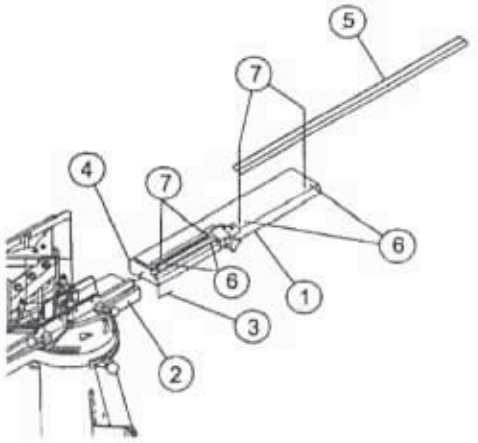


D-1-1

In General

The machine is delivered ready for start and complete with standard equipment.
Only the table extension (1) and divided beam (5) are dismounted during transport.

NOTE before startina 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 waste chute 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.

Fitting of the Table Extension and Divided Beams

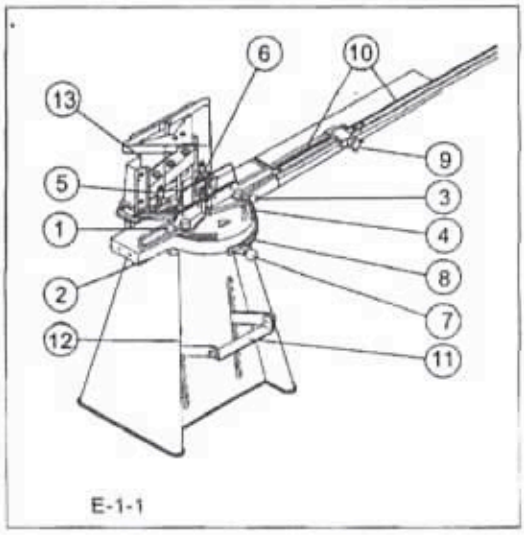
Before fitting the table extension (1) the ends of the table extension and the table (2) must be cleaned very thoroughly. Special attention must be paid to the pin and screw holes, as the smallest amount of dirt will prevent the correct alignment.

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. The included screw (3) is now 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).

BEWARE OF THE EXTREME SHARP KNIVES



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

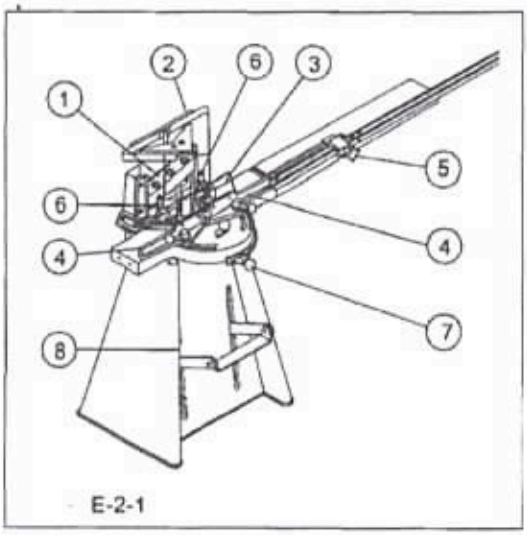
10= Scale - length adjustment

11= Foot pedal - cutting movement ofthe knife block

12= Screw - height stop for knife block

13= Star wheel - fastens safety guard

BEWARE OF THE EXTREME SHARP KNIVES



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
fitting of all safety devices:
safety guard for knives (2)
safety guards on fences (3)

d) table and table extension
cleanness and undamaged surface

2. Adjustments

a) the angle of the fences (4)
(adjustment instructions page E-3)

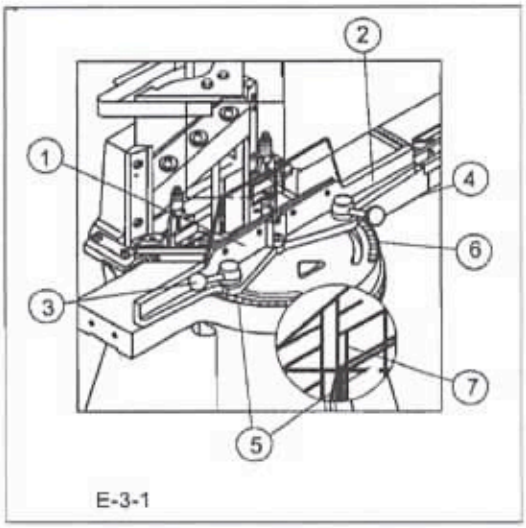
b) length of moulding (5)
(adjustment instructions page E-4)

c) rebate supports (6)
(adjustment instructions page E-5)

