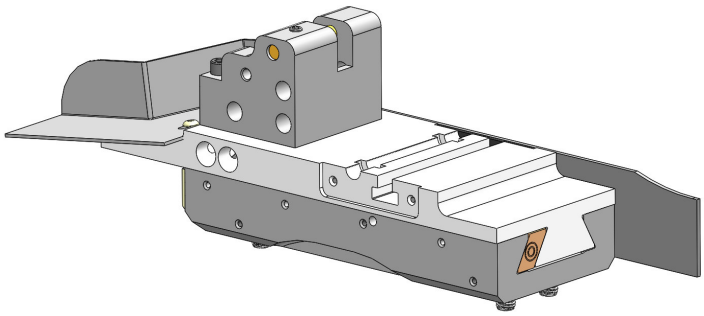
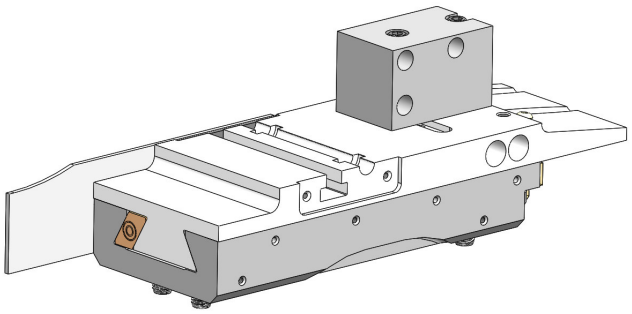
DAVENPORT MACHINE | CJWINTER

Divisions of *Brinkman Products, Inc.*
A Brinkman International Group, Inc. Company

132 EG Series Slides



132EGA-1st Position



132EGB-2nd Position

Installation, Operation and Maintenance Instructions

132 EG Series Slides
132EGA-1st Position
132EGB-2nd Position

Installation, Operation and Maintenance Instructions

Congratulations on the purchase of your C. J. Winter 132 EG Series Reversible Slide for your Davenport Automatic. With proper care, this investment will provide years of reliable service with virtually zero maintenance. Although the 132 EG is similar in many respects to your old Main Tool Slides, there are several significant changes which affect both installation and operation. This manual will describe those changes, and how they affect your use of the slide.

Installation

Your 132 EGA/B will be shipped with everything you need to replace your existing unit with an updated, C. J. Winter slide. It comes fully assembled, with the exception of the 1st & 2nd position Chip Guards, which are included as standard equipment, at no extra charge, on the 132 EG slides.

To install your new 132 EG into your Davenport Automatic, follow these simple steps:

1. Disconnect all drive mechanisms from your old slide and remove the slide from the machine.

2. Remove all grease lines/fittings from the slide pockets and clean the pockets thoroughly, and oil lightly.

   Your 132 EG does not require any lubrication once installed. You no longer need to grease your slides, and therefore you will find no grease fittings on the 132 EG.

3. Remove the 2 Flat Head Socket screws that hold the Base Endplate (132008) to the Base (132003-1).

   See included assembly diagram for part #'s and Descriptions.

4. Loosen the Gib Adjusting Screw (component of part #14).

***** Caution *****

<u>DO</u> <u>NOT</u> tighten gib when it is outside of an assembled 132 EG. Doing so will cause the gib to collapse, and may cause irreversible damage to the gib.

5. Pull the upper portion of the 132 EG, the slide (132001-1), out from the back of the Base (132003-1). The Base End Cap (132008) should still be attached to the upper Slide. Put this upper assembly aside.

***** Caution *****

Each 132 EG consists of a MATCHED pair of precision machined components. heSlide (132001-1) and Base (132003-1) are a Matched Set and are engraved with a serial # during manufacture to identify them as such. They should not be mixed with other 132 EG components and must be kept in serial pairs to maintain the precision and longevity they were designed for.

6. Remove the Gib (132058) from the Base (132003-1) by pulling the Gib towards the center of the dovetail. If needed, a standard screw driver can be used to pry the Gib free, but take care not to damage the dovetail surfaces. Put the Gib aside.

