

1009-74522-0

Bearing Box	Bearing	Seal
CXF-105	NA 484-472 D	CR-37433
CXF-106	NA 484-472 D	CR-37433
CXF-107	NA 484-472 D	CR-37433
CXF-108	NA 484-472 D	
CXF-110	NA 484-472 D	
CXF-111	NA 484-472 D	

CR OAK Seal #487324 M1 cross over
number CR-37433

1042-37500-0

Doug Eddy

413 525 8461

OPERATING MANUAL
with
PARTS LISTS & CHARTS
for

S & S Type CXF
SLITTER-SCORER
4-BAR
(6" diameter shafts)

JUNE 1974



S & S CORRUGATED PAPER MACHINERY CO., Inc.
160 North Fourth Street
Brooklyn, N.Y. 11211
Telephone: (212) 782-9700

OPERATING MANUAL
with
PARTS LISTS & CHARTS
for
S & S Model-CXF SLITTER-SCORER
(4-bar)
(6" diameter shafts)

S & S CORRUGATED PAPER MACHINERY CO., Inc.
160 North Fourth Street
Brooklyn, 11, New York

Telephone: STagg 2-9700

LUBRICATION CHART

S & S CORRUGATED PAPER MACHINERY CO., INC.

The lubricants listed below are manufactured by Socony Mobil Oil Company, Inc. and are recommended to assure "trouble-free" service.

CORRUGATED COMBINING MACHINES

<u>TYPE OF EQUIPMENT</u>	<u>METHOD OF APPLICATION</u>	<u>RECOMMENDATION</u>
SINGLE FACER		
Bearings	Oilers	Mobil D.T.E. Oil Extra Heavy
	Fittings	Mobilplex EP No. 1
Open Gears	Brush	Dorcia 150
Open Chain Drive	Hand	Mobil Vactra Oil Extra Heavy
Slip Gears On Pressure	Rolls-Plug	Mobil 600W Cylinder Oil
PREHEATER (SINGLE AND DOUBLE)		
Bearings	Oilers	Mobil D.T.E. Oil Extra Heavy
	Fittings	Mobilplex EP No. 1
Geared Motor Drive	Splash	Mobil 600W Cylinder Oil
Open Gears		Dorcia 150
BRIDGE		
Bearings		Mobilplex EP No. 1
Open Gears or Sprockets & Chains		Dorcia 150
DOUBLE BACKER		
Bearings	Oilers	Mobil D.T.E. Oil Extra Heavy
	Fittings	Mobilplex EP No. 1
Enclosed Gears	Bath	Mobil D.T.E. Oil Extra Heavy
Open Gears	Brush	Dorcia 150
Open Chain Drive	Hand	Mobil Vactra Oil Extra Heavy
DUPLEX OR TRIPLEX SLITTER		
Bearings		Mobilplex EP No. 1
Open Gears or Sprockets & Chains		Dorcia 150
CONTINUOUS PRECISION SHEET CUT-OFF (SINGLE & DOUBLE)		
Enclosed Gears, & Bearings & Pump		Mobil D.T.E. Oil Extra Heavy
Roller Bearings		Mobilplex EP No. 1
Vari-Speed Motor Drive		
Enclosed Gears		Mobil D.T.E. Oil Extra Heavy
Bearings	Grease Gun	Mobilplex EP No. 1
Knife Bar Gears		Mobilplex EP No. 1
SHEET COLLECTOR AND SIDE DELIVERY		
Bearings		Mobilplex EP No. 1
Open Gears or Sprockets & Chains		Dorcia 150

LUBRICATION CHART

FOR EQUIPMENT MANUFACTURED BY

S & S CORRUGATED PAPER MACHINERY CO., INC.

The lubricants listed below are manufactured by Socony Mobil Oil Company, Inc. and are recommended to assure "trouble-free" service.

However, other high-quality products of an equivalent value can also be used.

