the machine back to fifth position to replace the feed tube pusher. Use feed tube wrench block (848-W) and hold in a vice so that the desired feed tube hole is exposed. Turn the feed tube so that the key fits into the slot in the wrench block. Tighten the vice. Take the feed finger wrench (848-3) and place over the feed finger. Take a 5/32 hexagon set screw wrench and put through the feed finger wrench and the feed finger. Now remove the feed finger. There is also a right hand thread on the feed finger. Wipe off and oil the feed finger tube unit, insert the new feed finger and again tighten with the feed finger wrench. Return the feed finger tube unit into the machine, and release the feed slide guide latch (5165). Using the short sample bar ends, adjust the collet tension with the chuck adjusting nut. Insert the cam lever handle (5080-146) into the chuck opening cam lever (5017-1). Open and close the collet against the stock to get the feel of the correct tension. When the correct tension has been maintained, lock the chuck adjusting nut. CAUTION - Collet (chuck) and chuck lever breakage is caused by improper tension. Use extreme care. Index the next spindle and repeat above. After assembling all collets replace stock reel tubes in proper location. Lock stock reel with set screw and replace chuck lever roll throwout (5080-292-3).

SETTING THE STOCK STOP

NOTE - The machine is still in direct low speed.

METHOD #1 - Stop the machine in loading position #5. (Approximately 55 hundredths). When cutoff tool withdraws enough to clear the stock before the head unlocks, raise the knurl knob on feed lever (5016) to free feed lever throwout (5174) and Withdraw from cam race. Put cam lever handle (5080-146) into the feed lever (5016), push the feed lever to the extreme left. Now open the collet by hand. After the collet is open feed the stock by hand. Move the feed lever as far right as necessary to feed the length of the piece required. Measurement for the correct length of piece should be as follows: Length of piece plus some amount for facing. Putting your scale against the face of the cutoff tool which is toward the stationary head, move the stock to a predetermined place on the scale. Close the collet by hand, disengage chuck slide opening guide latch (5161-1) index the machine halfway until the piece comes in line with the stock stop plate. Loosen the binding screw in the bed which binds the stock stop screw (888-1). Turn the stock stop screw, moving the first position spindle until the stock stop plate is firmly against the end of the piece. CAUTION - Under no circumstances do you use the turnbuckle connection to adjust this. Raise the knurl knob on feed lever (5016). Moving the lever by hand, line up the roll, insert the feed lever roll throwout in the cam race. Manually backup the machine until feed tube is fully withdrawn (61 Hundredths). Loosen the binding screw locking the feed screw crank handle (7186-1). Adjust now for the stock feed out. Turn the crank on the feed slide. The amount the feed slide moves can be measured between the steel washer on the feed tube and the end of the inner spindle. This distance is the length of the piece, plus the cutoff. All this plus approximately 1/4" extra feed is to take care of the backlash in the feeding mechanism.