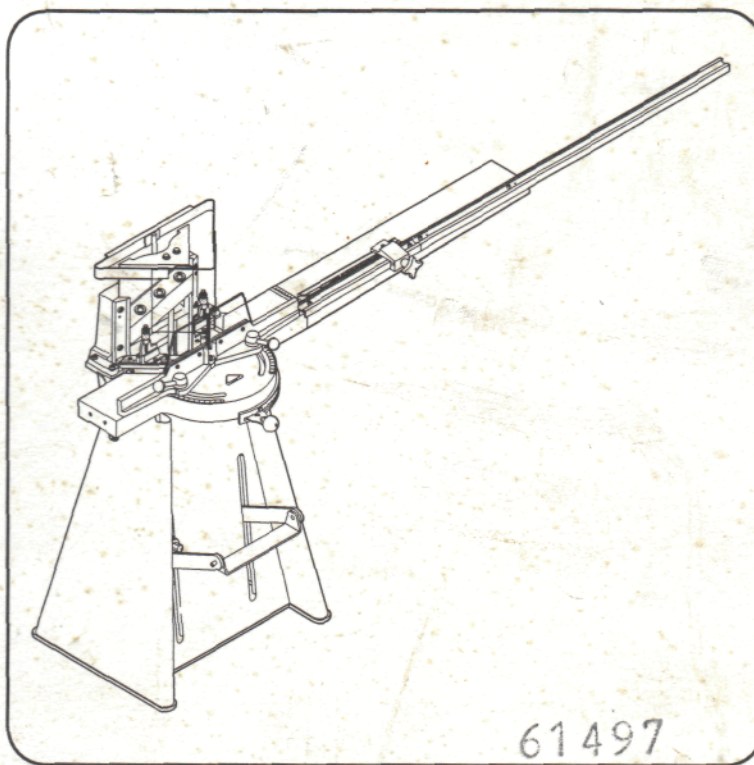


Instructions Manual

MORSØ Mitring machine Model F



61497

 **dan-list^{a/s} MASKINFABRIK**
HARALDSVEJ 21 - DK-8900 RANDERS - DANMARK

Instructions manual MORSØ Mitring machine Model F

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Beware of the extreme sharp knives

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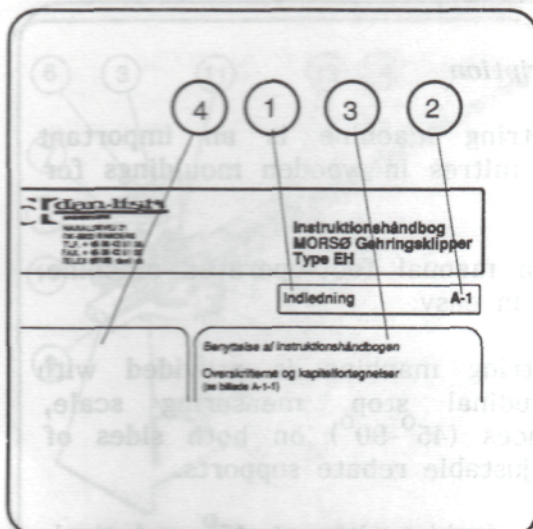


Instructions manual MORSØ Mitring machine Model F

FUNCTIONAL DESCRIPTION B-1

INTRODUCTION

A-1



picture A-1-1

We recommend to read this instruction manual carefully before the first starting of the machine.

Defects of the machine provably arisen due to mistakes in operation will not be covered by the warranty.

Use of the Instruction Manual:

In this instruction manual all information needed for using all possibilities of the MORSØ-mitring machine is found.

(see picture A-1-1)

(1) Head Lines

Refers to the head line of the chapter.

(2) Index of pages

The letter is the description of the chapter. The figure is the consecutive page number in the chapter.

(3) Text

The texts belonging to the chapter in which you will find all information and explanations necessary.

(4) Illustration

Drawing to the text in (3).



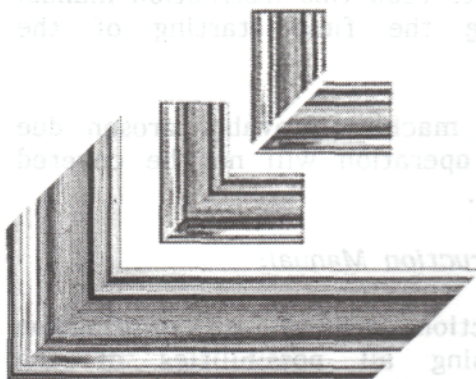
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**Beware of the extreme
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Instructions manual MORSØ Mitring machine Model F

FUNCTIONAL DESCRIPTION B-1



picture B-1-1

General Description

MORSØ-F mitring machine is an important help to make mitres in wooden mouldings for all purposes.

MORSØ-F is a manual foot-operated machine. The operation is easy.

MORSØ-F mitring machine is provided with sliding longitudinal stop, measuring scale, adjustable fences (45° - 90°) on both sides of the knives, adjustable rebate supports.

MORSØ-F cuts double mitre at 45° and single mitre up to 90° .

With the **MORSØ-F** you achieve a quite smooth, clean, and exact cut when you cut the work piece in two cuts.

This is done manually on the **MORSØ-F**.

The conveying (forward movement) of the knife block is made so that the last cut is a so-called trim-cut.

A special lever system makes the operation of the machine very easy. Twin return springs bring the knife block back to starting position.

The height movement of the knife block (length of stroke) is continuously adjustable.

The pieces of moulding can be joined without any finishing.

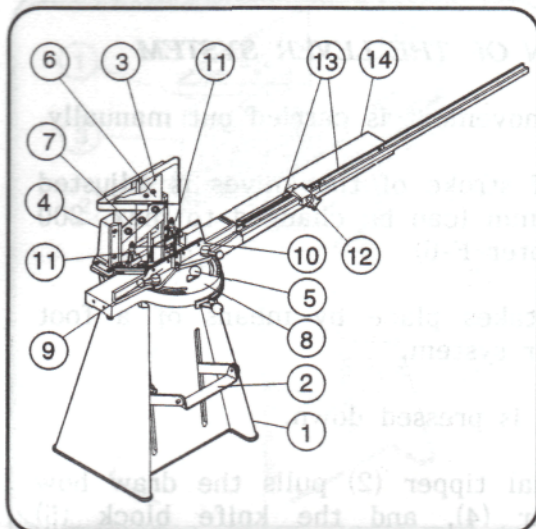
(Picture B-1-1).



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Instructions manual MORSØ Mitring machine Model F

FUNCTIONAL DESCRIPTION B-2



picture B-2-1

Machine Description

The **MORSØ-F** is constructed as a compact machine with a solid dimensioned frame (1), with built in lever system (2). The cutting function (3) is placed on top of the machine.

In the slide frame (4) fitted at the cross (5) the knife block (6) is moved up and down. The cross (5) runs in the guidings of the table.

The knives (7) fitted on the knife block cut the moulding.

The conveying (forward movement) of the knife block takes place manually.

The moulding is placed on the table (8) against the fences (9) + (10) adjusted in the angle required.

The rebate supports (11) are adjusted to the height of the rebate.

The length of the finished moulding is adjusted by means of the stop block (12). The measurements are read from the scales (13) on the table extension (14).

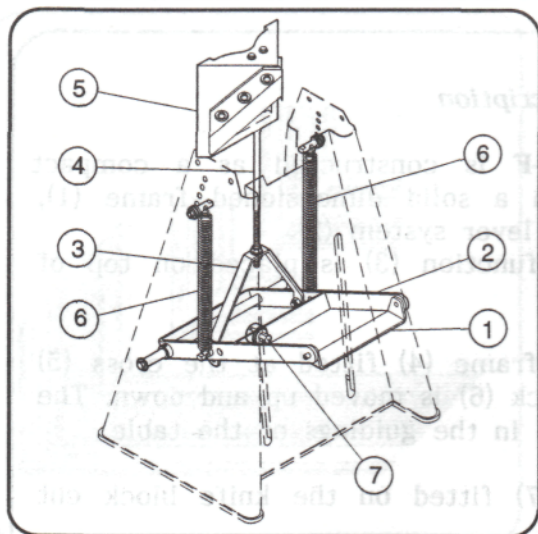


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FUNCTIONAL DESCRIPTION B-3



picture B-3-1

DESCRIPTION OF THE LEVER SYSTEM

The cutting movement is carried out manually.

The length of stroke of the knives is adjusted to max. 165 mm (can be changed to max. 200 mm, see chapter F-6).

The cutting takes place by means of a foot operated lever system.

The pedal (1) is pressed down.

The foot pedal tipper (2) pulls the draw bow (3), draw bar (4), and the knife block (5) down.

By relieving the foot pressure from the foot pedal the knife block returns to top position by means of the two springs (6).

The height stop (7) is slidable.

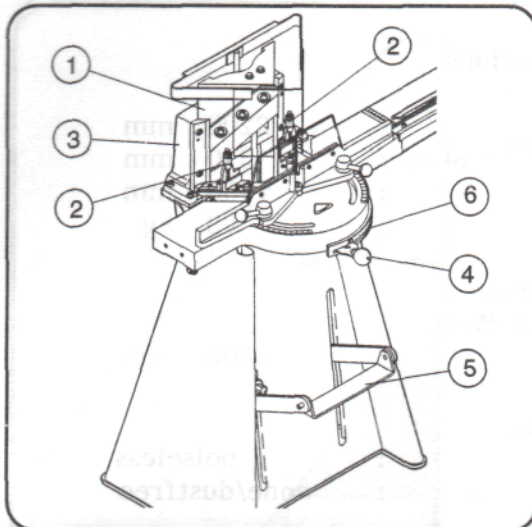


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FUNCTIONAL DESCRIPTION B-4



picture B-4-1

DESCRIPTION OF CUTTING

The knife block (1) is in top position and the slide frame (3) in the rear position.

Working with a moulding with rebate the rebate supports (2) are adjusted to the height of the rebate.

The forward movement is adjusted manually with handle (4) to a suitable starting position on the moulding.

The pedal (5) is pressed home, then relieve the foot pressure so that the springs take the knife block (1) back to top position.

The handle (4) is now moved a suitable distance forward (depending on the hardness of the wood) in the tooth arc (6), and you make the next cut.

Proceed in this way until the moulding is cut through.

The last cut must always be a small cut. The tooth arc is constructed so that the last tooth only has half travel compared to the other teeth.

Even with small mouldings you must make the last small cut in order to achieve a good result.

