

PART 1

Introduction – and the application of basic typographical theory

- CHAPTER 1 **General information**
- CHAPTER 2 **Introduction to the working of a 'Monotype'
Super caster**
- CHAPTER 3 **Suggested instructional syllabus**
- CHAPTER 4 **Typographical features and dimensions of type**
- CHAPTER 5 **Type alignment**
- CHAPTER 6 **Basic unit and set**
- CHAPTER 7 **Measuring the cast with the micrometer gauge**

PART 1

Key references

Chapter 1

- 1 Screw
- 2 Escapement
- 3 Ingot chain
- 4 Hook
- 5 Metal ingot
- 6 Screw
- 7 Iron float
- 8 Float chain
- 9 Escapement brake
operating bar extension

Chapter 5

- 1 Sighting plate
- 2 Micrometer knob
- 3 Slip gauge

Chapter 7

- 1 Upper handwheel 'type' scale
- A Coarse graduations:
0.1 in (1/10 in)
- B Four sub-divisions of (A) :
0.025 in (1/40 in)
- C Thousandths scale : 0.001 in
(1/1000 in) – twenty-five sub-
divisions of (B)
- D Vernier scale : 0.0001 in
(1/10000 in) – ten sub-divisions
of (C)
- E Ratchet stop
- F Thimble
- G Spindle and anvil faces
- H Sleeve

PART 2

The main sections of the machine

- CHAPTER 8 **Introduction**
- CHAPTER 9 **Mould blade sizing mechanism**
- CHAPTER 10 **Matrix heads base**
- CHAPTER 11 **Composition matrix head**
- CHAPTER 12 **Display matrix head**
- CHAPTER 13 **Counter bracket and counter mechanism**
- CHAPTER 14 **Strip cutting and stacking mechanism**
- CHAPTER 15 **Pump mechanism**

PART 2

Key references

Chapter 9

- 1 Handwheel
- 2 Wedge screw
- 3 Wedge
- 4 Support pin
- 5 Connecting tube
- 6 Intermediate lever
- 7 Fulcrum pin eccentric
- 8 Plate
- 9 Pin
- 10 Driving block abutment
- 11 Plate
- 12 Mould blade stop
- 13 Handwheel lock screw
- 14 Wedge screw scale
- 15 Wedge screw scale
- 16 Screws (3)
- 17 Wedge indicator
- 18 Scale screws
- 19 Wedge screw clamp nut
- 20 Wedge indicator pin
- 21 Wedge screw housing
- 22 Wedge indicator scales
- 23 Wedge screw housing screws
- 24 Wedge screw housing base
- 25 Support pin
- 26 Mould blade slide
- 27 Driving block
- 28 Mould blade slide drive lever
- 29 Screw
- 30 Handle
- 31 Screw
- 32 Scale
- 33 Wedge screw nut
- 34 Screws
- 35 Pin
- 36 Nut
- 37 Ball socket plug lock nut
- 38 Ball socket plug
- 39 Ball socket
- 40 Nut
- 41 Retaining plate
- 42 Taper pin
- 43 Gauge

- 44 Block
- 45 Cap
- 46 Knob
- 47 Guide rod
- 48 Adjusting nut
- 49 Collar
- 50 Guide rod pin
- 51 Lever
- 52 Plunger
- 53 Lock pin

Chapter 10

- 1 Thumb screw
- 2 Type carrier cover
- 3 Type carrier
- 4 Fulcrum pin
- 5 Type pusher
- 6 Matrix heads base
- 7 Clamp screw
- 8 Distance piece
- 9 Type pusher lever
- 10 Type channel blocks
- 11 Lock nut
- 12 Type pusher lever connecting rod
- 13 Galley locating block
- 14 Galley clamp
- 15 Galley
- 16 Yoke
- 17 Cam lever extension
- 18 Cam lever
- 19 Type pusher cam lever
- 20 Type pusher connecting rod nut
- 21 Lock nut
- 22 Connecting rod
- 23 Type support spring cam bracket
- 24 Cam
- 25 Type clamp operating block
- 26 Mould blade
- 27 Mould coupling hook
- 28 Crossblock
- 29 Type carrier guard
- 30 Taper pins (2)
- 31 Screws (2)

