



## **Servicing the Model 4 and 6 Nameplate Detail Presses**

The most common replacement on the nameplate detail press is the ram, part number 033074, detail 28. This device carries the character dial up and down while making a mark, so it receives the most wear. We recommend replacing the depth adjustment screw (part number 033086, detail 39-44) at the same time the ram is replaced.

The most common adjustments are for tag thickness and table spacing

The following tools will be needed to service the Model 4 and 6:

3/32" long arm hex key

3/16" long arm hex key

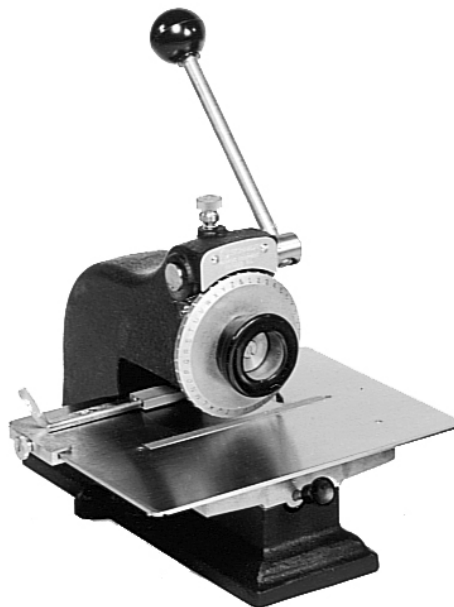
5/16" box / open end  
wrench

3/8" box / open end wrench

6" adjustable wrench

slotted blade screwdriver

6-inch scale



Note: On machines prior to serial number 45000, the jam nut on the bell crank screw was 7/16" across the flats, hence the reason for the adjustable wrench in addition to the box /open end wrenches.

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## Replacing the Ram (part 033074, detail 28)

This set of instructions consists of two (2) sections – section one details **removing the ram**, while section two details **replacing the ram**.

Upon completing the removal and replacement, it is necessary to adjust the machine for the thickness of the tag you are marking. Please see the section **“Adjusting the Model 4 or 6 for Tag Thickness”** to properly adjust the machine.

### Removing the Ram

1. Unscrew the slotted screw in the center of the dial knob (45) and remove the character dial from machine.
2. Slide the table (5) all the way to the right.





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3. Remove the stop screw from the table slide (located at the upper left hand corner of table slide assembly 4-21-41).



corner of  
table slide  
assembly  
4-21-41).



4. While holding the table with your left hand, push in and hold the space button (2-24) and slide the table off the machine to the left.

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5. Turn machine upside-down and remove connector link (36) by pushing in on the space button (2-24). Occasionally, the nut and screw on the bell crank (17) must be loosened to remove connector link.



on the space button (2-24). Occasionally, the nut and screw on the bell crank (17) must be loosened to remove connector link.



6. Remove the four  $\frac{1}{4}$  - 20 socket head cap screws from the table slide assembly. They are located at bottom mid-section of table slide, and hold the table slide assembly to the machine casting.



7. Lift the table slide assembly from the machine base and remove.



8. Unscrew the depth adjustment screw (39-44) from the ram. The ram can then be pushed down and off the machine.

Note: Occasionally, the gib (27, located on the left hand side of the dove-tail section) will drop off the machine when removing the ram. To re-install the gib, hold the gib in place while installing the new ram. The gib should be flush with the face of the casting, otherwise it will interfere with the character dial during operation. There are three set screws (gib screws) with jam nuts that hold the gib in place. The screws may have to be loosened in order to install the new ram (28). When the new ram is in place, snug up the screws and then tighten the jam nuts. Make sure that the ram (28) has free up and down motion when you pull down on the operating handle (32-33). If the ram does not travel freely, loosen the gib screws slightly and snug the jam nuts.

### Installing the new Ram

1. Using a scale, note the distance between the head of the capstan screw (30) and the top of the damaged ram **before** removing the capstan screw.



Keep the distance the same when replacing the capstan screw into the new ram. Also remove the 3/32" set screw from the damaged ram and re-install it into the new ram until it makes contact with the capstan screw – **do not tighten the set screw yet.**

2. Slide the new ram from the bottom up through the dove-tail section of the casting, then replace

plunger spring (46) into hole at top of casting and screw the depth adjustment screw into the ram until the operating handle can be pulled down no further than the 9 o'clock (horizontal) position.

3. Re-install the table slide assembly (4-21-41) onto the machine base using the four ¼ - 20 socket head cap screws.
4. Turn the machine upside-down and install the connector link (36) to the stud on the bell crank (17) and stud on the pawl assembly (11-12-7-38).
5. Replace the character dial and test the machine for spacing and depth of mark.

