A-13-B-3

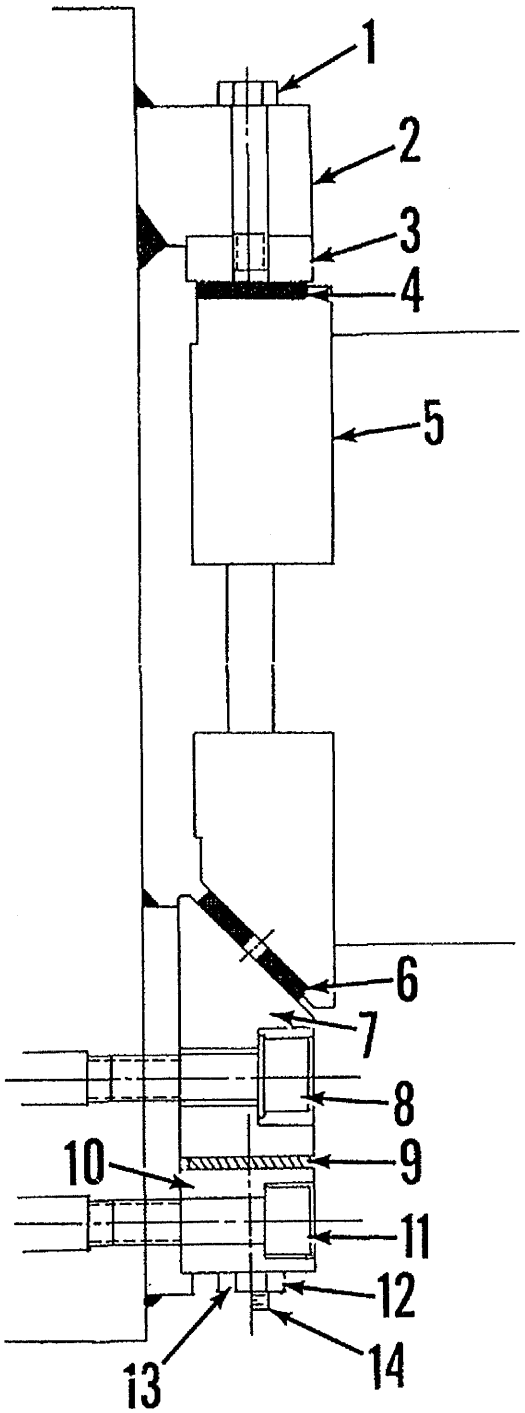
GIB ADJUSTMENT

1. Remove die and set counterbalance pressure at zero. Place slide at mid-stroke position with adjustment at mid-point.
2. Place the CONTROL POWER SELECTOR SWITCH in the "OFF" position and lock. Place the MAIN DISCONNECT SWITCH in the "OFF" position and lock.
3. Slightly loosen gib clamping cap screws (Part No. 8) on each side of the frame.
4. Loosen gib bolts (Part No. 13). Loosen jam nut (Part No. 12) and adjust gib (Part No. 7) using screw (Part No. 14) until there is zero clearance on gib surfaces.
5. Using a feeler gage or hole gage, measure the space between the gib (Part No. 7) and the gib block (Part No. 10) where the spacers (Part No. 9) are located. Record the measurement.
6. Make a new spacer equal to the recorded measurement MINUS .005 inch for each point. These spacers must be ground from steel and as large as illustrated.
7. Remove each front gib bolt (Part No. 13), insert new spacer made for each point, and re-insert the front gib bolt (Part No. 13).

NOTE: Do not remove more than one front gib bolt at a time on each gib.

8. Recheck the gib surfaces for a minimum front-to-back clearance of .002 inch total for each side. If necessary, regrind the spacers to achieve this.

4 POINT INSET GIBBING



1. Rear Gib Adj. Bolt
2. Frame
3. Rear Gib
4. Rear Gib Liner
5. Slide
6. Front Gib Liner
7. Front Gib
8. Cap Screw
9. Spacer
10. Front Gib Block
11. Cap Screw
12. Jam Nut
13. Bolt
14. Set Screw