- 32 Lever
- 33 Fixed type channel block latch
- 34 Screws (2)
- 35 Hexagon screws (2)
- 36 Releasing lever latch
- 37 Adjusting rod
- 38 Plunger lock pin knob
- 39 Latch trip plate
- 40 Plunger
- 41 Pump driving rod release trip bracket
- 42 Nut
- 43 Ball stud
- 44 Extension eccentric
- 45 Extension bolts
- 46 Connecting rod lock nuts
- 47 Yoke
- 48 Type carrier connecting rod yoke pin
- 49 Packing plate
- 50 Cover
- 51 Type pusher cover screws (6)

Chapter 11

- 1 Centring pin coupling head
- 2 Matrix lifter stop collar
- 3 Matrix lifter
- 4 Adjusting screws (2)
- 5 Stop nut
- 6 Loading spring
- 7 Matrix holder
- 8 Auxiliary loading spring
- 9 Centring pin
- 10 Centring pin loading spring bridge
- 11 Matrix cam lever
- 12 Lock nut
- 13 Matrix lifter lever connecting rod
- 14 Matrix head
- 15 Matrix lifter lever
- 16 Nuts (2)
- 17 Centring pin auxiliary loading spring bridge

Chapter 12

- 1 Spring box yoke pin
- 2 Lock wedge spring box
- 3 Yoke pin
- 4 Lock pin
- 5 Lifter lever
- 6 Matrix lifter spring
- 7 Lifter lever block
- 8 Lifter lever block spring
- 9 Matrix lifter lock wedge
- 10 Matrix holder adjusting pad
- 11 Adjusting screw
- 12 Matrix lifter
- 13 Matrix holder
- 14 Locating key lever
- 15 Matrix holder locating key
- 16 Matrix cam lever
- 17 Matrix lifter stud nuts
- 18 Lock nut
- 19 Spring box rod
- 20 Spring box cap
- 21 Handle
- 22 Matrix head side cover
- 23 Screws (3)
- 24 Display matrix bridge

Chapter 13

- 1 Knob
- 2 Screws (4)
- 3 Counter bracket
- 4 Counter drum
- 5 Wedge indicator scale
- 6 Wedge indicator pin
- 7 Type carrier cam lever extension
- 8 Yoke
- 9 Spring rod end pin
- 10 Jet block driving rod
- 11 Stacking mechanism
- 12 Lever
- 13 Mould lead clamp lever
- 14 Lead clamp lever
- 15 Lock wedge
- 16 Lead clamp intermediate lever rod

- 17 Screw
- 18 Bracket
- 19 Yoke pin clip
- 20 Counter bracket projections (2)
- 21 Chain
- 22 Hook
- 23 Weight
- 24 Lever
- 25 Rod
- 26 Lead clamp intermediate lever spring box
- 27 Matrix cam lever
- 28 Stop lever
- 29 Pump connection rod
- 30 Ratchet stop disc
- 31 Lever
- 32 Ratchet detent
- 33 Pawl
- 34 Ratchet wheel
- 35 Pawl trip pin
- 36 Setting latch
- 37 Blade stop
- 38 Actuating lever link
- 39 Lead mould blade stop lever handle
- 40 Measure gauges
- 41 Length gauge
- 42 Screw
- 43 Sliding jaw
- 44 Galley
- 45 Matrix box tray

Chapter 14

- 1 Link yoke
- 2 Actuating block link
- 3 Lead stacker bar
- 4 Lead stacker
- 5 Pin
- 6 Connection rod
- 7 Lead stacker lever
- 8 Cutter blade pin
- 9 Cutter actuating lever
- 10 Fulcrum pin
- 11 Cutter blade
- 12 Bracket
- 13 Lock screw
- 14 Fulcrum pin
- 15 Cutter cam lever
- 16 Hexagon screw
- 17 Actuating lever pin
- 18 Taper pin
- 19 Screw
- 20 Bracket
- 21 Taper pin
- 22 Screw
- 23 Rod yoke pin
- 24 Yoke
- 25 Cutter setting lever rod
- 26 Rod yoke
- 27 Plunger link
- 28 Lock nut
- 29 Screws (2)
- 30 Lead guide bracket
- 31 Spring
- 32 Cutter setting lever
- 33 Cutter blade bracket
- 34 Lock nut
- 35 Cutter actuating block
- 36 Abutment
- 37 Cutter setting block
- 38 Actuating plunger
- 39 Plunger spring
- 40 Actuating lever
- 41 Stop lever