1. Bearings lubricated through pressure fittings.

MOBILUX GREASE NO. 2

2. Enclosed Gears and Bearings bath oiled or fed by drip lubricator.

MOBIL D.T.E. OIL EXTRA HEAVY

3. Open Gears fed by drip lubricator.

MOBIL DORCIA 150

4. Chains or Sprockets.

MOBIL VACTRA OIL EXTRA HEAVY

5. Worm Gears hand or bath oiled.

MOBIL CYLINDER OIL 600W

6. Spur Gears open or covered hand applied.

MOBILUX GREASE NO. 2

7. Steam Joints.

MOBIL CYLINDER OIL 600W

8. Air Control Valves and Leather Oil Retainers.

ANY MINERAL - NEATSFOOT OIL

9. Oil treatment of Corrugating Rolls.

RUBREX 100

10. Bijur Lubricator

MOBIL VACTRA OIL EXTRA HEAVY

Fig. # 3

- * (1) 3-CX-670-J Head V-type creaser
- * (2) 3-CR-1185-A Head, flat anvil creaser
(for body scoring and slit-scoring)
- * (3) 3-CX-653-J Head, male creaser (profile)
- * (4) 3-CX-653-J Head, female creaser (profile)
- * (5) 3-SL-1051-A Head, knife (for regular slitter blade and
slit scoring blade)
- * (6) 2-944-79-0-G Blade, regular slitter
- * (7) 2-944-1402-0-0 Tapered blade, slit-scoring (special)
- (8) 2-CXD-35-C Holder, scale
- (9) 1-CXD-37B Collar, scale holder
- (10) 3/8-16 x 3/4" long thumb screw
- (11) 1-CX-626-C Block, side gauge (short)
- (12) 1-942-692-0-0 Knob, side gauge adjusting
- (13) 1-CX-69A Stud, side gauge lock
- (14) 1-STD-307 Washer, side gauge
- (15) 2-CX-625-D Block, side gauge (long)
- (16) 1/2" x 1-1/2" long hex head cap screw
- (17) 1-CB-43-B Handle sheet pusher
- (18) 2-CB-42-3B Sheet pusher
- (19) 1-CB-104 Plate, sheet pusher
- * (20) 7/16-14 x 1-1/2" long socket head cap screw
(for clamping heads)
- * (21) 5/16-18 x 3/4" long hex head cap screws
(for 2-944-79-0-G)
- * (22) 5/16-18 x 5/8" long hex head cap screws
(for 2-944-1402-0-0)

* Items marked by an asterisk (*) are listed on the "Suggested Parts List".

CORRUGATED COMBINING MACHINES (CONTINUED)

<u>TYPE OF EQUIPMENT</u>	<u>METHOD OF APPLICATION</u>	<u>RECOMMENDATION</u>
SHAFTLESS MILL ROLL STAND		
Bearings, Fittings, Etc.	Gun	Mobilplex EP No. 1
Six Inch Shafts & Drive Screws		Mobilgrease Special
Main Worm Gear		Mobil Vactra Oil No. 4
CONVERTING MACHINES		
FLAP CUTTER, COATING MACHINE, BA PARAFFINING MACHINE, SLITTER REWINDER, ECCENTRIC SLOTTER, *OPENTHROAT TAPER, SAMPLE MACHINE, LAP GLUER, JAW SLOTTERS, BENCH SHEAR		
Bearings	Circulation	Mobilplex EP No. 1
Open Gears or Sprockets & Chains		Dorcia 150
*Equipped with Hydraulic Lift		Mobil D.T.E. Oil Heavy Medium
DELUXE SLITTER-SCORER		
Enclosed Gears & Bearings	Grease Gun	Mobil D.T.E. Oil Extra Heavy
Roller Bearings & Electric Motor		Mobilplex EP No. 1
Bearings		
ROTARY SLOTTER		
Gears		Dorcia 150
Bearings (grease lubricated)		Mobilplex EP No. 1
DELUXE PRINTER-SLOTTER		
Enclosed Gears & Bearings		Mobil D.T.E. Oil Extra Heavy
Kicker and Motor Bearings		Mobilplex EP No. 1
DELUXE COMBINATION PARTITION AND BOX SLOTTER		
Enclosed Gears & Bearings		Mobil D.T.E. Oil Extra Heavy
Motor Bearings		Mobilplex EP No. 1
FINISHING MACHINES		
ZS AUTOMATIC FOLDING & SQUARING MACHINE, ZB FOLDER TAPER MACHINE AND ZLG AUTOMATIC FOLDER GLUER		
Enclosed Gears & Bearings		Mobil D.T.E. Oil Extra Heavy
Drive Chains, Adjusting Chains, Feed Screws		Mobilplex EP No. 1
Bearings (grease lubricated)		Mobilplex EP No. 1
TYPE C - CUTTING AND CREASING PRESS		
Bijur Lubricator	Reservoir	Mobil Vactra Oil Extra Heavy
Bearings, Fittings	Gun	Mobilplex EP No. 1