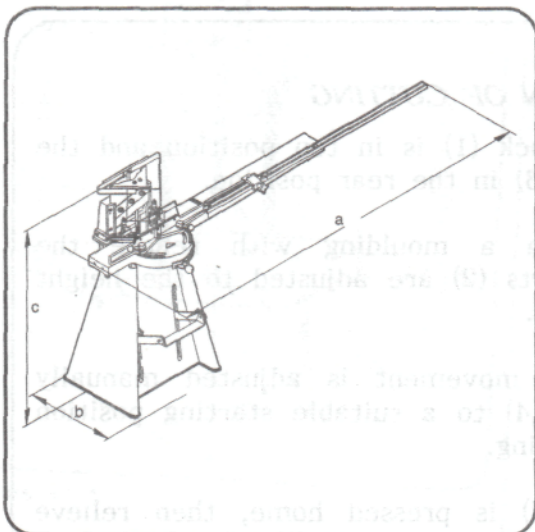


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Instructions manual MORSØ Mitring machine Model F

TECHNICAL DATA

C-1



picture C-1-1

Machine Dimensions

(max.):		
Length (a)	:	2200 mm
Width (b)	:	510 mm
Height (c)	:	1150 mm
Weight	:	98 kg

Placing Measures:

Spaciousness to Wall		
min.	:	1000 mm

Noise/Pollution:

Noise Level	:	noiseless
Pollution	:	none/dustfree

Working Capacity:

Mitres	:	
Double	:	45°
Single (left-right)	:	
up to	:	90°
Length of Moulding		
from 100 mm to max.	:	1500 mm
Working Width (max.) *	:	100 mm
Working Height (max.)*	:	160 mm
Square Cutting (max)	:	65/65 mm
Measuring Scale (up to):	:	1500 mm

*see diagram, page C-2 and service F-6

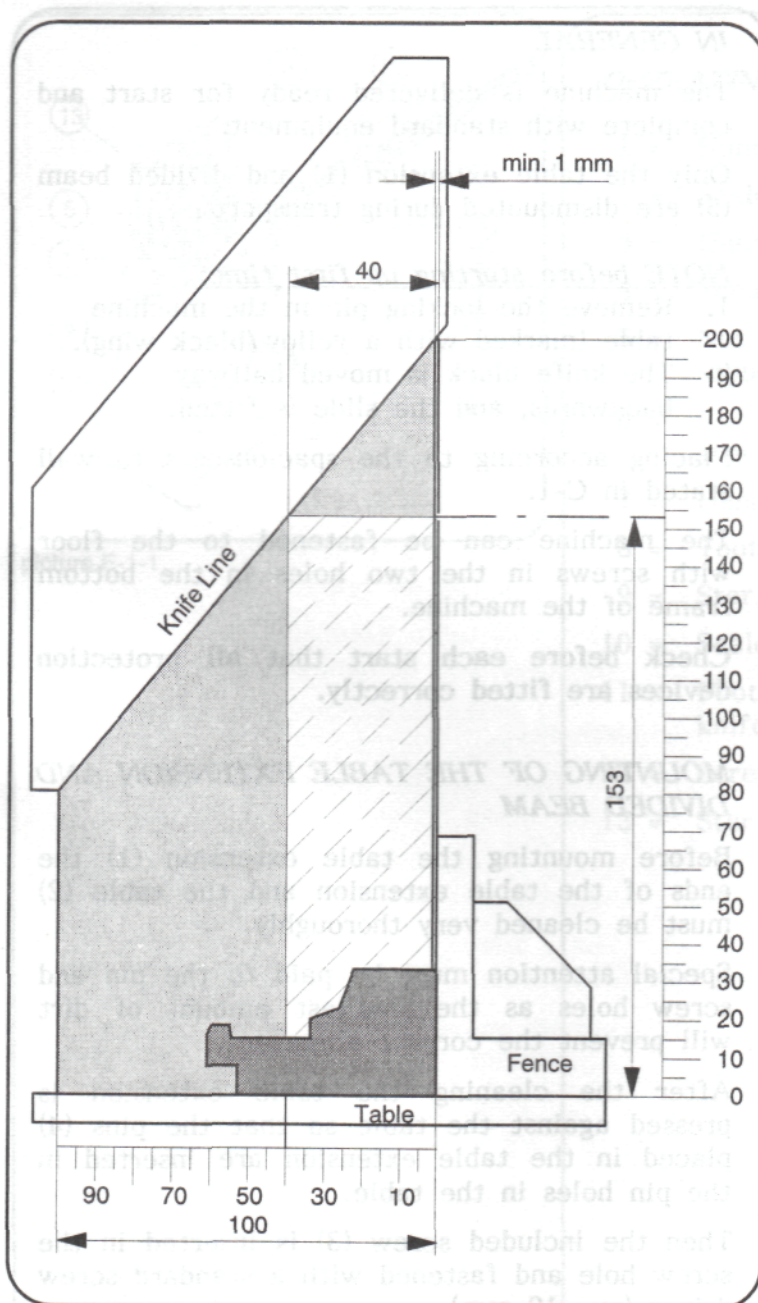


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Instructions manual MORSØ Mitring machine Model F

TECHNICAL DATES

C-2



picture C-2-1



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MORSØ F-9503 C-2/gb1

DIMENSIONS OF WORK PIECE

By means of the diagram, figure C-2-1, the cross section of the work piece can be determined.

The knife line determines the max. height.

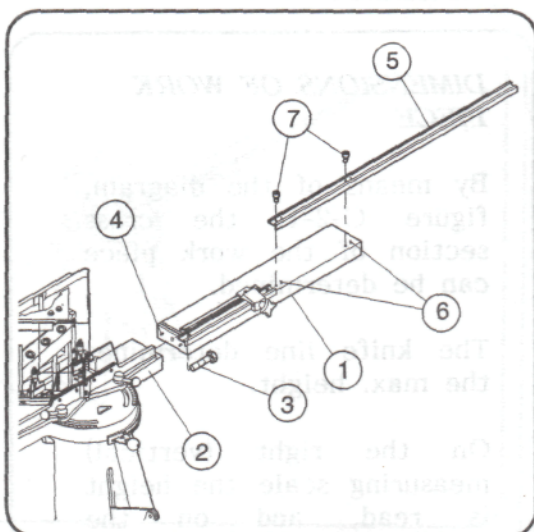
On the right (vertical) measuring scale the height is read, and on the horizontal measuring scale the width is read.



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Instructions manual MORSØ Mitring machine Model F

MOUNTING INSTRUCTIONS D-1



picture D-1-1

IN GENERAL

The machine is delivered ready for start and complete with standard equipment.

Only the table extension (1) and divided beam (5) are dismantled during transport.

NOTE before starting up first time:

1. Remove the locking pin in the machine table (marked with a yellow/black wing).
2. The knife block is moved halfway backwards, and the slide is fitted.

Placing according to the spaciousness to wall stated in C-1.

The machine can be fastened to the floor with screws in the two holes in the bottom frame of the machine.

Check before each start that all protection devices are fitted correctly.

MOUNTING OF THE TABLE EXTENSION AND DIVIDED BEAM

Before mounting the table extension (1) the ends of the table extension and the table (2) must be cleaned very thoroughly.

Special attention must be paid to the pin and screw holes as the smallest amount of dirt will prevent the correct alignment.

After the cleaning the table extension is pressed against the table so that the pins (4) placed in the table extension are inserted in the pin holes in the table.

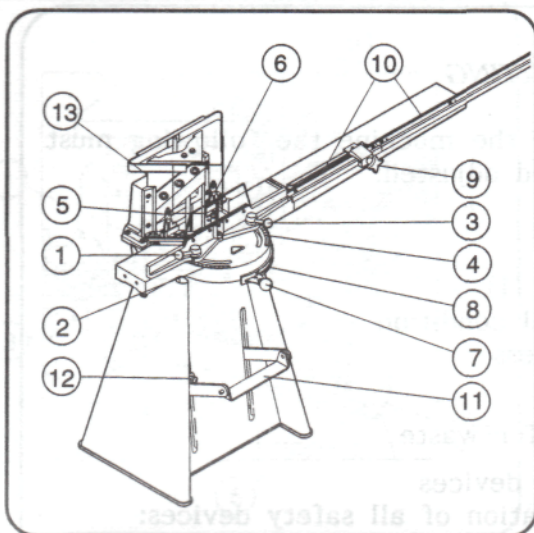
Then the included screw (3) is inserted in the screw hole and fastened with a standard screw driver (nv= 19 mm).

The divided beam (5) is fitted on the table extension (pins (6) are fitted in the table extension). It is fastened with cylinder screw (7).

(Extra extension table and supporting leg can be delivered as accessories).



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picture E-1-1

OPERATING DEVICES

- 1 = Handle - fastens the left fence
- 2 = Scale - degree adjustment of left fence
- 3 = Handle - fastens the right fence
- 4 = Scale - degree adjustment of right fence
- 5 = Nut - height adjustment of left rebate support
- 6 = Nut - height adjustment of right rebate support
- 7 = Hand Lever - forward movement
- 8 = Tooth Arc - forward movement
- 9 = Star Wheel - adjustment of stop beam
- 10 = Scale - length adjustment
- 11 = Foot pedal - cutting movement of the knife block
- 12 = Screw - height stop for knife block
- 13 = Star Wheel - fastens safety guard

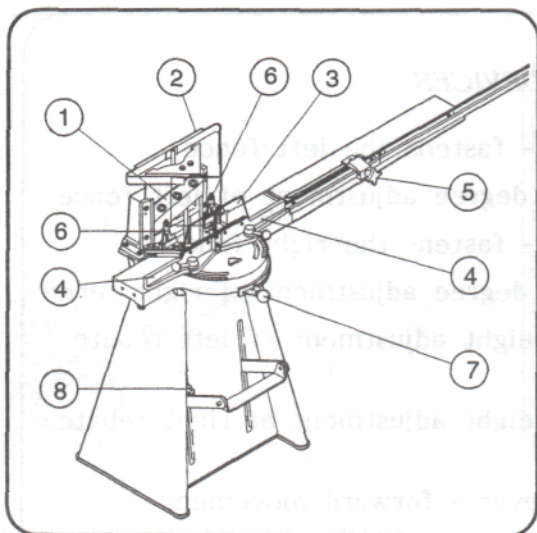


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OPERATING INSTRUCTIONS E-2



picture E-2-1

BEFORE STARTING

Before starting the machine the following must be checked and adjusted:

1. Check

- a) knives (1)
general condition
sharpness
- b) waste
room for waste
- c) safety devices
installation of all safety devices:
safety guard for knives (2)
safety guards on fences (3)
- f) table and table extension
cleanness and undamaged surface

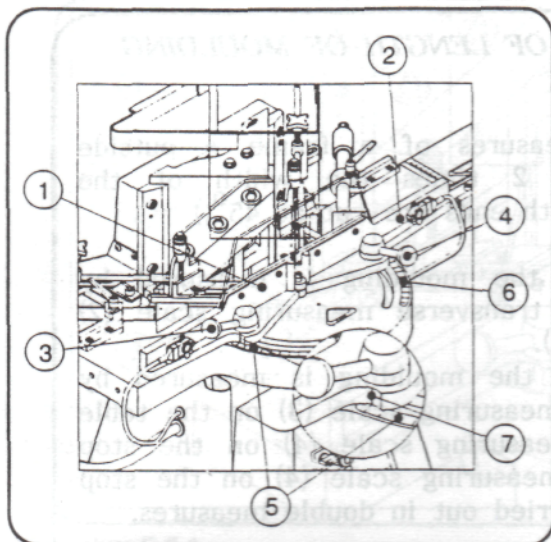
2. Adjustments

- a) the angle of the fences (4)
(adjustment instructions page E-3)
- b) length of moulding (5)
(adjustment instructions page E-4)
- c) rebate supports (6)
(adjustment instructions page E-5)
- d) forward movement (7)
(adjustment instructions page E-5)
- e) height stop (8)
(adjustment instructions page E-6)

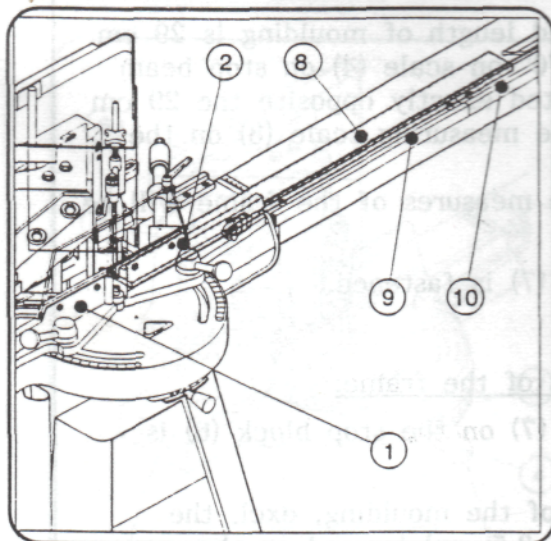


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OPERATING INSTRUCTIONS E-3



picture E-3-1



picture E-3-2



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DEGREE ADJUSTMENT OF FENCES

The fences (1) + (2) are adjusted as required (from the factory they are adjusted to 45° for double mitre).