PART 2 (continued)

Key references

Chapter 15

- | | |
|-------------------------------------|------------------------------|
| 1 Spring | 44 Nut |
| 2 Stop plates | 45 Nozzle |
| 3 Pump body spring rod | 46 Crosshead stud |
| 4 Lock nut | 47 Pump body operating rod |
| 5 Pump body spring rod lock nut | 48 Nuts |
| 6 Swing frame post | 49 Adjusting nut |
| 7 Piston operating rod | 50 Pump driving rod |
| 8 Piston springs | 51 Actuating rod |
| 9 Trip latch | 52 Pump driving rod link |
| 10 Piston operating rod crosshead | 53 Lock nut |
| 11 Pump lever connecting link | 54 Latch stand shaft nut |
| 12 Pump body lever | 55 Latch abutment plate |
| 13 Pump body lifting lever | 56 Crosshead eye |
| 14 Pump body lifting lever | 57 Latch stand shaft arm |
| 15 Pump body | 58 Piston spring rod eye |
| 16 Piston | 59 Pump stop collar |
| 17 Piston lever | 60 Latch stand shaft |
| 18 Link pin | 61 Latch pin |
| 19 Pump bell crank | 62 Latch trip plates (upper) |
| 20 Pump body lifting spring | |
| 21 Piston stem | |
| 22 Piston stem end | |
| 23 Piston stem end lock nut | |
| 24 Hat valve | |
| 25 Bottom plug | |
| 26 Bush (lower) | |
| 27 Bush (upper) | |
| 28 Fulcrum pin | |
| 29 Pump body lifting lever | |
| 30 Locating pin | |
| 31 Nozzle setting gauge | |
| 32 Swing frame adjusting screws (3) | |
| 33 Swing frame studs | |
| 34 Nozzle squaring post | |
| 35 Nozzle gauge | |
| 36 Piston spring rod | |
| 37 Crosshead stop post | |
| 38 Piston crosshead | |
| 39 Pump body spring rod crosshead | |
| 40 Lock nut | |
| 41 Pump body operating rod lever | |
| 42 Operating rod | |
| 43 Nut | |

PART 3

Sources of motion and the Varigear speed drive unit

CHAPTER 16 **The Varigear unit and gear box**

CHAPTER 17 **The cams**

PART 3

Key references

Chapter 16

- 1 Loose pulley
- 2 Fast pulley
- 3 Belt
- 4 Anchor block
- 5 Spring rod
- 6 Belt
- 7 Base plate
- 8 Speed indicator dial
- 9 Flange
- 10 Control spindle
- 11 Flange
- 12 Vee belt
- 13 Shaft
- 13a Shaft
- 14 Shaft
- 14a Shaft
- 15a Double gear
- 15b Double gear
- 16a Double gear
- 16b Double gear
- 17 Gear
- 18 Gear
- 19 Yoke
- 20 Control handle
- 21a Gear
- 21b Gear
- 22a Gear
- 22b Gear
- 23 Dog clutch
- 24 Control handle
- 25 Control handle
- 26 Shaft
- 27 Filler plug
- 28 Oil level plug
- 29 Drain plug
- 30 Screws (4)
- 31 Cowling
- 32 Motor mounting flange
- 33 Plug

Chapter 17

- 1 Type carrier cam lever guard
- 2 Screw
- 3 Screw
- 4 Cover plate
- 5 Galley bracket
- 6 Belt shifter ring rod latch
- 7 Gear guard
- 8 Vernier scale
- 9 Driving camshaft nut
- 10 Pulley
- 11 Driven camshaft gear
- 12 Handwheel
- 13 Driving shaft
- 14 Driving pulley clutch
- 15 Driving pulley
- 16 Link
- 17 Pump driving rod yoke
- 18 Pump driving rod yoke lock nut
- 19 Counter actuating rod eye
- 20 Link lock nut
- 21 Pump cam lever
- 22 Cam lever shaft gear
- 23 Bracket screw
- 24 Belt shifter ring rod end
- 25 Driving camshaft gear
- 26 Oil pan
- 27 Oil level plug

