

NAME: B HEAD STEM MACH.

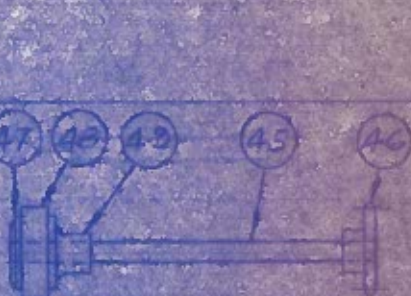
D-1131-2

MACHINE NUMBER: #23-ET

ISSUED: APR. 21, 1959

PARTS LIST

REVISED: APRIL 1964

PART NO	NAME OF PART	MAT'L	QTY REQD	DWG NO	NOTES
34	IDLER BRACKET	C.I.	1	B-5333	
35	SHOULDER SCREW	C.R.S.	1	B-5333	
36	IDLER SPROCKET #KSU-12		1	B-5330-1	
39	SHAFT 22 1/2" LONG	C.R.S.	1	B-5333	
40	WORM GEAR 16 PITCH #D-1610		1	B-5330-1	
41	WORM #DH-1618		1	B-5330-1	
42	SHAFT 9 5/8" LONG	C.R.S.	1	B-4876	
40A	HELICAL GEAR #HB16R		1		
41A	" " #HB10R		1		
45	SHAFT 7 5/8" LONG	C.R.S.	5	B-4876	
46	SPROCKETS #KSU-12		6	B-5330-1	
47	COVER	C.I.	6	B-4876	
48	FRICTION RING	RUBBER	6	B-4876	
49	FRICTION HEAD	C.I.	6	B-4876	
46A	SPROCKETS #KSU-14		6		
52	BUSHING	BRONZE	8	B-6081	
53	FRICTION GEAR	C.I.	8	B-2165	
54	THRUST BEARING #1006		8	B-4996	
57	PUSH-UP ARM - FOR DOUBLE PUSH UP DEVICE ONLY	C.R.S.	1		
58	PUSHUP TRACK	C.R.S.	1	29755	

CHAS. EISLER

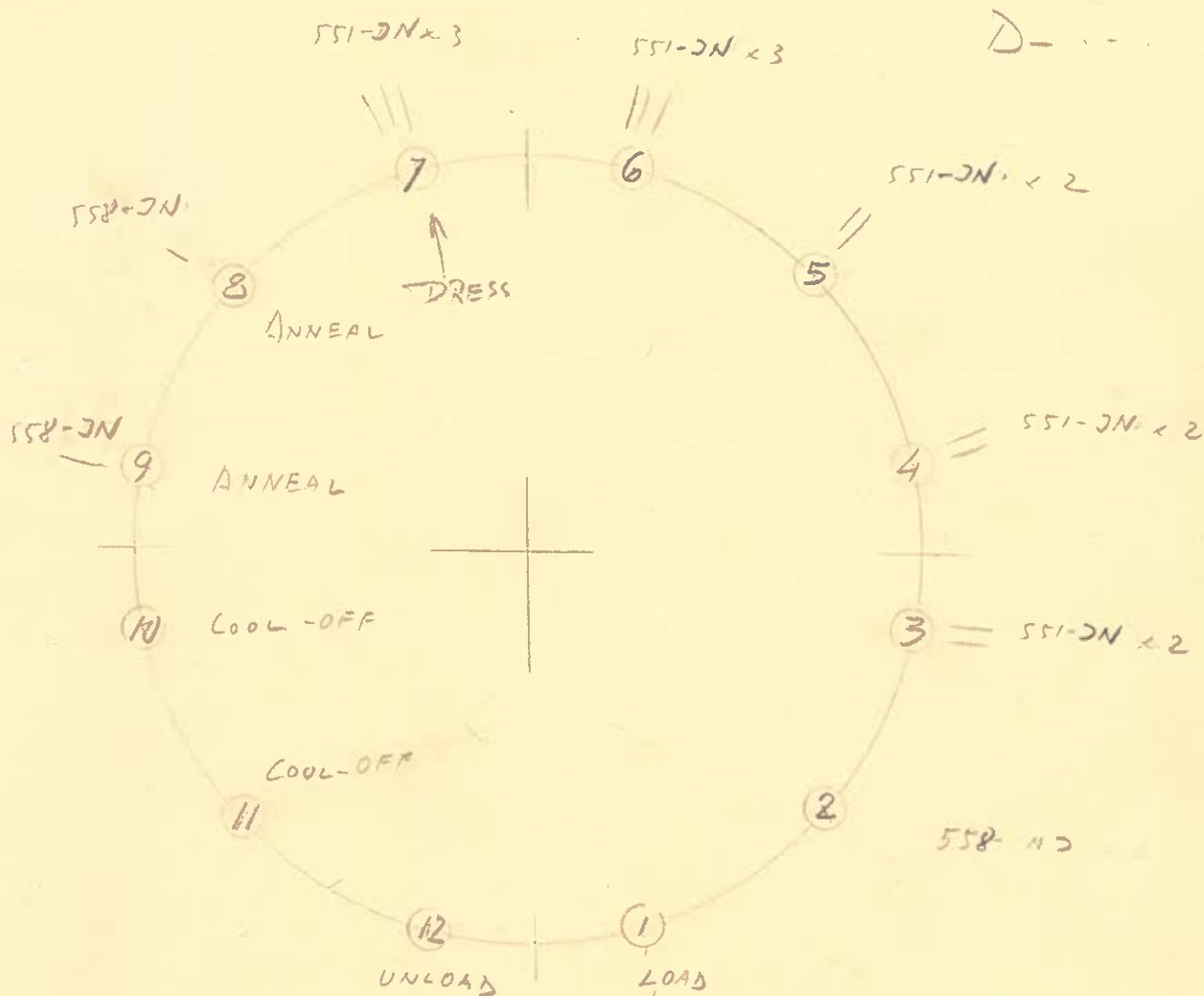
EISLER ENGINEERING CO., INC.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