7. Use the included hardware to affix the chip guard to the base.

8. Mount the Base into your machine using the included hardware.

*****PLEASE NOTE*****

The 132 EG has been designed to fit snugly into the hand-scrapped pocket of your Davenport. If your slide does not slip easily into this pocket, check for burrs or chips or any abnormality in the pocket. DO NOT use tools to force the base into the pocket. If needed, the chip guard can be removed and ground for a custom fit. Also, the bottom of this pocket MUST be FLAT to avoid distortion to the base which can cause binding of the slide. Check flatness and scrape any high spots.

9. Re-install the Gib (132058)

10. Flood all the dovetail surfaces of the base and slide with **clean** way oil, making sure not to introduce any *chips* or *debris* onto these surfaces.

11. Insert the upper portion of the slide through the back of the Base, and re-install the screws holding the Base Endplate (132008) onto the Base .

12. RE-attach drive mechanisms. (1st and 2nd position Drive pins are different, 132012 is the 1st position pin, 132013 is the 2nd position pin)

When installing the cam follower arms behind 1st position, check for clearance between the hubs on the arms, and the slide components. Some of these cast arms have rough and irregular shaped hubs, and modification with a grinding wheel may be needed to clear your slide.

OPTIONAL EGX KIT INSTALLATION

See included assembly diagram for part #'s and Descriptions.

The EGX kit will allow the 132EG to retract an additional 9/16" out of the work zone. This may be needed when using oversize tooling in the 2nd Position.

1. Remove the Base Endcap from the Slide Base by loosening the Flat Head Screws.
2. Press the Finishing Plug into the Base Endcap.
3. Feed the Cap Screws through the Washers, Base Endcap and Spacer.
4. Tighten the Cap Screws into the Slide Base where the Base Endcap was removed in step 1.
5. Remove the existing 5/16 x .50 Set Screws.
6. Move the 2nd Position Drive Pin to the front ½" hole.
7. Install the 5/16 x 1.00 Set Screws.

OPERATION

There are a few features on the 132 EG Series Reversible Slide that make its operation slightly different than previous equipment you may have used.

1. Gib Adjustment

- The **132 EG** uses **E**xpansion **G**ib technology. To tighten the slide, turn the gib screw clockwise in small increments (1/8th turn) until all the play has been taken out of the slide.
- A properly adjusted slide should be tight, but should actuate by hand and return under its internal spring load.
- Under normal use, the Gib should only require adjustment once every 4-6 weeks, and that adjustment should be small.

During initial break-in, adjustments may be needed more frequently.

2. Lubrication

- Other than the way oil used during installation, no other lubrication is needed. This is a result of the low-friction coating and polymer laminates applied to the slide surfaces.

MAINTENANCE

With proper care, your 132 EG will provide you with years of reliable, highly accurate, and trouble-free service. But keep these maintenance tips in mind when working with the 132 EG.

1. Chip Removal

- Clean the dovetail surfaces between jobs. Chips can and will get everywhere on your Davenport, and by cleaning the slideways, you will prolong the life of your slide.

2. Gib Inspection

- Inspect the polymer laminate on the flat expansion gib periodically (every few months or between jobs). If this laminate is torn, peeling, or is worn so that the Gib is less than 0.443" thick on the 2 central pads, then the laminate is worn more than 1/3 of the way through, and the Gib should be replaced.
- Using a Gib with a severely worn laminate will result in tearing of the laminate and may cause non-repairable damage to the slide.

3. Low Friction Coating

- The very thin low-friction coating on the slide and base does wear slowly over time. It takes on a high polish, burnished look, which is normal, but the dull base material should not show through.
- When the coating wears enough to smooth out the milling marks on a large part of the running surface, you should consider having the coating restored by C. J. Winter.
- This is a low cost, efficient way of extending the life of your 132 EG and getting back that "new slide" accuracy and performance.
- Our restoring process will strip the worn coating back to bare metal, which is still wear free and in new condition. We will then re-plate the components, and return the slide in virtually new condition at a fraction of the cost of re-scraping a conventional tapered-gib slide.
- Under similar usage, this process will be needed at intervals roughly 5 to 10 times longer than conventional slides last between re-scraping, and can be done many times without degrading the slide accuracy.

For more information on the installation, operation, or maintenance of your 132 EG, please visit us at
http://www.cjwinter.com
or call us toll free at 1-800-288-7655.

