

INDEX

A

Aluminum sleeve for plunger rod, 152.

Assembler: upper idle pulley or stud worn, 13, 60; matrix delivery belt should be tight and free, 13; gum under matrix delivery belt, 13; chute rails may catch mat, 13; large plate should not be sprung, 13; small cover must not be under large cover, 13; pulley should run steadily, 13; when to replace matrix delivery belt, 59; matrix delivery belt should not be home-made, 60; installing matrix delivery belt, 60; leather dust after installing new matrix delivery belt, 60; adjusting chute rail springs to new belt, 60; bushing in assembler block, 60; matrix delivery belt support plate adjustment, 61; replacing or peening chute rails, 63; soldering chute rail springs, 62; when to replace chute block, 63; soldering chute rails, 62-63; small cover must be fitted, 62; drill hole to hold small cover in place, 62; small cover should stay in place, 62; small cover should not fit in farther than big cover, 61; large entrance cover catch must hold, 61; large entrance cover must fit, 61; when to replace chute rail springs, 63; chute springs, 63-64; adjusting chute spring, 64; height of chute spring, 64; belt shifter needs oil, 64; Intertype drive belt must be crossed properly, 64; old style assembler drive clutch slips out, 64; inspect the belt shifter, 65; belt should be tight, 13; to remove the assembler block, 65; the matrix catch spring, 65; worn gears howl, 65; to remove star wheel spring, 65; put cup grease in star wheel gear, 65; to set tension of the wheel, 66; star wheel can be stiffened with gasoline, 66; star wheel can be softened with oil, 66; types of star wheel, 67; assembled slide chatters, 67; flat spring on operating lever should function, 67; adjustable buffer at right hand, 67; brake shoes, 67; brake springs, 67; roller may be oiled, 68; assembling elevator should seat every time, 68; bell hammer trip may cause trouble, 68; roller may bind in groove in assembled slide, 68; operating lever should have movement, 68; setting length of line with new star wheel, 70; how to make a model 15 assemble better, 70-71; spaceband buffer should be replaced, 77; stiff star wheel makes mats jump out, 82; tight assembling elevator gate makes mats jump out, 82; mats click too much as they fall, 82-83; transpositions (see Transpositions).

Assembler block: bushing in block, 60.

Assembler chute rails (see Assembler).

Assembler entrance partitions: must not impede mats, 10; must not be too low, 11; how they should be bent, 56; models 1 and 3, 56; model 15, 70-71; display mats may hit on top, 57; to adjust Intertype guides, 58; may be notched for big mats, 57-59; to remove the guide, 57; wear on mats may be reduced, 58; to adjust the plate, 58; floor of the plate should be below the magazine, 58; floor of the plate should not be too low, 58; sidewise adjustment of the plate, 58; must be bent for big mats, 58; may be thinned, 59; all should be solid, 59; first guide should be solid, 59.

Assembler slide: hits a hard spot, 68; bracket may be loose, 67; assembler slide fails to return, 68; chatter, 68; assembler slide return spring need not be stiff, 69; to remove assembler slide, Linotype or Intertype, 69; installing an extra spring on assembler slide, 69-70.

Assembling elevator: should seat every time, 68; side play, how to take it up, 72-73; should fall by its own weight, 73; to remove, 73; delivery slide releasing wire screw should be free, 73; to adjust width between front and back, 73; do not file fitted surfaces, 73; to

repair the gate, 74; to lubricate the duplex rail, 74; to install matrix buffer, 74; to check and repair gate, 74-75; to repair back half, 75; fiber buffer should not be used when badly worn, 75; setting the gate, 75-76; square up the gate, 76; binds against line delivery channel, 76; correct height, 76; operating lever affects height of assembling elevator, 76; should stay up when mats are sent in, 76; stop bar banking plates may be on upside down, 77; mats will not deliver in bold-face position 77; adjust line delivery releasing wire, 77; spaceband buffer should be replaced, 77; mats jump out, 82; gate too tight makes mats jump out, 82; first mat jumps out, 83; heavy mats jump out, 83; spacebands do not settle down, 94; fiber buffer may keep spacebands up, 94; (see also Spacebands).

Auxiliary line safety: saves black-face squirts, 109; is worth the price, 202.

B

Back knife: setting, 217-218. (See Knives.)

Back squirts: poor lockup most common cause, 166; may be caused by pump stop, 118; hot metal a common cause, 166; metal on back of mold, 166; cold metal will cause, 166; too much metal in pot will cause back squirts, 167; dirty plunger will cause back squirts; tight plunger or dross ring will cause, 167; short, spongy stroke of plunger may cause back squirts, 167; may be caused by broken pot spring, 167; worn vise shaft may cause, 167; recasting big slugs must be slowed down, 168; broken pot cam roller bearing may cause back squirt, 168; high mouthpiece heat may cause, 168; may be caused by broken pot cam roller bearing, 168; may be caused by broken pot leg bushing, 168; may be caused by pump stop bracket set too high, 168; may be caused by pot lever rubbing on cam, 168; "after"-squirts, various causes, 168; broken crucible lug may cause, 169; may be caused by loose tie rod, 169; caused by shallow cross vents, 169; cross vents too big at bottom, 169; caused by high spot in throat, 169; caused by loose vise locking screw, 169; caused by faulty electrical controls, 169; mouthpiece does not lock up at lower edge, 170; sprung mold posts may cause, 170; may be caused by warped disk, 171; not usually caused by warped mold, 171; may be caused by mold ground down, 171; cause of squirts when machine changed to short measure, 171-172; how to clean up, 172; squirts on short slugs only, 178; may be caused by distorted mouthpiece locking up against new mold, 183; may be caused by new mouthpiece locking up against a bad mold, 183.