23-12-TE

12 Pos. Special Pinch Press
MACH. ROB. SHOW.

BURNER LAY-OUT



5/10/78/

NAME: ROTARY ANNEALING OVEN		D-1404 -1
MACHINE NUMBER: 27-SA		ISSUED: 1/5/63
OPERATING INSTRUCTIONS		REVISED:
Gas heated, rotary annealer, designed for annealing small processed glass parts such as press stem, button stem, pinch seals or butt seals. Adjust height of turret to permit the glass part to protrude into heat channel at the desired section. To ignite gas burner, remove front sliding end plate, open gas valve, make sure whole burner is lit. Open air valve to add air until flame loses yellow color. Size of flame will control temperature. Open vent covers for circulation of combustion gases. When temperature indicator has settled at desired temperature proceed with loading. Burner is constructed to allow a decrease of heat. Highest temperature should be at the loading position. Loading should take place in front of end plate and turret advanced until glass part reaches inside heat channel near burner position. Remove annealed product when loading into same stem holder.		
CHAS. EISLER EISLER ENGINEERING CO., INC. 750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.		

NAME: TIPLESS STEM MACHINE		D-326
MACHINE NUMBER: 23 SERIES	ISSUED: Jan. 1, 1941	
OPERATING INSTRUCTIONS		REVISED: Jan. 1, 1945

Jan. 1, 1950

INSTRUCTIONS FOR OPERATING EISLER NO. [REDACTED]
[REDACTED] HEAD TIPLESS STEM MACHINE.

SETTING UP

Unpack carefully and set up machine on level floor. Clean all parts with kerosene to remove protective grease coat. Oil and grease working parts thoroughly. Connect air and gas to manifold (gas: red markings.) Connect motor and be sure machine will turn in direction as indicated by arrow on spider.

Before operating machine under power turn over spider by hand for at least one complete revolution and check working parts for being in alignment.

Set fires at each position adjusting same with needle valves. For fire arrangement see sketches on page 33, Eisler Catalog No. 38-CE.

Adjust air on blowout.

OPERATION

Lead wires into respective holes provided for in die block after setting stop pins for hole lengths. Load flare into flare holder. Place exhaust tube in position. After cycle of operations, including forming of the stem-press, unload finished stems and place same into annealer to prevent cracks.

ADJUSTING THE STEM-PRESS

In order to meet requirements as to variable thickness of the stem-press, the cam actuating the press jaws may be adjusted. Lowering of the press cam -- located in front beneath table of machine --, will result in thinner stem presses, while raising it reverses the effect. Be careful not to lower the cam in excess; hard hitting press jaws may crush the glass.