DAVENPORT MACHINE | CJWINTER

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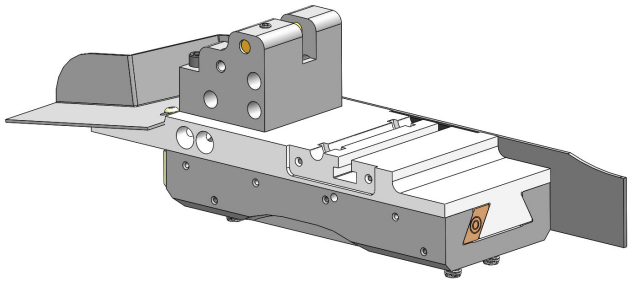
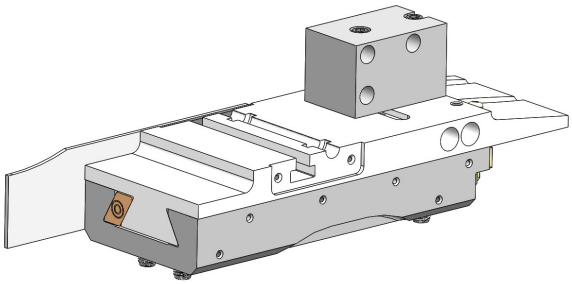
BRINKMAN INTERNATIONAL GROUP, INC.

Product Bulletin

132EGA Cross Slides 132EGB





CJWinter's 132EG series cross slides have recently been updated to include several new features to improve serviceability, longevity and quality of the slides. The top blocks are now smaller and position specific, making them more similar to the classic Davenport size for 1st and 2nd position. They are also completely removable, which makes maintaining the slides and adjacent machine components much easier. This also allows customers the option of leaving the top off completely in 2nd position, opening up room for larger tools, extra clearance for 3rd position swing-arm attachments, and easier access to the work-zone. For strength and rigidity, the slides and bases are now machined from solid billet material, not castings. 132EG series slides now come with hardened and ground dovetail ways to compliment the patented **Zero-Clearance Expansion Gib** design to ensure highly rigid tool delivery and long trouble-free life. Slides now come standard from the factory with a precision-ground clearance between slide and chip guard plate. When ordering slides, use assembly numbers 132EGA and 132EGB for position-specific equipment.

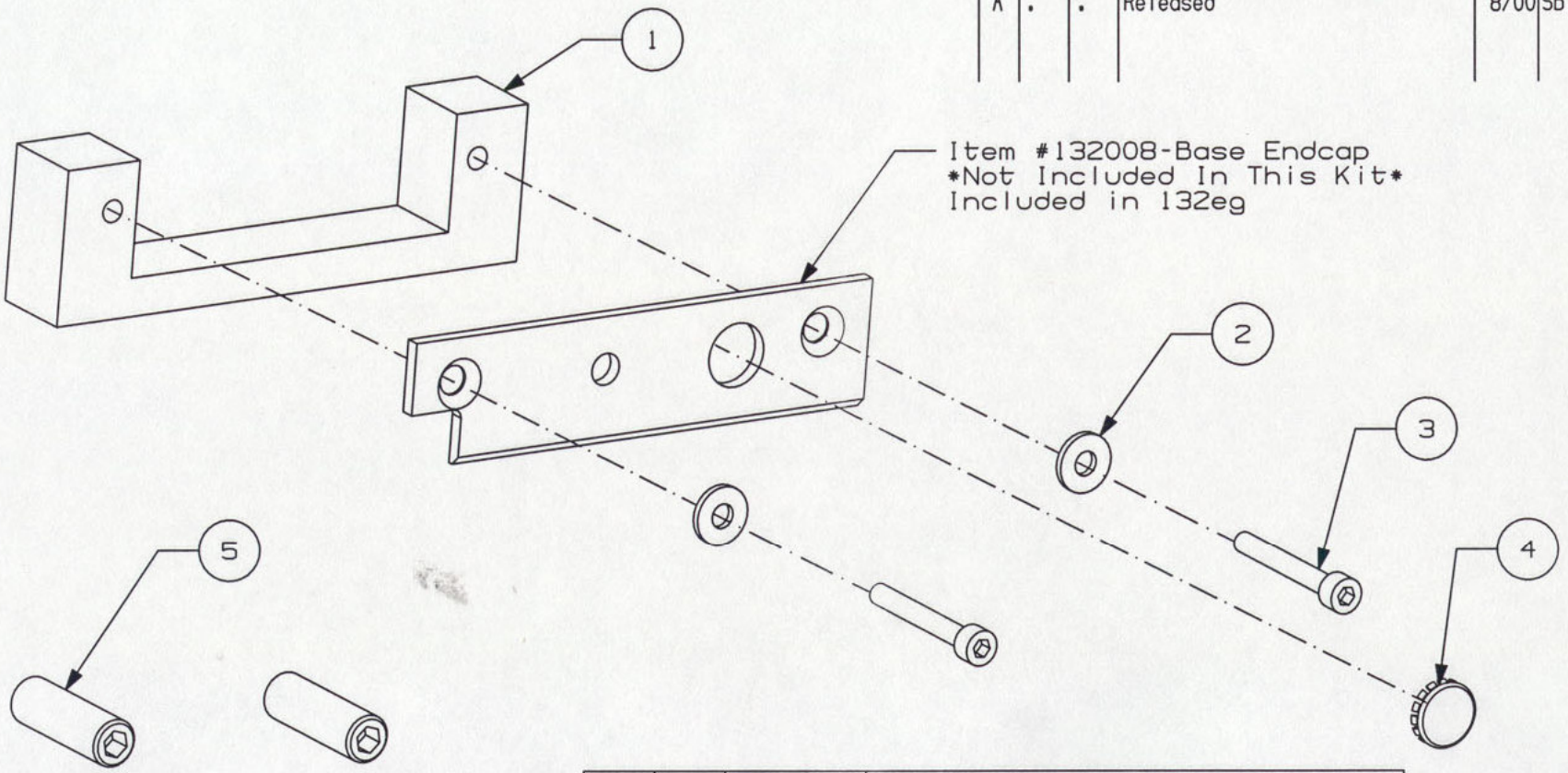
New Features:

