Tighten the binding screw. After making your test piece you can now make your final adjustments.

METHOD #2 - NOTE - For the second method, the machine is still in direct low.

Stop the machine in the loading position #5, (approximately 55 hundredths) when the cutoff tool withdraws enough to clear the stock before the head unlocks. Now insert the cam lever handle (5080-146) in to the front tool arm cam lever (5080-46). Swing the front tool arm (459) across the stock making sure that we have a good clean cutoff. Hold the chuck slide opening guide latch (5161-1) out to prevent stock from being fed. Now to measure for the correct length of the piece to be fed out. Correct length to be fed out will be the width of the cutoff tool plus the length of the piece plus a small amount for facing off. Adding these all together we get the resulting length of the piece to be fed out. A planer gauge or a plug of the desired length may be used. Index the machine halfway until the piece comes in line with the stock stop plate. Loosen the binding screw on the stock stop screw (888-1). Insert the planer gauge or your plug between the end of your stock and the end of the stock stop plate. By moving the stock stop screw (888-1), move the first position spindle until the stock stop plate comes firmly against the planer gauge. CAUTION - Do not use the turnbuckle connection under any circumstances. Manually backup the machine until feed tube is fully withdrawn (61 hundredths). Adjust the stock feed out. Turn the crank on the feed slide. The amount the feed slide moves can be measured between the feed tube steel washer and the inner spindle. This distance is the length of plug, plus 1/4" extra feed. The 1/4" extra feed is to take care of backlash in the feeding mechanism. This entire distance can be measured with inside calipers. Now tighten the binding screw. After making the test piece make any fine adjustments that need to be done.

STOCKING THE MACHINE

Machine should be stopped in loading position #5 when the cutoff tool withdraws enough to clear the stock, before the head unlocks. (Approximately 55 hundredths). Put the cam lever handle (5080-146) into the chuck opening cam lever (5017-1). Raise the chuck lever roll throwout, (5080-292-3). To clear the chuck and feed cam, now to load the new bars. The new bars should be chamfered on both ends wiped clean and oiled prior to stocking the machine.

CAUTION - Spindles should be stopped when loading bars. Insert the bars into the wire case tubes. After the bars of stock are in the wire case tubes and through the feed tube nut bushings and pushed into the feed tube, the collet is opened by hand. With the wire adjusting handle (5080-395) operator pushes the long rod to the left. Wire adjusting lever (5080-394) is turned in line with the stock to be inserted and quickly pushed by short strokes through the collet. This will eject the remaining bar end. The collet is closed by hand. The stock should be out far enough through the collet to clean up the bar end with the cutoff tool. The collet is closed by hand, with the cam lever handle (5080-146) in the chuck opening lever. Start the spindle, insert the cam lever handle (5080-146) into the cutoff tool arm. Now cut the cuttoff end clean. Engage the feed clutch with starting shaft handle lever (5080-383) to index the machine. Repeat this pro-