SUGGESTED LIST OF PARTS
to be kept in stock for
S & S TYPE "CXF" SLITTER-SCORER
(6" diameter)

<u>QUANTITY</u>	<u>PART NUMBER and DESCRIPTION</u>
2	2-CX-653-J head, male creaser (profile)
2	2-CX-653-J head, female creaser (profile)
2	3-CX-670-J head, V-type creaser
2	3-CR-1185-A head, flat anvil creaser
4	3-SL-1051-A head, slitter blade
12	2-KN-79-G blade, slitter
72	7/16-14 x 1½" long, socket head cap screws (for clamping heads)
72	5/16-18 x 3/4" long, hex head cap screws (for KN-79-G)

SPECIAL PARTS FOR SLIT-SCORING OPERATION

To be used with a Tie Brace CXF-10006

3-CR-1185-A head, flat anvil
3-SL-1051-A head, slit-score blade
2-KN-1402 blade, slit-score
5/16-18 x 5/8" long hex head cap screws (for 2-KN-1402)
7/16-14 x 1½" long socket head cap screws (for clamping heads)

All of the above parts are marked with an asterisk (*) on the following parts charts.

SUGGESTED LIST OF PARTS

to be kept in stock for

S & S TYPE "CXF" SLITTER-SCORER
(6" diameter)

<u>QUANTITY</u>	<u>PART NUMBER and DESCRIPTION</u>
2	2-CX-653-J head, male creaser (profile)
2	2-CX-653-J head, female creaser (profile)
2	3-CX-670-J head V-type creaser
2	3-CR-1185-A head, flat anvil creaser
4	3-SL-1051-A head, slitter blade
12	2-944-79-O-G blade, slitter
72	7/16-14 x 1-1/2" long, socket head cap screws (for clamping heads)
72	5/16-18 x 3/4" long, hex head cap screws (for 2-944-79-O-G)

SPECIAL PARTS FOR SLIT-SCORING OPERATION

To be used with a Tie Brace CXF-10006

3-CR-1185-A head, flat anvil
3-SL-1051-A head, slit-score blade
2-994-1402-0-0 blade, slit-score
5/16-18 x 5/8" long hex head cap screws (for 2-944-1402-0-0)
7/16-14 x 1-1/2" long socket head cap screws (for clamping heads)

All the above parts are marked with an asterisk (*) on the following parts charts.