Black-face flipper: causes double-black squirts, 109; machine should have auxiliary line safety, 109.

Border block: use of Linotype block on Intertype, 252; slugs stick to border slide, 152.

Brake: on drive shaft, not needed, 252.

C

Channel entrance partitions: must be aligned with magazine, 243; general care, 243; much trouble caused by partitions that have lost resilience, 244; upper parts of partitions should be aligned, 243; replacements, 244; lateral adjustment of Intertype, 243; space between partitions and magazine, 245; alignment of floor with floor of magazine, 245; may be torn up when free gear in clutch is not free, 246; reasons for mats striking, 247.

Chilled slugs: (see Slugs).

Chute rails and springs: (see Assembler).

Chute spring: (see Assembler).

Clutch: machine does not start, 102, 252; cracks when first elevator goes down, 111; setting of clutch, 250-251; if assembler slows down when clutch slips, 251; machine keeps going when clutch is off, 251, 252; brake on drive shaft not needed, 252.

Cold face (see Slugs).

Crucible: reaming, 159-161; (see Pot).

D

Distributor: stops may be caused by worn toes, 40; brass dust around the mat lift, 54; snow gathers on distributor box, 138; stopping-bar type, 243; mats must clear partitions, 243; mats lying flat on channel entrance partition, 243; adjustment of distributor beam, 244; space between bottoms of mats and tops of partitions, 244; adjustment of mat guard, 245; adjustment of mat guard on spiral automatic, 245; hooking the spring on spiral automatic, 246; stopping bar should be free and with not too strong a spring, 243; clutch springs are stretched too far, 246; to adjust the clutch spring collar, 246; to oil the distributor clutch, 246; fails to stop when gate pulled down, 247; mats hit on channel entrance partitions, 247; mats jiggle on bar, 247-248; leveling affects distribution, 247, 249; mats drop late, 248; mat guard must not be set too close, 248; mats fly out on floor, 248; mats twist on bar, 248; heavy 14-point has to be carefully adjusted for distribution, 248; too many mats in channel will cause stops, 249; too much speed causes trouble, 249; vibration of floor causes trouble, 249; bent ears on thin mats cause many stops, 249; battered magazine entrance causes stops, 249; how to make large mats drop in a narrow auxiliary, 249.

Distributor box: rails must be level, 239; adjustment of mat lift, 239; spring in front rail must be correctly bent, 239; bar point must hold back second mat, 239; separator for big mats on slow distributor, 239; parts to be replaced, 238; long bar points should be avoided unless necessary, 238; bar must be free to move up and down, 238; rails should be replaced in pairs, 238; fitting to machine, 240-241; adjustment, 239; rebuilding, 238-239; positioned by three lugs, 240; should not move up and down on pins, 240; to adjust the mat lift, 240-241; if mat lift picks up two mats, 241; to set lift cam on back screw, 241; general suggestions, 241-242; should have replacement for front rail spring, 242; mat lift fails to pick up last mat, 242; to remove bar point from bar, 242; mats fail to feed into screws, 242; to remove wrong front or turned mat, 242; if rails set too close, mats will jump out on floor, 248; rails wrongly set will make mats twist on bar, 248; thin mats lifted two at a time causes bent ears, 249.

Distributor bar: should be proper distance from machine frame, 240.

Distributor shifter: care and adjustment, 237.

Double-black squirts may be prevented by auxiliary line safety, 202. (See Black-face flipper).

Drive shaft pinion: when worn, makes machine jerk, 251.

Dross: in throat, 146; dross behind the mouthpiece causes chilled slugs, 146, 183, 187; how to test for dross in throat, 184.

E

Eccentric in mold slide lever: adjustment, 125.

Ejector: must have clearance between mold and ejector blade, 136; check list of causes for stuck slugs, 188; to adjust ejector lever pawl, 204; to remove ejector lever pawl, 204; broken buffer spring will make slugs jump out on floor, 204; slugs tip when delivering, 204-205; when Intertype ejector hard to change, 205; repairing old style ejector slide, 205-206; repairing universal ejector slide, 206; slugs pull back in mold, 210; welded lever may interfere with setting of ejector lever pawl, 210; improved controller link may be applied, 207; to replace Intertype blade in universal ejector, 207; when ejector blade sticks in hollow slug, 207; do not pound out stuck slugs, 207; when Intertype blade jams after kicking out a short liner, 207-207; to replace master blade in Intertype ejector, 208; remove ejector lever link on Intertype when lowering vise to second position, 208; ejector blade scores inside of mold, 209; trouble caused by warped mold cap, 209; slugs eject with difficulty, check list, 209; why do slugs pound at ejection? 209.

Escapement (see Verge rack).

Escapement lever (see Goosenecks).

F

Face (see Slugs).

