

OPERATION AND MAINTENANCE  
OF THE  
"STAR" AUTOMATIC  
QUADDING ATTACHMENT  
MODEL "E" - HYDRAULIC

**LINOTYPE PARTS**

  
*Company, inc.*

FACTORY & MAIN OFFICE  
SOUTH HACKENSACK, N. J.

WESTERN BRANCH  
KANSAS CITY 6, MO.

OPERATION AND MAINTENANCE  
OF THE  
**"STAR" AUTOMATIC**  
**QUADDING ATTACHMENT**  
**MODEL "E" - HYDRAULIC**

—OR—  
**OLDER MODELS CONVERTED  
TO DIAL TYPE SELECTOR**



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OPERATION AND MAINTENANCE  
OF THE  
STAR AUTOMATIC  
GUARDING ATTACHMENT  
MODEL 57, HYDRAULIC

OR  
OLDER MODEL CONVERTED  
TO DIAL TYPE SELECTOR

## A HINT TO THE OPERATOR

If you have operated another type of quadder put it out of your mind. Start fresh with this STAR QUADDER, and you will find it exceedingly simple.

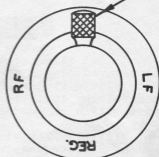
## THE SELECTOR

The drawing at the right is a replica of the Selector Dial as it appears on the Quadder. The Dial may be turned in either direction to select the desired operation.

LF means LEFT FLUSH  
 RF means RIGHT FLUSH  
 CEN. means CENTER  
 REG. means REGULAR OR JUSTIFIED POSITION

The Indicator Knob enables you to feel the position of the Dial even without looking after you have become accustomed to it. Practice with it for a few moments before you begin actual operation.

## Dial Indicator Knob



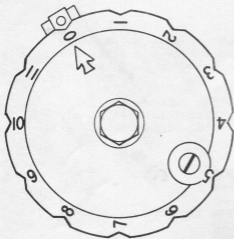
## Selector Dial

## CHANGING MEASURES

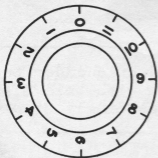
FIRST BE SURE TO TURN SELECTOR TO "REG" OR "LF" ON THE DIAL

At left is a drawing of the MEASURE CONTROL DIAL. It is synchronized with the Assembler Slide and the Vise Jaws, as well as with the Mohr Saw if you have one. This Dial is turned until you reach the desired measure on the Assembler Slide Scale. For even measures you let the "0" on the Dial come to rest at the red indicator. Odd measures are obtained by turning further the required number of points.

Example: To set a 11-1/2 Pica Measure turn Dial till 11 picas are reached, then turn 6 points further.



## Measure Control Dial



**Point Setting Dial**

THE POINT SETTING DIAL shown at the left is found under the Selector Arm, at the lower end of the Quadder. This must be turned to correspond with the Measure Control Dial for all odd measures except the 1/2 pica measures. For instance, a 24 pica plus 4 pt. (24.4) measure would show the indicator on both dials at number 4.

#### CENTERING ON LEFT SIDE OF SLUG

Set slide scale on Quadder Case (see drawing adjacent at desired length of line to agree with Vise Jaw setting. With middle finger of left hand, get under the upper block and raising indicator to center measure desired on scale, push button on Quadder Case in to engage rack.

EXAMPLE: You wish to center 4 picas on left side of 20-pica measure.

PROCEDURE: Turn Dial Selector to Left Flush. Set Measure Control to 20 picas. With Left Center Button out, slide scale to line up Figure 20 with red indicator. Raise block until indicator reaches the numeral "4" on the scale-- then push button in to engage the rack.

