

# The Intertype Autospacer

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... Its Functions  
Care, Operation  
and Adjustment

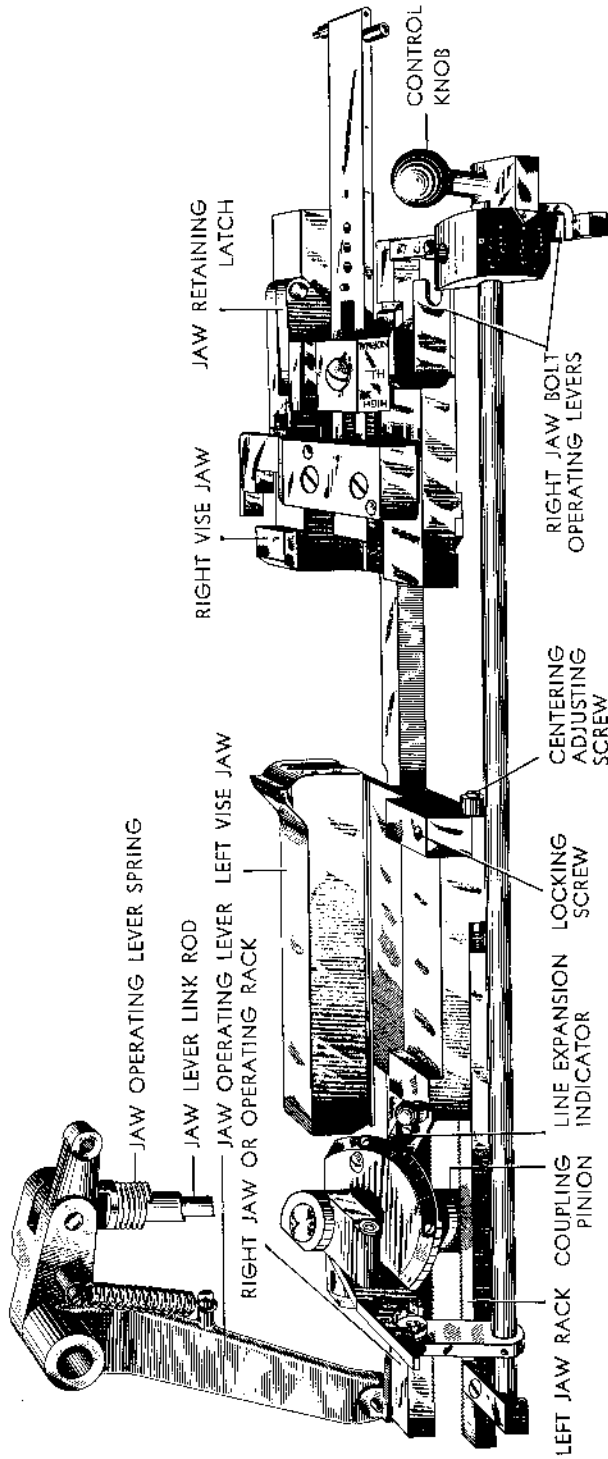


FIG. 1.—View Showing the Working Parts on the Vise Cap.

# THE INTERTYPE AUTOSPACER

## Its Functions, Care, Operation and Adjustment



This description is intended to serve two purposes. In the first place, it will instruct the operator in the working of the controls on Autospacer-equipped machines. Secondly, it will assist the machinist in caring for and maintaining the Autospacer.

**The Intertype Autospacer** is an automatic quadding and centering device. The chief differences between a quadding and non-quadding machine, as far as the operator is concerned, are the control knob and the line expansion indicator on the vise cap. The manipulation of these two controls is all the operator needs to do to get the full results of which the Autospacer is capable.

**The Control Knob** position determines whether the right vise jaw moves in to bring the line flush left, both jaws move in for centering, or the left jaw moves over to the line at the flush right position. Changing the position of the control knob should be done only when the machine is stationary in the normal position.

**When Changing Measure**, the knob must be at the *flush left* position and the left jaw against its stop after the measure has been set.