MAINTENANCE

Compensate machine for possible wear. After many years of continuous operation a loose fitting due to wear may eventually be acquired between geneva and driver. To overcome this play of the spider, loosen two screws on central hub of machine and turn spindle slightly; the eccentricity of the spindle will take care of the above condition providing a tight fit again.

APPROVED:

CHAS. EISLER
EISLER ENGINEERING CO., INC.
 750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: 8 HEAD STEM MACH

D-1131-3

MACHINE NUMBER: 238T

ISSUED: NOV. 30, 1959

PARTS LIST

REVISED: APRIL 1964

PART No.	NAME OF PART	MAT'L	No. REQ'D	DWG No	NOTES
65	COLLAR $1\frac{1}{8}$ O.D. x $\frac{1}{2}$	STEEL	1	B-6595	
66	HEAD STOP	C.R.S.	1	B-6595	
67	HEAD STOP BEARING	C.R.S.	1	B-6595	
68	RETURN SPRING	MUSIC WIRE	1	B-6595	
69	COLLAR $1\frac{5}{8}$ O.D. $\frac{3}{8}$	C.R.S.	1	B-6595	
72	COVER	C.I.	1	B-6595	
73	FRICTION RING	RUBBER	1	B-4876	
74	FRICTION HEAD	C.I.	1	B-6595	
75	FRICTION PINS	FIBER	3	B-6595	
76	FRICTION RING BUSHING	BRONZE	1	B-6595	

CHAS. EISLER

EISLER ENGINEERING CO., INC.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: 8 head tipless stem machine

D-338-A

MACHINE NUMBER: 23-8T

ISSUED: 1/1/41

FLOOR PLAN

REVISED: 7/17/54

2nd Rev. April 1964
3rd Rev. September 1964

OUTSIDE PIPE AIR
INSIDE PIPE GAS
3/4" PIPE.

26"

40"

60"

30"

CENTER OF GAS PIPE
(RED MARKING) IS $1\frac{3}{4}$ "
AWAY FROM CENTER
OF AIR PIPE.

NO. 23-8T
CATALOG NO. 38-CE,
PAGE 37 & CATALOG
NO. 45-CE, PAGE 96

1. Unpack machine carefully and screw it down to floor.
2. Clean all parts with kerosene to remove protective grease coat.
3. Oil and grease working parts thoroughly. (air: marked white)
4. Connect air and gas to manifolds (gas: marked red)(oxy: Green-if supplied)
5. Connect motor and be sure machine will turn in direction as indicated by arrow on spider.
6. Adjust air blowout.
7. Set fires adjusting same with arrow on spider.

Before operating machine under power, index spider by hand and check all working parts for adjustment.

