satisfactory and machine is running at operating temperature, increase the oil feed. Carefully disconnect the drive discharge lines and remove lubricator from resevoir. NOTE - Index whole number on cam on which locating pin is engaged, pull out knurled knob and rotate until locating pin enters index hole with next higher number. Too little oil at the continuous line bearings, same inspection procedure as above. If everything is satisfactory, turn continuous bypass valve adjustment clockwise with result in increase in the oil pressure while machine is in operation until proper oil flow is achieved. Too much oil at bearings in either line, continuous or cyclic, procedures would be reverse of those described above. For too little or too much oil at one bearing only, meter units of same type but next higher or lower flow rate should be used. The cyclic bypass valve adjustment is under the name plate, continuous bypass valve adjustment in under the cone-shaped nut.

Oil the machine daily using flush button when starting up the machine. Also use the oil gun to oil all fittings prior to starting up the machine. Plugs at the bottom of the worm housing should be removed every three months and the housing flushed out with an OSHA approved solvent. Replace the plugs and fill with fresh oil.

TOOLING UP A NEW JOB

Remove high speed pin, put machine in direct low and insert manual reverse for ease of set up. Then, remove the tooling and equipment used in the previous job. Remove all tools, backup tension screws, take out the feed tubes and install new feed fingers. Remove the collets from the spindle between the 4th and 5th position and wash out the spindles with an OSHA approved solvent and boiler brush after washing swab with lubricating oil. Now oil and insert the new collets (chucks) and the feed tubes. Repeat the above operation until all collets and feed tubes have been replaced.

Insert five bars of stock in the machine and adjust all the collets. (Adjust the amount of stock that will be fed out by the crank on top of the feed slide). Remove the cam carriers and put on the new set in which the cams for the new job have already been mounted. Now locate the block on the cam levers to get the required amount of movement for the tools. Put on the spindle change gears and the feed gears. Now index the machine manually to be sure all components are working freely. The machine is now ready for tooling which should be correctly sharpened before starting to set up the machine.

First, put in the cutoff tool and adjust approximately 1/16" away from the face of the collet. Cutoff the end of the bar by operating the cutoff tool by hand. Open the collet and feed out the stock the length needed for the job. Close the collet by hand and cut a slight groove in the stock. Withdraw the latch (5161-1) on the top of the collet opening lever so the stock will not be fed out in any of the spindles as the work spindle head is indexed. In the first position, mount the tool holder for the first position in place. Index the spindle carrier until the stock comes in line with the stock stop face of the tool holder. (Approximately 1/2 Index).