- **Removable Top Block** – Low profile, position-specific, easier adjustments & machine maintenance
- **Solid Billet Material –** Adds strength, rigidity, and enhances quality.
- **Hardened Dovetail Ways and Tooling Area** – Deep case-hardened, ground for precision and smooth running, longer life and resistance to wear and damage
- **Precision ground clearance between slide and chip guard plate** – tight gaps, and curved leading edge of slide to help wipe chips away and keep slide clean.

CJWinter and Davenport Machine OEM parts are constantly being redesigned to maximize the *value* to the Customer. Any parts supplier can sell you yet another *replacement* part for your *problem*. Let the team at Davenport Machine supply you with a cost effective *solution* to it instead. Contact your local distributor, or call us directly at 1-800-344-5748 and ask about our many new and improved products that will help put profits back where they belong… in your pocket.

Visit us at www.davenportmachine.com today to see all of our New Product Bulletins

REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	.	.	Released	8/00	SB



These screws replace item #132015
to hold B position drive pins

Item	QTY	Part #	Description
1	1	132021	Spacer for 132EGX
2	2	132023	Washer, Flat: 5/32 ID
3	2	132022	Screw: SHCS, 6/32 x 1.00
4	1	132025	Plug, Finishing: 25/64
5	2	132024	Screw: SSS, 5/16-24 x 1.00 Full Dog

UNLESS OTHERWISE SPECIFIED:
DRAWING MUST COMPLY TO C. J. WINTER ENGINEERING STANDARD E1058 & ASME Y14.5M 1994 UNTOLERANCED DIMENSIONS ARE BASIC

