Adjust the stock stop screw (888-1) on the right hand end of the tool spindle, adjust until the face of the holder comes in contact with the stock. Now, index and lock the spindle carrier. Try the first tool by hand with the hand lever (5080-146) and adjust the tool to cut the correct size. Turn the handwheel until the roll of the cam lever is at the highest point of the cam. Now adjust the turnbuckle link connection with the cam lever so the tool is fed to the correct dimension. Index the spindle carrier to the next position, with the next tool holder use the same procedure as described above. When using a forming tool, adjust the forming tool to the correct height to the center of the work. Line it up with the groove already cut in the work piece by the cutoff tool. When the roll on the cam is at the highest point of the cam, adjust the turnbuckle connection so as to cut .010 smaller than the required size. Adjust the cross slide stop screw until it comes in contact with a .005 feeler gauge placed between the tension screw and the stop screw in the spindle carrier. Turning the tension screw 1/4 turn will give approximately .005 pressure to insure forming the same size on all spindles. Mount the balance of tools, index the spindle carrier to the next position and mount the next tool as described above. Repeat this operation until all tools are in place. Now engage latch (5161-1) to feed stock, before beginning to run the job check the piece of work from each spindle. Make any adjustments as needed.

CHANGING THE COLLETS (CHUCKS)

The machine is indexed to fifth position, to approximately 96 hundredths, shut the machine off. The machine should be in a position where the cutoff tool is clear of the stock just after the head locks. Loosen the set screw locking the stock reel. Back the stock reel tubes away. Raise the feed slide guide latch (5165). Withdraw the pusher tube unit toward the stock reel. Handle this unit very carefully. Remove any tool holders if it would obstruct withdrawl of the collet. Raise the chuck lever roll throwout (5080-292-3) from engagement of the cam race. Now insert the cam lever handle (5080-146) into the chuck opening cam lever (5017-1) and manually open the collet. Now manually crank (use handwheel) the machine back to approximately 1/2 index. Remove the upper rear guard (MB-387-1) on the rear of the machine. Lock the spindles by placing a brass rod between the spindle gears. Insert the chuck wrench into the inner spindle to the first mark on the wrench. Rotate the wrench clockwise or counterclockwise at the same time pushing on the pin at the end of the pusher rod until the pins in the wrench enter the holes in the collet. Insert the cam lever handle (5080-146) into the knurled collar on the end of the wrench. Turning the handle clockwise will unscrew the collet (the collet has a right hand thread). Clean inside of inner spindle and outer spindle with an OSHA approved boiler brush and OSHA approved solvent then swab with lubricating oil. Select collet for next job. Remove all burrs, if any, from the inside of the collet. Wipe all threads and lubricate with oil. Insert the collet and screw up tight. Tighten with collet wrench and remove the collet wrench. NOTE - There are two collet wrenches. One for oversize (2816-45-SA), and one for regular (2816-41-SA). Manually crank (use handwheel)