If, for instance, you want to make a 6-sided (hexagonal) frame the following procedure is used:

6 pieces of moulding are cut in the normal way at 45° so that the inside measure of each piece of moulding is equal to the finished inside measure of the frame plus approx. the width of the rebate.

Hand levers (3) and (4) are loosened and the fences are turned according to the scales (5) and (6) to 60° .

The degree adjustment is read by means of the mark (7).

After the adjustment the hand levers (3) and (4) are fastened again, and all moulding ends a cut separately at 60° - single mitre.

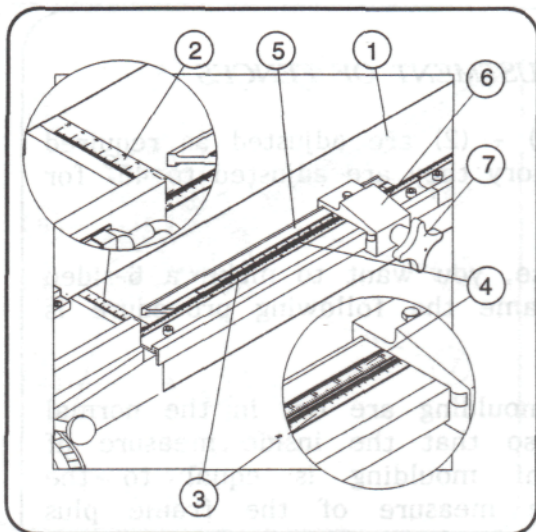
EXACT ADJUSTMENT OF THE FENCES:

When the fences have been adjusted to other degrees than 45° the correct re-adjustment to 45° is made as follows:

Put a straight steel ruler (8) against the measuring scale (9) so that it also reaches along the right fence (2). Now you adjust the right fence (2) according to the steel ruler, and the right fence (2) will be exactly adjusted at 45° .

Put the steel ruler (8) against the right fence (2) (that is now exactly adjusted at 45°), and proceed as mentioned above with the adjustment of the left fence (1).

OPERATING INSTRUCTIONS E-4



picture E-4-1

ADJUSTMENT OF LENGTH OF MOULDING

Principle:

The inside measures of a frame = outside measures less 2 times the width of the moulding (if both ends are cut at 45°.)

The width of the moulding is measured by means of the transverse measuring scale (2) on the table (1).

The length of the moulding is measured by means of the measuring scale (3) on the table (1) and the measuring scale (4) on the stop beam (5). The measuring scale (4) on the stop beam (5) is carried out in double measures.

Example 1:

Outside measures of the frame:

1. Star wheel (7) on stop block (6) is loosened.
2. The required length of moulding is 29 cm. The mark "0" on scale (4) on stop beam (5) is adjusted exactly opposite the 29 cm mark on the measuring scale (3) on the table.
The outside measures of the frame will be 29 cm.
3. Star wheel (7) is fastened.

Example 2:

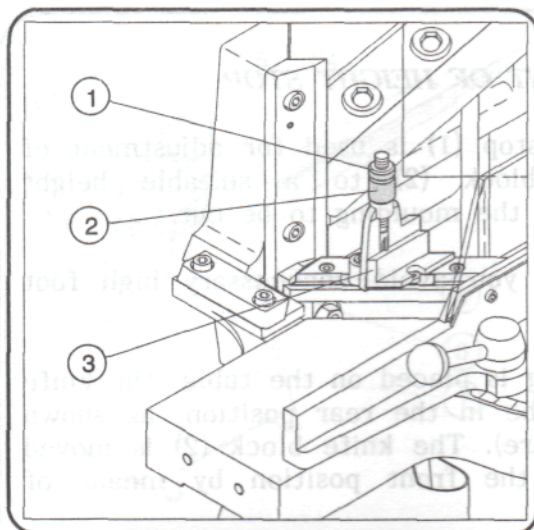
Inside measures of the frame:

1. Star wheel (7) on the stop block (6) is loosened.
2. The width of the moulding, excl. the rebate (e.g. 3.5 cm) is read on the transverse scale (2) on the table.
3. The required length of moulding is 27 cm. The 3.5 cm mark on scale (4) on the stop beam (5) is adjusted exactly opposite the 27 cm mark on the measuring scale (3) on the table.
The inside measures of the frame will be 27 cm.
4. Star wheel (7) is fastened.



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OPERATION INSTRUCTIONS E-5



picture E-5-1

ADJUSTMENT OF REBATE SUPPORTS
(picture E-5-1)

The knife block must be in top position during the adjustment.

The rebate supports are only used when cutting mouldings with rebates.

To adjust the rebate supports knurled nut (1) is loosened.

Place the moulding to be cut in the machine. Push the rebate supports (3) into the rebate of the moulding.

Press the moulding down on the machine table.

The height of the rebate supports is adjusted by means of the knurled nut (2). The rebate supports must be adjusted so that they are approx. 1/2 mm under the rebate of the moulding.

After the adjustment the knurled nut (1) is fastened.

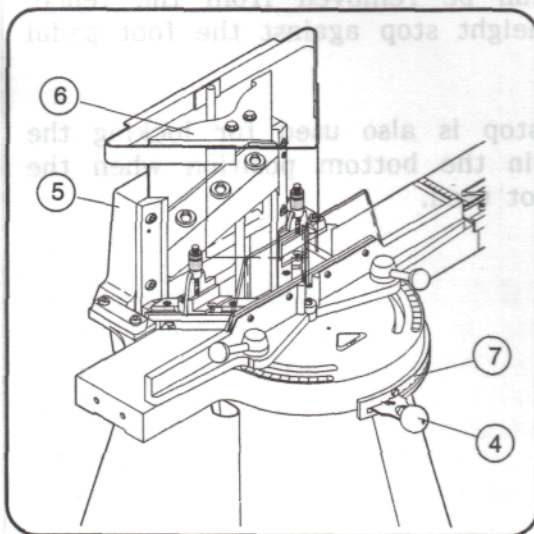
The rebate supports can be removed from the machines when the knife block is in the rear position.

ADJUSTMENT OF THE FORWARD MOVEMENT
(Picture E-5-2)

The slide frame (5) and the knife block (6) are moved forward to a suitable starting position on the moulding to be cut (depending on the hardness of the wood) in the following way:

The handle (4) is pressed down so that it does not touch the teeth of the tooth arc (7) (to avoid wear of the teeth) and moved forward to the position required, yet no further than to the second last tooth. The last tooth is for the trim-cut.

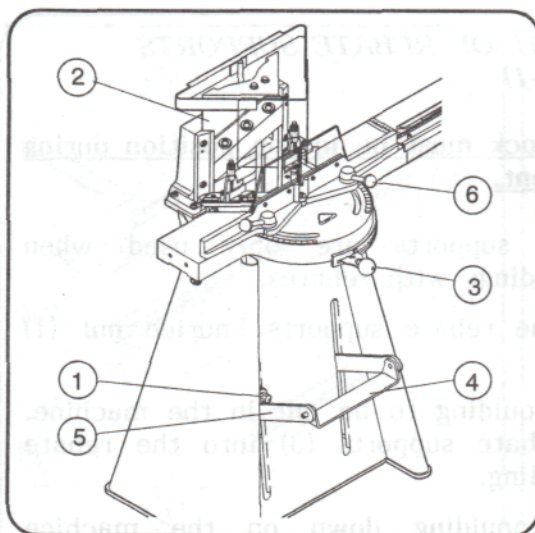
The teeth of the tooth arc have same travel, apart from the last tooth that has half travel for the trim cut which must always be used.



picture E-5-2



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picture E-6-1

ADJUSTMENT OF HEIGHT STOP

The height stop (1) is used for adjustment of the knife block (2) to a suitable height compared to the moulding to be cut.

In this way you avoid unnecessary high foot movements.

The moulding is placed on the table (the knife block must be in the rear position, as shown on the picture). The knife block (2) is moved forward to the front position by means of handle (3).

With the foot pedal (4) the knife block (2) is moved down to the height required, yet min. 20 mm above the moulding.

The height stop (1) is loosened with handle (6), which can be removed from the fence. Fasten the height stop against the foot pedal tipper (5).

The height stop is also used for locking the knife block in the bottom position when the machine is not used.

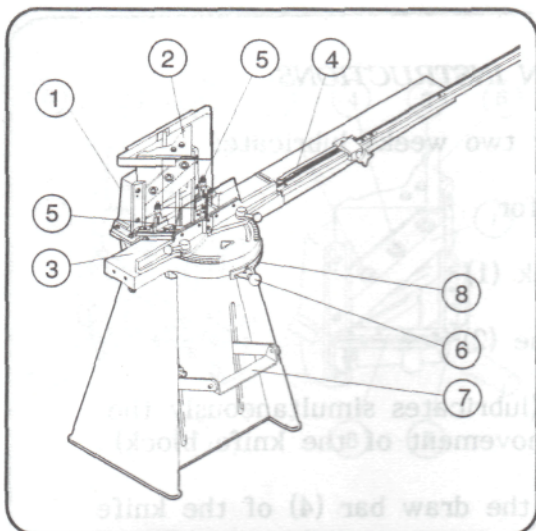


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OPERATING INSTRUCTIONS E-7



picture E-7-1

WORKING PROCEDURE

The knife unit (1) must be in rear position and the knife block (2) in top position.

Place the moulding on the machine table (3) and push it up to the adjusted stop beam (4) (see E-4).

With mouldings with rebate the rebate supports (5) are adjusted as described under E-5.

With the handle (6) the knife unit (1) is moved to a suitable starting position on the moulding. E.g. Working with a 60 mm wide moulding the knife unit (1) is moved about 40 mm forward.

The foot pedal (7) is pressed home, then the foot pressure is relieved so that the springs can take the knife block back to top position.

The handle (6) is moved a suitable distance forward in the tooth arc (8) and you make the next cut.

Proceed in this way until the moulding is cut through.

The last cut must always be a small cut (trim-cut). Even with small mouldings that could easily be cut in one cut you must make the last small cut in order to achieve a good result.

The tooth arc is constructed so that the last tooth only has half the travel compared to the other teeth.

AFTER WORKING PROCEDURE

Clean the machine.

Remove the waste.

Check the whole machine.

The knife block is locked in bottom position.