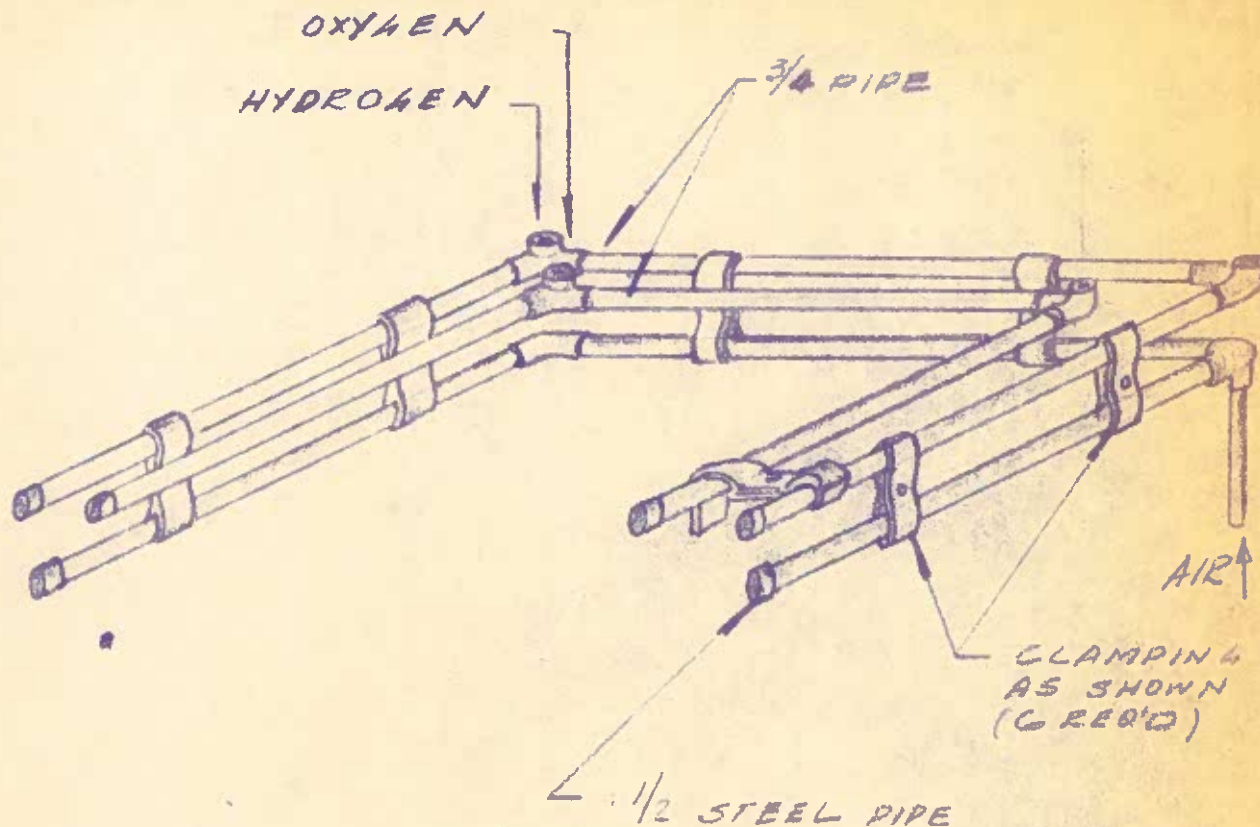
For instructions on operation, on setting stem-press thickness, and on maintenance, see instruction sheet No. D-326.

CHAS. EISLER

EISLER ENGINEERING CO., INC.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: 8 HEAD STEM MACH		D-1275
MACHINE NUMBER: 23-BTE		ISSUED: 3-6-61
MANIFOLD ARRANGEMENT		REVISED:



NOTE:
WESTERN
ELECT CO,

CHAS. EISLER
EISLER ENGINEERING CO., INC.
750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: 8HEAD STEM MACHINE

D-1655

MACHINE NUMBER: 23-8T

ISSUED: 5-14-1969

FIRE LAYOUT

REVISED:

GAS MARKED	RED
AIR "	WHITE
OXYGEN "	GREEN

R G W

T T T



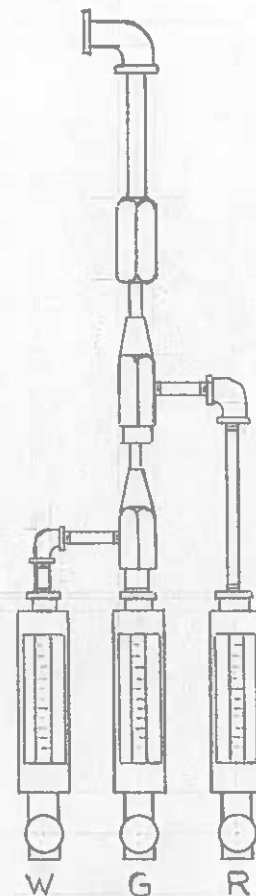
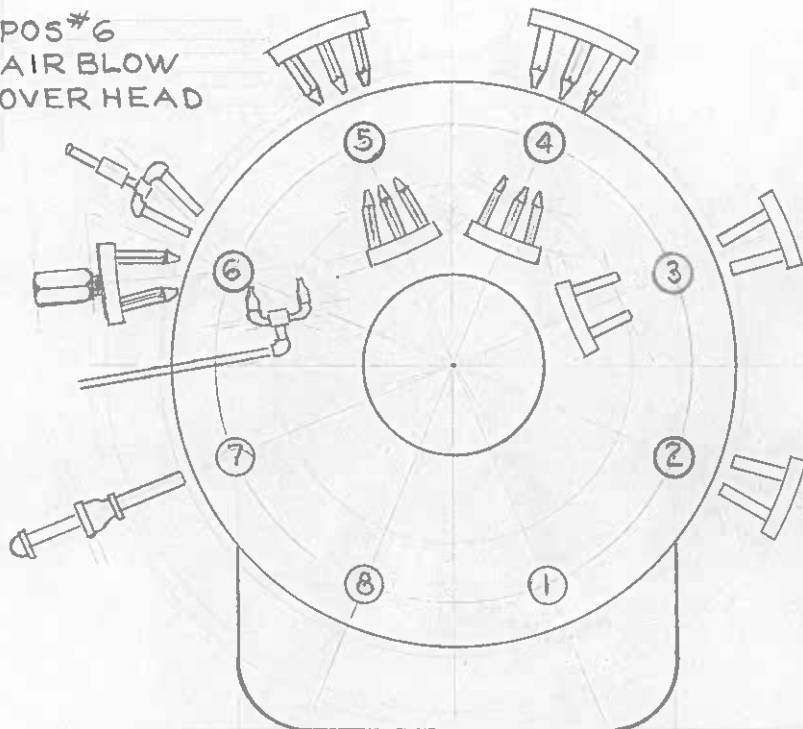
SHO-RATE