.020 | A | B | C

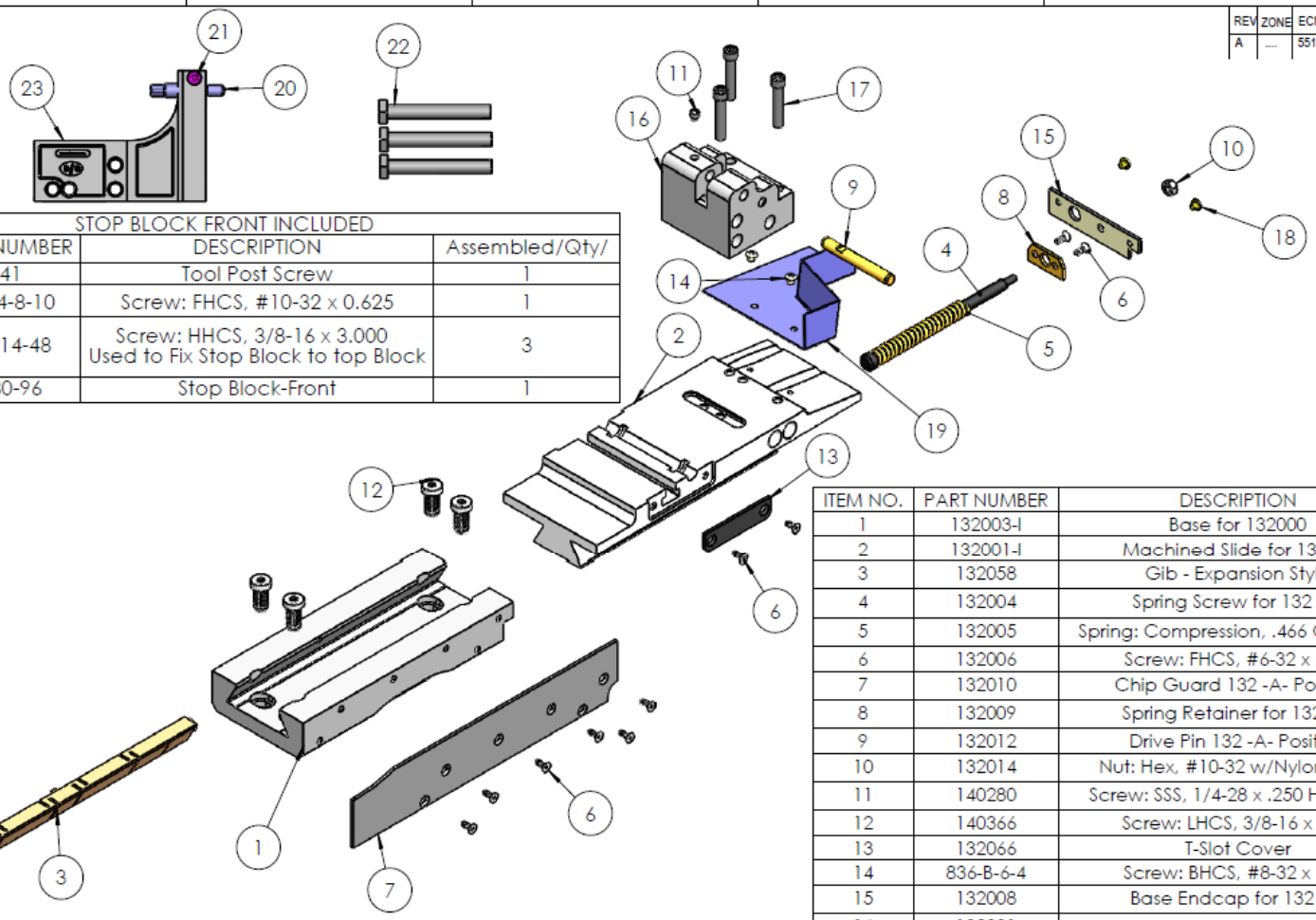
UG

DRAWN BY: J. Christ
DWG DATE: 8/2/00
ENG. APP: S. Belpanno
APP DATE: 8/2/00
MATERIAL: ..
HEAT TRT: ..

C.J.WINTER MACHINE TECHNOLOGIES, INC.

Conversion Kit: 132eg to 132egx

DWG. SIZE: A
SCALE: N/A
SHEET 1 OF 1
DRAWING NO. 132egx-kit



REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	....	5513	Released	3/12/18	JMH

STOP BLOCK FRONT INCLUDED			
ITEM NO.	PART NUMBER	DESCRIPTION	Assembled/Qty/
20	741	Tool Post Screw	1
21	836-4-8-10	Screw: FHCS, #10-32 x 0.625	1
22	835-14-48	Screw: HHCS, 3/8-16 x 3.000 Used to Fix Stop Block to top Block	3
23	5080-96	Stop Block-Front	1