- First elevator: it must rise after it seats, 107; seating adjustment, 107; vise automatic adjustment, 107; adjustment for height, 107; connecting link, 107; connecting link used to supplement height adjustment, 108; to set the gibs, 108; first elevator filling piece (see Black-face flipper), 109; should rise between justifications, 109; seats with a bang, 110; first elevator cam roll must turn, 111; jerks upward after cast, 111; jiggles coming down from transfer, 111-112; should not bind at transfer, 112; cuts groove in face plate, 113; machine stops on casting but not a tight line, 115-116; misadjustment of downstroke may cause squirts, 202; too deep a downstroke may cause damage to letter on right end of line, 224; pounds on upstroke, 226; gibs must be set before setting transfer, 227.
- First elevator jaws: front jaw adjusting bar must have a bevel, 102; broken spring pawl will stop line, 102; last mat falls from end of line, 103; duplex rail levers worn flat, 104; lugs on duplex rail should be flush with surface, 104; duplex rail should not be loose, 104; duplex rail should not stick, 104; test with a new thick mat, 105; clean out metal around screw head, 105; adjusting bar to be replaced, 105; adjusting bar may be honed, 105; to adjust the back bar, 105-106; duplex rail lugs should be flush with surface, 105-106; back jaw should be parallel with front jaw, 105; back jaw should be same height as front jaw, 106; back jaw should be even on the end with front jaw, 106; spring pawls may be ground down, 106; Intertype spring pawls may be put in with grease, 106; tension on spring pawls must be equal, 106; adjustment of the line stop, 106; .005" at delivery channel, 108; must be parallel with mold, 109; duplex rail must not be loose, 110; lugs on duplex rail may make elevator seat with a bang, 111; line delivery long finger's spring rivets must be smooth, 111; mat jumps out of line, 112; mat at end jumps out of line, 112; mat in middle of line jumps out, 112; mold cap strikes jaw at lockup, 112-113; bad jaws, bad duplex rail, or broken jaw spring pawl will cause front squirts, 201; new adjusting bar may be needed to keep letters parallel with slugs, 223; must be level for good transfer, 227; setting of duplex rail lever block, 228; 30-pica lines catch as second elevator starts up, 233.

Floor wax: helps prevent accumulation of metal, 138.

Front squirts: caused by loose lines, 201; caused by main shaft bearing freezing up, 201; caused by tight lines, 201; may be caused by pump stop, 201; caused by first elevator paws, 201; may be caused by matrix with swollen toe, 201; if mold disk comes too far forward will prevent spread of line and cause squirt, 202; misadjustment of down-stroke may cause 202; cleaning up should be gentle, 202-203; cleaning metal from molds is not difficult but takes patience, 203; clean metal from vise automatic, 203.

G

Gas torch: do not fasten under mouthpiece, 139.

Goose-necks: must be straight and have even stroke, 6; may be peened, 6; take out one at a time, 43; polish hinge rod, 44; polish ends, 44; may have to be bent, 44; should fall by own weight, 44; tips should rise to same height, 44; may be lubricated on machine, 44; should have extra on hand, 46.

Grounds: most electrical trouble in pots comes from grounds, 191; testing for grounds, 191, 198; can be detected with machine in motion, 191.

H

Hairlines: nature of, 38; dry main cam shaft bearing may cause, 38; vise closing difficulties may cause, 38; caused by cleaning solution, 37, 38; caused by lines sent in without space-bands, 37; caused by loose lines, 38; caused by improper bands, 38; caused by loose justification, 38; how to weed out, 39; to prevent 39; suddenly appear on Intertype, 39.

Hempel: quoin used to repair magazine, 52.

Heating the pot: cleaning the gasoline burner, 189-190; rebuilding a gasoline burner, 189; pot relief plug should be used on gasoline burner, 189; how a gas burner should work, 190; appearance of flame indicates trouble, 190; baffle plates needed 190; governors, 190; frosty face at one end of slug, 224-225; when pot fails to heat, check list, 197; when metal overheats, 197; mouthpiece does not heat, 197; thermostats, 190; mercury thermostat obsolete, 190; new type mechanical thermostat can be applied to outstanding pots, 193; Intertype electric thermostat, 195; thermostat on lower pot when Monomelt is used, 196; to remove mercury thermostat, 196; to remove thermostat from the frozen pot, 197; a ground makes large spark at thermostat, 197; pot heat creeps, 199; thermostat must not test on bottom of crucible, 199; Linotype control panel and fuses, 193-194; the clapper switch, 194; hum on alternating current, 194; Intertype control panel, 196; Intertype closing coil adjustment, 196; hot spot in element squirts metal upward, 197; fluttering switch, 198; mercury tubes cannot be repaired, 199; field coil can be tested, 194; resistance coil can be tested, 194; 150-watt light bulb may be used for resistance coil, 198; rheostat may be partly burned out, 194, 197; general observations on electric heaters, 191; Linotype electric heaters, 191-192; to remove Linotype crucible heaters, 192; to remove Linotype crucible heaters that are frozen over, 192; Micro-Therm heaters, 195; Intertype heaters, 195; testing Intertype heating elements, 195; to remove Intertype throat heater, 196; to remove Intertype side element, 196; when plunger frozen, to remove Intertype heating elements, 196; machine will not cast if throat element is open, 195; machine will run on one pot element, 192; wires have special insulation, 192; crucible must be removed to install throat heater, 192; mouthpiece element easily removed, 192; do not run heaters in open air, 199; adjustment of Monomelt upper pot, 197; most trouble in electric pots comes from grounds, 191; testing for grounds, 198; (see also Grounds).

Hollow slugs (see Slugs).

Hone: for use on mouthpiece, 182.

Hot spot: on immersed elements, 197.

Hum: from electrical controls, 194.

I

Intermediate bar and pawl: 227-228.

Intertype keyboard spring: does not function, 4.

J

Justification: strength of springs, 37, 93; vise closing difficulties may cause hairlines, 38; line does not justify on Intertype, 39; to test strength, 93; springs cannot be too soft, 94; cam roll causes stops at casting, 116; springs need oiling, 121; how to clean out oil holes in levers, 121; difference in justification springs, 122; lines vary in length on left end, 122; vise closing wedge felt wipers should be oiled, 123; on Intertype, border block recasting pin causes squirts, 128; mold disk's forward thrust may prevent spread of line and cause squirts, 202.