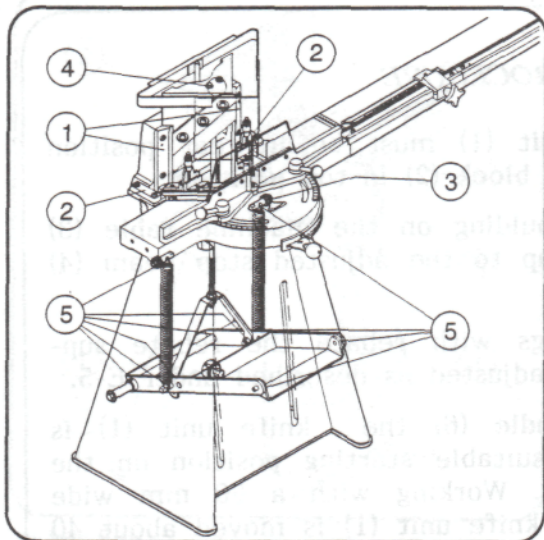


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Instructions manual MORSØ Mitring machine Model F

Service

F-1



picture F-1-1

LUBRICATION INSTRUCTIONS

Approx. every two weeks lubricate:

The guidings for

1. knife block (1)
2. slide frame (2)
3. cross (3) (lubricates simultaneously the forward movement of the knife block)
4. Links for the draw bar (4) of the knife block.
5. all links in the lever system (5), incl. spring suspension

Lubricant: SHELL TONNA TX 68 or a similar oil of another make.

CLEANING

MORSØ-F must be cleaned thoroughly after use.

Remove any waste wood from all the guidings.

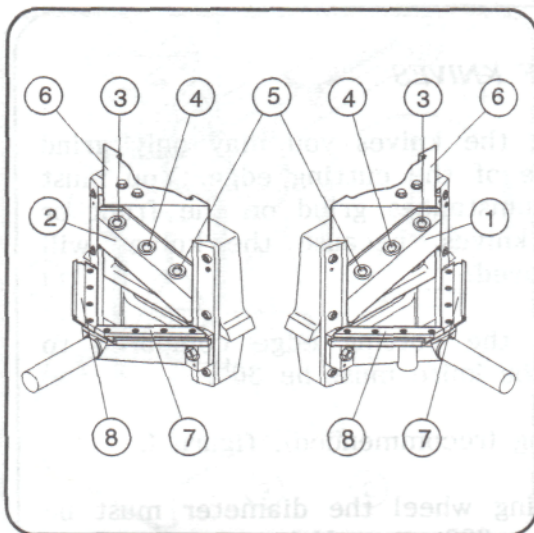
Remove the waste wood from behind the machine.



**Beware of the extreme
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**Beware of the extreme
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picture F-2-1

CHANGING OF KNIVES

When the cutting is no longer satisfactory, e.g. unclean cut surfaces with dents, the knives must be changed.

1. Screws (3), (4) + (5) are loosened with spanner (nv 17).
2. Remove screws (3) + (5).
3. Remove screw (4) from knife (1) while pressing the knife against the knife block (6) with your hand so that the knife will not fall down.

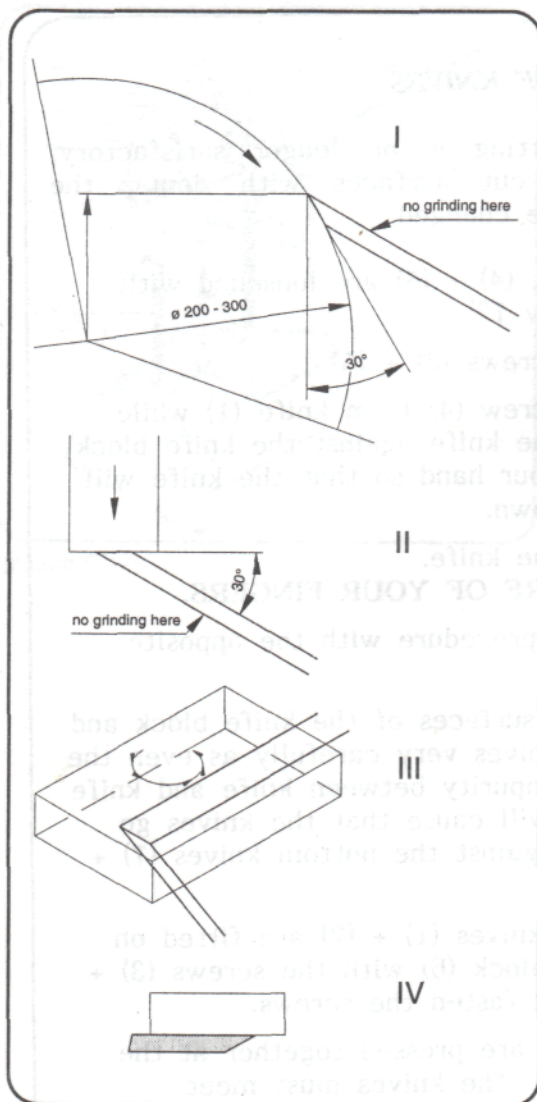
4. Remove the knife.

TAKE CARE OF YOUR FINGERS.

5. The same procedure with the opposite knife (2).
6. Clean the surfaces of the knife block and the new knives very carefully as even the smallest impurity between knife and knife block (6) will cause that the knives go too hard against the bottom knives (7) + (8).
7. Both new knives (1) + (2) are fitted on the knife block (6) with the screws (3) + (5). Do not fasten the screws.
8. The knives are pressed together at the front point. The knives must meet precisely at the front point and neither front edge must be further ahead.
9. Check if the cutting edges of the knives are in exactly the same height at the bottom. If not, the knives can be moved up or down separately until the correct position is reached.
10. Fasten the screws (3) (in both knives)
11. Insert the screws (4) and fasten them
12. Fasten screws (5)
13. Start the machine
14. Make a trial cut.



**Beware of the extreme
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picture F-3-1



Beware of the extreme sharp knives

GRINDING OF KNIVES

When grinding the knives you may only grind on the reverse of the cutting edge. You must under no circumstances grind on the front or ends of the knives, because the knives will then be destroyed.

The angle of the cutting edge compared to the front of the knife must be 30°.

Hollow grinding (recommended), figure I.

Using a grinding wheel the diameter must be between 200 - 300 mm. Using a cup wheel the diameter must be 150 mm.

Surface grinding figure II

Honing figure III

By setting the cutting edge you shall use a soft fine-grained silicon carbide hand flat stone that must be kept in oil or kerosine.

By setting the cutting edge you must under no circumstances sharpen lengthwise of the cutting edge, always crosswise.

First sharpen on the reverse side of the knife. The flat stone is to be kept in an angle of 31° compared to the front of the knife.

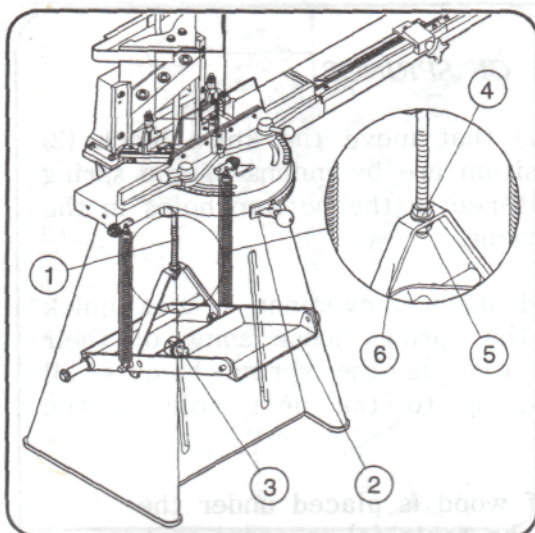
Take off burrs, figure IV

After the honing the burrs on the front of the knife are taken off with a slate flat stone that must be quite straight.

The flat stone must here be completely in line with the knife, because otherwise the outer cutting edge will get an incorrect angle.

Even the slightest error here will cause that the knife presses too hard against the wood during the cutting.

Please also see page F-4 Regulation of Draw Bar.



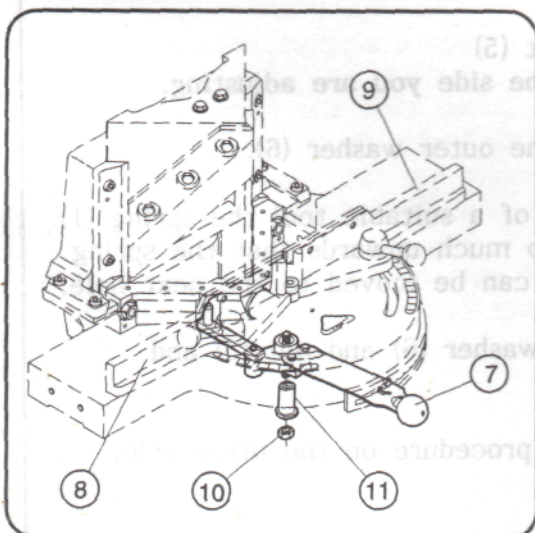
picture F-1

REGULATION OF DRAW BAR

As the knives are worn it will be necessary to adjust the draw bar (1).

The following procedure is used:

1. The foot pedal (2) is pressed home and locked by means of the height stop (3).
2. Loosen nut (4).
3. Nut (5) is screwed so much upwards that the knife edge goes about 4 - 6 mm under the upper side of the bottom knives.
5. Fasten nut (4) against the draw bow (6).



picture F-2

ADJUSTMENT OF FORWARD MOVEMENT

When you have changed used knives it might be necessary to adjust the forward movement.

1. The knife block unit is placed in the front position with handle (7) (on the picture it is shown in the rear position). The fences (8) + (9) must be adjusted on standard (45°) position and be fastened.
2. Loosen nut (10).
3. Bushing (11) is turned with a spanner until the front point of the knives goes a little bit between the fences (8) + (9), but the knives must not touch the fences.
4. Fasten nut (10) while holding the bushing (11) in the adjusted position by means of the spanner.

The position of the knives is checked by moving the knife block down slowly. If the fences (8) + (9) are not touched, put a moulding in the machine and cut it. If the moulding does not split on the front edge the adjustment is correct.



Beware of the extreme sharp knives



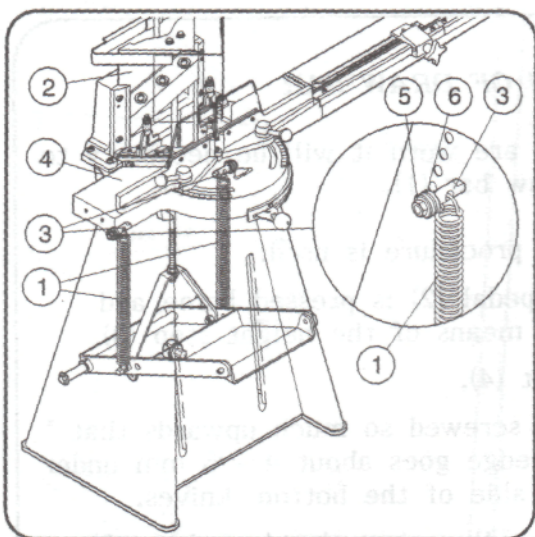
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Service

F-5



picture F-5-1

ADJUSTMENT OF SPRINGS

The springs (1) that move the knife block (2) to the top position are by means of the spring holders (3) fastened in the bottom holes in the sides of the frame.

