



P.O. BOX 2, DISLEY, CHESHIRE, SK12 2NN, ENGLAND.

Tel: 01663 762187  
Fax: 01663 762187

Suppliers of Machinery for Mitreing Wood and Metal and Underpinners for the Picture Frame Industry

## OPERATING INSTRUCTIONS FOR 78 PNEUMATIC WARNING. THE BLADES ARE VERY SHARP, TAKE CARE AT ALL TIMES.

As soon as you have unpacked the machine fit the Perspex guards supplied.

### Fixing of Table Extension

The two faces to be joined for the table extension, which has been removed for crating purposes, must be thoroughly cleaned. This applies in particular to locating pins and holes as well as screw threads, as the smallest amount of dirt will prevent the correct alignment.

Following careful cleaning the table extension is offered up to the machine table and the locating pins inserted in their respective holes. Next, the screws provided are inserted and tightened.

### Connecting Air Supply

The air supply should be connected from your compressor to the air mist regulator fitted to the front of the machine via a hole in the left hand side of the cabinet, using 6mm tubing. The left hand bottle collects moisture from your system and should be drained via the screw in the bottom on a regular basis.

The right hand bottle contains a fine oil which should be automatically drawn into the machine's air system to lubricate the cylinder and valves. It is important that the oil always flows and this can be regulated by an adjusting screw on the top of the oil bottle.

### Use and Adjustment of Rebate Supports

The rebate supports are only used for mouldings with rebates: for any other work they can be removed completely, provided the cutterblock is moved to its furthest position, i.e. giving maximum throat clearance.

The rebate support is moved into the rebate whilst the moulding is firmly held against both table and fence. In that position the support is adjusted to the full height of the rebate without moving the moulding off the table. Next, turn the locking screw to ensure that the rebate support remains firmly fixed.

For any of the above adjustments the knives should be moved back to their furthest position to prevent possible injury.

### Operating the Machine

Move the hand wheel clockwise: the knives are now in their foremost position and the knife block should be in its topmost position. Place the moulding on the tabletop and hold against the fence and adjust the height stop as described.

If it is a rebated moulding adjust the rebate supports as described.

Move the knife block back by means of the back hand wheel. The amount will depend on the height and width of the moulding. With a 60mm wide moulding the knife block should be moved approximately 40mm back.

Next, using one hand on each button, press the air buttons to bring the knife block down to cut the wood. When the cut is made leave go of the buttons and the knife block will return to its original position. Move the hand wheel one turn and repeat the cutting action until the moulding is completely severed.

The last cut should be only half that of its preceding ones. This last cut gives a planed finish to the cut. Operators should observe the advantage of this fine cut even with small-section mouldings which might easily be cut with a single cut.

### Changing of Knives

Before attempting to change the knives disconnect the air supply and press the air buttons to remove any residual air.

The knives and the knife block must be absolutely free from any kind of dust, for even the smallest amount of dust will prevent proper alignment and result in the knives being incorrectly adjusted in relation to the bottom knives.

Both the right and left hand knives are mounted on the knife block using, in the first instance, screws Nos. 89 and dowel pins. Do not tighten the screws. The knives are pressed together with hand pressure only: the knives must meet precisely and neither front edge must be proud.

When this is done lower screw No. 89 for each knife may be tightened.

Next check that both knives are at the same height, if the knives are not level at their lowest meeting point then they can be adjusted individually until the adjustment is complete. The knives are still only held by lower screw No. 89. Next, upper screw No. 89 is inserted and tightened.