PART 4

Matrices, matrix holders, mould oilers and mould blade forks – cooling the mould and an outline description of the moulds

CHAPTER 18 **Matrices**

CHAPTER 19 **Matrix holders**

CHAPTER 20 **Mould oilers and mould blade forks**

CHAPTER 21 **Cooling the mould**

CHAPTER 22 **Introduction to the moulds**

CHAPTER 23 **Moulds available for use on the Super caster**

PART 4

Key references

Chapter 19

- 1 Handle
- 2 Handle screw spring washers (2)
- 3 Handle plate
- 4 Handle screws (2)
- 5 Matrix squaring plungers (2)
- 6 Matrix squaring plunger levers (2)
- 7 Support wire
- 8 Matrix squaring plunger lever spring
- 9 Matrix retainer
- 10 Guide plate screws (6)
- 11 Matrix holder guide plate

PART 5

The type moulds

- CHAPTER 24 **Small type composition moulds, 5–14 pt**
- CHAPTER 25 **Quad and space mould, 5–14 pt**
- CHAPTER 26 **Large type composition moulds, 14–24 pt**
- CHAPTER 27 **Display type machine moulds, 14–36 pt**
- CHAPTER 28 **Short lead and rule mould, 1½, 2 and 3 pt**
- CHAPTER 29 **Super caster display type moulds, 14–36 pt**
- CHAPTER 30 **Super caster display type moulds, 42–72 pt**
- CHAPTER 31 **Casting low quads and spaces**
- CHAPTER 32 **Casting quotations from the Super caster 42–72 pt display type mould**
- CHAPTER 33 **Palace script mould, 14–42 pt**
- CHAPTER 34 **Italic mould, 14–42 pt**
- CHAPTER 35 **Duplex mould, 14–18 pt**
- CHAPTER 36 **Duplex low quad mould, 14–18 pt**
- CHAPTER 37 **Triplex mould, 26 pt**

PART 5

Key references

Chapter 24

- 1 Matrix heads base
- 2 Distance piece
- 3 Type pusher lever connecting rod
- 4 Matrix heads base screws (4)
- 5 Type carrier connecting rod
- 6 Cam lever
- 7 Cam lever
- 8 Mould blade slide drive lever connecting tube
- 9 Ball end lock nut
- 10 Connecting tube ball end
- 11 Mould blade slide drive lever intermediate lever
- 12 Clamp screw
- 13 Mould blade slide driving block abutment
- 14 Mould blade slide
- 15 Stop lever handle
- 16 Wedge screw clamp nut
- 17 Wedge screw housing
- 18 Matrix head screw
- 19 Composition matrix head
- 20 Screws (3)
- 21 Matrix lifter lever connecting rod
- 22 Nut
- 23 Eye
- 24 Yoke
- 25 Matrix cam lever
- 26 Cam lever extension
- 27 Pin
- 28 Cam lever
- 29 Type pusher cam lever
- 30 Nut
- 31 Type pusher connecting rod
- 32 Split pin
- 33 Intermediate lever
- 34 Fulcrum pin eccentric
- 35 Wedge indicator scale
- 36 Adjusting nut
- 37 Driving block screw
- 38 Fork bar
- 39 Set screw
- 40 Connecting pin
- 41 Crossblock
- 42 Upper mould blade
- 43 Low quad lever spring lever
- 44 Mould blade fork
- 45 Mould blade lever
- 46 Plate
- 47 Spring
- 48 Adaptor base
- 49 Locating screw
- 50 Adaptor base clamps (2)
- 51 Nut
- 52 Guide pin
- 53 Mould blade fork pin handle
- 54 Mould oiler
- 55 Crossblock oiler
- 56 Stud
- 57 Washer
- 58 Water supply piping
- 59 Screw
- 60 Matrix holder
- 61 Type support spring cam bracket
- 62 Type carrier
- 63 Coupling hook
- 64 Fixed type channel block
- 65 Adjustable type channel block
- 66 Thumb screw and washer
- 67 Cover plate
- 68 Cover plate screw
- 69 Blade holding down plate
- 70 Spring block plug
- 71 Spring block pressure screw
- 72 Spring block
- 73 Pressure screw lock nut
- 74 Side block cover spring screw
- 75 Side block cover spring
- 76 Adjustable gate block
- 77 Jet blade
- 78 Gate block adjusting screw
- 79 Fixed gate block
- 80 Crossblock backplate
- 81 Centre gib plate screw
- 82 Left-hand adjusting screw
- 83 Gib plate adjusting screw lock nut