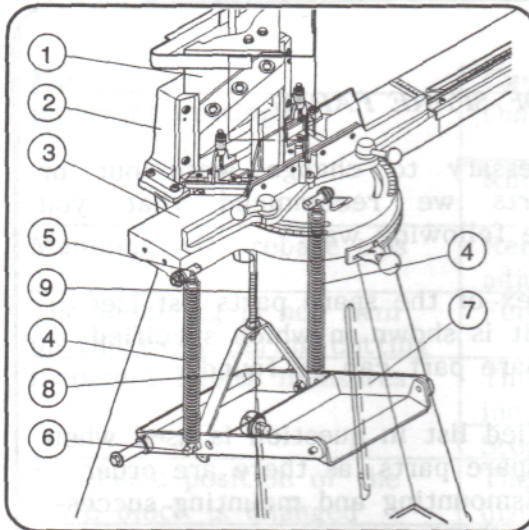
If the up and down movement is not quick enough or if the springs loose some of their tension after a while the spring holders (3) can be moved up to the next hole in the frame.

1. A piece of wood is placed under the knives on the table (4) in order to keep the knife block (2) up.
2. Loosen nut (5)
Only on the side you are adjusting.
3. Pull off the outer washer (6).
4. By means of a suitable tool the spring (1) is lifted so much upwards that the spring holder (3) can be moved to the next hole.
5. Put back washer (6) and nut (5) and fasten.
6. The same procedure on the other side.



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sharp knives**

MORSØ F.



picture F-6-1

ADJUSTMENT OF HEIGHT MOVEMENT

The height movement of the knife block (1) is adjusted to max. 165 mm from the factory.

In the following way the machine can be adjusted to a height movement of max. 200 mm:

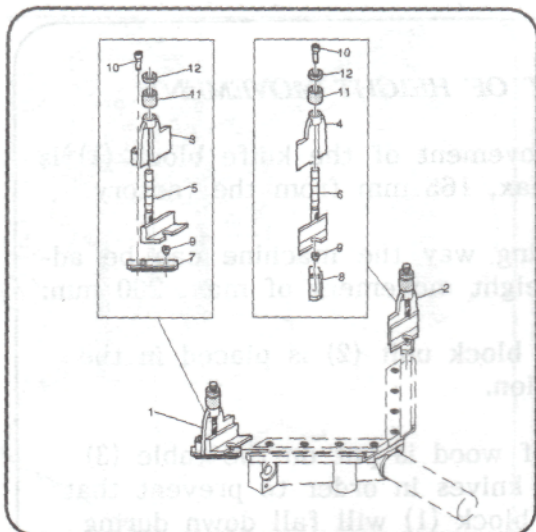
1. The knife block unit (2) is placed in the rear position.
2. A piece of wood is put on the table (3) under the knives in order to prevent that the knife block (1) will fall down during the adjustment.
3. The springs (4) is pulled out of the spring holders (5) and draw bow holders (6).
4. The draw bow holders (6) placed in the rear holes in the foot pedal tipper (7) are moved to the front holes in the foot pedal tipper (7).
5. Fasten the draw bow holders (6) in the draw bow (8) again.
6. Place the springs (4) in the spring holders (5) and the draw bow holders (6).
7. The draw bar (9) is adjusted as described under F-4.



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**Beware of the extreme
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picture F-7-1

CHANGING OF SPARE PARTS

If it is necessary to change worn out or destroyed parts we recommend that you proceed in the following way:

1. In the index of the spare parts list (see page I-1) it is shown in which specified list the spare part can be found.
2. The specified list in question is used when changing spare parts, as there are order number, dismounting and mounting succession of the spare part.
3. Example:
 Parts in the rebate support must be changed:
 Figure I-1 shows that the parts are stated in figure I-5. Under Pos. 1, 2, and 4, the parts necessary for the repair, the dismounting and mounting succession are shown.
 In the text part of the illustration the order number and spare part designation are stated.



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Beware of the extreme sharp knives

Instructions manual MORSØ Mitring machine Model F

LOCATING FAULTS

G-1

Faults	Cause	Repair
Incorrect cuttings	Dull knives	Replace knives See page F-2
	Knives incorrectly installed	Check the installation See page F-2
Moulding with rebate tips	Rebate supports incorrectly adjusted	Correct the adjustment See page E-5
The moulding is not firm on the table during cutting	Fences loose	Fasten fences See page E-3
Incorrect length measures	The length measure incorrectly set	Correct the length measure See page E-4
	Stop beam loose	Fasten stop beam
The basic position of the knife block is changed	The height stop is displaced	correct the adjustment see page E-7
The moulding is not cut quite through	The forward movement is not correct adjusted	correct the adjustment see page F-4



Beware of the extreme sharp knives

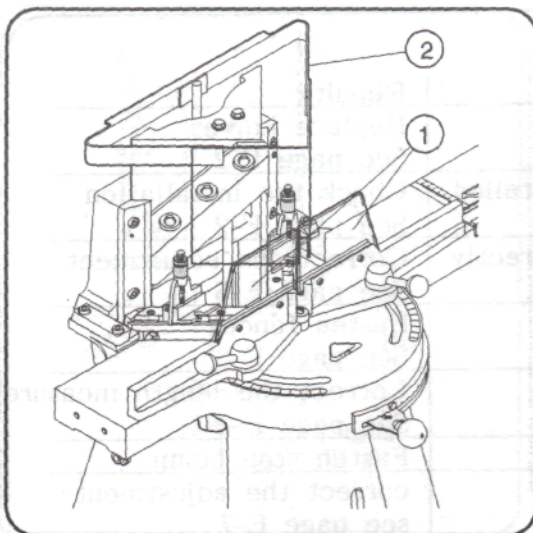


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Instructions manual MORSØ Mitring machine Model F

SAFETY

H-1



picture H-1-1

SAFETY DEVICES

According to current safety regulations **MORSØ-F** must not be used without the following safety devices:

1. Safety Guards (1) in the fences
2. Safety Guard (2) for knife block



SAFETY REGULATIONS

On delivery of the machine to the consumer

DAN - LIST A/S

guarantees that **MORSØ-F** mitring machine is constructed and fitted according the CEN/TC 142 (Safety Regulations for wood working machinery).

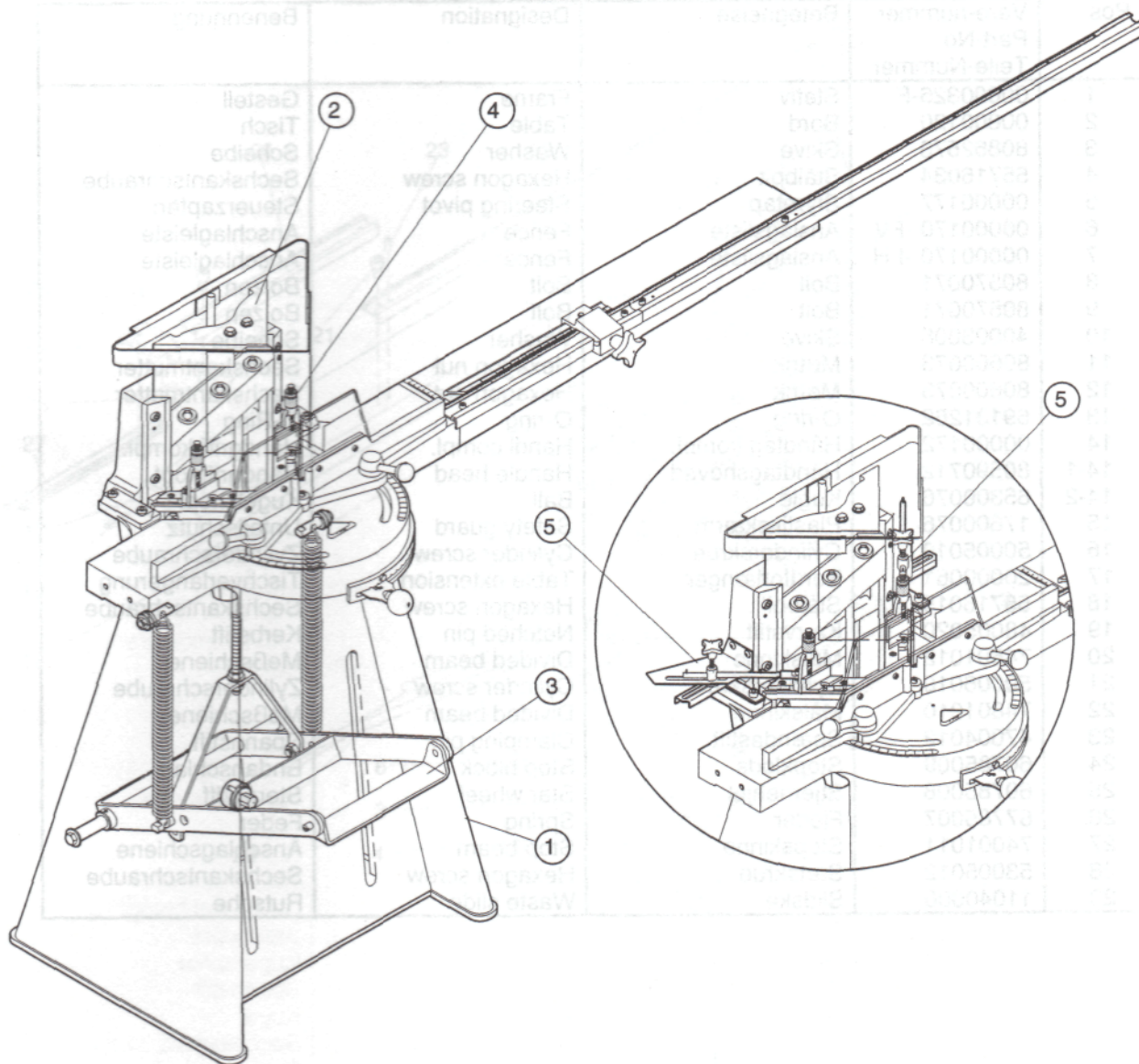
At start and use of the mitring machine **MORSØ-F** the operator must pay attention to current national and international safety regulations.

If the operator does not observe the above mentioned regulations the factory does not guarantee for damages to the machine or the operator.



