

ADJUSTABLE SLIDE and CLAMP ASSEMBLY (Accessory for CM-79 Portable Carriage)

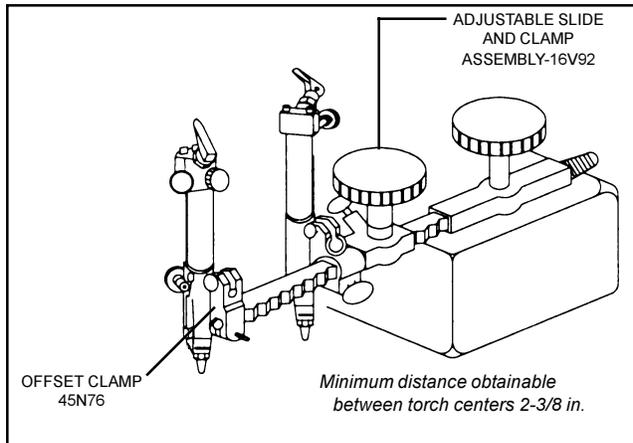


Fig. 1 - Setup for Double Torch Operation with Both Torches on Same Side of Carriage

INTRODUCTION

The Adjustable Slide and Clamp Assembly is designed for double torch operation with the CM-79 torch riggings (Figs. 1 and 2). The **ASSEMBLY** consists of two parts, the adjustable **SLIDE** and the torch holder **CLAMP**.

The **SLIDE** is a slotted fixture which can be slipped into either end of the rigging rack, and is equipped with a pinioned knob that engages the rack teeth. The knob is turned to move the **ASSEMBLY** along the rack. The **ASSEMBLY** can be locked in position on the rack by means of a locking thumbscrew on the **SLIDE**.

The **CLAMP** is the connecting fixture between the **SLIDE** and the torch holder. One end of the **CLAMP** fits over the end of the **SLIDE**. The other end of the **CLAMP** receives the torch holder stud. The position of the **CLAMP** on the **SLIDE** can be adjusted to control torch lead or lag angle along the line of cut. The torch holder stud in the other end of the **CLAMP** can be turned to control torch angle for bevel cutting. Both ends of the **CLAMP** are provided with thumbscrews for locking the torch in position at the desired angle along or across the line of cut.

INSTALLATION FOR DOUBLE TORCH OPERATION

1. Check to see that the fiber plug under the locking thumbscrew on the adjustable Slide and Clamp Assembly does not project into the space to be occupied by the rack. If it does, remove it by forcing it all the way out with the thumbscrew. Remove the thumbscrew, reinsert the plug in its proper position, then replace the thumbscrew.

NOTE: Care should be taken to see that the fiber plug is not lost or damaged in sliding the assembly on and off the rack.

2. Slip the adjustable Slide and Clamp Assembly on to either end of the rack with the slide locking thumbscrew away from the toothed side of the rack.
3. Insert the protruding stud of the torch holder into the torch holder clamp on the assembly. Tighten the clamp thumbscrews.
4. Install the torch in the holder.
5. Attach your present clamp and torch holder to either end of the rack and install the torch. Loosen the clamp thumbscrew that locks the torch-holder stud in position and back the stud out about 1/4 in. until the two torches are in alignment.

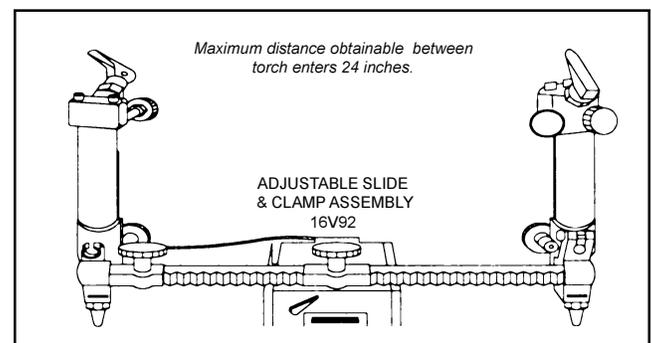


Fig. 2 - Setup for Double Torch Operation with Torches on Opposite Sides of the Carriage

F-9520-C

**Be sure this information reaches the operator.
You can get extra copies through your supplier.**

NOTE: If the accuracy of torch alignment is a critical factor in the operation, correct alignment can be automatically obtained by using an offset clamp (45N76 available as an accessory). The thumbscrews from your present clamp may be retained for use with the offset clamp, or two additional thumbscrews from your present clamp may be retained for use with the offset clamp, or two additional thumbscrews may be purchased, if so desired.