R G W

T T T



SHO-RATE

POS #6
AIR BLOW
OVER HEADSHO-RATE AT POS. #4 & 5

POS. #	BURNER	VENT	USE	FIRE CHECK
2	551-JN	50-53	GAS & AIR	—
3	551-DN	40-44	" "	—
4	0F1-043	52-54, 36-52	GAS, AIR, OXY.	72 FIR
5	0F1-043	52-54, 36-52	" " "	72 FIR
6	551-JN-1142A-8INS	50-53, 60-73, 55-60, 45-54	" " "	72 FIR
7	551-JN	57-64	GAS & AIR	—

CHAS. EISLER

EISLER ENGINEERING CO.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: HAND AND GENEVA DRIVEN FORMING MACHINE

D-645

MACHINE NUMBER: 23 SERIES

ISSUED: Sept. 1, 1948

OPERATING INSTRUCTIONS

REVISED:

For additional operating instructions see D-454.

This machine can be indexed by hand or by power using the geneva drive.

1. For hand indexing: Loosen two screws on top of turret near center shaft.

Pull out both keys and tighten screws again. Now turret will rotate free and is disconnected from geneva drive.

Remove set screw from side stop. Spring operated side stop should stop turret in the working position after indexed by hand.

Press lever underneath table is connected with a chain to a foot lever and is provided with a counterweight. This foot lever is only used when the machine is set up for hand index.

2. For machine operation: Loosen two screws on top of turret near center shaft. Push in both keys to connect turret with geneva gear and tighten screws again. Now turret will move with geneva gear.

Push down plunger on side stop and place in set screw to keep plunger in bottom position.

Now the side stop will not interfere with the machine operation.

Remove counterweight and disconnect chain from press lever underneath table. Loosen set screw at end of press lever and remove chain supporting stud. Place roller stud in end of press lever so that the roller is lined up with the cam surface and tighten set screw.

APPROVED:

CHAS. EISLER

EISLER ENGINEERING CO., INC.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.

NAME: HAND AND GENEVA DRIVEN FORMING MACHINE

D-645

MACHINE NUMBER: 23 SERIES

ISSUED: Sept. 1, 1948

OPERATING INSTRUCTIONS

REVISED: APRIL 1964

For additional operating instructions see D-454.

This machine can be indexed by hand or by power using the geneva drive.

1. For hand indexing: Loosen two screws on top of turret near center shaft.

Pull out both keys and tighten screws again. Now turret will rotate free and is disconnected from geneva drive.

Remove set screw from side stop. Spring operated side stop should stop turret in the working position after indexed by hand.

Press lever underneath table is connected with a chain to a foot lever and is provided with a counterweight. This foot lever is only used when the machine is set up for hand index.

2. For machine operation: Loosen two screws on top of turret near center shaft. Push in both keys to connect turret with geneva gear and tighten screws again. Now turret will move with geneva gear.

Push down plunger on side stop and place in set screw to keep plunger in bottom position.

Now the side stop will not interfere with the machine operation.

Remove counterweight and disconnect chain from press lever underneath table. Loosen set screw at end of press lever and remove chain supporting stud. Place roller stud in end of press lever so that the roller is lined up with the cam surface and tighten set screw.

APPROVED:

CHAS. EISLER

EISLER ENGINEERING CO., INC.

750 SOUTH 13TH ST. NEAR AVON AVE. NEWARK 3, N. J. U. S. A.