**Beware of the extreme
sharp knives**

Oversigt - Index - Übersicht



Pos	Betegnelse	Designation	Benennung	på tavle Figur auf Tafel
1	Grundmaskine	Basic machine	Grundmaschine	I-2
2	Knivhovedenhed	Knife block unit	Messerkopf-Einheit	I-3
3	Drivmekanisme	Drive equipment	Antriebsmechanik	I-4
4	Falsstøtter	Rebate supports	Falzauflagen	I-5
	Ekstraudstyr	Accessories	Zusatzrüstung	
5	Falsstøtter, autom.	Rebate support, automatic	Falzauflage, automatisch	L-2

**dan-list A/s**

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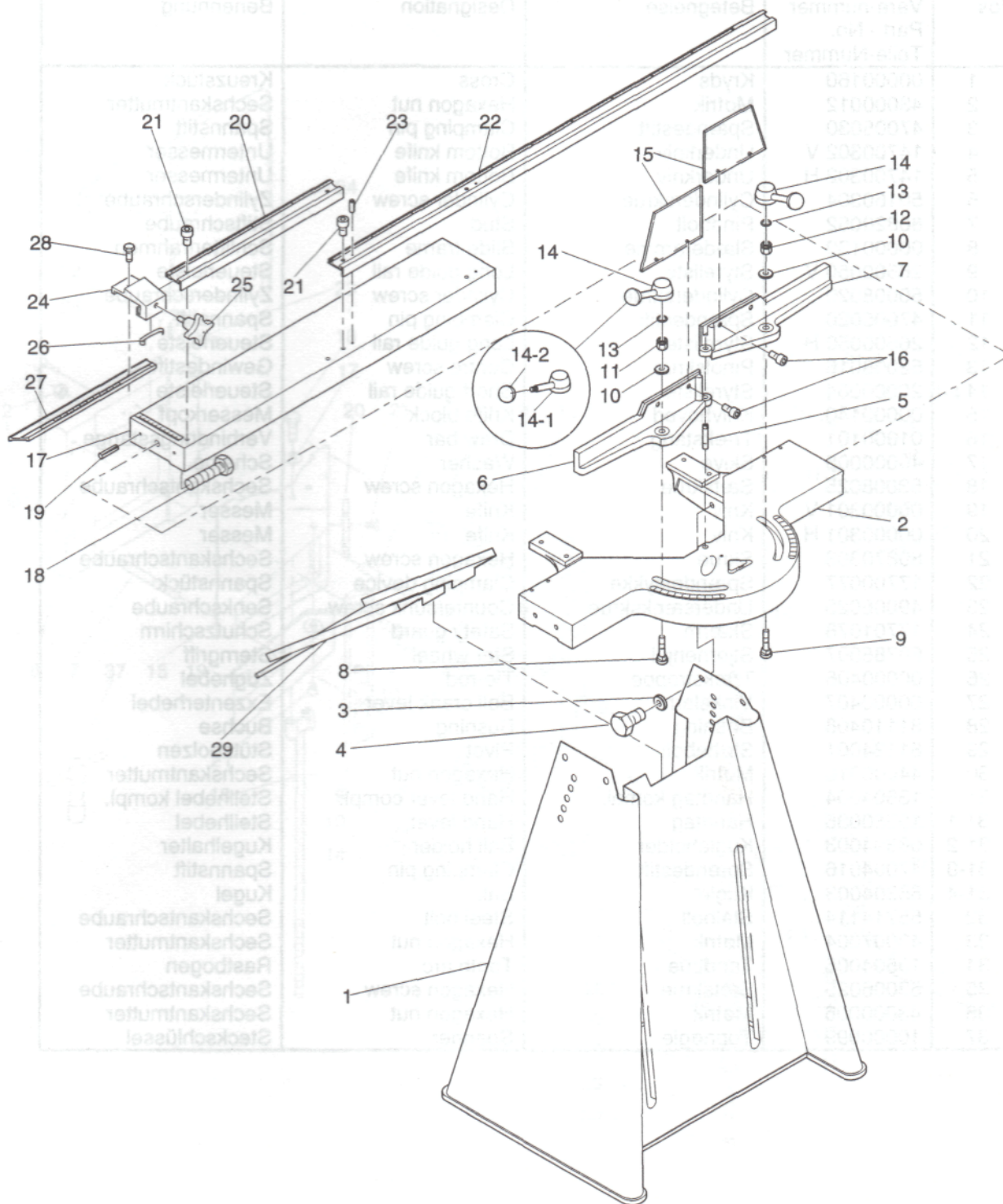
**Instructions manual
MORSØ Mitring machine
Model F****Index of spare parts****I-2****Grundmaskine - Basic machine - Grundmaschine**

Pos	Vare-nummer Part-No. Teile-Nummer	Betegnelse	Designation	Benennung
1	00000326-F	Stativ	Frame	Gestell
2	00000120	Bord	Table	Tisch
3	80862576	Skive	Washer	Scheibe
4	55716034	Stålbolt	Hexagon screw	Sechskantschraube
5	00000177	Styretap	Steering pivot	Steuerzapfen
6	00000170 -FV	Anslagsliste	Fence	Anschlagleiste
7	00000170 -FH	Anslagsliste	Fence	Anschlagleiste
8	80570071	Bolt	Bolt	Bolzen
9	80570071	Bolt	Bolt	Bolzen
10	40003008	Skive	Washer	Scheibe
11	80600073	Møtrik	Hexagon nut	Sechskantmutter
12	80600073	Møtrik	Hexagon nut	Sechskantmutter
13	69131262	O-ring	O-ring	O-Ring
14	00000172	Håndtag kompl.	Handl compl.	Handgriff kompl.
14-1	80590712	Håndtagshoved	Handle head	Handgriffkopf
14-2	65300076	Kugle	Ball	Kugelknopf
15	17600076	Plastikskærm	Safety guard	Unfallschutz
16	50005010	Cylinderskrue	Cylinder screw	Zylinderschraube
17	20000061	Bordforlænger	Table extension	Tischverlängerung
18	55716015	Stålbolt	Hexagon screw	Sechskantschraube
19	48005020	Kærvstift	Notched pin	Kerbstift
20	74501012	Målskinne	Divided beam	Meßschiene
21	50006010	Cylinderskrue	Cylinder screw	Zylinderschraube
22	74801010	Målskinne	Divided beam	Meßschiene
23	47004012	Spændestift	Clamping pin	Spannstift
24	60785009	Stopklods	Stop block	Endanschlag
25	60785008	Stjernehjul	Star wheel	Sterngriff
26	67785007	Fjeder	Spring	Feder
27	74001011	Stopskinne	Stop beam	Anschlagschiene
28	53005012	Sætskrue	Hexagon screw	Sechskantschraube
29	11040000	Slidske	Waste slide	Rutsche

pictur

MORSØ F-

Grundmaskine - Basic machine - Grundmaschine



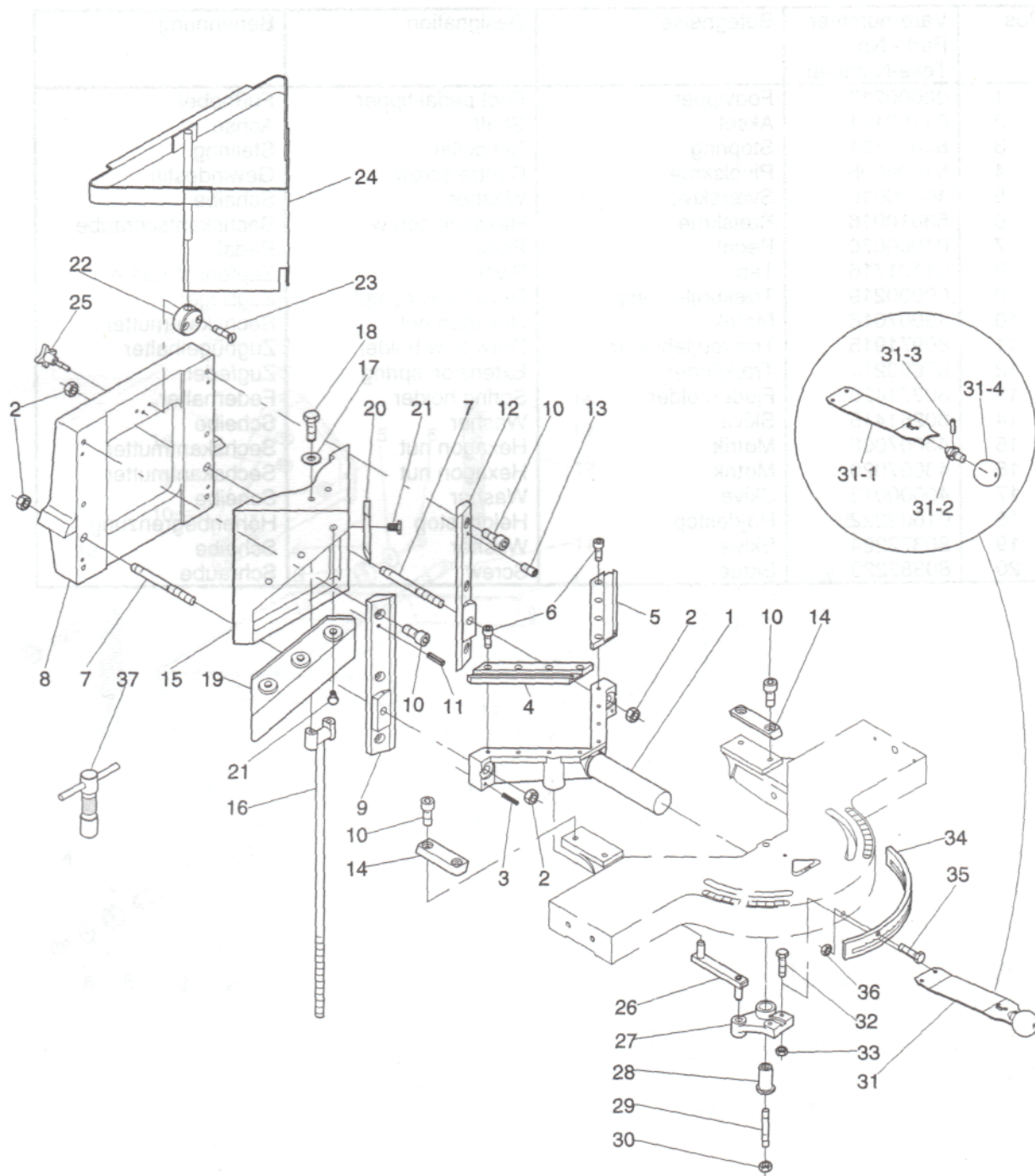
Knivhovedenhet - Knife block unit - Messerkopf-Einheit

Pos	Vare-nummer Part - No. Teile-Nummer	Betegnelse	Designation	Benennung
1	00000160	Kryds	Cross	Kreuzstück
2	43000012	Møtrik	Hexagon nut	Sechskantmutter
3	47005030	Spændestift	Clamping pin	Spannstift
4	14700302 V	Underkniv	Bottom knife	Untermesser
5	14700302 H	Underkniv	Bottom knife	Untermesser
6	50160304	Cylinderskrue	Cylinder screw	Zylinderschraube
7	80820052	Pindbolt	Stud	Stiftschraube
8	00000130	Slæderamme	Slide frame	Schlittenrahmen
9	26500050 V	Styreliste	Long guide rail	Steuerleiste
10	50008020	Cylinderskrue	Cylinder screw	Zylinderschraube
11	47005020	Spændestift	Clamping pin	Spannstift
12	26500050 H	Styreliste	Long guide rail	Steuerleiste
13	52008016	Pinolskrue	Centre screw	Gewindestift
14	20000064	Styreliste	Short guide rail	Steuerleiste
15	00000140	Knivhoved	Knife block	Messerkopf
16	01000101	Trækstang	Draw bar	Verbindungsstange
17	40000008	Skive	Washer	Scheibe
18	53008025	Sætskrue	Hexagon screw	Sechskantschraube
19	00000301 V	Kniv	Knife	Messer
20	00000301 H	Kniv	Knife	Messer
21	80870303	Skrue	Hexagon screw	Sechskantschraube
22	17700077	Spændestykke	Clamping device	Spannstück
23	49006025	Undersænskrue	Countersunk screw	Senkschraube
24	17701078	Skærm	Safety guard	Schutzschirm
25	60785007	Stjernehjul	Star wheel	Sterngriff
26	00000406	Trækstroppe	Tie-rod	Zughebel
27	00000407	Vinkelarm	Bell crank lever	Exzenterhebel
28	81110408	Bøsning	Bushing	Buchse
29	81124001	Støttebolt	Pivot	Stützbolzen
30	44000010	Møtrik	Hexagon nut	Sechskantmutter
31	13504004	Håndtag kompl.	Hand lever compl.	Stellhebel kompl.
31-1	10350035	Håndtag	Hand lever	Stellhebel
31-2	08394003	Kugleholder	Ball holder	Kugelhalter
31-3	47004016	Spændestift	Clamping pin	Spannstift
31-4	65304003	Kugle	Ball	Kugel
32	55714114	Stålbolt	Steel bolt	Sechskantschraube
33	43007004	Møtrik	Hexagon nut	Sechskantmutter
34	19504005	Tandbue	Tooth arc	Rastbogen
35	53006025	Sætskrue	Hexagon screw	Sechskantschraube
36	43000006	Møtrik	Hexagon nut	Sechskantmutter
37	10000099	Topnøgle	Spanner	Steckschlüssel