K

Keyboard: mat fails to respond, 1, 5; mat drops when keyrod works by hand, 4; delayed-action response, 13; belt should be tight, 13; double response, 13; dirt around banking bar makes doubles, 14; temporary remedy for doubles, 13; banking bar too high, makes doubles, 14; pins missing from banking bar, 14; locking rod makes doubles, 14, 17; continuous response, 15; mats drop without hitting, 16; mats drop without being hit on Intertype, 16; fulcrum rod dirty, 16; burrs on weights cause trouble, 16; fulcrum rod should be emerald, 14; key

lever must be clean, 14; key lever may be sprung, 14; key lever burred on end, 16; correct speed, 16-17; too much speed causes transpositions, 78; speed may have been changed, 83; leveling is essential, 18; heat does not bother, 18; cold makes sluggish action, 18; remove for cleaning, 22; to remove models 1, 3, and 5, 23; to remove models 8 and 14, 23-24; to remove swinging, 24; to remove Intertype, 25; to dismantle, 25; keybuttons can be washed, 26; parts to be washed, 26; process of cleaning, 26; assembly of, 26-27; frequency of cleaning, 27; trouble develops after cleaning, 44; rebuilding, 45-47; to remove and replace key levers, 45; key levers may be bent, 45; fulcrum rod can be shifted, 46; weights can be shifted, 46; adjusting the touch, 47-48; cleaning the bail box, 50; keyrds on auxiliary have double springs, 50; care of the bail box, 50; to remove the bail box, 51; keyboard may be raised, 10.

Keyboard cams: must be oiled and must drop to roll, 13; cam drops but does not turn, 11, 12; cam fails to turn after sitting a few minutes, 13; rubber roll may be glazed, 5; plunger should clear by .005", 4; cam yoke may be gummy, 4; cam pivot may be dry, 5; cam or pivot may be worn, 5; stop pin in cam may be worn, 14; how to repair stop pins, 17; trigger may be gummy, 4; when trigger bite is excessive, 10; trigger seat filed out causes trouble, 14, 16; cam yoke may be spread, 9; stop pin on the "comb" may be bent, 5; stop strip may be worn at point, 14; stop strip may be repaired, 15; to position stop strip, 18; if stop strip falls inside cam frame, 18; stop strips to be replaced, 46; locking bar may be too low, 4; banking bar may be out of position, 4; most trouble on back frame, 18; cleaning, 28-30; unwashed, 29; what oil to use, 30; how to distinguish cam frames, 30; oiling, 28, 30; transposing cams may clear up trouble, 44; set screw in rubber roll shaft bushing sometimes must run loose, 10, 28; long screws in ends of frames should not be tightened, 10; cam frame pieces may not fit, 10; cam wire may be bent or dirty, 4; new cam yoke wires best, 46; replaced with trigger out of position, 15; trigger locking wire, 30; trigger may be shifted, 46; (see also Space-bands).

Keybuttons: can be washed, 26.

Keyboard: transpositions (see Transpositions).

Keyrod: must ride high enough, models 1 and 5, 3; should return to lower position, 4; may be stretched, 9; cleaning, 42; flush out guides, 42; to clean on machine, 41; lower guide may be worn, 46; may be chewed up at the verges, 46; to remove models 1 and 3, 41; to remove model 5, 41; to remove models 8 and 14, 41; to remove old style Intertype, 42; to remove new style Intertype, 42; Intertypes have sidewise adjustment, 10; to replace, 43; to replace a single keyrod, 48-49; spaceband keyrod worn at banking bar, 88.

Knife wiper: general observations, 221; may make first elevator seat with a bang, 110; to fasten lower mold banking block, 221; fails to remove the tinfoil shaving, 222; may damage top end of slug, 224.

Knives: slugs tapered top to bottom, 212; slugs thinner in middle, 212, 213; hump at bottom of ribs, check list, 203; slugs trimmed too fat will bow up, 216; knife trims well on all but 6-point, 216; miscellaneous causes of bad trim, 217; variation in the height of slugs caused by worn mold disk stud, 219; how often they should be sharpened, 220; knives should not be home-ground, 219; erratic trim caused by worn vise locking screws, 123; loose mold disk causes varying trim, 211; to repair loose mold disk hub, 211; one mold is square the other is not, 214; when shimming job is necessary, 214; method of shimming molds, 214-216; use of sector screws on Linotype, 215, 216; left-hand knife should trim overhang at top, 216; left-hand knife should not trim too much, 222; left-hand knife should not be moved, 216; setting the side knife, 211-212; to set side knives without a micrometer, 217; adjusting knife block gibs, 216; when are side knives worn out? 220; should be ground in pairs of equal height, 213; back knife may cause shiny bottom, 188; how to set the back knife, 217; always use new back knife, 217; do not try to readjust an old back knife, 218; metal gathers under backknife, 219; shimming molds for height, 217-218.

L

- Line delivery: adjustment for end of stroke, 100; adjustment for return, 100; speed of going over, 99; delivery slide blocks bind, 102; when to replace long finger blocks, 97; swollen toes cause trouble, 102; last mat falls from end of line, 105; squabbled lines on Intertype, caused by broken coiled spring, 103; right end of delivery channel rail worn, 103; delivery channel aligning piece, 103; brass friction plate should be watched, 98; replacement of line delivery link is not difficult, 100; screw in the trailing piece can be fastened, 98; delivery lever link screw should be pinned, 98; to remove the delivery slide, 102; adjustment of line delivery channel, 100; adjustment of line delivery channel rails, 101; line delivery rails must be same height, 101; grinding off boss from line delivery channels, 101; new line delivery spring sometimes necessary, 99; lubrication, 97; curve in the short finger, 97; long finger should be straight, 98; copper spring on split finger should not be too strong, 98; long finger crawls to shorter measure, 98; machine does not start, 102.
- Liner: nibs knocked off, 135, 224; to repair bent liners, 135; worn liner may cause squirts, 172.
- Lockup: to adjust mold disk lockup, 124-125; to test mouthpiece lockup, 177; red lead used in testing, 178; soot used in testing, 178; mold disk's forward thrust may cause squirts, 202; pot lockup can affect height of slug, 218.