On machines equipped with the Mohr Saw it should be remembered that changing the setting of the saw also changes the setting of the left vise jaw. Therefore, when the saw is set, the control knob should first be put at *flush left*, and after the saw setting is made, the left jaw should be moved against its stop before the position of the control knob is changed again.

**The Line Expansion Indicator** is provided with a scale from 0 to  $3\frac{1}{2}$  ems. With the indicator set at 0, the machine will quad or center every line, with or without spacebands. If the indicator is set anywhere above 0, lines tighter than the indicated amount will justify, provided there are enough spacebands. Three or four bands for each em expansion is a good rule. The usual setting for justification of lines up to 12 picas is 2 on the indicator scale. For longer measures, up to  $3\frac{1}{2}$  ems expansion can be used. If there are insufficient bands for the necessary expansion of a line set within the indicated limit, the line will be lost—that is, it will not be cast—the same as a loose line on a non-quadding machine. If the line is short by more than the indicated amount, it will be quadded out automatically.

**The Assembler Slide** is provided with a *red pointer* which shows on the *stationary scale* how much the line lacks of being full. This is shown in Fig. 2. In the illustration the pointer indicates that the line lacks  $9\frac{1}{2}$  picas of being full. If this line is sent over, it will quad, regardless of the position of the line expansion indicator.

Assume that the line expansion indicator is set at 3. All lines to be justified must be set so that the pointer on the assembler slide is carried past 3 on the

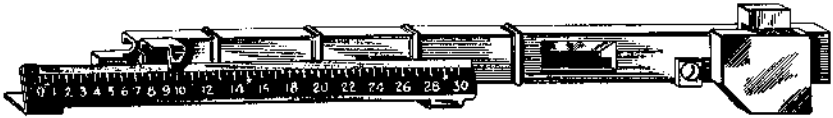


FIG. 2.—Assembler Slide and Scale

stationary scale. A line that does not carry the pointer up to 3 on the stationary scale will quad. It is advisable to avoid setting the line short by the exact amount shown on the line expansion indicator, as wear on the star wheel affects the accuracy of the reading of the stationary scale. A good rule is to allow at least  $\frac{1}{2}$  em leeway to be sure of the desired result. The assembler slide finger should be reset occasionally to compensate for wear on the star wheel.

The **Delivery Slide Long Finger** never needs setting on Autospacer machines. Short lines or even single matrices are brought up to it by the short finger, and the long finger is locked automatically for safe delivery. As the delivery slide returns, the long finger is left in the 30-em position. Cleaning the notched bar and wiping it over with an oily rag is occasionally necessary. The detent fulcrum pin and spring and the detent release should have an occasional drop of oil to assure free working. Surplus oil will foul matrices and should be avoided.

**Spring-Loaded Rails A, B and C** have been provided in the assembling elevator and the first elevator front jaw, as shown in Figs. 3 and 4. These rails press gently against the matrices to hold them in position. They are so adjusted as to hold the matrix line somewhat tighter on the left end in the

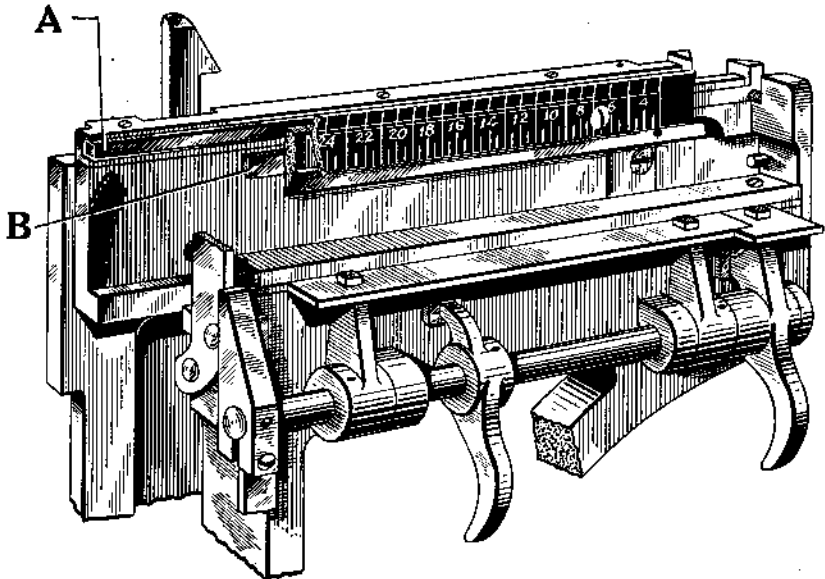


FIG. 3.—Assembling Elevator Showing Spring Rails A and B.

