

INSTRUCTIONS FOR INSTALLATION OF STAR ELECTRIC POT

Upon receipt of the Pot, inspect the pot legs, mouthpiece, and other items for any indication of damage or breakage. Also, be sure that the voltage on the name-plate agrees with your line current. Each Pot is carefully inspected before packing and shipping, and if there is any damage, contact the carrier immediately and notify Star Parts, Inc., giving us the full information.

We recommend that a competent machinist make the installation of the new STAR Pot.

Remove the old pot from the machine. Remove the pot leg bushings. It will be easier to remove the right hand pot leg bushing first. We supply two new bushings with the STAR Pot, one being the standard 1" which is used on the right hand side, the left being .015" oversize. Using a micrometer, determine the exact thickness of the old right hand pot leg bushing, fitting the new bushing to this size. The left hand bushing, being oversize, will require fitting so there is absolutely no play when it is installed. The accuracy with which these bushings are fitted determines, to a large extent, the accuracy of your final slug trim.

Before installing the new Pot, remove the upper right hand pot leg adjusting screw and nut to permit clearance. When the Pot is in place, the parts can be inserted for adjustment. On Intertype machines, it is necessary to remove Part No. R-14 Mold Gear Arm Support, which contains the chute for back knife trim. This part can be replaced after the Pot is installed. Some early model Intertypes do not have the chute and it is therefore not necessary to remove this part when installing the Pot.

POT LEVER ADJUSTMENT: Before installing the Pot Lever Eye Bolt, remove the pins which hold the pot lever eye bolt sleeve, permitting the sleeve to float. Turn the adjusting nut and lock nut nearest the pot forward, to the limit of the thread. Next, assemble the eye bolt in its usual manner, adjusting the clearance between the pot lever and the nut to 1/8" to 3/16" when the pot is forward on the long shoe of the pot cam at casting position. Follow this by adjusting the forward nut which was previously loosened, until it compresses the spring as determined by the sleeve.

When the Pot is installed on an Intertype, it is necessary to change the complete eye bolt, which accompanies your new STAR Pot.

ADJUSTING THE LOCK-UP. When installing the Pot, approximately center the pot legs on the new bushings, using caution in tightening the adjusting screws. Secure a vertical alignment of each end of the pot so the mouthpiece holes will be fully on the mold cavity as indicated by either a red-lead or smoke lock-up. Adjust the pot legs to secure an even contact of the mouthpiece with the back of the mold over the entire end-to-end surface.

AUXILIARY CRUCIBLE ADJUSTMENT: An auxiliary adjustment is also available, allowing the crucible to be tilted forward or backward to attain parallelism between mouthpiece and mold. This adjustment should be used,

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however, ONLY when the regular methods of obtaining lock-up have failed to secure perfect results, in this manner:

The Auxiliary adjustment is located at the bottom of the Pot Jacket, rear, in the form of a rod, bushing, and lock nut. The threaded bushing is turned to the right to tilt the crucible forward, and to the left to drop the crucible back. The lock nut must, of course, be loosened first before attempting adjustment, and tightened when adjustment is completed. It is also very important that the four pot cover screws and the two terminal cover screws be loosened before this adjustment is used, as the cover is used to hold the crucible down in the jacket. Forcing the crucible up by means of the adjustment, without the bolts being loosened, would have a tendency to strip the threads. Each time the adjustment is made, these pot cover screws or bolts must be tightened down again before taking a lock-up impression.

If more impression is needed on the upper portion of the mouthpiece, tilt the crucible forward by turning the adjusting bushing to the right; if more impression is needed at the bottom of the mouthpiece, turn the bushing to the left. Adjustments should be made by no more than one turn at a time, -- and less, if necessary. This is a very fine adjustment, and if the leg adjustments have been properly accomplished, very little adjustment should be required at the auxiliary point.

POT WIRING: Be sure the electrical specifications on the Pot correspond to the current supply and follow the directions and print enclosed with the Pot. Remove the cover from the terminal box on the side of the Pot and note that Terminal 7 has a jumper which is connected to a terminal. This jumper places the stand-by or auxiliary pot heater into operation, and should be used when the Pot is heated for the first time. Fill the new Pot with hot metal if available, or short slugs and chips of metal, for faster initial heating of the Pot. The auxiliary heater is used only for the initial heating of the Pot, or for cleaning or replacement of the regular pot heater.

IMPORTANT NOTE:

After the Pot has been filled and reaches its normal temperature, turn off the power supply. Remove the jumper connected to the left hand terminal and Terminal No. 7; move the jumper to the right, connecting it to the right hand terminal which places the regular pot heater into operation. Either of the heaters will melt the metal. Should there be any failure of the regular heater, placing the jumper to the auxiliary position will permit the pot to operate until such time as a new heater can be installed. The auxiliary heater should only be used as just described or temporarily in emergencies only, if you wish to retain its advantage as an emergency tool.

INTERTYPE INSTALLATIONS: When the Pot is installed on an Intertype using the cam-operated slug lever, this cam will require installation to the right hand pot leg. Be sure the lock-up is correct, then place the cam over the right hand pot leg, locate, drill and tap 1/4" x 24 holes for the installation of the cam. Because of variations in machines, we pur-

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posely do not drill these holes. A special pot leg adjusting screw and nut is supplied and will be required if the cam is applied.

TYPE FACE AND METAL LEVEL: The metal level in the STAR Pot should be carried slightly above the top of the pot well. During casting, it may be possible to see the top of the well, which is a normal condition.

METAL TEMPERATURE: Best results are usually obtained by running the pot temperature from 535 to 540 degrees, and the mouthpiece control between 140 and 180 on the scale. When the mouthpiece temperature is carried at 180, there may be some indication of overheating if the machine is permitted to stand for some time. However, this will usually correct itself after casting several slugs. The final settings of the mouthpiece will, of course, be governed by the slug size and speed of operation. The above temperature settings are only a guide, and may vary depending on type of feeder, voltage, etc.

MOUTHPIECE CONTROLS: In plants, such as newspapers, which usually run on one measure, and therefore do not vary the Mouthpiece Control, the following procedure should be followed: Each day, the dial should be moved around a complete turn, slowly, two or three times. This will keep the contact surface from oxidizing, and thus keep the transference of the power at full efficiency.