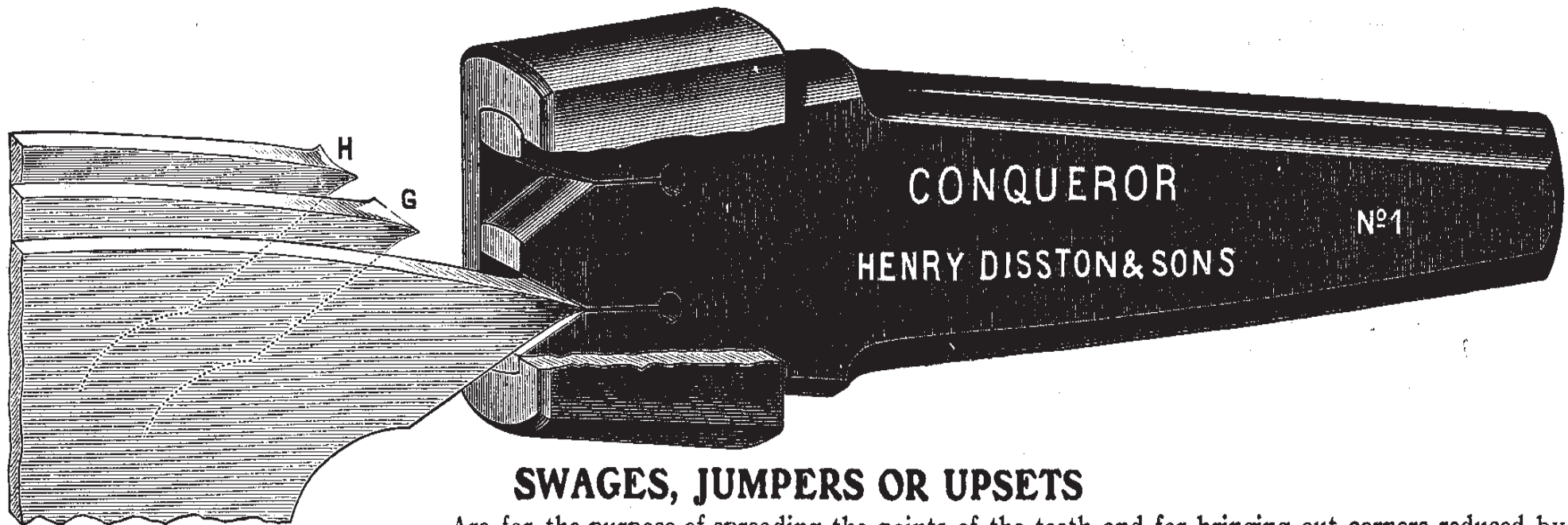


# THE CONQUEROR SWAGE, JUMPER OR UPSET.

No. 1. For large Circular Saws.



## SWAGES, JUMPERS OR UPSETS

Are for the purpose of spreading the points of the teeth and for bringing out corners reduced by wear, thus saving time, saw, and files, if properly used.

The teeth of a saw require to be swaged to a sharp, keen edge. The bottom of the openings in the Conqueror are slotted, and it is impossible to blunt or injure the fine cutting edge of the tooth, which is a frequent result with solid swages. One of the principal drawbacks in the manufacture of solid swages is the difficulty experienced in properly hardening them at the bottom of the openings, which portion of the swage does all the work, and requires to be hardened in the most perfect manner. The Conqueror is hardened before the sleeve is driven on, and the hardening composition passes freely through the slots at the bottom of the openings, thus insuring an even and correct hardening in that portion of the Swage where it is most required.

## DIRECTIONS FOR USING THE CONQUEROR SWAGE.

File the tooth sharp to the shape of the gauge packed in each box, in order that the Swage may operate on the point. Oil the point of the tooth, then apply the rounded or convex jaws of the Swage—these take their bearings on the centre of the tooth, spreading and shaping it as shown in section "H" of the above sketch.

Now apply the square or flat opening—this will square up the point of the tooth, as shown in section "G" of sketch.

If the first operation with both dies does not give sufficient spread, file the tooth again to fit the gauge and proceed as before.

In swaging use a light hammer, and do not strike too heavy a blow. Oil the tooth frequently.

Hold the Swage in proper line (see position of Swage in relation to tooth in cut) so as not to drive the point of the tooth below the cutting line.

**MADE IN SIX DIFFERENT SIZES TO SUIT ALL THICKNESSES OF SAWS.**