#### HALF-PICA MEASURE

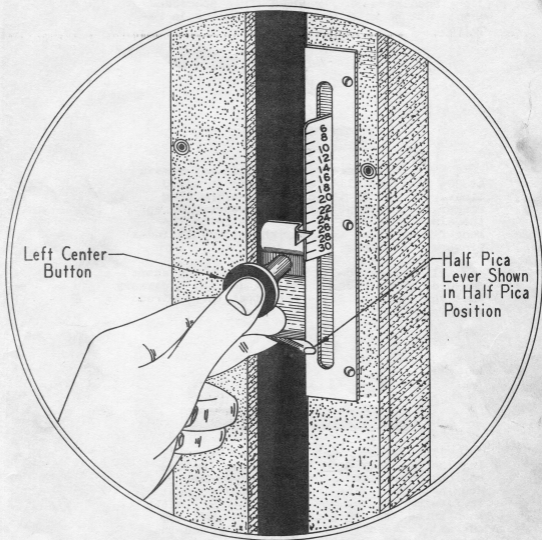
When centering half-pica measure, pull the bronze lever below the left center scale to the right. This lever is used only in connection with centering on left side of slug.

For example: If you are setting centers on 12-1/2 pica measures, the Vise Jaws and Assembler are set at 12. The 1/2 pica lever is then pulled to the right for the extra 1/2 pica.

#### USE OF QUADS

It is absolutely necessary for proper operation to use quads as follows:

CENTERING....At the beginning and end of line.  
 RIGHT FLUSH...At beginning of the line.  
 LEFT FLUSH...At end of the line.





**RECASTING QUADDED LINES**

When recasting quadded lines Spacebands should not be used if positive spacing is required.

**DELIVERY SLIDE**

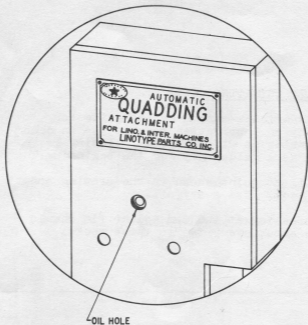
The long finger of the Slide may remain at  $30\frac{1}{2}$  picas at all times, except on mixed lines. In the latter case, close the long finger to the first matrix before sending up the elevator. This is done by sliding the long finger block to the right with your index finger, left hand.

If a long run is to be made on any short measure, it is recommended, though not necessary that the Delivery Slide be set at the desired measure.

**POT SIGNAL LIGHT AND SWITCH**

The Signal Light and Switch controlling the Pot Pump Stop Solenoid are located on the lower right side of the Quadder Housing. The light indicates that current is flowing through the Solenoid. The Switch when turned to off position, shuts off the current between the Vise Jaw Switch and the Solenoid, and prevents a line from being cast. This Switch is therefore useful for turning the machine around through the entire cycle for test observation without casting a slug.

Further detailed information on the operation of the Electro Pump Stop system will be found in the Maintenance Manual.



#### MAINTENANCE INSTRUCTIONS

Like any other piece of moving machinery, your Quadder will work at its peak efficiency ONLY with regular care. In the case of the STAR Quadder, this routine is so light, and requires so little time, there is no reason for neglecting it.

#### CLEANING AND OILING:

Once a month, or more often if necessary, open Vise to lowest position. Turn Selector Dial to "REG" position. Squirt kerosene in vise cap ways, clean out ways thoroughly with a rag. Squirt some quadder oil in the ways, and spread it by working jaws to and fro manually.

Into the hole found in the top cover of the Quadder Case (illustrated above) squirt a few drops of the same oil every two weeks.

Periodically, about every two months, remove both upper and lower covers, - held on by Allen Head Screws. Clean ways on which the Blocks slide with kerosene. Dry, then lubricate with quadder oil, applied with finger. Blow or brush out any dirt found in upper mechanism.

**HYDRAULIC ACTUATING UNIT:**

Experience should be the guide for frequency of lubrication because use in each plant varies so widely. The following is offered as a guide only for the beginning:

Oil at point shown in the drawing about once a week. Use heavy oil.

Greasing at the Cam Roller Pin should be done about every two to three weeks.

