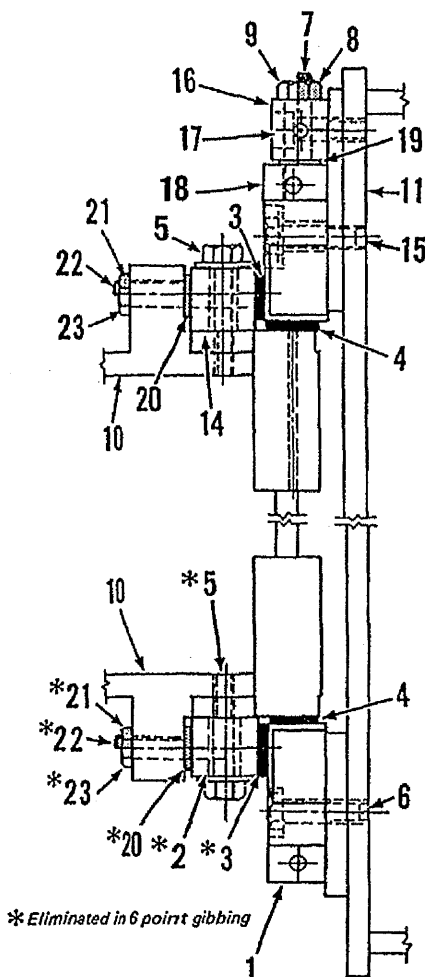


FORM A-13-B-2



* Eliminated in 6 point gibbing

1. Front Gib
2. Slide Gib Support Block (R.H. Front, L.H. Rear)
3. Slide Liner
4. Slide Liner
5. Support Block Clamping Bolt
6. Gib Clamping Bolt
7. Rear Set Screw
8. Rear Jam Nut
9. Rear Gib Bolt
10. Slide
11. Frame
14. Slide Gib Support Block (R.H. Rear, L.H. Front)
15. Gib Clamping Bolt
16. Rear Gib Support Block
17. Block Mounting Capscrew
18. Rear Gib
19. Rear Gib Spacer & Shims
20. Slide Spacer & Shims
21. Slide Jam Nut
22. Slide Set Screw
23. Slide Gib Block Bolt

SQUARE GIBBING – INBOARD TYPE

GIB ADJUSTMENT

Before adjusting the press gibs, the following must be done.

1. Remove die and place slide at bottom of stroke position with adjustment at midpoint. Set counterbalance pressure at zero.
2. Place the PRESS STROKING SELECTOR SWITCH in the "OFF" position and remove key. Place the MAIN DISCONNECT SWITCH IN THE "OFF" position and lock.

FRONT TO BACK CLEARANCE (See Illustration)

1. Slightly loosen gib clamping bolts (15) on each rear corner of the frame.
2. Loosen jam nuts (8) on the set screws (7) in the rear gib support block (16).
3. Turn all rear set screws (7) until there is zero clearance between the gib surfaces and slide liners (4).
4. Using a feeler gage or a hole gage, measure the space between the support block (16) and the rear gib (18) where each of spacers (19) are located. Record these new measurements.
5. Make new spacers (19) (or reuse old ones) equal to the new recorded measurements minus .005" for each point. These spacers must be ground from steel and as large as illustrated (19).
6. Remove each rear gib bolt (9), insert the appropriate new rear spacer (19) made for each specific point, and reinsert the rear gib bolt (9). **NOTE:** Do not remove more than one rear gib bolt (9) at a time on each gib.
7. Tighten all rear gib bolts (9) and gib clamping bolts (15), the set screws (7) should be out of contact with the gib (18) and locked with jam nuts (8).
8. Recheck the gib surfaces (4) for a minimum front-to-back clearance of .0015" total. If necessary, use shim stock under the spacers (19) to achieve this.

SIDE TO SIDE CLEARANCE

1. Slightly loosen support block clamping bolts (5) on each corner of the slide (10).
2. Loosen jam nuts (21) on the set screws (22) in the slide (10).
3. Turn all slide set screws (22) until there is zero clearance between the gib surfaces and slide liners (3).
4. using a feeler gage or hole gage, measure the space between the gib blocks (2) (14) and the slide (10) where each of slide spacers (20) are located. Record these new measurements.
5. Make new slide spacers (20) (or reuse old ones) equal to the new recorded measurements minus .005" for each point. These spacers must be ground from steel and as large as illustrated (20).
6. Remove each slide gib block bolt (23), insert the appropriate new slid spacer (20) made for each specific point, and reinsert the slide gib block bolt (23). **NOTE:** Do not remove more than one slide gib block bolt (23) at a time on each gib.
7. Tighten all slide gib bolts (23) and support block clamping bolts (5). The set screws (22) should be our of contact with the gib support blocks (2) (14).
8. Recheck th gib surfaces (3) for a minimum side-to-side clearance of .0015" total. If necessary, use shim stock under the spacers (20) to achieve this.

IMPORTANT: After completing press gib adjustment as instructed above, the set screws (7) (22) are not in contact and should never be used as push/pull devices to maintain gib adjustment. The gib bolts (9) (23) must always be drawn up tight against the correct size spacers (19) (20) to insure positive clearances.

NOTE: When trial running the press, heating of the gibs indicates that additional gib clearance is required.