M

- Machine: fails to start, 102, 252; machine stops at casting but not a tight line, 115-116; machine stops at transfer, 115; keeps going when clutch is off, 251, 252.
- Magazine: mat stuck in magazine, 2; mat in place but won't drop, 2; mat with short toes may not drop, 40; remove escapement cover to see why mats don't drop, 11; escapement cover should be bowed, 3; burrs at bottom may impede mats, 11; to loosen screws may help mats, 11; thick mats may rub against binding screw, 5; binding screw may be too tight, 5; proper cleaning, 31; use carbon tetrachloride for cleaning, 36; importance of carbon tetrachloride, 31-32; do not use graphite, 33; frequency of cleaning aluminum, 33; aluminum magazines sometimes require graphite, 33; graphite on models 25 and 26, 33; remove hairs after cleaning, 32; automatic lock should be inspected, 31; always check toes of mats when putting magazine on machine, 34; warped or sprung, 51; taking apart, 51; putting back together, 52; remedying minor bends, 52; to take a burr from a channel, 3, 52; to prepare a channel broach, 52; gibs to hold magazine frame in place, 53; to identify the top frame, 53; taking off, of an old style 8, 52; to take out the middle verge rack of an old style 8, 53; to remove flat mats, 2; too many flat mats, 12; dirty magazine may cause transpositions, 78; battered magazine entrance causes stops, 249; thin mats in split magazines, 49; trouble with distribution on auxiliary, 49-50; trouble with escapement on auxiliary, 49-50; punch-board auxiliary, 50; channels out of alignment on auxiliary escapement, 51.
- Main cams: use oil on main cams, 250; starting and stopping adjustments, 250-251; eccentric screw adjustment, 250; flange collar adjustment for clutch, 250-251; setting of forked lever, 251; should bounce back at stopping point, 251; machine jerks as it turns over, 251.
- Matrices: should not hit assembler entrance partitions, 10, 57; toes stick out but do not drop, 6; fails to slide out of magazine, 11; should not tip forward when you open assembling elevator gate, 75; mats jumping out of assembling elevator caused by stiff star wheel or tight assembling elevator gate, 82; dirty mats may cause transpositions, 78; frequency of cleaning, 35; cleaning solutions, 34, 36; cleaning with solutions may cause hairlines, 37; rubber eraser for cleaning, 34; can be cleaned with carbon tet, 34, 35; line mats up in galley for cleaning, 35; cleaning casting side, 35; gum accumulates on sides, 35; some dirt should be left on sidewalls, 34; what causes hairlines? 36-38; jump out of line in first elevator jaws, 112; catch in first elevator jaws as second elevator starts up, 233; sloppy

back jaw is bad, 55; summary of kinds of damage, 54; bend on upper ears, 54; check list, 242; mold shaving tops of toes, 40; toes damaged, 54; burrs on lower toe, 54; crushed toes but not tight lines, 116; swollen toe may cause front squirt, 201; when to discard for wear on toes, 40, 55; toes reduced .020" cause twisting on bar, 248; bent ears on thin mats cause many stops, 249; too many in channel cause mysterious stops, 249; thin mats may double up, 55; thin mats in split magazines, 49; be careful with mat file, 55; installing a new font of mats, 55; cause for letters out of alignment, 40; thick mats may hit magazine guard strip, 5; rebuilding, 40.

Matrix delivery belt: (see Assembler).

Matrix hook: how to make, 2.

Micrometer: to set knives without, 215-216.

Metal: too much metal in pot will cause back squirts, 167; should be cleaned, 162; suggestions for proper care, 164; value of flux, 163; use of flux; pigging is important, 163; foundry type contaminates, 162; indications of zinc, 163; properties of ingredients, 163; converting stereo into linecasting, 162; should be analyzed, 162; how important are exact proportions? 165.

Model 15: to make assemble better, 70-71.

Molds: types of mold, 132; snow gathers on front, 138; floor wax helps prevent accumulation of metal, 138; do not leave locked on cast, 139; be sparing with mold polish, 133; may be ground down by mold polish, 171; proper way to clean, 133; after polishing with graphite, wipe off, 36; do not remove molds unless for repair, 133; how to remove a mold for repair, 133; how to tell if a mold is warped, 134; to straighten mold posts, 134; molds out of square, 136; loose mold screw will cause uneven letters, 225; to fasten lower mold banking block, 221; oversize mold cap screws, 135; metal on back causes backsquirts, 166; loose mold screws cause squirts, 128; bad mold may cause squirts with new mouthpiece, 185; worn liner may cause backsquirts, 172; warped molds seldom cause squirts, 171; spring mold posts may cause back squirts, 170; must have clearance between mold and ejector blade, 136; slugs pull back in mold, 210; ejector blade scores inside of mold, 209; ejection trouble caused by warped mold cap, 209; to change liners, 134; nibs knocked off liners, 135; nibs on liners damaged by universal ejector, 224; repairing bent liners, 135; process of seating mold properly, 134, 215; molds must be parallel with vise jaws, 125; one mold is square, the other is not, 214; shimming job necessary, 214; shimming molds for height, 217-218, method of shimming molds, 214-216; to remove Intertype mold, 134; mold cap strikes first elevator jaw at lockup, 112-113; do not remove molds to clean up squirts, 172.

