

NUMBERALL

STAMP & TOOL CO., INC.

USER MANUAL & PARTS LIST

MODEL

40B

S/N:

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MODEL 40B NUMBERING & LETTERING PRESS

Uncrating Procedure

1. Remove the cardboard liner contained in the shipping container.
2. The Model 40B may now be removed directly upward. The press weighs 40 pounds and **should be lifted with caution**.
3. Remove the wooden shipping base attached to the press. This base will restrict handle travel.
4. Bolt the press securely to a solid bench to avoid accidental upset. Make sure to allow for full handle travel.
5. Any shipping damage to the press must be reported immediately to the common carrier and to Numberall.

Product Description

The Model 40B is a manually operated press, designed for stamping name tags, keys and other small parts.

Equipped with the standard table, the Model 40B will stamp over an area 4" x 5". It will stamp 4-1/4" from the top edge of a tag and will accept material up to 5-3/4" wide. Extra long tables and spacing racks are available.

The Model 40B stamps one character at a time and advances automatically after each impression to assure correct spacing and alignment. Depth of impression is easily adjustable and repeatable.

Strip Holders and Nests are available to hold any shaped part. A standard clamping mechanism accepts parts up to 1/8" thick.

Function of Controls

1. DIAL SELECTOR KNOB (40B-386) - The dial selector knob positions the characters to be stamped. A pointer, fastened on top of the casting above the dial, points to the character selected.
2. ADJUSTABLE TENSION BLOCK ASSEMBLY - (40B-363) Located behind the character dial is the adjustable tension block assembly. By turning the brass screw, the tension on the dial can be adjusted. Too light a tension may

not allow the dial to seat properly. Too tight of a tension will make the dial difficult to move.

3. OPERATING HANDLE (40B-332) - The operating handle, located on the right side of the press, when depressed, moves the table up and down. **CAUTION: When experimenting with the handle, be careful not to accidentally stamp the table. KEEP HANDS CLEAR OF TABLE.** Each time the handle is depressed, a character is stamped and the table moves one space to the left. Moving the handle a half-stroke and back up, will advance the table without stamping a character. It is important to make sure the handle is returned to its full up-right position, otherwise the table will not space properly.
4. TABLE RELEASE LEVER (40B-372) - The table release lever is located on the right-hand side, underneath the table. By depressing this handle, the table can be manually moved to the right margin stop.
5. DEPTH OF IMPRESSION SCREW (40B-306) - The depth of impression adjustment screw is a silver knurled screw located in the front, near the bottom of the press. This screw limits the upward travel of the table. Turning the screw outward (down), will allow the table to move further upward.
6. SPACING ADJUSTMENT SCREW (40B-308) - This screw is a silver, knurled screw located on in the front of the press, directly below the table. The screw has a jam nut, which must be loosened for adjustment. This screw limits the downward travel of the table. Turning the screw inward (upward) will allow the table to move further downward. By adjusting the downward limit of the table travel, letter spacing can be controlled. Before adjustment, the machine may single space, fail to space, or multiple space. For each different character size or if material thickness changes, an adjustment may need to be made. During adjustment, make sure the handle is returned to the full, upright position.
7. TABLE STOP CLAMP (40B-302) - The table stop clamp is located on the right-hand side, on the table stop bar (40B-304). The stop limits the right-hand travel of the table, which controls the left margin.
8. TABLE INSERT CLAMP ASSEMBLY (40B-17) - This clamp, located on the left-hand side of the table, secures the table insert. After loosening the brass screw, the insert can be moved forwards and backwards. Engraved markings on the left-hand edge of the insert are provided for reference purposes. Each increment measures 1/16". An arrow index is stamped on the left-hand side.

Adjustments for Stamping

1. Place the material to be stamped on the table and secure it with the table clamps or special holding fixture (a special nest or slide). If a piece of scrap

material is to be used for setup, make sure it is the same thickness of the actual material to be stamped.

2. Center the table. This is accomplished by depressing moving the operating table left or right. Loosen the table insert clamp and move the table fore or aft. Return the handle to the full, upright position after moving the table.
3. Turn the depth of impression screw all the way inward.
4. Depress the operating the operating handle fully and make sure the character dial does not touch the material that is to be stamped.
5. While holding the operating handle in the down position, turn the depth of impression screw outward until the character dial touches the work piece. Turn the screw outward 1/4th of a turn and try a sample stamping. Make sure the handle is fully depressed against the depth of impression screw. The screw may have to be adjusted until a suitable depth is obtained.
6. If the operating handle is in an uncomfortable position, it can be adjusted as follows:
 - a. Remove the black button head screw, which keeps the table elevation gear from moving left or right. It is located about 1" to the left of the spacing adjustment screw on the front of the press.
 - b. Slide the operating handle to the right and reposition it once it clears the press. Make sure the handle can make a full cycle.
 - c. Tighten the button head screw.
7. To set the table stop, first loosen the thumb screw on top of the stop and slide the stop to the right hand end of the stop bar. Depress the table release lever and slide the table until the character wheel is about one space to the left of the proper location. Release the table release lever. Operate the press handle for one complete cycle. Slide the stop against the right-hand side of the table and tighten the thumb screw.
8. The table insert can be moved fore and aft for line spacing. Loosen the table insert clamp on the left-hand side of the table. Line to line spacing can be aligned by using the stamped marks on the side of the table insert, and the arrow on the guide rail. Each line measures 1/16" spacing. Retighten the clamp after each adjustment.

