

LIGHT SPINDLE MOULDER TYPE BER

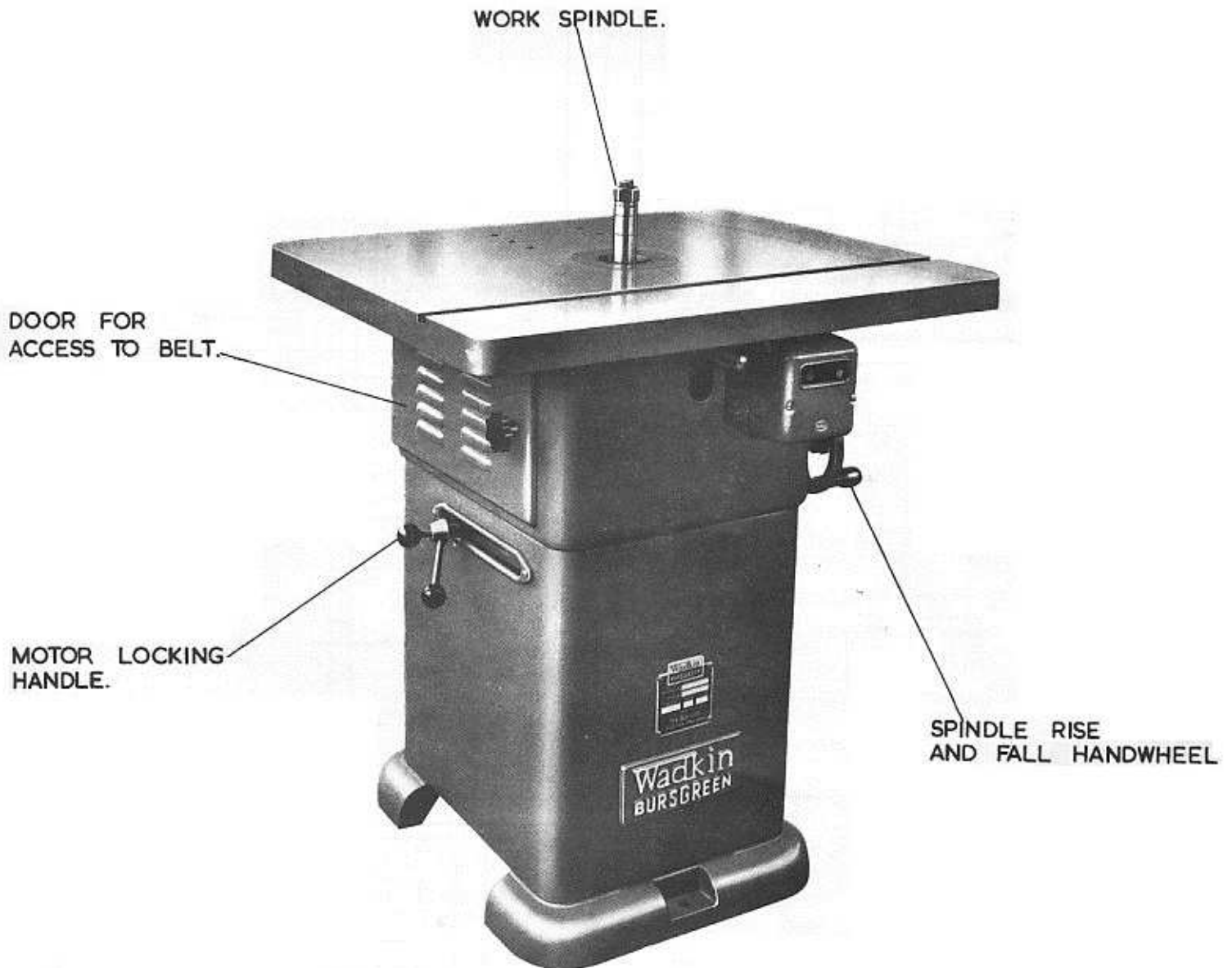


FIG. 1.