Mold disk: movement of the disk, 124; disk should not rise, 109; to adjust mold disk lockup, 124-125; vibrates as it locks up, 138-139; vibrates as it revolves, 139; mold disk does not make its quarter turn, 141; turns hard, 129; causes of pounding or snapping, 128; timing, 131; loose mold screws cause squirts, 128; molds must be parallel with vise jaws, 125; shimming molds for height, 217-218; mold disk guides affect height of slug, 218; worn mold disk stud may cause variation in height of slugs, 219; how to shim a worn mold disk stud, 211, 219; to fasten lower mold banking block, 221; rebounds against line, 224; bad mold disk lockup causes snow, 138; too much forward-and-back play in mold slide, 124, 126; sloppy forward thrust makes snow, 138; warped disk may cause squirts, 171; to check for warped disk, 127; a warped disk can be corrected by shimming molds, 127, 214; forward thrust may cause squirt, 202; improper forward thrust will cause uneven letters, 225; to remove mold cam shoes, 126; when to replace mold cam rolls, 126; to remove mold cam lever, 127; to set the mold disk guide support screw, 128; to adjust mold slide gib, 128; to remove mold slide, 129; to remove mold disk but not slide, 130; to oil the mold slide, 139; Intertype mold cam safety lever adjustment, 129; rebuilt disks, 127; do not fasten gas torch under mouthpiece, 139.

- Mold disk banking block: when to replace, 137; mold must not bank on at casting, 137.
- Mold disk locking studs: should be oiled, 136; replacement, 136-137; blocks must be doweled, 137; disk should not rise, 109.
- Mold polish: may damage molds, 171.
- Mold slide (treaded under Mold disk).
- Mold turning mechanism: mold disk does not make its quarter turn, 141; care of the mold turning cam shoes, 140; to adjust the cam shoes, 140-141; to apply cam shoe wiper, 140; care of the mold turning bevel gear, 140; mold turning cam can be welded on machine, 141; do not oil mold disk turning brake, 141; oil shaft on Intertype, 142.
- Monomelts: useful, 252; care of electrical heating equipment, 252.
- Mold wipers: don't use mold polish on wiper, 171; failure to keep mold clean will cause back squirts, 166; back wiper must bear against the disk at normal, 143; use oil on back mold wiper, 142; do not have oil in the mold around liners, 143; oil on front mold wiper, 142.
- Mouthpiece: to test mouthpiece lockup, 177; does not lock up at lower edge, causes back squirts, 170, 182; pot leg adjusting screw loose may throw off lock-up, 168; how to hone, 181-182; venting a mouthpiece, 178, 180; cleaning out vents and holes, 180; cross vents must be deep enough, 180; shallow cross vents cause back squirts, 169; how to open vent properly, 179; cross vents too big at bottom, 169; how to close vent, 179-180; when it has to be removed, 173; how to remove a wedge mouthpiece, 173-174; how to remove a screw mouthpiece, 174-175; grinding in wedge mouthpiece, 175; to fit a screw mouthpiece, 175-176; should be straightened before grinding, 175; to fit Intertype, 176; how to seal, 176; may be put on without sealer, 176; how to stop a leak, 181; jet marks should not run over edge of slug, 171; holes must be properly positioned, 176-177; holes should lie close to back of slug, 225; end holes should be open, 225; partly covered hole causes cold face, 185; hole partly closed causes letters to fall off, 185; holes may be moved by shifting pot leg, 185; position should be noted before removal, 174; to locate when position lost, 176; enlargement of mouthpiece holes, 183; an extra hole may help, 225; holes 6 points apart, 147; how to drill out holes, 182; if drill breaks off in holes, 183; pot cracks on breakaway, 210; holes may be broached or tapered, 210; mouthpiece does not heat on electric pot, 197; may be distorted by casting against a bad mold, 183; use of oversize screws, 174-175; how to test for dross in throat, 184.

O

- Oil: use oil in honing mouthpiece, 182.

P

- Penetrating oil: use in removing mouthpiece, 174-175.
- Plunger: general action, 150; proper action, 151; cleaning plunger, 151; should have a full, free stroke, 186-187; drilling hole in bottom, 151, 186; adjustable vents, 152; stress of plunger spring, 186; lack of tension of plunger spring causes chilled slugs, 187; to set the spring, 155; to change the spring from one notch to another, 155; to remove the plunger spring, 154; to replace the plunger spring, 154-155; oversize spring, 155; riding too low in well makes hollow slugs, 151, 186; oversize cam roll may be necessary, 186; dirty plunger will cause back squirts, 167; short, spongy strokes may cause back squirts 167; pump stop bracket set too high, causes back squirts, 168; becomes disconnected, 153; plunger pin keeper spring should be spring steel, 153; how to loosen a stuck plunger, 153-154; dross ring in crucible, 151; metal collects on plunger rod, 152; aluminum sleeve for rod, 152; symptoms of a loose plunger, 159; loose plunger causes hollow slugs, 159; reaming of the crucible, 159-161; too big a plunger, 162.

Plunger spring (see Plunger).