- 84 Gib plate
- 85 Intermediate plate
- 86 Side block cover spring
- 87 Side block cover spring screw
- 88 Screw side block
- 89 Blade stop
- 90 Blade stop support screws (2)
- 91 Blade stop support

Chapter 25

- 1 Adaptor base
- 2 Knurled screw
- 3 Type clamp operating block
- 4 Distance plate
- 5 Cover plate
- 6 Cover plate screw
- 7 Spring block plug
- 8 Spring block pressure screw
- 9 Spring block pressure screw locknut
- 10 Clamping bar
- 11 Clamping bar screws
- 12 Crossblock
- 13 Gib plate
- 14 Intermediate plate
- 15 Spring block
- 16 Screw side block
- 17 Nick side block
- 18 Blade stop
- 19 Blade stop support

Chapter 26

- 1 Inset screws
- 2 Cover plate
- 3 Mould inset
- 4 Upper mould blade
- 5 Lower mould blade
- 6 Mould blade lever
- 7 Intermediate plate
- 8 Crossblock
- 9 Jet blade
- 10 Mould coupling hook
- 11 Holding back screws
- 12 Mould blade back stop screw
- 13 Cover plate screws
- 14 Mould blade abutment

Chapter 27

- 1 Type pusher lever connecting rod
- 2 Matrix lifter lever connecting rod
- 3 Type support spring cam bracket
- 4 Display matrix bridge
- 5 Hexagon screws
- 6 Type channel block
- 7 Type carrier connecting rod
- 8 Cover plate
- 9 Upper mould blade
- 10 Lower mould blade
- 11 Abutment
- 12 Cover plate screws
- 13 Blade back stop screw
- 14 Intermediate plate
- 15 Mould blade operating lever spring box
- 16 Mould blade lever

Chapter 28

- 1 Type carrier connecting rod yoke pin
- 2 Type carrier cam lever extension
- 3 Type support spring cam bracket
- 4 Mould blade slide drive lever connecting tube
- 5 Intermediate lever
- 6 Type clamp operating block
- 7 Inset holding-down screw (vertical)
- 8 Matrix stop
- 9 Cover plate
- 10 Cover plate screws
- 11 Matrix
- 12 Mould blade abutment
- 13 Mould blade abutment screws
- 14 Clamp screw
- 15 Bridge
- 16 Inset holding-down screw (vertical)
- 17 Inset
- 18 Matrix locator
- 19 Inset holding-down screw (horizontal)
- 20 Crossblock
- 21 Inset holding-down screw (horizontal)
- 22 Matrix clamp screw lock nut

Chapter 30

- 1 Matrix lifter lever connecting rod
- 2 Display matrix bridge
- 3 Type channel block
- 4 Type pusher lever connecting rod
- 5 Type carrier connecting rod
- 6 Cover plate
- 7 Mould blade abutment screws
- 8 Dowel pins
- 9 Mould blade abutment
- 10 Intermediate plate
- 11 Cover plate screws
- 12 Side block
- 13 Mould blade
- 14 Side block
- 15 Cover plate screws (short)

Chapter 31

- 1 Knurled adjusting screw
- 2 Space casting attachment
- 3 Low quad lever (Adaptor base)
- 4 Mould blade lever spring
- 5 Mould blade lever
- 6 Blade operating lever spring box
- 7 Lower mould blade lever
- 8 Low space cap clamp
- 9 Hexagon headed screws (2)
- 10 Low space cap clamp
- 11 Mould blade cap handle
- 12 Blade cap screw
- 13 Mould blade cap
- 14 Low space cap