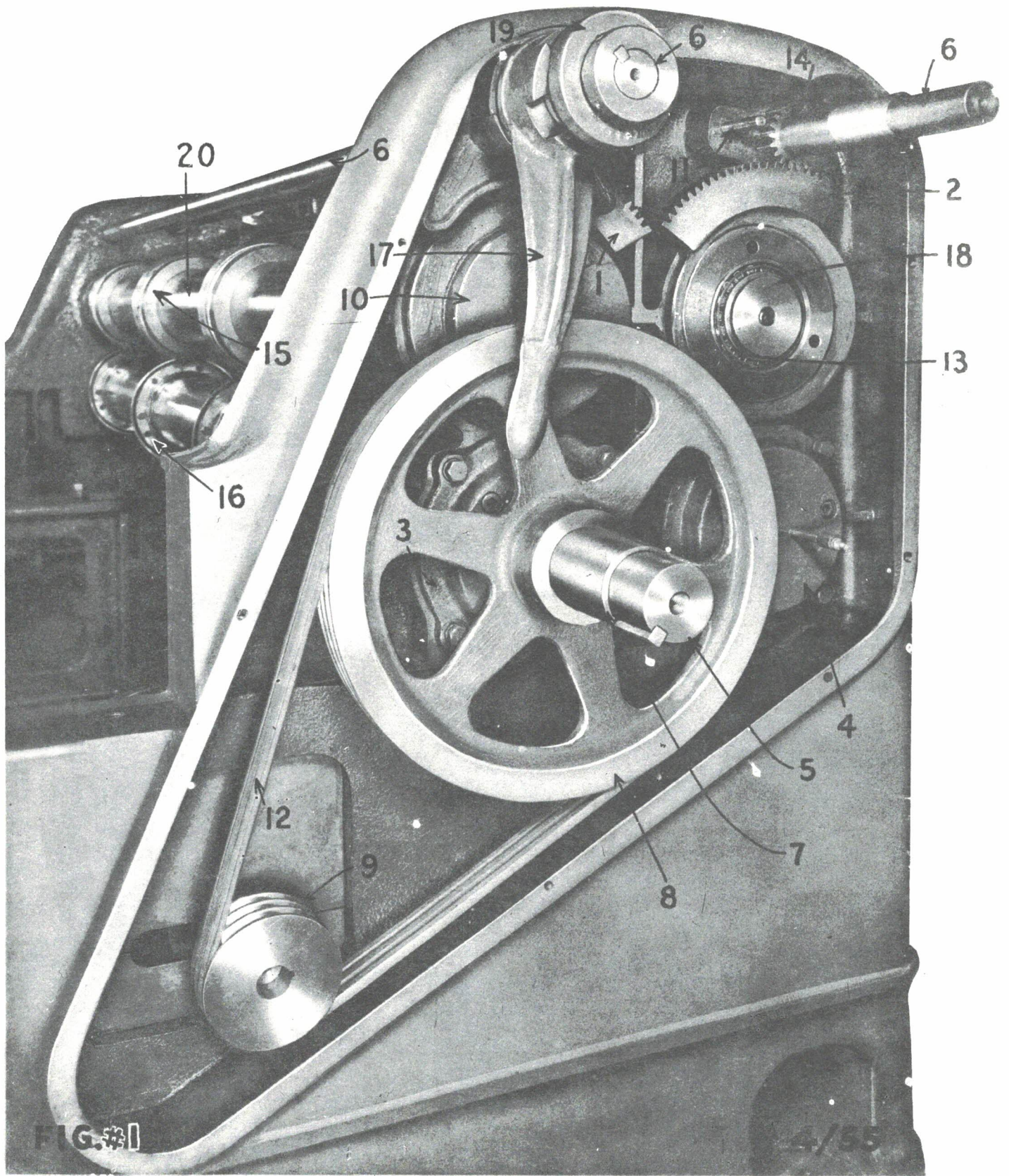


Fig #1 Drive Side (pulley side)

When ordering parts, give machine serial number, type of machine, part number and description.