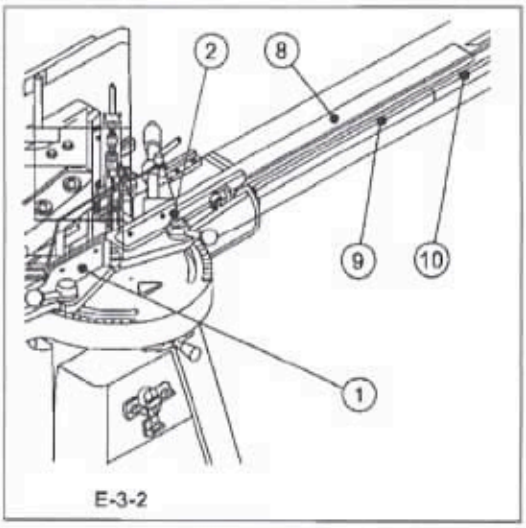
d) forward movement (7)
(adjustment instructions page E-5)

e) height stop (8)
(adjustment instructions Page E-6)

BEWARE OF THE EXTREME SHARP KNIVES



E-3-1



E-3-2

BEWARE OF THE EXTREME SHARP KNIVES

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).

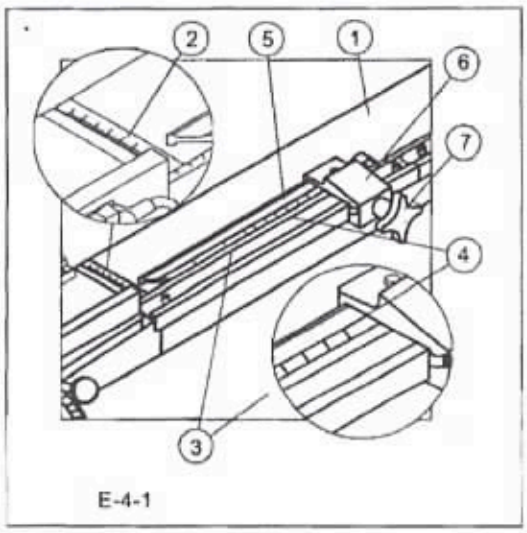
After the adjustment the hand levers (3) and (4) are fastened again, and all moulding ends are cut separately at 60° - single mitre.

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).



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 b,?,am (5) is carried out in double measures.

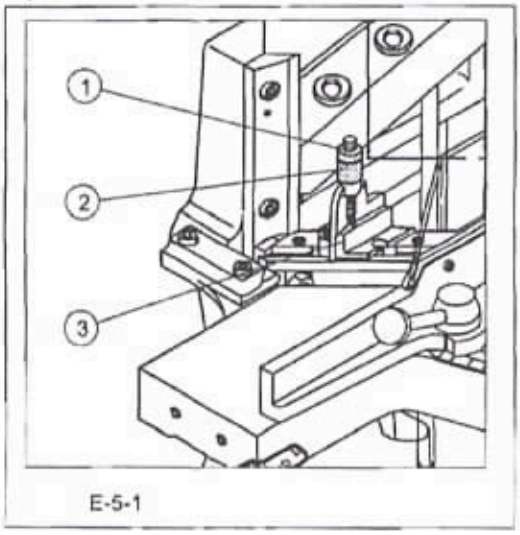
Example 1:
Outside measures of the frame:

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 n-side measures of the frame will be 27 cm.
4. Star wheel (7)is fastened.

BEWARE OF THE EXTREME SHARP KNIVES



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.

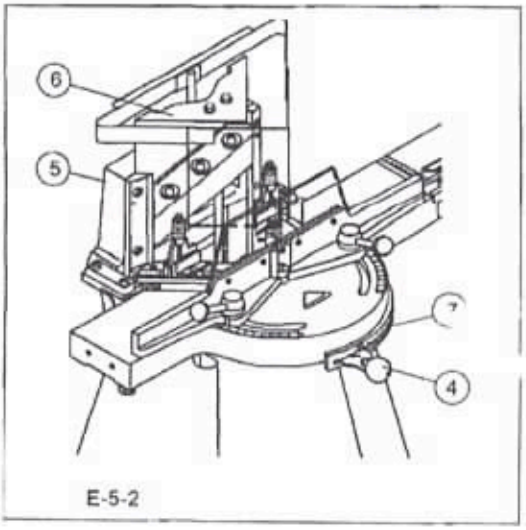
Place the moulding to be cut in the machine. Push the rebate supports (3) Into the rebate of the moulding.