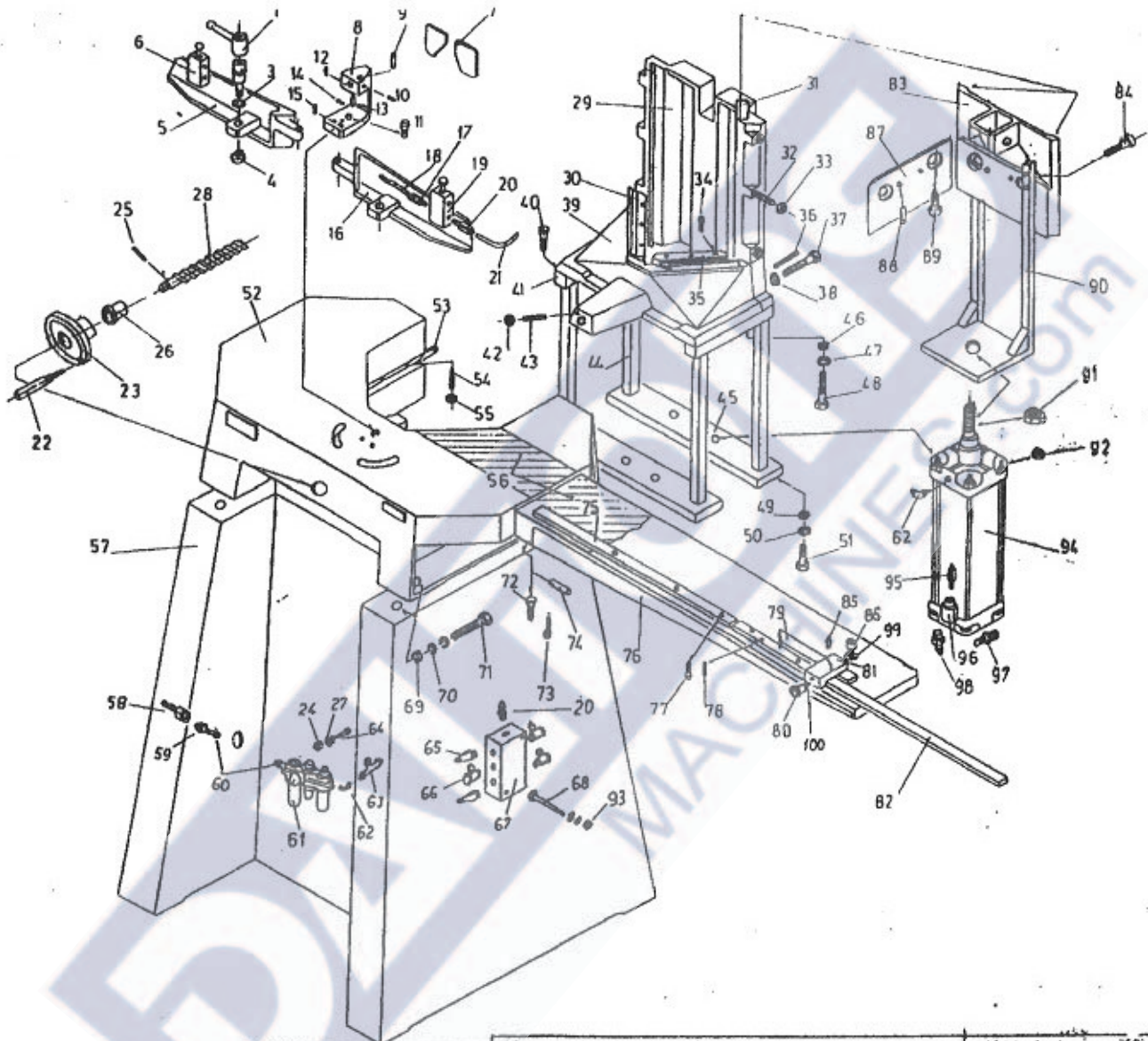
### Cutting of Mitres other than 45 Degrees

If, for instance, a six sided frame is to be made then the following method is used:

Six mouldings are cut in the normal manner with angles of 45 degrees each. However, each side is made slightly larger than the intended final size.

Each fence is then set at 60 degrees and the ends are recut individually at 60 degrees.





CONSTRUCCIONES MECANICAS

o'legui

LISTA DE RECAMBIOS CIZALLA INGLETADORA MOD. 78/PNEUMATICA

LISTE DE PIECES DETACHEES CIZAILLE COUPE D'ANGLE MODELE 78/PNEUMATIQUE

SPARE PARTS LIST-MITRE-CUTTING MACHINE TYPE 78/PNEUMATIC

ERZATZTEILLISTE-GEHRUNGS WINKEL-SCHNITTMA SCHINE TYPE 78/PNEUMATIK

Our Local Engineer uses:-  
 SILKAIR AIRLINE OIL  
 REF VG22.  
 But ANY SIMILAR OIL WILL  
 BE SUITABLE