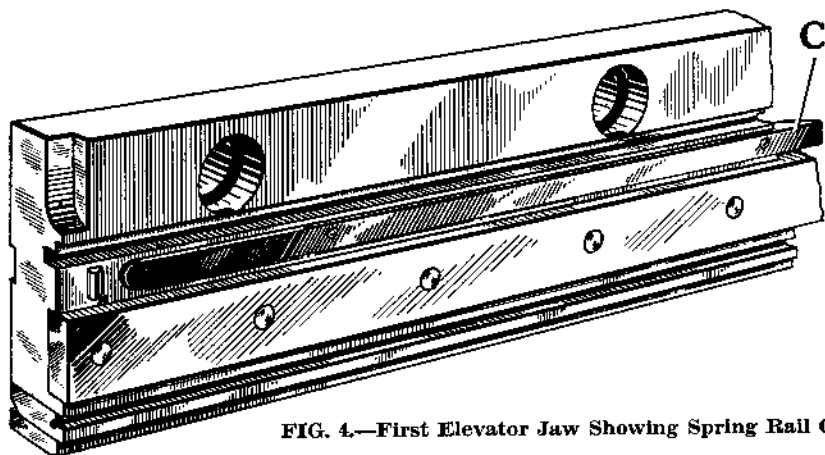


FIG. 4.—First Elevator Jaw Showing Spring Rail C.

assembling elevator. In the first elevator jaw the line stop holds the left end of the line and the rail presses more firmly on the right end of the line. The only attention necessary is to be sure that the rails are straight and free-working.

An **Automatic Line Stop**, shown in Fig. 5, is provided to control lines of any length in the first elevator jaw. During the transfer of the line, the line stop is brought back to the extreme right by the returning pawl attached to the transfer slide. If the spring-loaded *friction plunger A* is removed for any reason, it is important to replace it so that the sharp corner banks against projection *B* on the line stop. These parts should be lubricated with powdered graphite.

**Left Hand Indentions** on Autospace machines are set by means of a convenient knurled knob. To line up the last character on the left with the end of the slug, loosen the locking screw *A*, Fig. 6, on top of the vise closing bracket and adjust the knob until the left jaw is properly set. Then tighten the locking screw *A* and loosen collar *C* by unscrewing the set screw *B*. Set the scale on the collar so that 0 corresponds with the 0 on the bracket and tighten the set

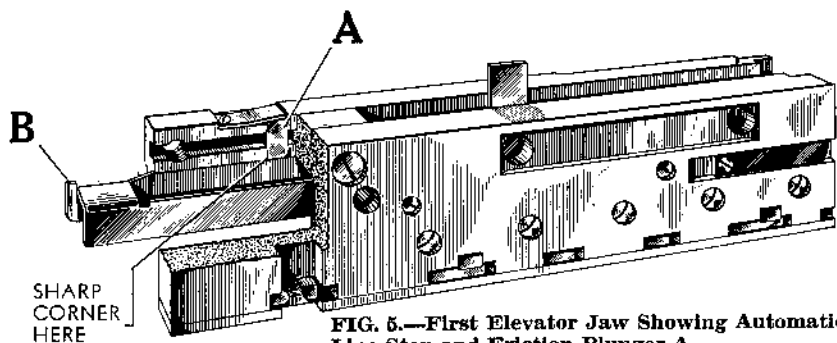


FIG. 5.—First Elevator Jaw Showing Automatic Line Stop and Friction Plunger A.