- | | | |
|--------|---------------------------------|---|
| (1) | 4-CXF-108-D | Bearing box, upper slitter shaft |
| (2) | 4-CXF-109-D | Bearing box, upper creaser shaft |
| (3) | 3-CXF-110-A | Bearing box, lower slitter shaft |
| (4) | 3-CXF-111-A | Bearing box, lower creaser shaft |
| (5) | 3-CXF-121-C - 1 | Shaft, lower slitter and drive (82" machine) |
| | 3-CXF-121-C -2 | Shaft, lower slitter and drive (96" machine) |
| | 3-CXF-121-C -4 | Shaft, lower slitter and drive (120" machine) |
| (6) | 2-CXF-123-A-1 | Shaft, eccentric bushing adjusting (82" machine) |
| | 2-CXF-123-A -2 | Shaft, eccentric bushing adjusting (96" machine) |
| | 2-CXF-123-A-4 | Shaft, eccentric bushing adjusting (120" machine) |
| (7) | 1-CXF-126 | Spacer, handwheel and pulley |
| (8) | 3-CXF-127 | Pulley, main drive, 5 grooves |
| (9) | 2-CXF-2071-A | Sheave, motor, 5 grooves |
| (10) | 2-CXF-130-1 | Cover, upper creaser bearing box. |
| (11) | 1-CXF-131-A | Pin, upper bearing box clamp |
| (12) | #6A8- 68.9" pitch length V-belt | |
| (13) | NA-484-472D | Timken bearing (2 bearings on each shaft #(5) and (20) |
| (14) | 1-MCXD-20B | Pinion, bearing box adjusting (keyway put in at assembly) |
| * (15) | 3-SL-1051-A | Head, slitter blade and slit-score blade |
| * (16) | 2-KN-79-G | Blade, slitter |
| (17) | 2-CXD-17-C | Locknut, eccentric bearing |
| (18) | 1-CXD-32-E | Retainer, gear and bearing |
| (19) | 1-CXD-19-B | Clutch, eccentric bearing adjusting |
| (20) | 3-CXF-122-E-1 | Shaft, slitter and scorer (82" machine, 3 req.) |
| | 3-CXF-122-E-2 | Shaft, slitter and scorer (96" machine, 3 req.) |
| | 3-CXF-122-E-4 | Shaft, slitter and scorer (120" machine, 3 req.) |

Item #17 Points to Handle which is Part # CXD-00018
CXD-00017 is Locknut

When ordering parts, give machine serial number, type of machine, part number and description.

- (1) 4-CXF-108-D Bearing box, upper slitter shaft
- (2) 4-CXF-109-D Bearing box, upper creaser shaft
- (3) 3-CXF-110-A Bearing box, lower slitter shaft
- (4) 3-CXF-111-A Bearing box, lower creaser shaft
- (5) 3-CXF-121-C-1 Shaft, lower slitter and drive (82" machine)
- 3-CXF-121-C-2 Shaft, lower slitter and drive (96" machine)
- 3-CXF-121-C-4 Shaft, lower slitter and drive (120" machine)
- (6) 2-CXF-123-A-1 Shaft, eccentric bushing adjusting (82" machine)
- 2-CXF-123-A-2 Shaft, eccentric bushing adjusting (96" machine)
- 2-CXF-123-A-4 Shaft, eccentric bushing adjusting (120" machine)
- (7) 1-CXF-126 Spacer, handwheel and pulley
- (8) 3-CXF-127 Pulley, main drive, 5 grooves
- (9) 2-CXF-2071-A Sheave, motor, 5 grooves
- (10) 2-CXF-130-1 Cover, upper creaser bearing box
- (11) 1-CXF-131-A Pin, upper bearing box clamp
- (12) #6A8 68.9" pitch length V-belt
- (13) TD0-484-472D Timken bearing (2 bearings on each shaft(#5)&(20)
- (14) 1-MCXD-20B Pinion, bearing box adjusting (keyway put in at assembly)
- * (15) 3-SL-1051-A Head, slitter blade and slit-score blade
- * (16) 2-944-79-0-G Blade, slitter
- (17) 2-CXD-17-C Locknut, eccentric bearing
- (18) 1-CEB-78 Retainer, gear and bearing
- (19) 1-CXD-19-B Clutch, eccentric bearing adjusting
- (20) 3-CXF-122-E-1 Shaft, slitter and scorer (82" machine, 3 req.)
- 3-CXF-122-E-2 Shaft, slitter and scorer (96" machine, 3 req.)
- 3-CXF-122-E-4 Shaft, **slitter** and scorer (120" machine, 3 req.)

* Items marked by an asterisk (*) are listed on the "Suggested Parts List".