Pot (see Heating the pot): to test the lockup, 177; lockup can affect height of slugs, 218; cleaning pot well, 151; greasing pot lever roll, 148-150; thermometer temperatures, 147; to set temperature without a thermometer, 146; action of the pot is important, 144; must retreat after first lockup, 138; cold face caused by clogged throat, 183; how to test for dross in throat, 184; dross should be flushed out of throat, 175; mouthpiece holes may be moved by shifting legs, 185; to remove thermostat from a frozen pot, 197; can be melted down with a blow torch, 193; to remove Intertype throat heater, 196; to remove Intertype side element, 196; do not run heaters in open air, 199; failure of pot to retreat between justifications will cause uneven letters, 225; to remove the crucible, 192; to remove metal pot, 200; electric and gas pot interchangeable, 198; packing gas pot jacket, 199; packing electric pot crucible, 198-199; pot cracks on breakaway, 210; pot lever broken by double black-face, 123; eye-bolts, 144-145; metal level should be kept up, 145; dross in throat, 146; dross ring in well, 157; dross ring may cause back squirts, 167; broken pot spring may cause back squirts, 167; broken pot leg bushing may cause back squirts, 168; use hard oil on pot leg bushings, 200; pot lever should not rub on cam, 168; broken crucible lug may cause back squirts, 169; do not leave screw out of pot top in front, 169; lockup pressure, 147-148; gauge for pot spring pressure, 148; most crucible crack on gas heat, 156; quick drop may cause crack in crucible, 155; pot relief plug will help prevent cracking, 156; repairing or welding a cracked crucible, 156-157; reaming the crucible, 159-161; reaming is for an expert, 186; cost of leaving heat on over night as opposed to turning it off over night, 157-158.

Pot well cleaner: type to use, 152.

Pump stop: adjustment, 117; adjusted but does not function, 117; pump stop adjustment on Intertype, 117; adjustment for height, 118; should not clear block too much, 118; worn cam or roll may cause trouble, 117, 118; may cause hairlines, 201; may cause squirts, 201; steel wire spring should operate, 118; auxiliary spring not needed, 118.

Q

Quick drop: will improve face on big sizes, 184.

R

Red lead: used in testing mouthpiece lockup, 178, 182.

Rheostat: machine will not cast if rheostat is open, 195; one point may be burned out, 194, 197.

Rubber rolls: installation 19, 20; remove gear before installing, 21; should be 1 inch in diameter, 5; should be washed, 28; deep groove makes spaceband transpositions, 15, 92; groove may indicate bent escapement plunger, 7; may creep out from under cam, 12; to prevent creeping, 21; creeping roll makes spaceband transpositions, 92; corrugated may not be used on Intertype, 20; if one letter deeply grooved, 21; can be patched, 21; screws should not be tightened on bushings, 28; may have gasoline or oil on it, 12; may be running backward, 12.

S

Slugs: good slug is parallel, 212; miscellaneous causes of bad trim, 217; knife trims well on all but 6-point, 216; bow up at the top, 135-136; too fat, will bow up, 216; left-hand knife should trim overhang at top, 216; slugs tapered from top to bottom, 212; slugs thinner in the middle, 212, 213; hump at bottom of ribs, check list, 213; to get slugs parallel without a micrometer, 215-216; letters on butted slugs do not align, 223; new adjusting bar may be needed to keep letters parallel with slugs, 223; letters hang over at end of slugs, 120-121; lines vary in length on left end, 122; capitals trimmed off top, 109; check list, 222; letters fall off of slug, 185; sides of characters damaged by spaceband, 223; descenders nicked off, 223; top end damaged, 224; letter nicked at right end of line, 224; certain letters pressed down, 224; some letters are low on slug, 225; frosty face on one end, 185; check

- list of remedies, 187-188; frosty face at one end, 224-225; check list of causes for chilled slugs, 187; poor face caused by shallow vents, 180; cold face caused by dross in throat, 146, 183, 187; lack of tension of plunger spring causes chilled slugs, 187; cold face on recasting border, 225; on big mats, move to left or right to get good face, 185; quick drop will improve faces on big sizes, 184; do not expect to print big sizes on enamel stock, 184; first few slugs have shiny bottom, 219; shiny bottom, check list of causes, 188; pot lockup can affect height of slugs, 218; variation in height caused by worn mold disk stud, 219; mold disk guides can affect height of slug, 218; holes must be properly positioned, 176-177; jet marks should not run over edge, 171; one mold is square, the other is not, 214; when mold shimming job is necessary, 214; broken buffer spring will make slugs jump out on floor, 204; slugs tip when delivering, 204-205; check list of causes for stuck slugs, 188; slugs pull back in mold, 210; pot cracks on breakaway, 210; why do slugs pound under ejection? 209; causes of hollow slugs, 183-187; check list of causes of hollow slugs, 187; better slugs obtained with less spring pressure, 186; transfer spring in place of plunger spring causes hollow slugs, 187; hollow slugs caused by lack of ventage, 147; hollow slugs caused by loose plunger, 159; recasting big slugs must be slowed down, 168.
- Seating molds: proper method, 134.
- Second elevator: adjustment at transfer and at distributor box, 234; must be in good shape for transfer, 228; bar plate should not move, 227; lubrication, 234; dismantling, 234; repairing and rebuilding, 225; must be aligned with distributor box bar, 235; starting spring replaced at transfer, 235; jiggling, 236; wrong bar length causes difficulty with transfer, 236; new bar may have to be "broken," 236; extra spring to minimize swinging, 236; distributor shifter, 237.
- Sennett Positive Assembler: is efficient assembler, 79.
- Shimming molds: 214-216.
- Slug lever: setting and care, 222.
- Snow: gathers on molds, 138; gathers on distributor box, 138; caused by bad lockup, 138; caused by sloppy forward thrust, 138.
- Spaceband box: action of box, 84; to remove, 85; to replace and test, 89; to test life pawl, 89; to install new lift pawls and screws, 85; to adjust the lift pawls, 86; to install new rails, 85; rails may curve in, 86; to set the center bar, 86; to adjust the chute, 87; to adjust the short chute, 87; worn holes where shaft works, 85; holes may be enlarged, 85; levers should be tight on shaft, 85; to adjust the Intertype box, 90; the Linograph box, 91; if the top end of the band goes over, 88; one ear hangs back, 89; double bands, 89; spring on spaceband weight, 88; spring on spaceband keyrod, 88; spaceband keyrod worn at banking bar, 88; enlarged hole at right end of spaceband lever, 88; spaceband lever on model 1, 88.
- Spacebands: should not accumulate metal, 38, 96; how to clean, 95-96; frequency of cleaning 96; proper rubbing board, 96; proper graphite, 96; do not use powdered mica, 96; do not use Bon Ami, 95; repairing, 91; do not buff on emery wheel, 91, 96; doubles, 15, 89; weak spring makes doubles, 15; tight spring cuts groove in rubber roll, 15; transpositions, 92-95; to test assembly, 89-90; do not settle down in assembling elevator, 94; rise first from the right, 93; invariably bent to the right, 94; should not bend, 93; to test strength of justification spring, 95; roughen justification bar to avoid bent bands, 94; strike on top of mats, 93; damage line just cast, 224; weight must have a spring, 12; keyrod holes may need drilling out, 12; keyrod may be worn in notch, 12; keyrod must have a spring, 12; keyrod may be beaten down, 46; keyrod hole may be enlarged, 46; worn spaceband ears, 91; spacebands twist in channel, 232; give trouble at transfer, 232; do not use at end of line, 92; do not use two together, 92; always run with sleeve to right, 92; should be replaced when a new font of mats installed, 53; kind to buy, 92; number in a set, 37; do not mix sizes, 91; oversized spaceband cam sometimes necessary, 92; should have extra cam on hand, 46; may be tapered on bottom, 95; lines sent in without, may cause hairlines, 37; use of laundry soap to help hairlines, 37.

