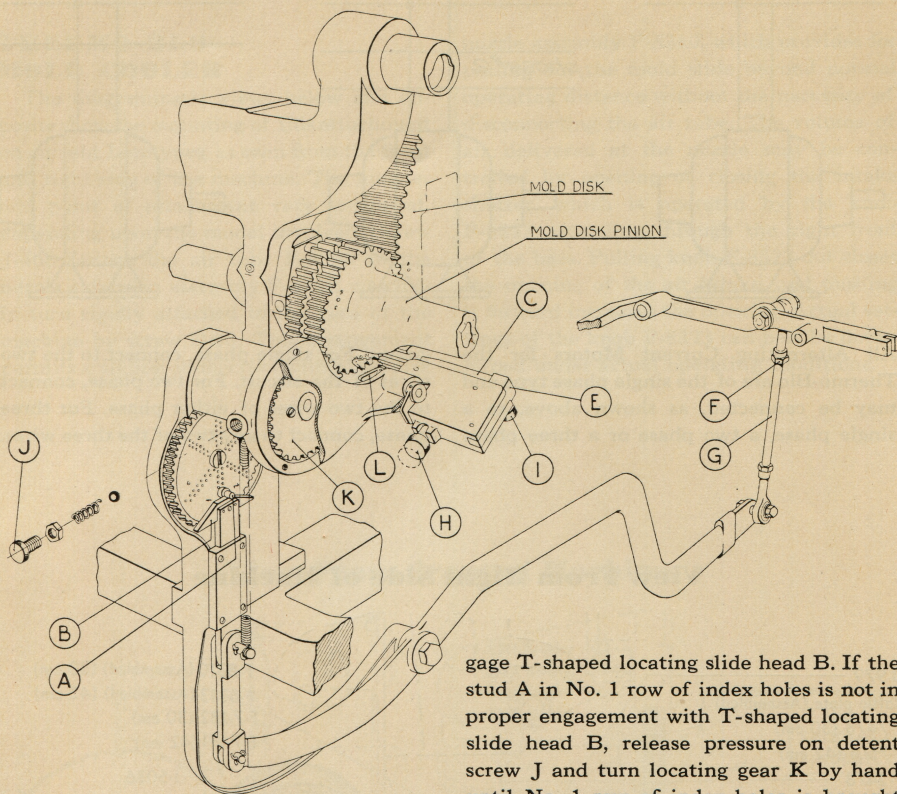


LINOTYPE AUTO-EJECTOR SET



Having been set to conform with the length of slugs to be ejected, this device automatically selects the correct ejector blades for each mold in the disk. The present discussion of the auto-ejector set will apply to six-mold machines where it finds one of its most useful applications due to the casting of constant measures and infrequent liner changes. To set the auto-ejector set, proceed as follows:

SETTING THE AUTO-EJECTOR

With Mold Disk Guide Knob H in lowered position (as illustrated), turn No. 1 mold to normal position (indicating line on face of mold disk should register with No. 1 position on mold disk shield). Index stud A in row No. 1 of index holes should now en-

gage T-shaped locating slide head B. If the stud A in No. 1 row of index holes is not in proper engagement with T-shaped locating slide head B, release pressure on detent screw J and turn locating gear K by hand until No. 1 row of index holes is brought into vertical position. When No. 1 row of index holes has been rotated into proper position, tighten detent screw J until there is little or no play in locating gear K. (Test this setting with finger.)

With No. 1 mold in normal or ejecting position, index stud A should be positioned in hole to agree with length of slug to be ejected from No. 1 mold. If not correctly positioned, proceed in the following manner: To change position of stud A, turn index dial $\frac{1}{4}$ turn clockwise by rotating mold disk pinion one revolution clockwise. This will give access to nut D (Fig. 2) on index stud A. Remove nut D, pull out index stud A, and re-set in index hole corresponding to length of slug to be ejected. Replace nut D and tighten securely. Repeat procedure for each successive mold until all index studs are in position to agree with

length of slugs to be ejected from each corresponding mold.

When length of line is changed on any mold, index stud in the corresponding row of index holes must be re-set to agree with the new length of slug to be ejected. This is accomplished by repeating the above procedure for each mold being changed to a new measure.

ADJUSTING THE EJECTOR CONTROLLER

If necessary to adjust the travel of the ejector controller (in order that index stud settings will produce corresponding settings of the ejector blade control lever), loosen lock nut F and turn rod G clockwise or counter-clockwise as necessary. When this adjustment is made, tighten lock nut F.

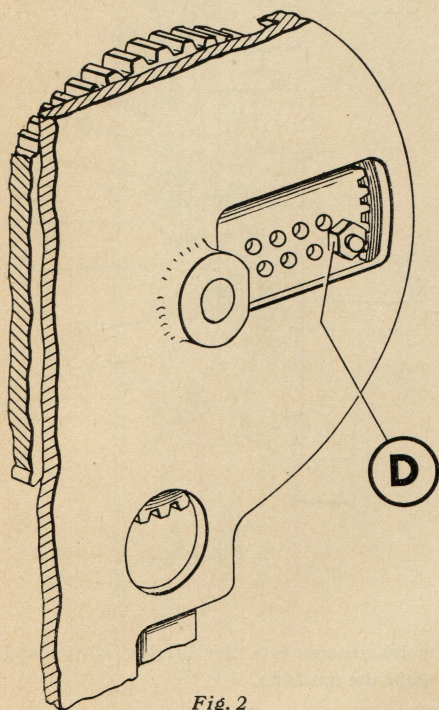


Fig. 2

MOLD DISK

When it is necessary to pull the mold disk forward for any reason, mold disk guide C engages the mold disk teeth and prevents the mold disk from being turned out of time with the mold-turning pinion or the auto-ejector set. This feature greatly facilitates returning the mold disk to normal position.

Should it be necessary to rotate the mold disk after it is pulled forward, mold disk guide knob H should be pulled out and locked. This retracts guide rail C, and moves mold disk pinion stop L in front of the mold disk pinion to prevent disturbing its setting. In this instance, when returning the mold disk to normal position, particular care must be exercised to assure that the mold disk is put back in correct time with the mold disk pinion.

To remove the mold disk beyond mold disk stop E, pull out mold disk guide knob H and lock it. Then release stop detent knob I and pivot mold disk stop E outward to permit full withdrawal of the mold slide. When the mold disk is removed beyond stop E it is not held in proper time by guide rail C, and in returning the mold disk to normal position, particular care must again be exercised to assure that it is put back in correct time with the mold disk pinion.

CAUTION—On six pocket mold disk machines care must be exercised when pulling the mold disk forward, since the equal spacing of six molds does not permit the mold disk teeth to mesh with guide rail C in all positions.

To bring mold disk forward onto guide rail C either mold number 1 or number 4 should be in "normal" or ejecting position. If mold disk is to be pulled forward with some other mold in "normal" or ejecting position, guide rail C must first be retracted.