

NUMBERALL

STAMP & TOOL CO., INC.

USER MANUAL & PARTS LIST

MODEL

94

S/N:

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MODEL 94 NUMBERING & LETTERING PRESS

Uncrating Procedure

1. The Model 94 is shipped bolted to a wooden skid. It is covered with a cardboard box that is stapled and banded to the wooden skid.
2. Cut the plastic shipping bands. Cut the cardboard box all the way around, within a couple of inches of the top of the wooden skid.
3. Lift off the cardboard cover, remove the protective plastic bag and unbolt the press.
4. The Model 94 weighs 88 pounds and should be lifted with caution.
5. Bolt the press securely to a solid bench to avoid accidental upset.
6. Any shipping damage to the press must be reported immediately to the common carrier and to Numberall.

Product Description

The Model 94 is a manually operated press, designed for stamping name tags, serial plates and other small parts. The Model 94 is a powerful machine. It will easily stamp a 3/8" character into mild steel stock.

Equipped with the standard table, the Model 94 will stamp an area of 6-1/4" x 7". It will stamp 4-1/2" from the top of the nameplate. Extra wide tables and spacing racks are available.

The Model 94 stamps one character at a time and advances automatically after each impression. Blank spacing is accomplished by half stroking the operating handle.

Character Dial wheels and corresponding spacing racks are available in the following sizes: 1/8", 5/32", 3/16", 1/4", 5/16", and 3/8". Other sizes are available as special orders. Strip holders and special nests to hold tags or parts are also available.

Function of Controls

1. OPERATING HANDLE (94-202) - The operating handle, located on the right side of the press, 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 cycled up and down, 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. The handle should be operated from stop to stop (except when a blank space is needed). It is important to make sure the handle is returned to its full up-right position, otherwise the table will not space properly.

2. **TABLE ELEVATION SCREW NUT (94-98)** - This knurled nut, located in the front near the base of the frame casting, adjusts the height of the table. Turning the nut counter-clockwise lowers the table. Turning the nut clockwise raises the table. The table has a vertical adjustment of 2".
3. **SPACING ADJUSTMENT SCREW** - This screw adjusts the spacing mechanism of the table. When exchanging spacing racks, it may be necessary to turn the screw in or out to produce correct single spacing. Depending on the position of the screw, the table will either not space, single space, or double space. A position can easily be found where the machine will single space for any character size. A jam nut must be loosened to turn the screw. Retighten it after adjustment.
4. **MARGIN ADJUSTMENT STOP** - The margin adjustment stop slips over the rectangular steel bar, which extends to the right from the machine. A thumb screw tightens and loosens the stop. The stop limits the right-hand travel of the table, which sets the left margin.
5. **DIAL CHARACTER WHEEL** - The dial character wheel selects the characters to be stamped. Rotate the dial until the character desired is at the bottom of the wheel, beneath the character dial pointer. The dial tends to center itself on a character. By applying very slight torque left and right on the dial, the operator can be certain that the dial is centered.

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 depressing the table release lever and moving the operating table left or right. Return the handle to the full, upright position after moving the table.
3. Lower the table by turning the elevation nut counter-clockwise, until the operating handle can be fully depressed and the character dial does not touch the material.

4. With the handle fully depressed, rotate the elevation nut clockwise, until the material and dial just touch. Return the handle to the full, upright position.
5. Rotate the elevation nut clockwise (1/8th of a turn at a time) and cycle the handle from full down to full up positions. Check the impression after each turn of the elevation nut. Stop the adjustment when a suitable impression is obtained. Make sure the handle reaches the down stop each time.
6. Operated the press several times to check the impression. Remember to return the handle to the full up position for proper spacing.
7. The Model 94 is now adjusted for repeated stampings with the same depth of impression, as long as the material thickness remains constant.
8. To set the table margin 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 operating handle a half-stroke and move the table until the character dial lines up a few spaces to the left of the beginning of the stamping area. Return the handle to the full up position. Now tap the table to the left VERY carefully. It will click when the spacing pawl engages with the spacing rack. After it clicks, move the operating handle a half-stroke and return. Repeat this until the dial is in line with the beginning of the stamping sequence. Slide the margin stop up against the table and tighten the thumb screw. The left hand margin is now set.
9. The table insert can be moved in and out after loosening the brass thumb screw located on the left side of the table. Line to line spacing can be judged using the engraved marks on the left side of the table insert. Each increment measures 1/16". An arrow is stamped on the table guide to serve as a reference point. Retighten the thumb screw after each adjustment.

