

VII. Miscellaneous

EJECTOR BLADES

EJECTOR blades are of different thickness and width, to accommodate the different sizes of bodies and lengths of slug, 5, 5½, 6, 7, 8, 10 and 11 point body sizes, and in width, for all lengths of slug from 4 to 30 ems, inclusive, varying by one em. Eight point ejector blade is used for ejecting 9 point slugs, as there are no 9 point ejector blades made. Eleven point ejector blade is the thickest and is used for all slugs 11 point and larger. When ordering ejector blades, the body and length of line must be given. For instance, 6 point, 12 ems.

Ejector blades used with recessed molds must be at least 5 points thinner than the slug to be cast, 5 point blade used with 10 point recessed mold, 6 point blade used with 11 point recessed mold, 7 point blade used with 12 point recessed mold, 8 point blade used with 13 and 14 point recessed mold.

Ejector blades used with head-letter molds start at 5 point with the thinnest liner used in the mold, as, for instance, a 15 to 19 point mold would take a 5 point ejector blade with 15 point liners, or a 32 to 36 point mold would take a 5 point ejector blade with 32 point liners, and the blades increase in thickness as the liners increase.

CHANGING EJECTOR BLADES

To change an ejector blade, open vise; if machine is fitted with mold ejector safety lever, push ejector lever back by hand; turn the mold disk until the slot is in the front of the blade; turn the machine backward until the second elevator falls to the safety hook; remove the ejector blade, and insert the proper size of blade to be used. Place the machine in its normal position. *Care should be taken that an ejector blade wider or of greater thickness than the slug to be cast is not put in the machine.* Liners or molds will be damaged if this important point is overlooked. Never deviate from the rule of *always changing the ejector blade before changing mold liners.* A good plan is always to *try* the ejector blade by hand *after* changing liners.

See page 68 for description of the universal ejector blade.

KNIFE WIPER

On the old style knife wiper operated by the first-elevator lever the knife-wiper bar should work freely in its guides and the tension of the knife-wiper bar spring should be just strong enough to balance the

weight of the knife wiper. A drop of oil should be placed on the working surface of the bar once a day and the lower guide should be kept free from trimmings of side knives. This form of knife wiper is now obsolete.

NEW STYLE KNIFE WIPER

The knife wiper in use on all later Linotypes is shown in Fig. 44. It is more compact and rigid in its construction and is not so liable to be bent. The new style is strongly recommended for replacement.

POT CRUCIBLES

We have had occasional complaint that the crucible of the metal pot becomes cracked, causing the metal pot to leak. To prevent this the gas should be turned on about half way for twenty minutes when starting to melt the metal, or until the metal becomes warm and expanded, after which the gas may be turned on full. When the gas is turned on full at first, the metal in the bottom of the pot melts sooner than the metal at the top, and the rapid expansion on account of the heat forces the molten metal through the minute pores in the crucible, and sometimes cracks it.

HOW TO PACK A POT JACKET

Mix the asbestos meal with water until a paste is formed; coat the pot jacket about one half inch thick on the inside, except in front, where the burners are located; place the crucible in the jacket, and pack the asbestos between the jacket and the crucible, filling in all the spaces around the crucible. *Asbestos must not be allowed to get into the well.* Stop up the well with a piece of rag, or waste, while packing the crucible. Care should be taken that the crucible fits in position firmly; then put on the cover and fasten it down. Turn on the heat about half force, and let the moisture dry out slowly; take three or four hours for this.