PART 5 *(continued)*

Key references

Chapter 32

- 1 Lifter lever shaft lock pin
- 2 Matrix lifter shaft lever handle
- 3 Core block matrix holder

Chapter 33

- 1 Crossblock backplate
- 2 Fixed gate block
- 3 Plates
- 4 Screws (4)
- 5 Upper mould blade
- 6 Screws (2)
- 7 Blade abutment
- 8 Screws (2)
- 9 Lower mould blade
- 10 Intermediate plate
- 11 Cover plate
- 12 Gate block operating lever
- 13 Adjustable gate block
- 14 Gag block
- 15 Fixed stop

PART 6

The strip moulds

CHAPTER 38 **Super caster lead and rule mould, 1–3 pt**

CHAPTER 39 **Super caster lead and rule mould, 4–18 pt**

CHAPTER 40 **Super caster furniture mould**

PART 6

Key references

Chapter 38

- 1 Spring block
- 2 Distance piece
- 3 Adjustable side block
- 4 Matrix clamp screw
- 5 Holding-down screws (2)
- 6 Left-hand side block inset
- 7 Matrix clamp
- 8 Right-hand side block inset
- 9 Plain cap
- 10 Matrix clamp pad
- 11 Holding-down screw
- 12 Spring block cover plate screws (2)
- 13 Spring block cover plate
- 14 Matrix setting plate screw
- 15 Matrix setting plate
- 16 Holding-down screws (2)
- 17 Holding-down screw
- 18 Clamp screw
- 19 Spring block inset screw
- 20 Distance piece
- 21 Lead clamp screw
- 22 Mould lead clamp lever
- 23 Lead clamp screw lock nut
- 24 Straightening device
- 25 Straightening device roller
- 26 Adjusting screw
- 27 Rule dotting attachment
- 28 Fixed side block
- 29 Jet cam
- 30 Jet pusher
- 31 Dotted rule supporting pad
- 32 Screws (6)
- 33 Eccentric pin
- 34 Horizontal screws (3)
- 35 Jet block stop
- 36 Jet block
- 37 Horizontal bolts (3)
- 38 Inset cover plate screws (2)
- 39 Side block holding-down screw
- 40 Matrix locator
- 41 Holding-down screw
- 42 Mould blade

- 43 Mould blade connection
- 44 Mould blade slide
- 45 Pump driving rod
- 46 Spring box end
- 47 Mould blade slide drive lever connecting tube
- 48 Spring box rod
- 49 Wedge screw housing
- 50 Counter bracket
- 51 Lead clamp intermediate lever
- 52 Lead clamp intermediate lever rod
- 53 Lead clamp intermediate lever rod swivel collar, upper
- 54 Yoke pin
- 55 Cutter blade bracket
- 56 Shear block
- 57 Lead guide bracket
- 58 Galley side wall
- 59 Galley plate
- 60 Lead clamp intermediate lever rod yoke
- 61 Mould clamps (2)
- 62 Jet block driving rod
- 63 Jet block driving rod connection rod
- 64 Jet block driving rod connection rod yoke
- 65 Yoke position pin screw
- 66 Connection rod yoke pin position pin
- 67 Type carrier cam lever extension
- 68 Matrix cam lever

Chapter 39

- 1 Nuts (3)
- 2 Jet block setting piece
- 3 Locking key
- 4 Washers (3)
- 5 Spring
- 6 Holding-down screw
- 7 Holding-back screws (3)
- 8 Matrix guide
- 9 High blade cap
- 10 Packing piece (0.075 in)
- 11 Facing plate
- 12 Matrix guide cover
- 13 Right-hand inset (special)
- 14 Matrix clamp screw
- 15 Matrix clamp
- 16 Distance plate
- 17 Holding-down screw
- 18 Holding-down screw
- 19 Left-hand side block inset
- 20 Fixed side block
- 21 Right-hand side block inset
- 22 Holding-down screw
- 23 Distance piece
- 24 Holding-down screws (2)
- 25 Mould blade
- 26 Matrix clamp pad
- 27 Horizontal bolts (3)
- 28 Clamp screw post
- 29 Adjustable side block
- 30 Cover clamp screw
- 31 Inset screw (short)
- 32 Base facing strip
- 33 Inset screw (long)
- 34 Inset screw (long)
- 35 Oil channel block
- 36 Screws (2)
- 37 Mould base
- 38 Friction plunger spring abutment
- 39 Spring
- 40 Friction plunger
- 41 Jet cam
- 42 Jet block
- 43 Mould lead clamp lever