Fig. #2

Operating Side (Gear Side)

- (1) 4-CXF-105-D Bearing box, upper slitter shaft
- (2) 4-CXF-106-D Bearing box, upper creaser shaft
- (3) 1-CXF-113 Gear, slitter and scorer shafts (4 req)
- (4) 1-CXF-114 Gear, lower intermediate
- (5) 1-CXF-115 Gear, upper intermediate
- (6) 1-CXF-116 Stud, intermediate gear
- (7) 2-CXF-123-A-1 Shaft, eccentric bushing adj. (82" machine)
- 2-CXF-123-A-2 Shaft, eccentric bushing adj. (96" machine)
- 2-CXF-123-A-4 Shaft, eccentric bushing adj. (120" machine)
- (8) 1-CXF-131-A Pin, upper bearing box clamp
- (9) 1/2" pipe thread, standard street ell
- (10) 1-MCXD-20-B Pinion, bearing box adj. (keyway put in at assembly)
- (11) 1-CXD-34 Collar, eccentric adj. shaft clamp
- (12) 1-CXD-29-A Washer, intermediate gear and bearing
- (13) 1-STD-330 Washer, slitter and scorer shaft
- (14) Ford breather cap
- (15) 1/2-13 x 1 1/2" long hex head cap screw
- (16) 1/2" lockwasher

Hyatt Bearng U-1207-TM or A-1207-TS (used on #(6) CXF-116)

↓
1008-28072-0

Figure #3

*(1)	3-CX-670-J	Head V-type creaser
*(2)	3-CR-1185-A	Head, flat anvil creaser (for body scoring and slit-scoring)
*(3)	3-CX-653-J	Head, male creaser (profile)
*(4)	3-CX-653-J	Head, female creaser (profile)
*(5)	3-SL-1051-A	Head, knife (for regular slitter blade and slit-scoring blade)
*(6)	2-KN-79G	Blade, regular slitter
*(7)	2-KN-1402	Tapered blade, slit-scoring (special)
(8)	2-CXD-35-C	Holder, scale
(9)	1-CXD-37B	Collar, scale holder
(10)		3/8-16x3/4" long thumb screw
(11)	1-CX-626-C	Block, side gauge (short)
(12)	2-STD-553-3	Knob, side gauge adjusting
(13)	1-CX-69A	Stud, side gauge lock
(15)	2-CXF-2077	Block, side gauge (long)
(17)	1-CB-43-B	Handle, sheet pusher
(18)	2-CB-42-3B	Sheet pusher
(19)	1-CB-104	Plate, sheet pusher
*(20)		7/16-14x1 1/2" long socket head cap screw (for clamping heads)
*(21)		5/16-18x3/4" long hex head cap screws (for KN-79G)
*(22)		5/16-18x5/8" long hex head cap screws (for 2-KN-1402)

Items marked by an asterisk () are listed on the
"Suggested Parts List"

- (1) 4-CXF-105-D Bearing box, upper slitter shaft
- (2) 4-CXF-106-D Bearing box, upper creaser shaft
- (3) 1-CXF-113 Gear, slitter and scorer shafts (4 req.)
- (4) 1-CXF-114 Gear, lower intermediate
- (5) 1-CXF-115 Gear, upper intermediate
- (6) 1-CXF-116 Stud, intermediate gear
- (7) 2-CXF-123-A-1 Shaft, eccentric bushing adj. (82" machine)
- 2-CXF-123-A-2 Shaft, eccentric bushing adj. (96" machine)
- 2-CXF-123-A-4 Shaft, eccentric bushing adj. (120" machine)
- (8) 1-CXF-131-A Pin, upper bearing box clamp
- (9) 1/2" pipe thread, standard street ell
- (10) 1-MCXD-20-B Pinion, bearing box adj. (keyway put in at assembly)
- (11) 1-CXD-34 Collar, eccentric adj. shaft clamp
- (12) 1-CXD-29-A Washer, intermediate gear and bearing
- (13) 1-STD-330 Washer, slitter and scorer shaft
- (14) # 802 Breather cap
- (15) 1/2-13 x 1-1/2" long hex head cap screw
- (16) 1/2" lockwasher

Hyatt Bearing U-1207-TM (used on #(6) CXF-116)

