

MONOTYPE' COMPOSITION CASTER: OPERATIVE'S EFFICIENCY GUIDE

Daily Routine

MOULD

Blow water from waterways and force oil through them each time a mould is removed from the machine.

Remove and clean crossblock; smear light film of mould oil on bearing surfaces before replacing.

Check coupling hook screw for tightness.

Lubricate bearing surfaces between coupling hook and type carrier with mould oil.

Check that crossblock oil pads are in contact with faces of crossblock.

Replenish syphon oiler and crossblock oiler with mould oil.

MATRICES

Wash cone holes and faces with suitable solvent (e.g. trichlorethylene) and blow clean with air blast.

Check position of centering pin in relation to cone holes.

Check draw rod lock nuts for tightness.

PUMP

Remove nozzle and, when cold, drill from both ends; 3/32" drill must not enter nozzle more than 2 3/16".

Examine tip of nozzle for wear and damage.

Clean piston with brass wire brush 48CT1 and pump body bushing (upper) with brass wire brush 48CT2; polish both parts with light application of 'Monotype' Pump Piston Paste.

When typemetal has reached casting temperature, agitate it with skimming spoon and remove dross.

TYPE

Examine type (1) for burrs to ascertain that mould gib plate, centering pin and bridge adjustment are correct, (2) for porosity to check for correct piston spring pressure and satisfactory condition of pump and piston.

Check alignment of character on type body.

Check setting of galley measure.

GENERAL

Lubricate all moving parts of machine and remove surplus oil. Open blow-off cocks and drain moisture from condensing tank and air pipes.

Weekly Routine

Thoroughly clean and oil machine, removing all surplus oil.

Carefully clean air tower air bar leather, removing accumulation of paper dust, etc.

Give jaw tongs spring box tubes three or four shots from grease gun.

Remove type carrier and clean metal from carrier slot in air pin block and type pusher guide; examine type clamp and type support spring for damage; clean and lubricate type carrier before replacing it.

Check coned end of centering pin with gauge 8CT4; return a worn pin for regrinding.

Check fit of centering pin and normal wedge locking pin in their respective bushes, and readjust them if necessary.

Check adjustment of mould gib plate.

Check adjustment of mould blade connecting rod.

Check all nuts and screws on machine for tightness.

Check level of oil in cam bath, replenishing if necessary.

Dismantle pump body and piston immediately after removal from molten metal, and remove all dross from components, using brass wire brushes 48CT1 and 48CT2, well arm drill 4CT1, nozzle tap 4CT5, tool for hole beneath nozzle 4CT7, pump body bearing nozzle-end cleaning tool 4CT4, pump body bush valve seating cleaning tool Xb21CT, piston stem end cleaning tool Xa29CT, pump body valve hole-drill .0595" diameter. Apply small quantity of 'Monotype' Pump Piston Paste to all components and polish them before reassembling. Heat pump body in molten metal before finally tightening its plug. Except with constant height moulds, check height-to-paper dimension of type for mould wear, and record dimension on prepared chart.

Replenish oil in compressor.

Examine compressor oil wicks and push down into aperture by wick retainer.

If fitted with screw cap greaser, screw down one turn.

Drain surplus oil from crankcase.

Quarterly Routine

Remove pump body lever and nozzle lifting lever; clean dross from bearings and threads with brass wire brush, polish threads and bearings by using small quantity of 'Monotype' Pump Piston Paste.

Clean pump and piston levers, and polish with 'Monotype' Pump Piston Paste.

Remove heater elements from pot and clean with brass wire brush.

Scrape dross from sides of melting pot.

Examine and clean nozzle-lifting lever bearing pin; if domed seating surface is worn, replace with a new pin. Polish pin with 'Monotype' Pump Piston Paste before reassembling.

Examine cone holes and faces of matrices; replenish any that are worn or damaged.

Examine tooth of normal wedge locking pin; if worn or damaged, return for regrinding.

Remove justification and transfer wedges; clean and replace after applying light film of lubricating oil.

Examine end of mould blade abutment slide screw; if domed end of pin is worn, replace with a new pin.

Remove water filter element, and wash foreign matter from strainer.

Clean syphon oiler and crossblock oilers and blow out oil ways with air blast. Remove metal chippings from oiler pads. Replace pads if badly worn.

Empty and clean cam bath; refill with clean lubricating oil.

Readjust, if necessary, clearance between motor belt and belt shifter eye, and tension of belt; this should be as slack as possible consistent with efficient drive.

Remove dirt and dust from vents of Caster and Compressor motors, to ensure free flow of air, and replenish grease caps.

Remove Compressor oil wicks and air-filter and clean in liquid trichlorethylene.

Recharge Compressor crankcase bearing with grease; do not over-charge.

Flush old grease from motor bearings about every two years, using volatile spirit (e.g. liquid trichlorethylene; paraffin should be strictly avoided). With light-grade lubricating oil, wash out spirit immediately after cleaning.

Recharge with grease-do not over-charge.

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