

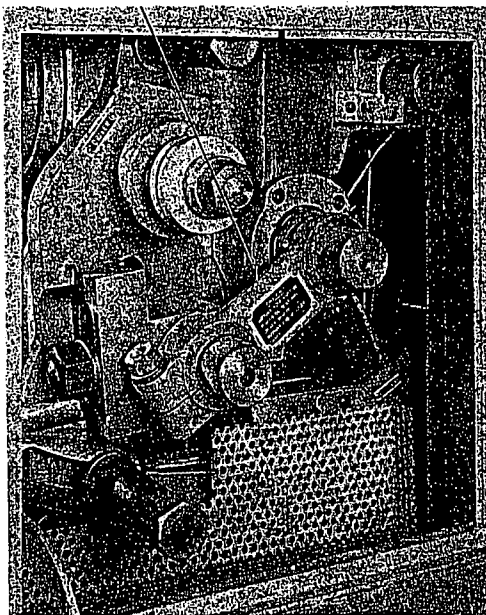


Fig. 21. This view located inside door 5 Fig. 2.

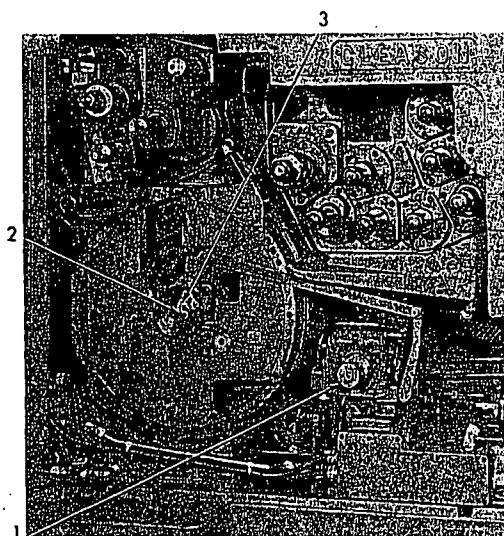


Fig. 23.

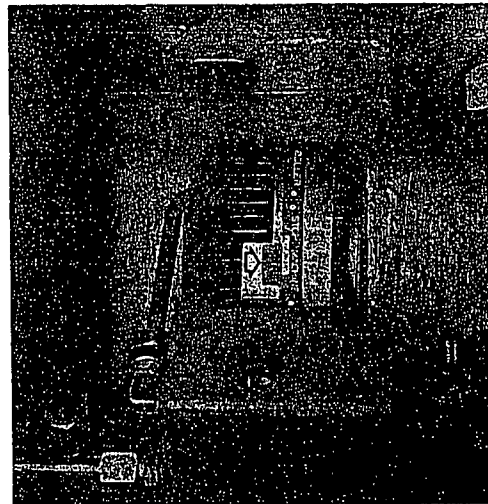


Fig. 22. This view located on left inside door 6 Fig. 2.

- E. Unlock roller eccentric block. (Two lock screws on cam angle dial 5 Fig. 16).
- F. Remove outer stud gear 1 Fig. 16.
- G. Rotate ratio of roll shaft 2 Fig. 16 to required roller eccentricity setting on scale 3 Fig. 20.
- H. Lock roller eccentric block.
- I. Reinstall ratio gear on shaft 1 Fig. 16.
- J. Set cam angle on cam angle dial by rotating shaft 2 Fig. 20.
- K. Engage clutch on modified roll change gear shaft 2 Fig. 20 and run machine through cycle to recheck settings.

18. Set Automatic Stop

The automatic stop 1 Fig. 23 shuts off the machine when all the teeth in the gear have been cut. It resets itself automatically every time the machine stops normally. Once having been set for the correct number of teeth, it requires no further attention. Before setting the automatic stop, it is important that the feed cam be stopped in the position indicated by the pointer and white band marked "Stop Machine" Fig. 22.

If it does not, it will be necessary to adjust the automatic stop trip cam. The cam is located immediately behind the slotted plate 3 Fig. 23. Loosen Allen screw 2 Fig. 23 and rotate the cam