OPERATION

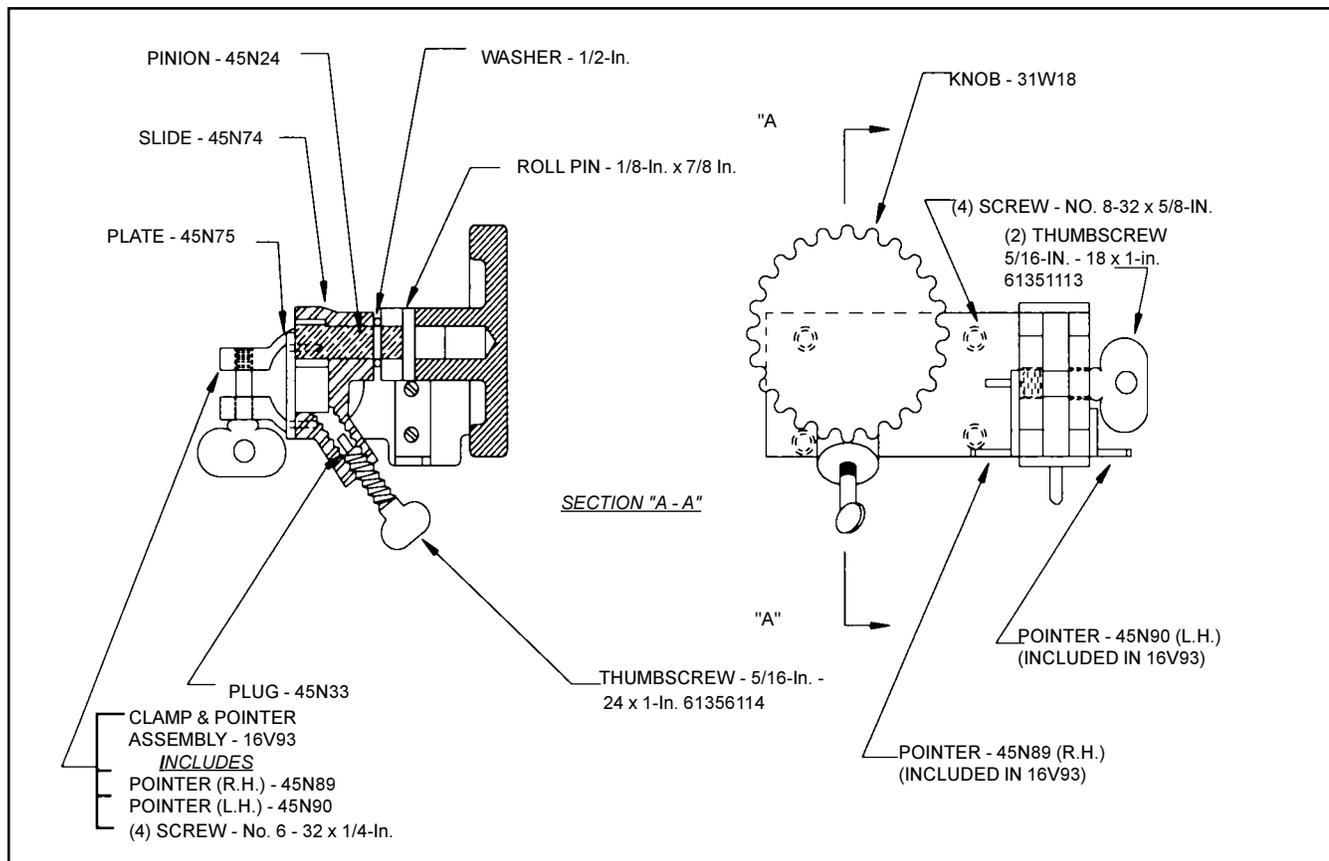
1. Use the pinioned knob to move the adjustable Slide

and Clamp Assembly along the rack to the desired position.

2. Lock the assembly in position on the rack with the locking thumbscrew on the side.

NOTE: The slide thumbscrew will lock only against the square sections of the rack, not against the round ends.

3. To adjust torch angle along or across the line of cut, loosen clamp thumbscrews, set torch at desired angle, and retighten thumbscrews.



Adjustable slide and Clamp Assembly - 16V92