44 Lead clamp screw
 45 Spring
 46 Retaining plate
 47 Lead clamp screw block
 48 Retainer
 49 Distance piece
 50 Dotted rule supporting pad
 51 Lead clamp
 52 Straightening device
 53 Straightening device roller
 54 Cam
 55 Screw
 56 Matrix locator (end)
 57 Matrix sealing slide
 58 Dotted rule attachment locator
 59 Distance piece
 60 Screw
 61 Matrix locator (side)
 62 Matrix cam lever
 63 Jet block driving rod connection rod lock nut, right-hand
 64 Jet block driving rod connection rod
 65 Yoke position pin screw
 66 Type carrier cam lever extension
 67 Jet block driving rod connection rod lock nut, left-hand
 68 Matrix lifter wedge spring box
 69 Mould blade slide drive lever connecting tube
 70 Lead clamp intermediate lever spring box
 71 Matrix lifter bracket hexagon screw
 72 Matrix lifter
 73 Matrix lifter lock wedge
 74 Lead clamp intermediate lever rod
 75 Lead guide bracket
 76 Cutter blade bracket
 77 Shear block
 78 Galley plate
 79 Galley side wall
 80 Jet block driving rod

Chapter 40

1 Wrench
 2 3-em setting gauge
 3 Cap
 4 Cap clamp screws (2)
 5 Core piece
 6 Screw
 7 Guard
 8 Cap clamps (2)
 9 Recess (in distance piece)
 10 Small side block
 11 Screws (2)
 12 Screws (2)
 13 Distance piece
 14 Screws (2)
 15 Large side block
 16 Bolt
 17 Nut
 18 Blade guide
 19 Knob
 20 Bracket
 21 Adjustable (non-fusing) stop
 22 Screw
 23 Actuating lever link
 24 Screw
 25 Ejection stop
 26 Screw
 27 Blade stop catch
 28 Mould blade
 29 Facing strip
 30 Mould base
 31 Screws (2)
 32 Jet strip
 33 Clamping bolts (2)
 34 Key-way
 35 Jet pushers
 36 Nozzle seating plate
 37 Jet cam
 38 Jet block
 39 Gib plate
 40 Friction plate
 41 Mould lead clamp lever
 42 Clamping lever assembly
 43 Clamping screw

44 Core piece screws
 45 Clamping lever
 46 Clamping shoe
 47 Side block alignment key
 48 Clamping shoe lever pivot
 49 Core piece
 50 Facing strip
 51 Mould blade slide drive lever
 52 Intermediate lever
 53 Mould blade slide drive lever connecting tube
 54 Nut
 55 Connecting tube ball end joint
 56 Mould blade slide, driving block abutment
 57 Matrix cam lever
 58 Lead clamp intermediate lever spring box rod end
 59 Jet block driving rod connection rod yoke
 60 Type carrier cam lever extension
 61 Wedge screw housing
 62 Lead mould blade stop lever handle
 63 Ratchet pin chain
 64 Plunger lever fulcrum pin
 65 Actuating lever
 66 Mould blade slide
 67 Mould oiler
 68 Counter bracket
 69 Lead clamp intermediate rod
 70 Furniture guide
 71 Lead stacker
 72 Nut
 73 Furniture trimmer attachment
 74 Box
 75 Matrix box tray

PART 7

Operational notes – and a study of type metal

CHAPTER 41 **Production of good type**

CHAPTER 42 **Type metal**

PART 7

Key references

Chapter 42

- 1 Temperature control unit
- 2 Heater element
- 3 Terminal box
- 4 Mains junction box
- 5 Melting pot leads
- 6 Mercury switch
- 7 Bourdon tube immersion element
- 8 Ammeter
- 9 Control box
- 10 On/off switch

APPENDICES

Fault finding chart

Tables

Index

Glossary

Further reading