ITEM NO.	PART NUMBER	DESCRIPTION	Assembled/QTY.
1	132003-I	Base for 132000	1
2	132001-I	Machined Slide for 132EG	1
3	132058	Gib - Expansion Style	1
4	132004	Spring Screw for 132 EG	1
5	132005	Spring: Compression, .466 OD x 3.50	1
6	132006	Screw: FHCS, #6-32 x .250	10
7	132010	Chip Guard 132 -A- Position	1
8	132009	Spring Retainer for 132 EG	1
9	132012	Drive Pin 132 -A- Position	1
10	132014	Nut: Hex, #10-32 w/Nylon Insert	1
11	140280	Screw: SSS, 1/4-28 x .250 Half Dog	1
12	140366	Screw: LHCS, 3/8-16 x .750	4
13	132066	T-Slot Cover	1
14	836-B-6-4	Screw: BHCS, #8-32 x .250	2
15	132008	Base Endcap for 132 EG	1
16	132031	TOP BLOCK FOR A-POSITION SLIDE	1
17	834-A-11-22	SHCS 1/4-28 X 1.375 LONG	3
18	836-B-5-4	Screw: BHCS, #6-32 x .250	2
19	5080-91-G-1	Front Cross Slide Guard	1

UNLESS OTHERWISE SPECIFIED: DRAWING MUST COMPLY TO C. J. WINTER ENGINEERING STANDARD E1058 & ASME Y14.5M 1994. UNTOLERANCED DIMENSIONS ARE BASIC
.020 | A | B | C | SW

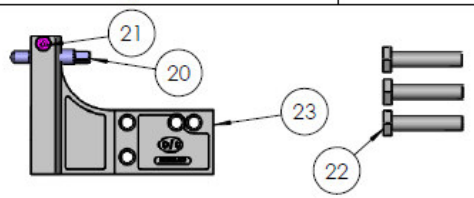
DRAWN BY:S. Belpanno
DWG DATE:06/01/99
ENG. APPR:J. Snow
APPR DATE:06/01/99
MATERIAL:See BOM
HEAT TRT:

C. J. WINTER MACHINE TECHNOLOGIES, INC.

132EG Series Slide: A Position

DWG SIZE B | SCALE: 1:5 | Sheet1

DRAWING NO. 132EGA



REV	ZONE	ECN	REVISION DESCRIPTION	DATE	ENG
A	....	5513	Released	3/12/18	JMH

STOP BLOCK REAR INCLUDED			
ITEM NO.	PART NUMBER	DESCRIPTION	Assembled/Qty/
20	741	Tool Post Screw	1
21	836-4-8-10	Screw: FHCS, #10-32 x 0.625	1
22	835-14-32	Screw: 3/8-16x2.000 Used to Fix Stop Block to top Block	3
23	5080-97	Stop Block - Rear	1

NOTE:
#10 is interchangable with #19 for required length

ITEM NO.	PART NUMBER	DESCRIPTION	Default/QTY.
1	132005	Spring: Compression, .466 OD x 3.50	1
2	132003-I	Base for 132000	1
3	132001-I	Machined Slide for 132EG	1
4	132058	Gib - Expansion Style	1
5	132004	Spring Screw for 132 EG	1
6	132006	Screw: FHCS, #6-32 x .250	10
7	132009	Spring Retainer for 132 EG	1
8	132013	Drive Pin 132 -B- Position	1
9	132014	Nut: Hex, #10-32 w/Nylon Insert	1
10	132015	Screw: SSS, 5/16-24 x .50 Cup Pt.	2
11	140366	Screw: LHCS, 3/8-16 x .750	4
12	132066	T-Slot Cover	1
13	836-B-6-4	Screw: BHCS, #8-32 x .250	2
14	132008	Base Endcap for 132 EG	1
15	132032	Machined Top Block for 132EGB	1
16	109030	Screw: SHCS 1/4-28 X 1-3/4"LG.	2
17	132011	Chip Guard 132 -B- Position	1
18	836-B-5-4	Screw: BHCS, #6-32 x .250	2
19	132024	Screw: SSS 5/16-24 x 1.00 Full Dog (NOT SHOWN)	2

UNLESS OTHERWISE SPECIFIED: DRAWING MUST COMPLY TO C. J. WINTER ENGINEERING STANDARD E1058 & ASME Y14.5M 1994. UNTOLERANCED DIMENSIONS ARE BASIC
.020 | A | B | C | SW

DRAWN BY:S. Belpanno
DWG DATE:06/01/99
ENG. APPR: J. Snow
APPR DATE: 06/01/99
MATERIAL:See BOM
HEAT TRT:

C. J. WINTER MACHINE TECHNOLOGIES, INC.

132EG Series Slide: B Position

DWG SIZE: B | SCALE: 1:3 | Sheet1
DRAWING NO. 132EGB