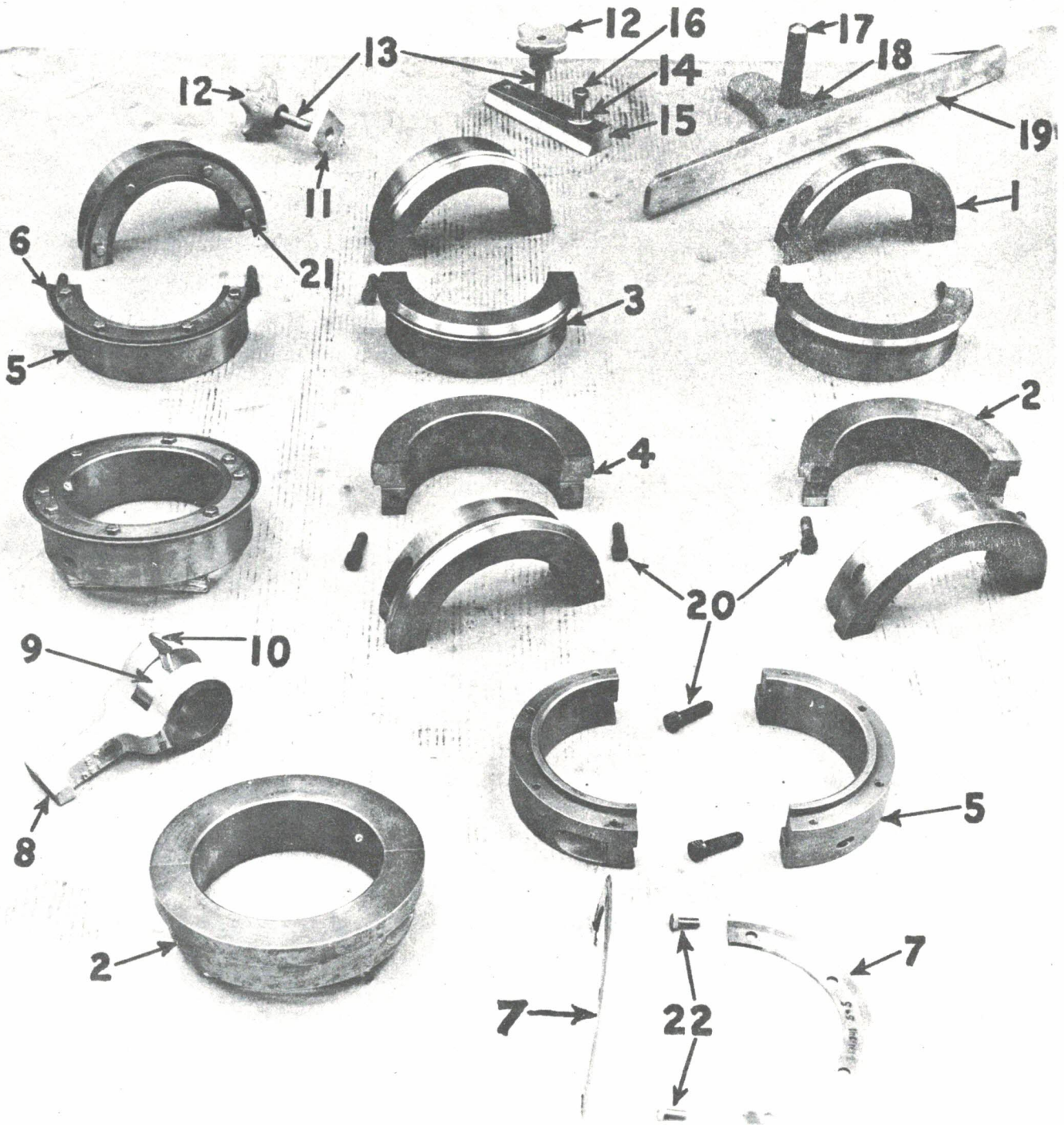


FIG. #3

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Bearing Box	Bearing	Seal
CXF-105	NA 484-472 D	CR-37433
CXF-106	NA 484-472 D	CR-37433
CXF-107	NA 484-472 D	CR-37433
CXF-108	NA 484-472 D	
CXF-110	NA 484-472 D	
CXF-111	NA 484-472 D	

CR OAK Seal #487324 M 1 cross over
number CR-37433
1042-37500-0