S P E C I F I C A T I O N

Standard diameter of top piece..	3/4"	20 mm
Size of table	30" x 24"	760 x 610 mm
Speed of spindle.	7,000 & 10,000 r.p.m.	
Alternative speeds to order	5,000 & 7,000 r.p.m.	
Rise and fall of spindle...	2"	50 mm
Height of table from floor	33 1/2"	850 mm
Horsepower of motor (3 phase)...	2	2
Speed of motor...	3000 r.p.m. - 50 cycles	36000 r.p.m. - 60 cycles
Floor space.	30" x 24"	760 x 610 mm
Net weight..	350 lb.	160 kg.
Gross weight	500 lb.	225 kg.
Approx. shipping dimensions	22 cu. ft.	0.60 cu.m.

INSTALLATION

Remove protective coating from bright parts by applying a cloth soaked in paraffin, turpentine or other solvent.

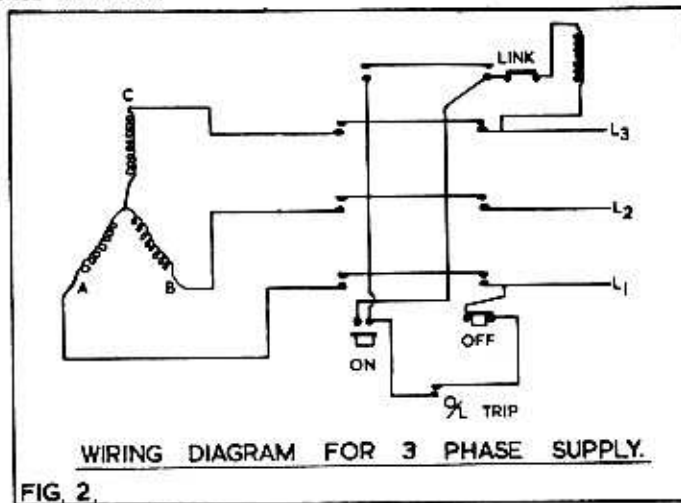


FIG. 2.

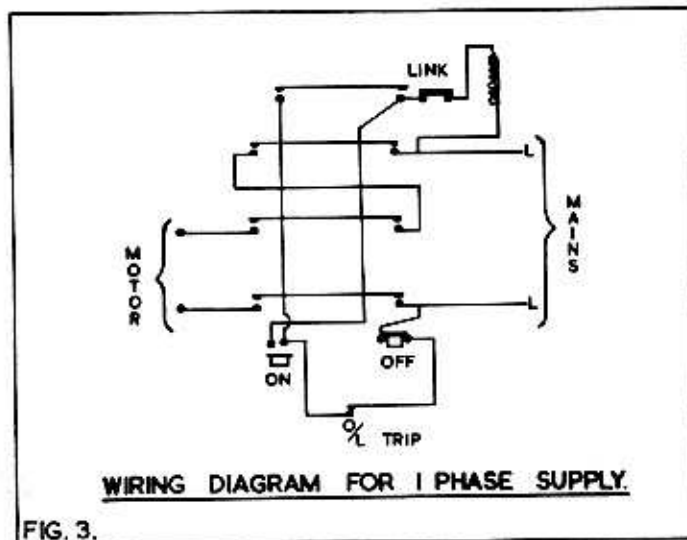


FIG. 3.

WIRING DETAILS.

The motor and control gear have been wired in before despatch. All that is required is to connect the power supply to the starter.

Points to note when connecting to power supply:-

1. Check the voltage, phase and frequency correspond to those on the motor plate, also the correct coils and heaters are fitted to the starter.
2. It is important that the correct cable is used to give the correct voltage to the starter as running on low voltage will damage the motor.
3. Check the main line fuses are of the correct capacity. See list below.
4. Connect the line leads to the appropriate terminals. See Fig. 2 for three phase supply. See Fig. 3 for single phase supply.
5. Check all connections are sound.
6. Check the rotation of the motor for the correct direction. If this is incorrect on three phase supply reverse any two of the line lead connections.