Character Dial and Spacing Rack Removal & Installation

1. Remove the Dial Retaining Screw (94-352), Character Dial Pointer (94-344), and Character Dial Washer (94-366) located in the center of the dial.
2. Pull the Dial off of the Dial Shaft (94-350).
3. Reverse the above procedure with the new Dial.
4. 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.
5. Remove the three screws that hold the spacing rack, which are located on the underside of the table.

6. 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

Keep a film of oil on the following surfaces:

- Square post (94-312) beneath the table
- Top and bottom of the upper knuckle (94-502)
- Top and lower pivot of the lower knuckle (94-504)
- Elevation screw (94-98A)
- Spacing cam (94-244)
- Pivot points on the spacing actuating lever (94-372)

Use graphite on the following surfaces: (NOTE: Oil used on these surfaces will accumulate dirt and may bind the machine)

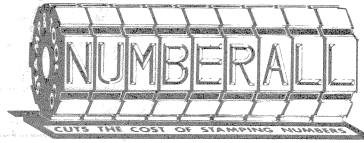
- Table dovetail strips (94-322)
- Table insert guides (94-25)
- Rear surface of the character dial
- Table vertical way plate (94-516)

The table tension spring (94-280) is located on the rear edge of the cast table. If the spring loses its set, the table may glide by and give improper spacing. The spring can be re-bent to provide proper tension.

