

Hammond Glider TRIMOSAW

MODELS G-100, G-140,
BGR-78 and BGS-78

Sawing is an important operation and for it you have installed the finest machine made that you may insure yourself accuracy with speed.

To derive maximum use and productive efficiency from your Glider TrimO saw, it should be oiled and cleaned regularly, the saw blades and trimmers kept sharp, and one person should be responsible for its condition. Your Glider has passed through rigid testing and inspection. Wear take-ups have been provided at wearing points that you may preserve its mechanical excellence.

The Model G-140 PlateSaw is the Glider Model which does not carry the following composing room equipment: Workholder Clamp, Miter Vise and Dial. The instructions herein pertaining to this equipment therefore do not apply to the G-140 PlateSaw.

INSTALLING THE GLIDER TRIMOSAW

Remove all shipping oil and grease with grease solvent. Be sure to clean all of the machined and all of the operating surfaces, give special attention to the micrometer gauge, gauge finger, workholder clamp and table ways to make certain they are clean and operate freely.

Electrical connection is made into the connecting box provided on the machine. The motor has been connected for the voltage shown on the Packing Slip. The lighting fixture plugs into connecting box cover for 110 volt machines only. On higher than 110 volt service the lighting fixture must be connected to a separate 110 volt line.

CLEANING AND OILING

CLEAN WEEKLY: (Use Grease Solvent and Clean Cloth)

- 1— Ball Bearing Table Ways: clean all four ways by cleaning half of each way with table at one end and repeat with table at other end. DO NOT OIL.
- 2— Gauge and Finger: clean the two sliding surfaces of the micrometer gauge and the two on the finger and the finger half-nut thread. DO NOT OIL.
- 3— Workholder Clamp: clean sliding surfaces (round rods). DO NOT OIL.
- 4— Table Ball Alignment: when doing weekly cleaning, bump the table at both ends of its stroke until the rubber bumpers are felt hitting the table stops. This will keep the balls in proper position to provide maximum sawing capacity in front of saw blade.

OIL WEEKLY: (Lubricate with SAE No. 20 Oil)

- 1— Workholder Clamp: oil four joints of toggle links.
- 2— Micrometer screw bearings.
- 3— Motor: lubricate according to motor manufacturer's instructions attached to motor.

OIL MONTHLY:

- 1— Saw raising screw threads.
- 2— Saw hanger pivot bearing.
- 3— Motor: lubricate according to motor manufacturer's instructions attached to motor.

DISMOUNTING AND MOUNTING SAW BLADE

Remove workholder clamp and pull table forward. On Model BGS SlugSaw push table to rear of machine. Raise saw blade to trimming position. Place box wrench on hexagon thru-bolt head at right end of arbor and "T" wrench in one trimmer lock. With "T" wrench resting on table, pull box wrench forward to loosen bolt. Unscrew bolt and remove saw together with saw head. Before mounting saw make sure faces of head and arbor are clean.

KINDS OF SAW BLADES

For Slugs and Rule	TX-770	7" dia.	70 Swaged Teeth DuraBlade.
For Stereotypes	TX-735	7" dia.	35 Swaged Teeth DuraBlade.
For Zinc	TX-7122	7" dia.	122 Set Teeth DuraBlade.
For Wood	WX-770	7" dia.	70 Set Teeth DuraBlade.
All-Purpose	TX-6536	6½" dia.	36 Teeth hollow ground hard metal blade. For slugs, rule, stereos, electros, zinc, copper, brass, and wood. Saw oiling device should be used with this blade to prevent loading.

TRIMMER TOOLS

TRIMMER TOOL LOCKS

Use T-Wrench for locking and unlocking trimmers. If the trimmers stick after unlocking, the locks can be loosened by tapping the end of the T-Wrench while it is in each lock.

SHARPENING TRIMMER TOOLS

See instructions on the Trimmer Tool Grinder and use flat face grinding wheel TX-108.

SETTING TRIMMER TOOLS

See instructions on the Trimmer Setting Gauge.

WORKHOLDER CLAMP

The workholder clamp is secured to the table by a fastening pin at the rear and an eccentric lock at the front. The rear fastening pin is adjustable for proper fitting of the clamp to the table.

The spring that determines the tension with which the clamp locks is located in the projection at the rear of the clamp frame. The tension can be varied with the set screw in this projection. Do not change the original tension setting unless necessary and then be sure the clamp operates with strong tension.

The clamp is designed for clamping down to eight point measure.

MITERING

See instruction plate on miter vise, if ordered with machine.

BATTER and LINE-UP GAUGE

The combination batter and line-up gauge is used for battering slugs against the finger before clamping, squaring of cuts and lining-up odd length slugs. It is also used for mitering — see instruction plate on miter vise if ordered with machine.

Tension adjustment is provided by set screw in batter bar holder. Squaring adjustment is provided in the mounting bracket.

ALL-PURPOSE SAW GUARD with LIGHTING FIXTURE

The All-Purpose Saw Guard with Lighting Fixture is mounted on the motor support shaft. To mount the Guard, slide arm onto the motor support shaft so that pin fits into the arm slot. Adjust cap screw so that the Saw Guard swivels with good tension. Then adjust lower and upper limit screws for clearance of 1/16" above workholder clamp, when Saw Guard is at both raised and lowered positions. Be sure workholder clamp clears Guard in both positions through full stroke of the gliding table.

For plate sawing the All-Purpose Saw Guard may be lowered to the height of the micrometer dial, by adjusting the thumb screw on mounting arm.

The All-Purpose Saw Guard and Lighting Fixture on the Model BGS SlugSaw are mounted on individual brackets provided on the machine.

For electrical connection to the lighting fixture see instructions under the paragraph — INSTALLING THE GLIDER TRIMOSAW.

ADJUSTMENTS FOR WEAR

MICROMETER GAUGE

End play may be removed by loosening set screw in end of handwheel and turning the handwheel while holding the micrometer gauge screw from turning.

MICROMETER GAUGE FINGER

Looseness in its fit may be eliminated by adjusting the threaded plugs on the front of the finger. First loosen the set screws that lock these plugs.

Looseness in the half-nut may be removed by tightening the screw on the right face of the arch. A set screw at the top must first be loosened.

SAW ARBOR

The arbor is fitted with two ball bearings. To remove end play or replace the bearings, please communicate with the factory for instructions.

GLIDING TABLE

If the gliding table doesn't appear to be operating correctly, clean all four ball bearing ways with grease solvent and bump the table at both ends until rubber bumpers are felt hitting to re-align the balls. The table should then run smoothly through its full stroke and not have any side play. DO NOT attempt to adjust the ball bearing ways without first communicating with the factory.

SERVICE DEPARTMENT

Our Service Department will gladly send you any additional information about your Glider TrimO saw you may care to have. Write us any time you feel we can be of help or assistance. Please give Model and Serial Number of your machine when writing.

NEW NAME
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INSTRUCTION SHEET
No. G-157