VOLTS	PHASE	S.W.G. TINNED COPPER WIRE	AMPS
220	3	24	17
340/420	3	25	15
550	3	29	10
200/250	1	19	38

LUBRICATION

It is advisable to keep all bright parts covered with a thin film of oil to prevent rusting.

TYPE OF OIL RECOMMENDED	POWER EM 125
TYPE OF GREASE RECOMMENDED	SHELL ALVANIA 3.

FOUNDATION

See Fig. 5 for bolt positions and clearance required. When installing the machine level the table by packing under the feet.

Foundation bolts are not supplied with the machine except by special order.

Sealed for life bearing on spindle require no lubrication.

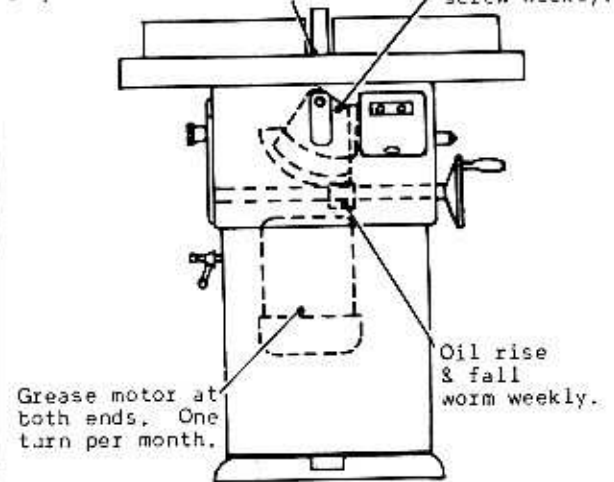


FIG. 4.

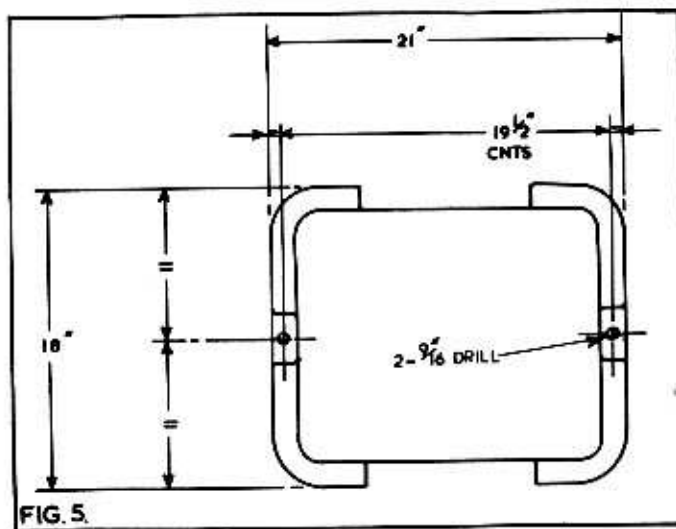


FIG. 5.