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.



E-5-2

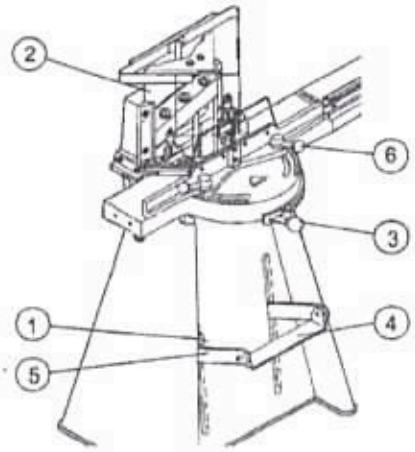
Adjustment of the Forward Movement (Picture E-5-2)

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 (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.

BEWARE OF THE EXTREME SHARP KNIVES



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.

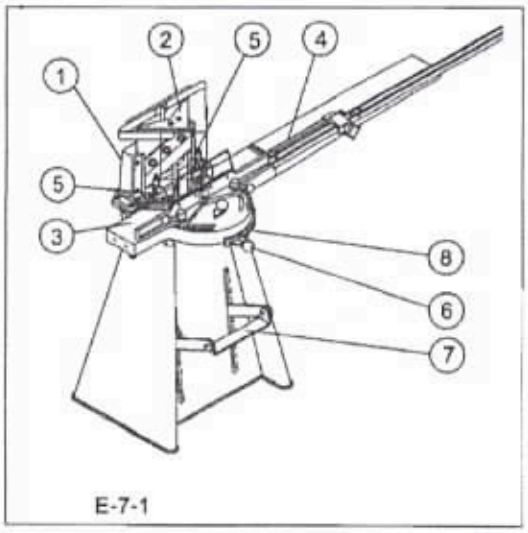
The moulding is placed on the table (the knife block must be in the rear position, as shown on the picture). The knife block (2) is moved forward to the front position by means of handle (3).

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.

BEWARE OF THE EXTREME SHARP KNIVES



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).

Working with mouldings with rebate the rebate supports 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

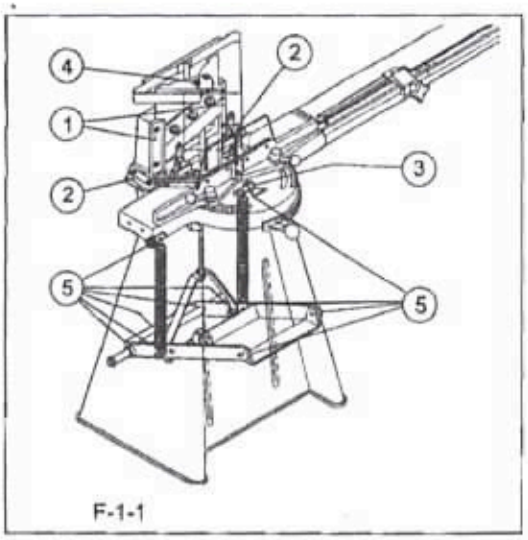
Clean the machine.

Remove the waste.

Check the whole machine.

The knife block is locked in bottom position.

BEWARE OF THE EXTREME SHARP KNIVES



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 Inife block).
4. Links for the draw bar (4) of the knife block.
5. All links in the lever system (5),incl.spring suspension.

Lubricant: Any acid-fiee oil.

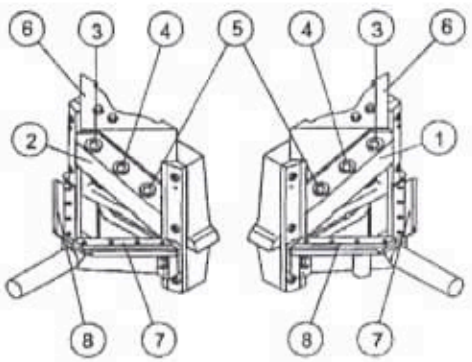
Cleaning

QJ-200 mitring machine 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 SHARP KNIVES



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, 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 SHARP KNIVES