

MANUAL OF INSTRUCTIONS

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Instructions for Adjusting Ludlow Mold and Adjusting Table Locking Down Mechanism on all Machines Above No. 2092 that are Equipped with the Equalizing Bar Lock

1st. Shut off motor. Remove two Part No. 746 (Safety Connecting Rod Studs) and Part No. 747-A (Safety Connecting Rod) on top of table and release two adjusting screws and lock nuts that are in the two equalizing bar locking clamps Part No. 588. Release the screw and lock nut on the left end of the locking equalizing bar lever (Part No. 585).

2nd. Turn machine over by hand until mold has reached the highest point of travel, then place gauge No. A-957 over mold and adjust height of main slide so that a two point lead will just fit between table top and bottom of gauge while holding gauge down firmly by hand on top of mold—then tighten screw and nut (Part No. 613-A and Part No. 615). While gauge is still in position, tighten screw in end of equalizing lever until the play is entirely taken out of the locking equalizing lever bar (Part No. 570-A)—then turn machine a little farther by hand, bringing crucible up to its highest point underneath mold. Place a cigarette paper under each roller and adjust the two screws in equalizing bar locking clamp so that paper will hold and yet can be drawn out from between the roller and equalizing bar shoe without tearing. Tighten all lock nuts after adjustments have been completed.

Note: If Operator does not understand the main slide adjustments on the Ludlow, follow instructions given below:

Loosen Part No. 613-A (Main Slide Adjusting Plate Screw) sufficiently to permit the moving of Part No. 612 (Main Slide Adjusting Plate)—then loosen Part No. 615 (Main Slide Adjusting Screw Nut) and raise or lower main slide with Part No. 614 (Main Slide Adjusting Screw) until you have the proper height of slide as given above.

Adjustable Table Locking Down Mechanism

1. See that the adjustable table lock in back of the mold is set to proper height when table is locked down in position and when knob on the table lock reads "ON."

2. To make this test, first release the spring on the table lock underneath the table, then lower the table and lock it down with the front table locks, then take a hold of that part of the adjustable lock which projects through the top of the table and move back and forth. If it moves very freely raise pawl underneath hand and move notched eccentric bushing to the left, mov-

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ing one notch at a time until lock binds slightly when you move same back and forth, then drop pawl in position and replace spring on lock underneath table. If unable to get the proper adjustment through the eccentric bushing that part of lock on main frame should be lowered. To make this latter adjustment, raise table top, release check nut and adjust screw to proper height. Lock check nut and make final adjustment with eccentric bushing as stated above, then replace spring on lock.

During a part of the cycle of the machine and at the period that the mold is in casting position, the automatic lock is in operation, locking table to the main frame of the machine. This lock is operated by a screw stud on the back side of the main slide. When slide raises, the screw stud forces lock into place and

lock is released by a spring as the slide returns to normal position. This screw stud also acts as a safety. In case table lock should be adjusted too high, this stud will break off when main slide raises, thereby preventing damage to the machine. In the event stud breaks off, readjust table lock and replace screw stud. (Note: See instructions in paragraph "a" of "Adjusting Table Locking Down Mechanism.") In case lock spring breaks or type metal, dirt, etc., gets into the lock and prevents same from releasing, remove screw stud by inserting screw driver from rear of machine. This will allow lock to be released and table raised. Clean lock thoroughly, assemble in place and replace screw stud.

For metal crucible adjustments, see Ludlow Manual of Instructions.

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