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ULTIMATE TUBING NOTCHER Adjustment Instructions

Upper & Lower Acme Screw and Bronze Nut Replacement:

1. Remove bolts holding vise base to compound feed table – remove vise.

Upper Adjustment Screw Replacement – Left-to-Right Movement:

2. Remove upper slider block adjustment screws using 3/16” Allen wrench – located on backside of upper slide gib assembly.
3. Loosen (Do Not Remove) 5 gib mounting 5/16” socket head cap screws on vise mounting plate to allow front gib clearance.
4. Turn upper hand wheel clockwise (left-to-right movement) to remove vise mounting plate and upper gibs from bronze gibs to expose bronze adjusting nut. Place vise mounting plate on bench. **CAUTION: Proceed with care – Do Not Drop**
5. Remove setscrew in upper bronze nut mounting block – use 1/8” Allen wrench.
6. Remove snap ring on each side of bronze nut.
7. Remove bronze nut from housing and discard.
8. Install new bronze nut (right hand thread) in upper mounting block.
9. Install new snap ring on each side of bronze nut.
10. Use 1/8” drill bit and drill point the bronze nut through the set screw hole in mounting block – Do Not drill through bronze bushing.
11. Install/Tighten set screw – use 1/8” Allen wrench.
12. Remove Nylok nut from hand wheel – use 3/4” socket.
13. Remove hand wheel from shaft.
14. Remove acme screw from bronze bushing and mounting block.
15. Replace bronze bushing in mounting block – shoulder to the inside of mounting block.
16. Install new acme screw in bronze bushing (right hand thread).
17. Install new bronze washer over shaft on outside of mounting block.
18. Install hand wheel and Nylok nut – Tighten until clearance between hand wheel and block is removed – DO Not over tighten

Lower Adjustment Screw Replacement – In-to-Out Movement:

19. Remove lower slider block adjustment screws using 3/16” Allen wrench – located on right side of lower slide gib assembly.
20. Loosen (Do Not Remove) 5 gib mounting 5/16” socket head cap screws on underside of base plate to allow left gib clearance.
21. Turn lower hand wheel clockwise (in-to-out movement) to remove bronze gib block from lower slide gibs to expose bronze adjusting nut. Place bronze gib block on bench. **CAUTION: Proceed with care – Do Not Drop**
22. Remove setscrew in lower bronze nut mounting block – use 1/8” Allen wrench.
23. Remove snap ring on each side of lower bronze nut.
24. Remove bronze nut from housing and discard.
25. Install new bronze nut (left hand thread) in lower mounting block.
26. Install new snap ring on each side of bronze nut.

27. Use 1/8" drill bit and drill point the bronze nut through the set screw hole in mounting block – Do Not drill through bronze bushing.
28. Install/Tighten set screw – use 1/8" Allen wrench.
29. Remove Nylok nut from lower hand wheel – use 3/4" socket.
30. Remove hand wheel from shaft.
31. Remove acme screw from bronze bushing and mounting block.
32. Replace bronze bushing in lower mounting block – shoulder to the inside of mounting block.
33. Install new acme screw in bronze bushing (left hand thread).
34. Install new bronze washer over shaft on outside of mounting block.
35. Install hand wheel and Nylok nut – Tighten until clearance between hand wheel and block is removed – DO NOT over tighten
36. Install slide gib block onto lower gibs on base plate – NOTE: Left hand thread bronze nut to be on bottom for in-to-out movement.
37. Thread lower acme screw into bronze nut – turn counterclockwise until seated against front bushing block
38. Install and adjust lower slide block screws (2) on right hand side until smooth in-to-out movement of table is achieved – CAUTION DO NOT over tighten - Adjust so have slight drag on slide blocks
39. Tighten 5 left gib 5/16" socket head cap screws on underside of base plate.
40. Install vise-mounting plate onto bronze gib block.
41. Thread upper acme screw into bronze nut – turn counterclockwise until seated against bushing block on right side.
42. Install and adjust upper slide block screws (2) on back side until smooth movement of table is achieved – CAUTION DO NOT over tighten - Adjust so have slight drag on slide blocks
43. Tighten 5 gib mounting 5/16" socket head cap screws on front of vise mounting plate.
44. Install 6" x 6" bronze gib block guard on backside.
45. Install vise and tighten bolts.