picture

MORSØ F-4

Knivhovedenhed - Knife block unit - Messerkopf-Einheit





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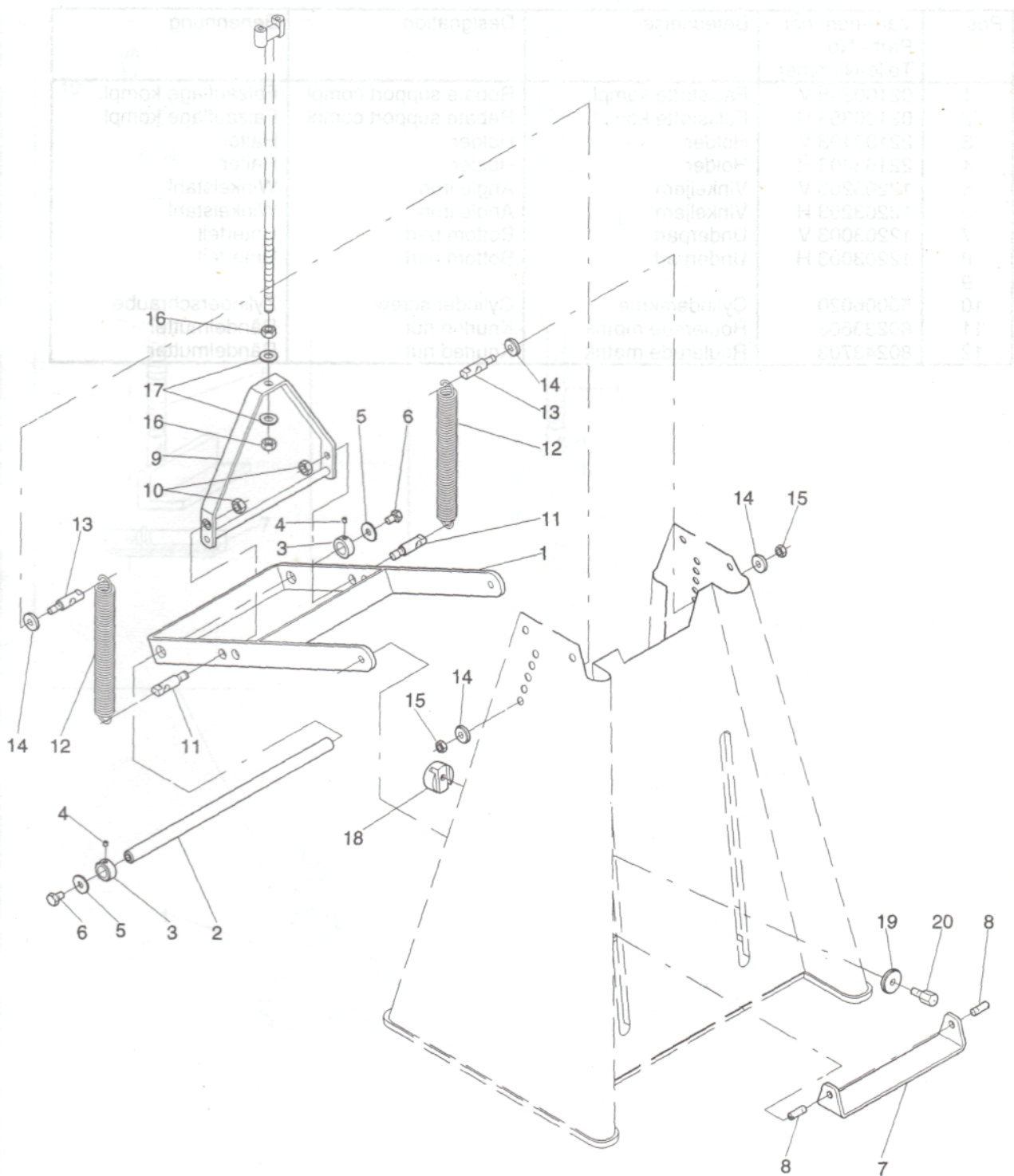
Drivmekanisme - Drive equipment - Antriebsmechanik

Pos	Vare-nummer Part - No. Teile-Nummer	Betegnelse	Designation	Benennung
1	00000217	Fodvipper	Foot pedal tipper	Fußhebel
2	01102121	Aksel	Shaft	Achse
3	80022124	Stopring	Set collar	Stelling
4	51006008	Pinolskrue	Centre screw	Gewindestift
5	40000010	Sværskrue	Washer	Scheibe
6	53010016	Sætskrue	Hexagon screw	Sechskantschraube
7	01000070	Pedal	Pedal	Pedal
8	01101716	Tap	Pivot	Zapfenschraube
9	00000219	Trækbøjle kompl.	Draw bow, compl.	Zugbügel
10	43007016	Møtrik	Hexagon nut	Sechskantmutter
11	80971915	Trækbøjleholder	Draw bow holder	Zugbügelhalter
12	67600214	Trækfjeder	Extension spring	Zugfeder
13	80271420	Fjederholder	Spring holder	Federhalter
14	80281415	Skive	Washer	Scheibe
15	43007008	Møtrik	Hexagon nut	Sechskantmutter
16	43007020	Skive	Hexagon nut	Sechskantmutter
17	40000012	Højdestop	Washer	Scheibe
18	01602222	Skive	Height stop	Höhenbegrenzung
19	80372224	Skrue	Washer	Scheibe
20	80382223		Screw	Schraube

picture

B

Drivmekanisme - Drive equipment - Antriebsmechanik





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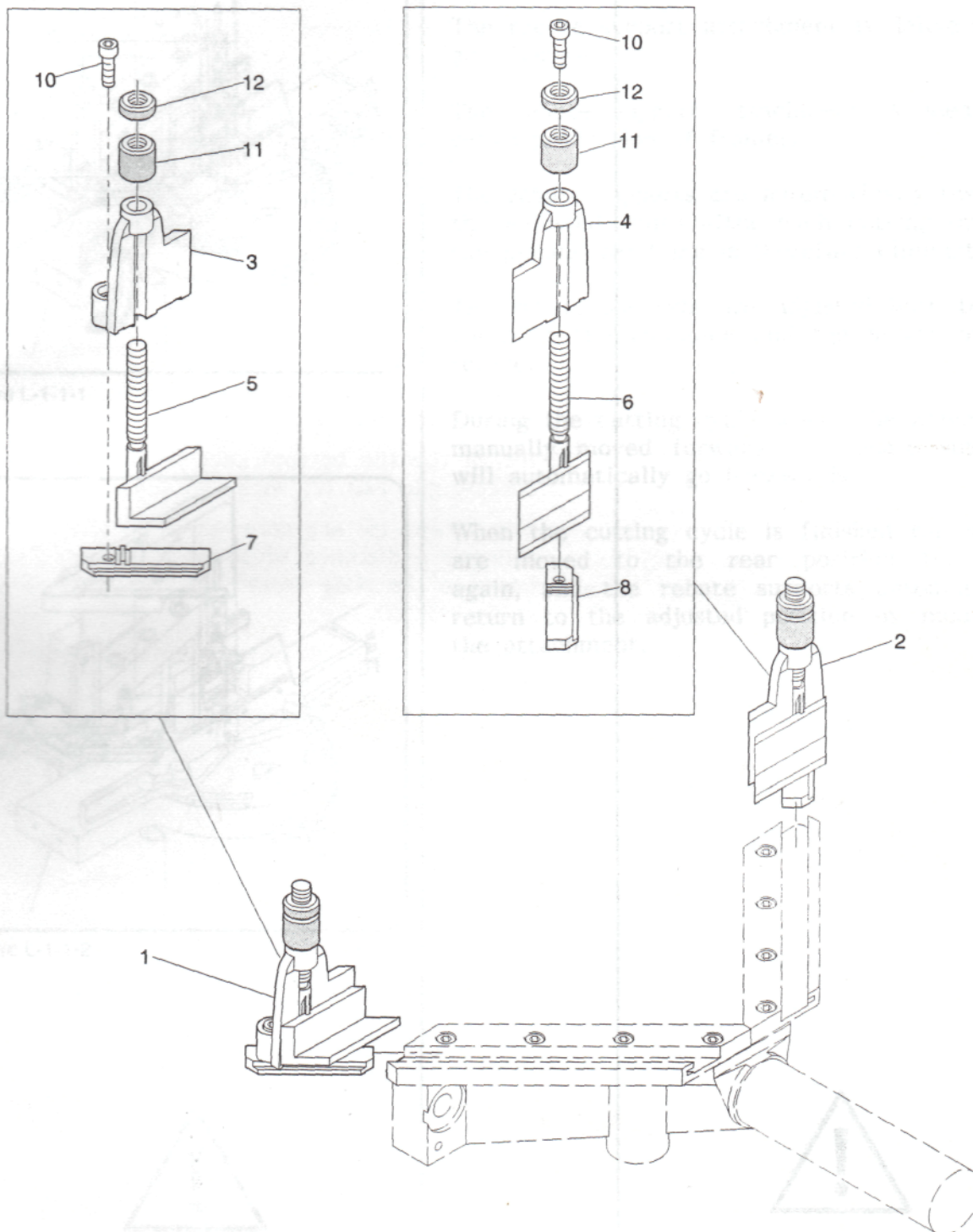
I-5