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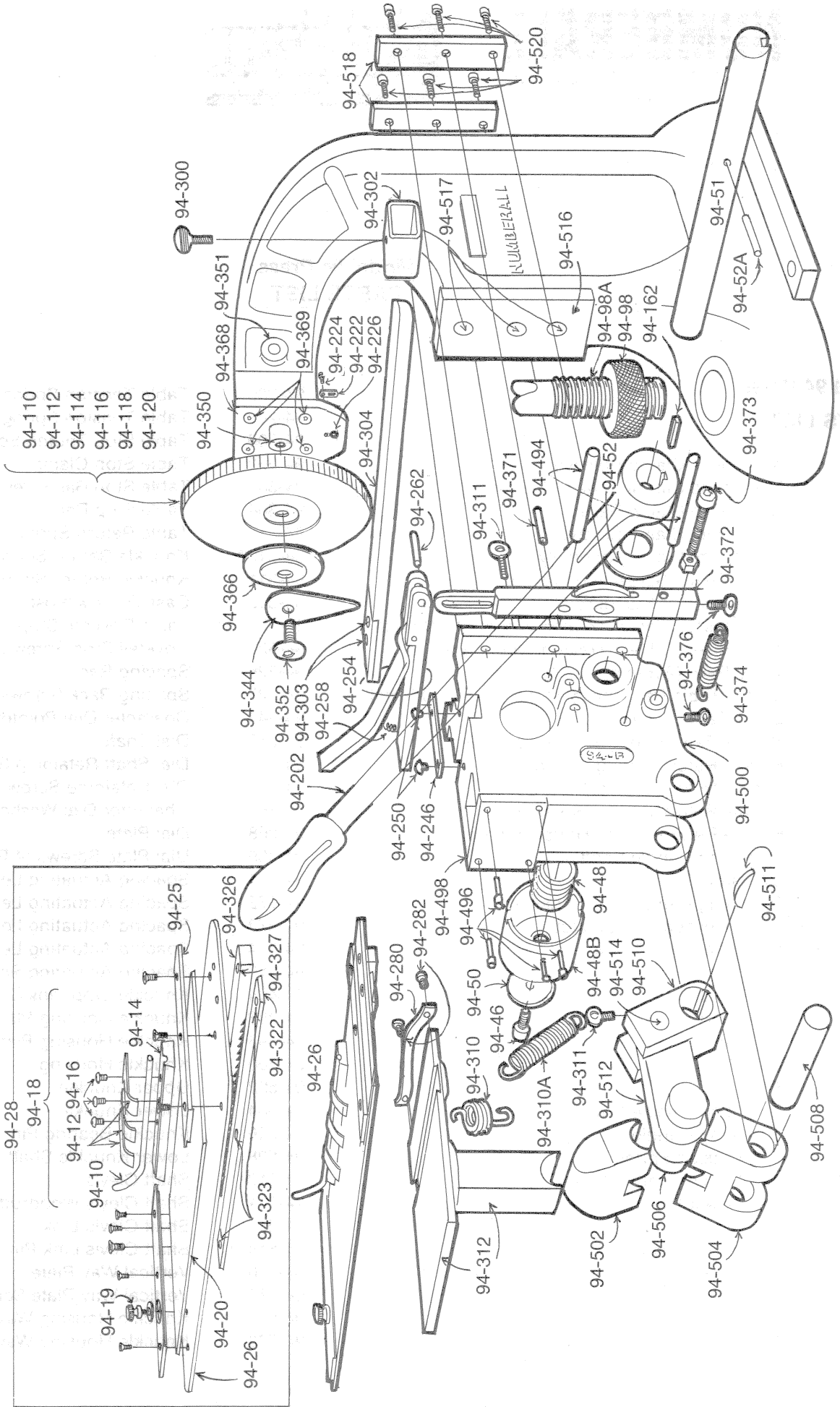
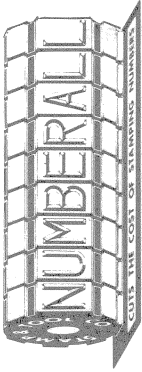
94-10	Nameplate Clamp Release Lever	94-280	Table Tension Spring
94-12	Nameplate Clip Springs (3 Req'd)	94-282	Table Tension Spring Screws (2 Req'd)
94-14	Nameplate Clamp Base	94-300	Table Stop Thumb Screw
94-16	Nameplate Clamp Screws (3 Req'd)	94-302	Table Stop Clamp
94-18	Nameplate Clamp Assembly	94-303	Table Stop Bar Screws (2 Req'd)
94-19	Table Clamp Screw and Washer	94-304	Table Stop Bar
94-20	Table Insert ** Standard **	94-310	Table Return Spring
94-22	Table Insert ** Heat Treated Without Exchange *	94-310A	Knuckle Return Spring
94-22A	Table Insert ** Heat Treated With Exchange **	94-311	Knuckle Return Spring Thumb Screw
94-25	Table Rails (2 Req'd)	94-312	Cast Table w/Post
94-26	Comp. Table Base Incl'g. Guide Rails & Dovetail	94-322	Table Dovetail Strip
94-28	Entire Table Assembly	94-323	Dovetail Strip Screw (3 Req'd)
94-46	Handle Return Spring Housing Screw	94-326	Spacing Rack
94-48	Handle Return Spring ** Wire **	94-327	Spacing Rack Screws (3 Req'd)
94-48A	Handle Return Spring ** Flat **	94-344	Character Dial Pointer
94-48B	Handle Return Spring Housing	94-350	Dial Shaft
94-50	Handle Return Spring Housing Washer	94-351	Dial Shaft Retaining Screw
94-51	Operating Handle Shaft	94-352	Dial Retaining Screw
94-52A	Operating Handle Shaft Pin	94-366	Character Dial Washer
94-52	Operating Handle Shaft Spacer	94-368	Dial Plate
94-98	Table Elevation Screw Nut	94-369	Dial Plate Screws (4 Req'd)
94-98A	Table Elevation Screw	94-371	Spacing Actuating Lever Pin
94-110	1/8" Dial	94-372	Spacing Actuating Lever Ass'y
94-112	5/32" Dial	94-373	Spacing Actuating Lever Screw & Nut
94-114	3/16" Dial	94-374	Spacing Actuating Lever Spring
94-116	1/4" Dial	94-376	Spacing Actuating Spring Thumbscrews (2 Req'd)
94-118	5/16" Dial	94-494	Knuckle Stop Pins (2 Req'd)
94-120	3/8" Dial	94-496	Knuckle Housing Plate Screws (4 Req'd)
94-162	Operating Handle Key	94-498	Knuckle Housing Plate
94-202	Operating Handle	94-500	Knuckle Housing
94-222	Dial Tension Spring	94-502	Upper Knuckle
94-224	Dial Tension Spring Screw	94-504	Lower Knuckle
94-226	Dial Detent Ball	94-506	Knuckle Bearing Pin
94-246	Spacing Pawl Retaining Plate	94-508	Lower Knuckle Shaft
94-248	Spacing Mechanism Base	94-510	Shaft Clevis
94-250	Spacing Pawl Retaining Plate Screws (2 Req'd)	94-511	Shaft Clevis Woodruff Key
94-254	Spacing Mechanism ** Complete Assembly **	94-512	Shaft Clevis Link
94-258	Spacing Pawl Spring	94-514	Shaft Clevis Link Pin
94-262	Spacing Mechanism Pins	94-516	Vertical Way Plate
		94-517	Vertical Way Plate Screws (3 Req'd)
		94-518	Knuckle Housing Way Plates (2 Req'd)
		94-520	Knuckle Housing Way Plate Screws (6 Req'd)

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ALWAYS SPECIFY SERIAL NUMBER WHEN ORDERING PARTS.

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For extra copies of this manual please call or
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