

HAMILTON SHIP CHRONOMETER

4. Insert locking jewel, with the large flat facing the locating bar of the fixture.
5. Swing the locating arm of the fixture to line up the jewel at the correct angle.
6. Insert locking jewel wedge pin lightly. With tweezers, mark pin just above the detent arm. See Fig. 58. Place pin in pin vice. With end-cutting pliers (Tool No. 77), cut off pin about 0.020 in. above the mark. Plane cut end smooth. Remove pin.
7. Line up locking jewel as in Operation 5.
8. Replace wedge pin and push it with tweezers so pin is flush with top of detent arm. Check the alignment of the large flat. Adjust, if necessary.
9. Remove detent from locating fixture. Turn over. With end-cutting pliers (Tool No.



Figure 58

77), cut off excess of wedge pin. See Fig. 59. Stone smooth.

CUTION

No stone here should be used in Operations 11 thru 12 until it has been used to stone the detent.

10. First stone for holding in place (Tool No. 81, see Fig. 8). Then stone of jewel-setting fixture of the fixture on top of the detent so it does not touch locking jewel.



Figure 60

11. Remove excess stoning by using an oil bath and pushing with end-cutting pliers (Tool No. 81) at the top.

CUTION

All exposed portions of the roller jewel must be free from stoning in all directions and be rounded.

NO-DEVELOPING IMPULSE ROLLER

To protect the roller and jewel during preceding operations, remove roller from the fixture.

1. Clean impulse roller with kerosene and dry it with air.
2. After drying thoroughly, place roller on roller setting bar (Tool No. 82) with the numbered side down, as in the right.
3. Insert a jewel in the slot, turned side of the jewel toward the operator and flush to the bottom. See Fig. 61. Select the jewel size jewel for light push fit with the roller. In trying several jewels, go to the roller. Leave the selected jewel in the slot of the roller.



Figure 61

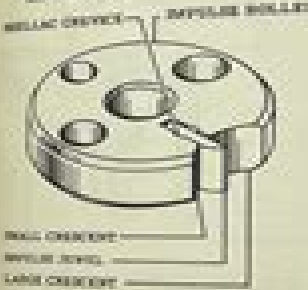


Figure 62

4. Put the jewel a little to the right to permit stoning to enter behind the jewel. Push to the roller, with jewel in place, so jewel goes in to the roller setting bar. See Fig. 62. 111. Place the roller holding tool across the impulse roller and lower it so that the roller is firmly resting the heater. The heater is Tool No. 8.
5. Apply a stoning stone to the warmed jewel, back and forth across the upper surface.
6. Flip the roller holding tool from the heater to the roller and up the roller end of the jewel to permit stoning to flow down the sides of the jewel.
7. Again, move the tool across the heater (see Fig. 62) so that the roller finally reaches the heater, with the jewel up and away from the heater.

IMPULSES

INSPECTION AND REPAIR

8. Apply stoning to the stoning surface on each side of the jewel (see Fig. 61) which shows these surfaces before the jewel was tipped up, when the stoning position, and remove the roller from the heater and remove the jewel. Be sure there is sufficient stoning on the top and back.
9. Cool in air and remove the roller from the roller holding tool.
10. Set the roller in the impulse roller jewel setting tool (Tool No. 100), keeping the numbered side down. This tool is shown in Fig. 63. Hold the tool with the left hand and tighten the clamping screw so that the roller jewel is toward the operator.
11. Place the setting tool on the heater and until the stoning surface. Remove from heater and push slipped-up jewel back into normal position. Pull the jewel out slightly. Push downward lightly on each end of the jewel to insure that the bottom of the jewel is flush with the numbered side of the roller.
12. Push the jewel locating slide of the setting tool forward gently as far as it will go to



Figure 63

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RM Cervero



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you call to worship please join with me in prayer heavenly father be with us today in this affirmation of your eternal power and grace

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web oct 11 2006 summary a funeral sermon for a middle aged man but could be adapted for any age on behalf of the family i would like to thank you for the kindness that you have shown during this very difficult time thank you for the flowers and food for the cards and calls and especially for your presence and prayers

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web this is a funeral outline that was created for the funeral of a middle aged christian man the first part is personal stories about his life funeral thank you on behalf of the family for being here today i know that this is a difficult day for you as the family

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web jan 5 2014 below is the homily that i preached at his funeral yesterday out here in the valley we ll miss him in so many ways and coracle celebrates bill and honors him a good man a good life a good death a homily for bill scherer we re all here today because of our lives have been touched by bill scherer

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web the gospel announces a father who s no stand off somewhere spectator to death someone aloof and unconcerned when it comes to the death of another thirty something man a man named jesus god the father sits in the front row of mourners the gospel announces a savior who makes new life available free to us because it comes at such a

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