BOTTOM LINER
510 STATIONARY DIE THRUST BLOCK	531 DIE CLAMP STUD
511 DIE SLIDE EXTENSION TOP LINER	537 DIE SLIDE R.H. SIDE LINER
512 DIE SLIDE EXTENSION L.H. SIDE LINER	538 FLOATING PLATE BOTTOM LINER
513 DIE SLIDE EXTENSION R.H. SIDE LINER	539 DIE SLIDE KNUCKLE WASHER
514 DIE SLIDE EXTENSION BOTTOM LINER	540 DIE SLIDE PIN THRUST BUSHING

ADJUSTMENT FOR SIDE WEAR

- 1 - WITH DIE SLIDE OPEN, REMOVE FRONT BACKING PLATE (509) AND LINER (509A).
- 2 - FORCE DIE SLIDE AWAY FROM BED LINER (507) AND, WITH FEELER GAUGE, FEEL BETWEEN BED LINER AND DIE SLIDE (501) DETERMINE THICKNESS OF SHIM TO BE INSTALLED, ALLOWING APPROXIMATELY .0009" PER INCH OF WIDTH OF DIE SLIDE FOR OPERATING CLEARANCE.
- 3 - REMOVE SCREWS HOLDING BED LINER (507), WITHDRAW LINER, FIT SHIM OF SUITABLE THICKNESS ON THE BED SIDE OF BED LINER, CUT HOLES FOR SCREWS AND BEND EDGE OF SHIM OVER BACK END OF BED LINER TO PREVENT SHIFTING.
- 4 - SLIDE BED LINER (507) WITH SHIM INTO PLACE, REPLACE SCREWS, AND CHECK FOR CORRECT OPERATING CLEARANCE WITH FEELER GAUGE AND BY TURNING MACHINE OVER BY HAND.
- 5 - SQUARE UP MOVING DIE SEAT WITH STATIONARY DIE SEAT BY SHIMMING OR MACHINING EXTENSION SIDE LINERS (512) AND (513).
- 6 - AFTER MACHINING FRONT BACKING PLATE LINER (509A) ON FRONT BACKING PLATE (509), INSTALL IN PLACE, SHIMMING BEHIND PLATE (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 LEFTHAND LIP LINER (504), REMOVE PLUG WASHERS (523), SLIDE FILLER PLATE (522) OUT FROM UNDER COVER (322), REMOVE SOCKET HEAD SCREWS THRU PLUG WASHER HOLES IN COVER PLATE (322), SLIDE LIP LINER (504) OUT FROM UNDER DIE SLIDE, FIT WITH SUITABLE SHIM 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 MACHINING OF TOP LINER (511) AND BOTTOM LINER (514).

DISASSEMBLY OF DIE SLIDE FROM MACHINE

- 11 - REMOVE COVER PLATES (322) AND (521), REMOVE CONNECTING LINK (403) AND TOGGLES (401) AND (402), REMOVE EXTENSION BOTTOM LINER (514), MOVING DIE SIDE LINER (516) AND MOVING DIE BOTTOM LINER (518).
- 12 - DROP ENDS OF CHAIN THRU HOLES 'A' IN DIE SLIDE (501), ANCHOR ENDS OF CHAIN BY SLIPPING SHORT BARS THRU END LINKS.
- 13 - LIFT SLIDE FROM MACHINE ON AN ANGLE, BEARING TO THE LEFT, TO ALLOW EXTENSION TO CLEAR BED.

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.