Character Dial and Spacing Rack Removal & Installation

1. Remove the allen set screw, located just behind the character dial on the right-hand side of the casting. Remove the character dial from the press.

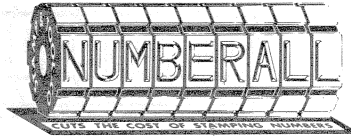
2. Remove the three screws that hold the dial to the dial knob and remove the dial.
3. Replace the dial and assemble the dial to the dial knob.
4. Re-tighten the set screw until the character dial is pulled snugly to the dial plate. **DO NOT OVER-TIGHTEN.** The character dial should turn easily, but should not have fore and aft play.
5. Depress the table release lever and pull the table completely off the press to the left. The spacing rack is located on the underside of the table.
6. Remove the three screws that hold the spacing rack, which are located on the underside of the table.
7. Exchange the rack, replace the dovetail strip and very slightly tighten the three screws. Now re-insert the table. It will be necessary to depress the table release lever in order not to damage the spacing pawl. Once the table is on the press, tighten the right hand screw securely. Then tighten the left hand screw and the middle screw last.

Lubrication & Maintenance

1. An oil hole is provided on the front of the press just below the spacing adjustment screw. A few drops of light oil should be applied here if bearing surfaces appear dry. Lubricate once a day if used continuously.
2. Lubricate the rear character dial surface, the table insert guides and the table dovetail strip with dry lubricant. **DO NOT USE OIL.**

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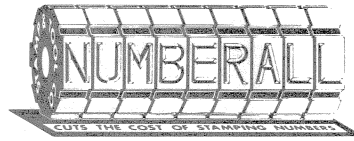
40B-08	Comp. Table Base Incl. Guide Rails & Dovetail (Dovetail Not Shown)	40B-338	Elevation Rack Cover Plate
40B-10	Nameplate Clamp Release Lever	40B-340	Cover Plate Mtg. Screws - 1/4 x 5/8 Socket Hd. Cap Screws (4 Req'd)
40B-12	Nameplate Clip Springs (3 Req'd)	40B-342	Elevation Gear Retaining Screw - 10/32 x 7/8 Button Hd. Socket Screw
40B-14	Nameplate Clamp Base	40B-344	Character Dial Pointer
40B-16	Nameplate Clamp Screws (3 Req'd) - 8/32 x 1/4 Round Head	40B-346	Dial Selector Knob
40B-18	Table Insert Clamp Assembly (Clamp, Screw, Spring)	40B-348	Dial Selector Knob Mtg. Screws - 6/32 x 1/2 Flat Hd. (3 Req'd)
40B-20	Table Insert	40B-350	Dial Shaft
40B-22*	Table Insert (Hardened)	40B-352	Dial Shaft Retaining Screw - 3/8 x 16 Cone Pt. Set Screw
40B-192	Table Spring Retaining Pin - 5/32 x 1 1/4 Roll Pin	40B-354	Character Dial 1/16"
40B-210	Thumbscrew - 10/32 x 1/2	40B-356	Character Dial 3/32"
40B-214	Spacing Adjustment Lock Nut - 1/4 x 20	40B-358	Character Dial 1/8"
40B-222	Dial Tension Spring (before S/N 2974K82)	40B-360	Character Dial 5/32"
40B-300	Thumbscrew - 10/32 x 1/2	40B-362	Character Dial 3/16"
40B-302	Table Stop Clamp	40B-363	Adjustable Dial Tension Blade Ass'y (after S/N 2974K82)
40B-304	Table Stop Bar	40B-364	Dial Detent Ball
40B-306	Depth Of Impression Adjustment Screw	40B-366	Dial Tension Spring Screw - 6/32 x 1/8 Round Hd.
40B-308	Spacing Adjustment Screw	40B-368	Dial Plate
40B-310	Table Return Spring	40B-370	Dial Plate Mtg. Screws - 8/32 x 3/8 Flat Hd. (4 Req'd)
40B-312	Cast Table	40B-372	Table Release Lever
40B-314	Table Elevation Rack	40B-374	Table Release Lever Shaft (before S/N 3227E84)
40B-316	Spacing Pawl	40B-375	Table Release Lever Shaft - new style (after S/N 3227E84)
40B-318	Spacing Pawl Shaft	40B-376	Table Release Lever Shaft Screw - 6/32 x 1/4 Round Hd. (before S/N 3227E84)
40B-320	Spacing Pawl Spring	40B-377	Table Release Lever Screw & Nut - new style (after S/N 3227E84)
40B-322	Table Dovetail Strip	40B-378	Table Release Lever Shaft Washer - 6/32 Flat (before S/N 3227E84)
40B-324	Spacing Rack & Dovetail Mtg. Screws - 8/32 x 1/4 Flat Head (3 Req'd)	40B-379	Entire Table Ass'y (40B-08 thru 40B-20)
40B-326	Spacing Rack	40B-380	Frame Casting
40B-328	Table Friction Spring		
40B-330	Operating Handle Shaft		
40B-332	Operating Handle		
40B-334	Operating Handle Screw - 1/4 x 5/8 Socket Hd. Cap Screw		
40B-336	Table Elevation Gear		

