

INSTALLATION OF LOCATING LEVER (5080-34-1)

1. Bushings should be flush and casting free of burrs or slag. Measure the opening where the Locating Lever mounts with a machinist's planer gauge. Write this dimension down.
2. Insert the Eccentric Bushing (5080-196) in the Locating Lever from the left-hand side. (See middle of page 5 Parts List Book).
3. Hold Locating Lever in a vise to seat eccentric. Measure from eccentric to flat of locating lever. Write this dimension down and subtract measurement of opening from it.
4. On a surface grinder position lever with eccentric up. Grind eccentric .002" over dimension from step #3.
5. Rub scrapper bluing on both sides of the locating lever and install into bed. Use Pin (624-1) to hold in position. Move locating lever back and forth in opening. **Use care, as lever may be tight.**
6. Remove lever and check opening for bearing, lever should be in contact with bed about 90%. Using a flat scrapper remove the high spots from the bed.
7. Repeat step #5 until 90% bearing is achieved. Be patient, do not score surface, keep smooth or "pick-up" will occur.
8. When required bearing is achieved Locating Lever Extension (5080-35-1) should be installed to Lever.
9. Install lever back in machine. Wedge Lever Extension roll against Locating Cam (5080-75-1) to simulate working mode.
10. Using an indicator, check position of spindles 3 and 5. Turn eccentric bushing (5080-196) until spindle 3 is less than plus .002.
11. Lock eccentric in place with 3/8-16 sq. head bolt (837-14-16) and remove lever from machine. **Take care as not to loosen wedge.**
12. Block lever to drill for pin and screws. Spot all holes with 1/4" drill. Drill pin hole first "D" (.248) approx. 3/4" deep and install .250 soft pin. Drill and tap for 1/4-24 x 1/2 screws (834-10-8).
13. Turn lever so screw bushing (5080-35-1-SB) is parallel. Spot through bushing. Remove wedge and extension. Drill and tap 7/16-14 hole for set screw (5080-35-1-SS).
14. Remove screw that is holding eccentric and drill through with 5/16 drill. Tap to 3/8-16.
15. Remove any burrs and be sure pin is below flush. Re-install lever in machine completely. Set roll pressure (see instruction book).