

GENERAL FEATURES OF THE MODEL B

Five spindles to provide sufficient tooling positions, producing the best quality of work. We also have various attachments which may be added to eliminate secondary operations. A regular and oversize machine can be adapted to any of the three cycles by changing of the motor pulley, (75, 60, or 45 cycle). A 75 cycle machine indexes in .4 of a second. The 60 cycle machine indexes in .5 of a second. The 45 cycle machine indexes in .66 of a second. Cams on the machine are calculated in hundredths, from 0 to 50 is the working portion and 50 to 100 is the high speed or index portion. The index time is the total idle time required to withdraw tools, index carrier, feed stock, and return tools to the working positions. There are charts marked 75 cycle for the wide range of spindle change gears for the 75 cycle, 60 cycle chart for the 60 cycle machine and the 45 cycle chart for the 45 cycle machine. There are a wide range of feed change gears for the 75 cycle, the 60 cycle, and the 45 cycle. See the charts for each particular cycle.

When a machine is received it should be carefully examined to make sure it has not been damaged in transit. If it has been damaged, notify the carrier and Davenport Machine, Rochester, New York. After the crate has been removed, check all parts such as cams, wrenches, gears, and so forth with the packing list. Thoroughly clean the machine of all slushing grease. The machine should be leveled and wired. The machine can be leveled by placing a straight edge on the cross slides, on which a bubble level can be placed to see if the sides are level. The center drive can also be used as a straight edge on which a bubble level can be placed, to see if the ends are level. The machine should have the corner pads inserted under it at the time of leveling and align stock reel to the machine, then lag the stock reel stand to the floor.

The machine should be well OILED with the gun supplied. Fittings are for oil only - not grease. Fill the lube gun with Mobil DTE Oil Heavy, or its equivalent, ISO-100-VG oil and also the Bijur lube pump reservoir. Check for nuts and bolts that may have loosened in transit. Install required cams in both tool spindle and cross slide area. Now turn the machine over by hand at least one complete cycle to make sure nothing is binding.

CAUTION - Do not run the machine if low pressure is less than five pounds and high pressure is less than fifty pounds. NOTE - See further oiling instructions. NOTE - If, for any reason, the gauges are disconnected, remove spindle change gears and push flush button on unit until air is purged from line and reconnect. Align the wire case carrier and connect to machine. Without spindle gears, start the machine, engage the starting hand lever, depress flush button on lubricator for 30 minutes, stop the machine, and put on the spindle gears. Approximately 900 R.P.M. is desired for breaking in the machine. Keep the flush button on the lubricator fully depressed for 5 minutes after each gear change. CAUTION - Never revolve spindles without indexing the head as the spindles are only lubricated in the 4th position.

Run the machine at approximately 900 R.P.M. for 2 hours. Change