Falsstøtter - Rebate support - Falzauflagen

Pos	Vare-nummer Part - No. Teile-Nummer	Betegnelse	Designation	Benennung
1	02100355 V	Falsstøtte kompl.	Rebate support compl.	Falzauflage kompl.
2	02100355 H	Falsstøtte kompl.	Rebate support compl.	Falzauflage kompl.
3	22103403 V	Holder	Holder	Halter
4	22103403 H	Holder	Holder	Halter
5	12203203 V	Vinkeljern	Angle iron	Winkelstahl
6	12203203 H	Vinkeljern	Angle iron	Winkelstahl
7	12203003 V	Underpart	Bottom part	Unterteil
8	12203003 H	Underpart	Bottom part	Unterteil
9			Cylinder screw	Zylinderschraube
10	50006020	Cylinderskrue	Knurled nut	Rändelmutter
11	80233603	Roulerede møtrik	Knurled nut	Rändelmutter
12	80243703	Roulerede møtrik		

pictur

Falsstøtter - Rebate support - Falzauflagen





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SUPPLEMENT

K-1

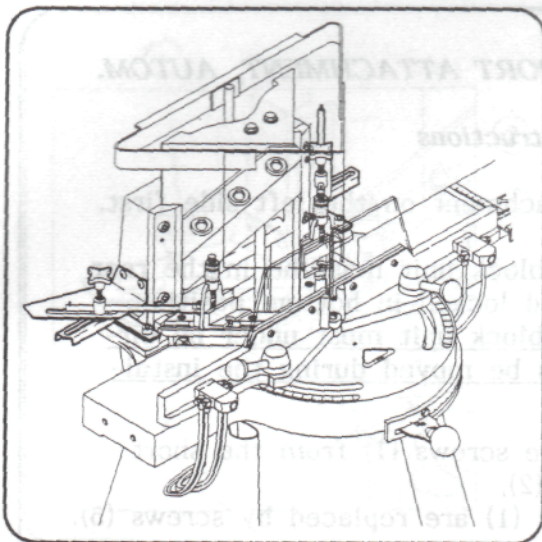


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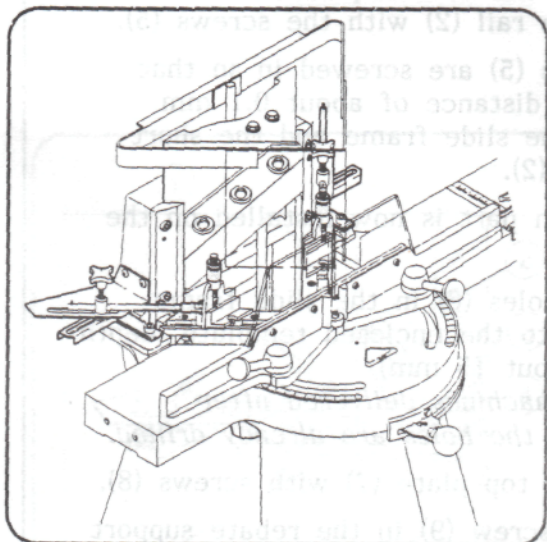
Instructions manual MORSØ Mitring machine Model F + H

Accessories

L-1-1



picture L-1-1-1



picture L-1-1-2

REBATE SUPPORT ATTACHMENT, AUTOM.

The rebate support attachment is delivered as accessories.

The rebate support attachment is ideal for series production of frames.

The rebate supports are automatically reset to the adjusted width after each cutting cycle - the manual resetting is therefore eliminated.

The rebate supports are adjusted both to the width of the moulding and the height of the rebate.

During the cutting cycle where the knives are manually moved forward the rebate supports will automatically go backwards.

When the cutting cycle is finished the knives are moved to the rear position for start again, and the rebate supports automatically return to the adjusted position by means of the attachment.

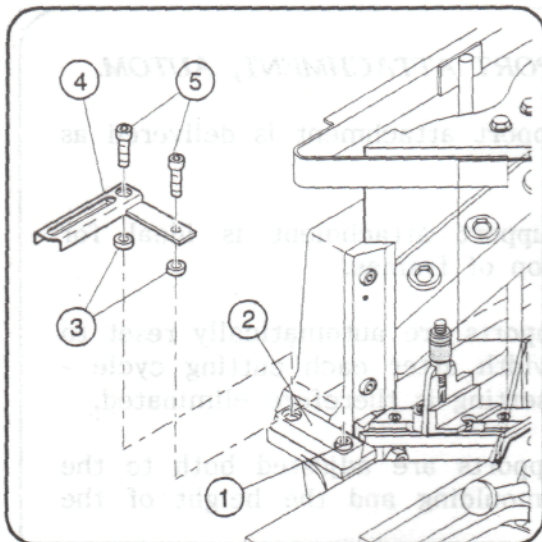


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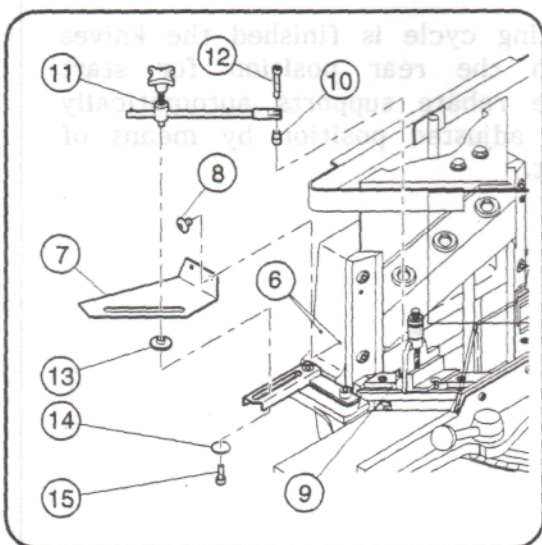
Instructions manual MORSØ Mitring machine Model F + H

Accessories

L-1-2



picture L-1-2-1



picture L-1-2-2

REBATE SUPPORT ATTACHMENT, AUTOM.

Installation Instructions

Install the attachment on the left side first.

1. The knife block unit must be in the rear position and locked in bottom position.
The knife block unit must under no circumstances be moved during the installation.
2. Remove the screws (1) from the short guide rail (2).
The screws (1) are replaced by screws (5).
3. Place the bushing (3) in the borings on the short guide rail (2).
4. Install the the bottom part (4) on the short guide rail (2) with the screws (5).
5. The screws (5) are screwed in so that there is a distance of about 0.1 mm between the slide frame and the short guide rail (2).
6. The bottom part is now installed on the right side.
7. Drill the holes (6) in the slide frame according to the enclosed template (depth of hole about 15 mm)
OBS: On machines delivered after 1995.02.01 the holes are already drilled.
8. Fasten the top plate (7) with screws (8).
9. Dismount screw (9) in the rebate support and put in bushing (10).
10. Install the draw bar (11) with the screw (12) - the draw bar holder must slide in the slot on both the top plate (7) and the bottom part (4).
11. Place the slide bar (13) between the top plate (7) and the bottom part (4).
12. Install the washer (14) with the screw (15).

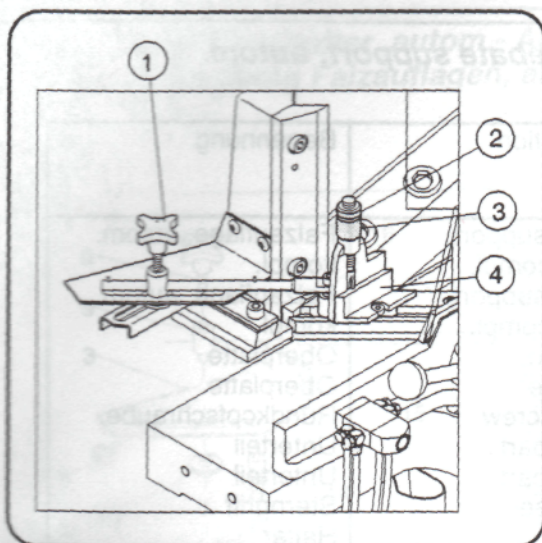


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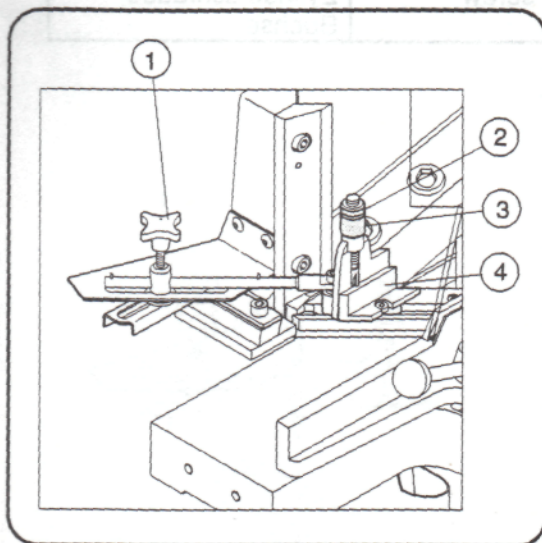
Instructions manual MORSØ Mitring machine Model F + H

Accessories

L-1-3



picture L-1-3-1



picture L-1-3-2

REBATE SUPPORT ATTACHMENT, AUTOM.

Adjustment of Rebate Supports

The knife block must be in top position during the adjustment.

The rebate supports are only used when cutting mouldings with rebate.

To adjust the rebate support star wheel (1) and knurled nut (2) are loosened.

Place the moulding in the machine. Push the rebate supports (4) into the rebate of the moulding.

Press the moulding down on the machine table.

The height of the rebate supports is adjusted by means of the knurled nut (3). The rebate supports must be adjusted so that they are approx. 1/2 mm under the rebate of the moulding.

After the adjustment the knurled nut (2) is fastened.

The rebate supports are fastened with star wheel (1) so that they have a distance of about 1/2 mm from the moulding.

The rebate supports can be removed from the machine when the knife block is in the rear position.



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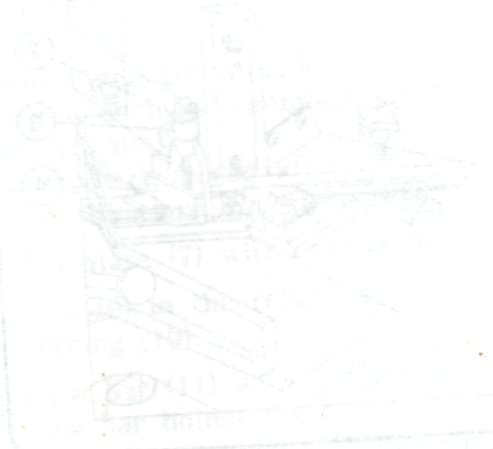
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Index of spare parts L-2

Ekstraudstyr Falsstøtter, autom.- Accessories Rebate support, autom. - Zusatzausrüstung Falzauflagen, autom.

Pos	Vare-nummer Part - No. Teile-Nummer	Betegnelse	Designation	Benennung
1	05000900 V	Falsstøtte, autom. kompl.	Rebate support, autom. compl.	Falzauflage, autom. kompl.
2	05000900 H	Falsstøtte, autom. kompl.	Rebate support, autom. compl.	Falzauflage, autom. kompl.
3	05000120 V	Overplade	Top plate	Oberplatte
4	05000120 H	Overplade	Top plate	Oberplatte
5	49005008	Rundhoved skrue	Round screw	Rundkopfschraube
6	05000121 V	Underpart	Bottom part	Unterteil
7	05000121 H	Underpart	Bottom part	Unterteil
8	60785007	Stjernehjul	Star wheel	Sterngriff
9	05000123	Holder	Holder	Halter
10	05000124	Glider	Slide bar	Gleitstück
11	05000125	Underlagskive	Washer	Unterlegscheibe
12	50004012	Cylinderskrue	Cylinder screw	Zylinderschraube
13	05000126	Bøsning	Bushing	Buchse
14	50008030	Cylinderskrue	Cylinder screw	Zylinderschraube
15	05000122	Trækstang	Draw bar	Verbindungsstange
16	47003016	Spændestift	Clamping pin	Spannstift
17	50006035	Cylinderskrue	Cylinder screw	Zylinderschraube
18	05000127	Bøsning	Bushing	Buchse



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Ekstraudstyr Falsstøtter, autom.- Accessories Rebate support, autom.
- Zusatzausrüstung Falzauflagen, autom.