Note: There are two (2) studs on the pawl assembly. The connector link should be placed on the stud **opposite** the stud that the space button assembly (2-24) pushes on.



## Model 4 & 6 Adjustment Procedures

### Adjusting the Model 4 or 6 for Tag Thickness

To determine if the machine requires adjustment, (with the character dial on machine) pull the operating handle (32-33) down. the operating handle should not be pulled down past the 9 o'clock (horizontal) position. if it does, adjust the depth adjustment screw (39-44) clockwise until you can pull down to slightly above the 9 o'clock (horizontal) position.

**It is crucial that when making a mark with your Model 4 or 6, the operating handle should not be pulled down past the 9 o'clock (horizontal) position. The head of the depth adjustment screw (39-44) should hit the machine casting when the operating handle is pulled down to the 9 o'clock (horizontal) position. This will control the depth of mark and avoid bending the depth adjustment screw and breaking the ram.**

Place a tag to be marked in the Table Gauge Assembly (41-73) [or in your current tag fixture or nest] and pull down on the operating handle.

Is there a mark? Is the mark too deep or too shallow?

#### **If the mark is too deep....**

1. Remove the character dial from the machine. Insert the end of a 3/32" hex key into any of the holes in the capstan screw (30) and turn the capstan screw approximately four to five holes clockwise. This will move the ram upward and away from the piece to be marked.
2. Readjust the depth adjustment screw (39-44) counter clockwise so that when the operating handle is pulled down it stops slightly above the 9 o'clock (horizontal) position.
3. Replace the character dial on the ram and pull down on the operating handle to make a mark on the tag. If the mark is still too shallow, repeat steps 1 & 2. If mark is acceptable, remove the character dial and tighten the 3/32 set screw (located near the top of the ram). Replace the character dial on the ram. Your depth of character is now completed.



### **If the mark is too shallow....**

1. Remove the character dial from the machine. Insert the end of a 3/32" hex key into any of the holes in the capstan screw (30), and turn the capstan screw four or five holes counter clock-wise. This will move the ram downward and closer to the piece to be marked.
2. Readjust the depth adjustment screw (39-44) clockwise so that when the operating handle is pulled down it stops slightly above the 9 o'clock (horizontal) position.
3. Replace the character dial on the ram and pull down on the operating handle to make a mark on the tag. If the mark is still too shallow, repeat steps 1 & 2. If mark is acceptable, remove the character dial and tighten the 3/32 set screw (located near the top of the ram). Replace the character dial on the ram. Your depth of character is now completed.

When the depth of mark is satisfactory for your application, you may experience the table skipping when you make a mark. This is common when a depth of mark adjustment is made by changing the capstan screw position.

### **Adjusting the Table Spacing on the Model 4 and 6**

1. Remove the character dial from machine.
2. Push the table (5) all the way to the right.
3. Remove the stop screw from the table slide (located at the upper left hand corner of table slide assembly 4-21-41).
4. While holding the table with your left hand, push in and hold the space button (2-24), and slide the table off the machine to the left.
5. Turn depth adjustment screw (39-44) counter clockwise approximately five turns, then pull operating handle (32-33) down until the shaft of the operating handle rests on the table slide assembly - leave the handle in this position throughout the following procedures.





6. Verify the adjustment of the pawl assembly in relation to the escapement wheel assembly.

The escapement wheel assembly (13-14) is located in the center of the table slide assembly.

The pawl assembly (11-12-7-38) is located in between the teeth of the escapement wheel assembly (13-14).



Move the handle to the 9 O'clock position. If the machine is adjusted properly, the top of the pawl should be flush with the top of the flat gear on the escapement wheel assembly. You should be able to run a fingernail across the flat starburst gear and across the pawl assembly.

To adjust the pawl assembly height, continue with the following steps:

7. Turn machine upside down and locate the nut and screw on the bell crank (17).
8. Loosen the nut on the bell crank.
9. Turn the screw on the bell crank clockwise to adjust the pawl assembly downward to achieve flushness with the escapement wheel assembly or counter clockwise to raise pawl assembly until flush with escapement wheel assembly
10. Tighten the nut on the bell crank once the adjustment is complete. Turn machine right side up.

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11. Raise operating handle and turn the depth adjustment screw clockwise until the operating handle can be pulled down no further than slightly above the 9 o'clock (horizontal) position.

12. Slide the table back onto the machine and replace the stop screw on the table slide assembly.

13. Install the character dial on the machine.

**Important Note!! - It is crucial that when making a mark with your Model 4 or 6, the operating handle should not be pulled down past the 9 o'clock (horizontal) position. The head of the depth adjustment screw (39-44) should hit the machine casting when the operating handle is pulled down to the 9 o'clock (horizontal) position. This will control the depth of mark and avoid bending the depth adjustment screw and breaking the ram.**