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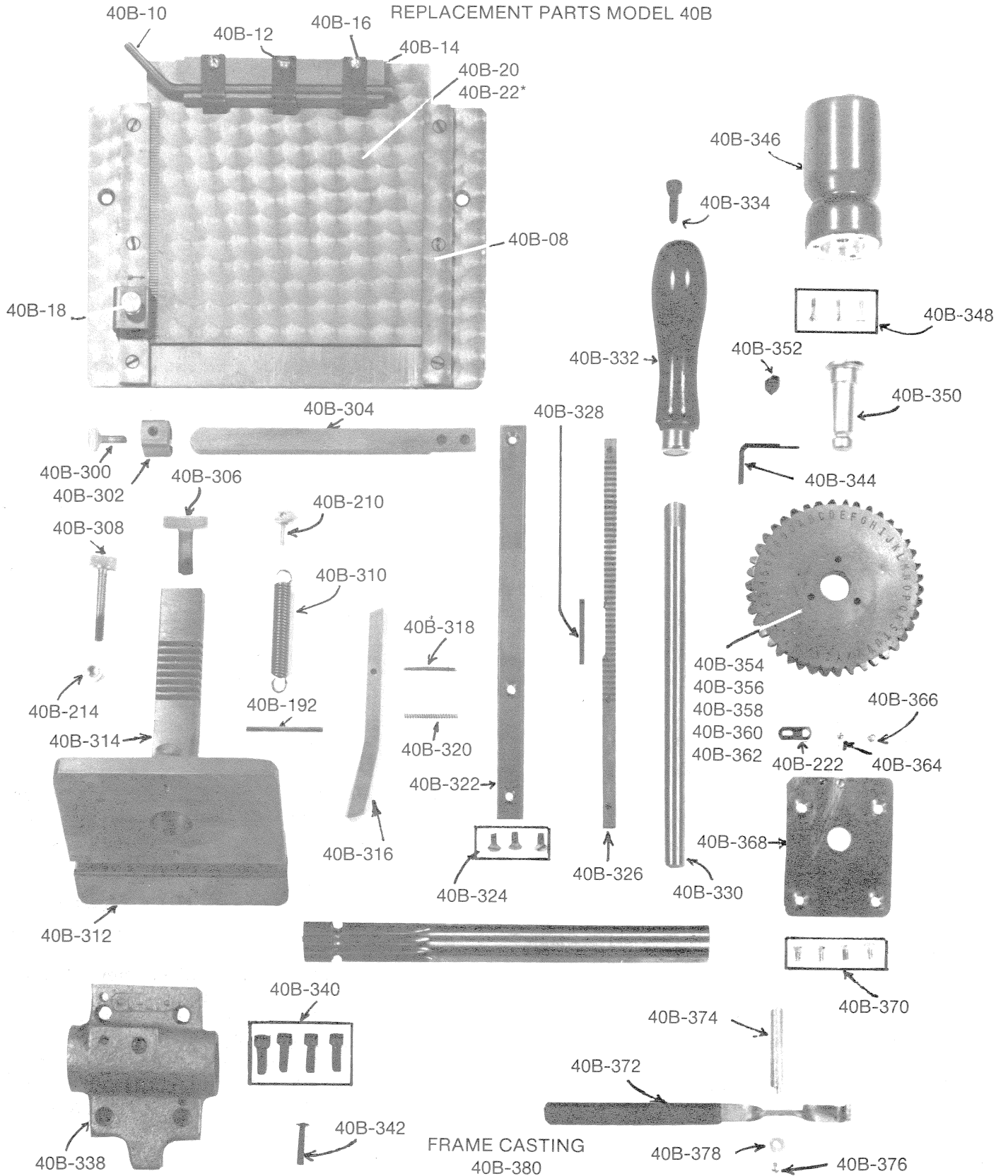
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REPLACEMENT PARTS MODEL 40B



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