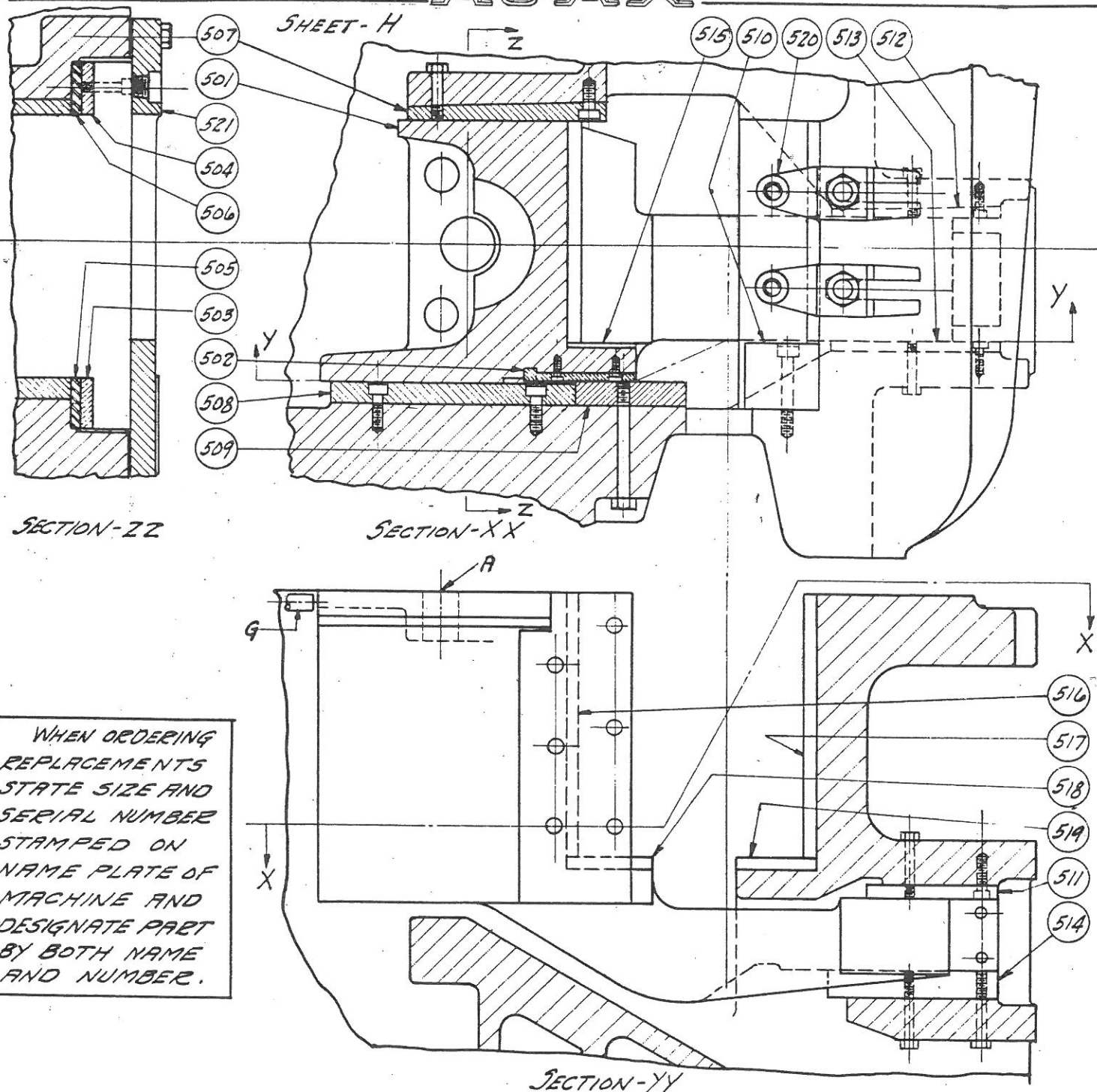




- 501 DIE SLIDE
 502 DIE SLIDE BRONZE SIDE LINER
 503 DIE SLIDE LONG LIP LINER
 504 DIE SLIDE SHORT LIP LINER
 505 BED LINER FOR DIE SLIDE LONG LIP
 506 BED LINER FOR DIE SLIDE SHORT LIP
 507 DIE SLIDE WEDGE SIDE LINER
 508 DIE SLIDE BACKING PLATE
 509 MOVING DIE THRUST BLOCK
 510 STATIONARY DIE THRUST 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
 515 MOVING DIE THRUST PLATE
 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

THE AJAX MANUFACTURING COMPANY
 EUCLID BRANCH P.O.
 CLEVELAND, OHIO.

ADJUSTMENT FOR SIDE WEAR.

- 1 - WITH DIE SLIDE CLOSED, REMOVE MOVING DIE THRUST BLOCK (509). THEN REMOVE DIE SLIDE SIDE LINER (502). FLAT HEAD SCREWS SECURING LINER (502) CAN BE REACHED WITH A SCREW DRIVER THRU THRUST BLOCK BOLT HOLES.
- 2 - OPEN DIE SLIDE WITH A JACK, FORCE DIE SLIDE AWAY FROM WEDGE (507), AND WITH FEELER GAUGE, FEEL BETWEEN WEDGE AND SLIDE TO DETERMINE THICKNESS OF SHIMS TO BE INSTALLED, ALLOWING APPROXIMATELY .015" 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 DIE SLIDE SIDE BRONZE LINER (502) AND MOVING DIE THRUST BLOCK (509) IN ORDER TO CORRECT IRREGULARITIES, INSTALL IN PLACE, SHIMMING BEHIND (509) FOR CORRECT OPERATING CLEARANCE.
- 7 - LINE UP DIE LINER (515) WITH STATIONARY THRUST BLOCK (510) BY SUITABLE SHIMMING.
- 8 - COMPENSATE WITH SHIMS BEHIND DIE SLIDE EXTENSION WEDGE SIDE LINER (512) AND SIDE LINER (513).

ADJUSTMENT FOR VERTICAL WEAR.

- 9 - TO TAKE UP THE GREATER WEAR ON DIE SLIDE SHORT LIP LINER (504), REMOVE ALLEN HEAD SCREWS THRU PIPE PLUG HOLES IN COVER PLATE (521). SLIDE LIP LINER (504) OUT FROM UNDER DIE SLIDE, FIT WITH SUITABLE SHIMS AND RETURN TO PLACE.
- 10 - TO COMPENSATE FOR WEAR ON BOTH LIPS REMOVE SHIMS FROM UNDER COVER PLATE (521).
- 11 - 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

- 12 - REMOVE COVER PLATE (521), REMOVE CONNECTING LINK (403) AND TOGGLES (401) AND (402). REMOVE BOTTOM EXTENSION LINER (514).
- 13 - DROP ENDS OF CHAIN THRU HOLES "A" IN DIE SLIDE, ANCHOR ENDS OF CHAIN BY SLIPPING SHORT BAR THRU END OF LINK.
- 14 - LIFT SLIDE FROM MACHINE ON AN ANGLE, BEARING TO THE LEFT TO ALLOW EXTENSION TO CLEAR BED FRAME.

STOP FOR BACK STROKE

THE STOP (9) 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 $\frac{1}{16}$ " OR $\frac{1}{8}$ ", NOT MORE.

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