**S A F E T Y**

**WHEN THE TABLE IS RAISED, BEFORE MAKING ANY TEST OR ADJUSTMENT, CHECK THAT THE SAFETY FINGER 753A IS OVER THE END OF THE PLUNGER CAM LEVER A258**

 **When Machine Stalls In Casting Position**

In the event the machine should stall due to a hot metal flash just as the cast is being made, or has just been made. It will be necessary to raise the Table No. 48, to investigate and correct the trouble, but before attempting to raise the table, t**he following procedure is IMPERATIVE!**

1. “Throw” the motor switch to the “OFF” position.
2. Remove Plunger Connecting Lever Pin, 275
3. Remove the Safety Lever Screw, 7301/2, which connects the Safety Connecting Rod, 747B. These parts are located on top of the table
4. This should permit the plunger cam lever to be depressed enough so that the Safety Finger, 753A, may be positioned over the top of the projecting end of the plunger cam lever. **It is most important that the safety finger be positioned over the cam lever BEFORE any attempt is made to raise the table.**
5. Release the Rear Table Latch, 86B, by removing the threaded Table Latch Yoke Pin, 83A. The removal of this threaded pin is accomplished by inserting a long screw driver through the ½ inch hole located on the rear side of the table near, the center, and unscrewing the threaded pin, thereby releasing Table Latch, 86B.
6. Release the Front Table Catches, A93A and 97. The Table may now be raised for observation of the location of the metal flashings.
7. Remove all metal flashings from the movable parts as well as the interior of the machine generally.
8. Add new Safety Key, 155B.
9. Replace Plunger Connecting Lever Pin, 275.
10. Reassemble all parts which have been removed.
11. Operate the machine manually until the cam shaft returns to the neutral or idling position.