Squirts: caused by border block recasting pin on Intertype, 128.

Starting and stopping adjustments (see under Main cams).

Star wheel (see Assembler).

Stone: proper stone to be used in honing mouthpiece, 182.

T

Thermometer: how to set temperature without, 146.

Transfer: complete setting of transfer, 226-229; mats should go over freely, 227; adjustment of transfer channel, 228-229; vertical alignment of the two elevators, 229; second elevator must be in good shape, 228; setting of duplex rail lever block, 228; setting of intermediate bar, 227-228; height of intermediate bar, 229; intermediate bar pawl, 227; transfer slide and finger, 230; transfer finger may have to be bent, 230; Intertype safety latch, 230; adjustment of transfer releasing lever, 230; 30-pica line hangs when it goes up, 232; transfer finger hits a 30-pica line, 231; 30-pica line will not go over properly, 231-232; 30-pica lines catch in jaws as second elevator starts up, 233; finger does not push bands under pawl, 232; care and adjustment of spaceband pawl, 231; spacebands twist in channel, 232; bands are left in channel, 232; bands do not go into the box, 232; mats spill out at transfer, 226-229; spaceband friction spring needed, 230, 233; leathers in transfer channel may be useful, 230; 14-point bold face will not transfer, 233; stop pawl for mats may be installed, 233; difficulty may be caused by wrong second elevator bar length, 236; first elevator pounds on up-stroke, 226; machine stops at transfer of vise automatic, 115.

Transpositions: check list, 78-79; caused by delayed-action response, 13; caused by dirty mats, 78; caused by dirty magazine, 78; caused by too much speed of keyboard, 78; often caused by operators, 80-81; 6- and 24-point together call for less speed, 79; Sennett Positive Assembler is efficient, 79; spaceband transpositions, 92-83.

V

Verge rack: shake out loose dirt, 32, may be graphited, 32; to remove from model 5, 8; to replace verges, or plungers, 7; one verge may be removed alone, 7; care of escapement plungers, 4; polish and graphite plunger, 7; plungers may be bent purposely, 7; plunger must be free, 7; gouge in end of plunger, 6; pawl must go to the floor of the channel, 3, 6; to install pawl, 3; springs may be weakened, 5; to rebuild, 7-8, 47; verges should be kept in order, 44; verges may be gouged, 6, 47; verges may have worn hole, 6; to repair verges, 9; care and replacement of Intertype verges, 8; spring tension, 9; springs should be flattened, 9; spring not parallel with slot in verge, model 15, 3; spring breaks off, 3; Intertype escapement spring, 9; verges may be put in backward, 44; channel not parallel with channel in magazine, 3, 12.

Vise: to lower to second position, 119; to raise back to first position, 119; vise stop spring broken, 120; vise closing wedge bent, 120; to fasten lower mold banking block, 221; pot leg bushings should be oiled, 167; worn shaft may cause back squirts, 167.

Vise automatic: setting, 107, 114; dog spring breaks, 114; gets choked with metal, 114; squirts can prevent operation, 203; acts too late, 114-115; top of stop rod must come high enough, 116; stops machine when no tight line, 115.

Vise jaws: should not accumulate metal, 121; should be replaced when worn, 121; letters hang over at end of line, 120-121; lines vary in length on left end, 122; molds must be parallel with vise jaws, 125.

Vise locking screws: loose screws may cause back squirts, 169; broken off by double-black-face lockup, 123; heak off when head-letter mold used without flipper, 123; need hard oil, 123; how to tighten right-hand screw, 125; should pull up evenly, 123; when they pull vise to one side, 123.

LINECASTING OPERATOR-MACHINIST

Compiled by

EDWIN B. HARDING

Professor Emeritus of Journalism and Printing

South Dakota State College

Edited by

NOEL M. LOOMIS

Linecasting Machinist

Minneapolis, Minn.

STOCKTON BOOK PUBLISHERS . PITTSBURGH, PENNSYLVANIA