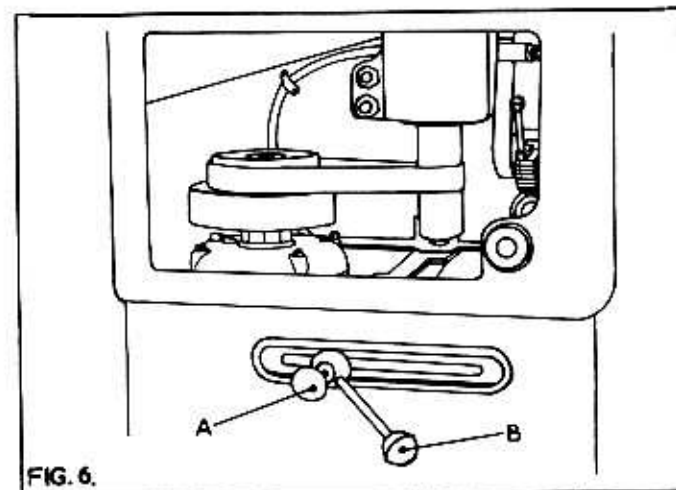


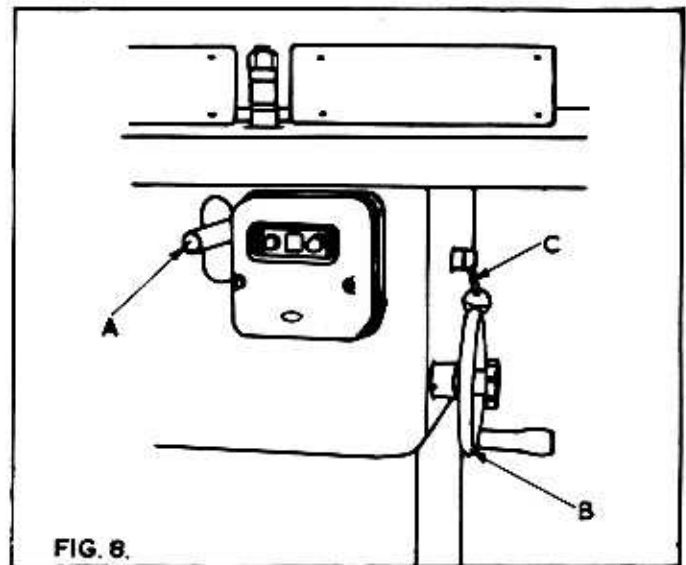
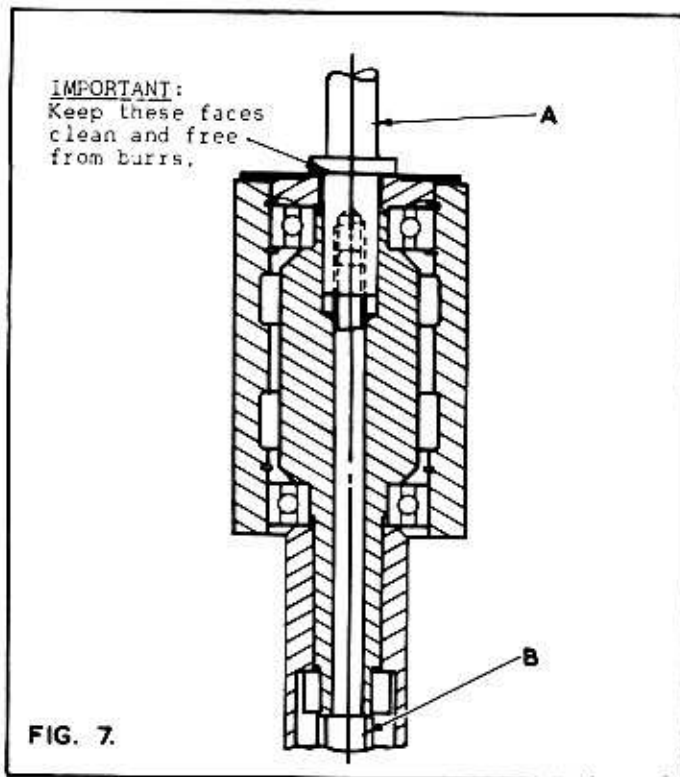
FIG. 6.

BELT TENSION

The drive of this machine is by means of an endless flat belt from a 2 HP motor mounted on a hinged bracket inside the base of the machine. A hand lever removes the tension on the belt for changing the speed of the machine.

TO CHANGE THE SPEED THE UNDERMENTIONED PROCEDURE SHOULD BE FOLLOWED.

1. Open the door on the left hand side of the machine for access to the pulleys.
2. Remove the tension on the belt by unscrewing the ball handle "B" (right hand thread) as shown in Fig. 6 and move the handlever "A" along the slot towards the front of the machine.
3. Select the required speed and re-tension the belt by moving the handlever "A" along the slot away from the front of the machine.
4. When the required tension is reached re-tighten the ball handle "B".



RISE AND FALL OF SPINDLE.

The spindle rise and fall is by means of the hand-wheel "B" in Fig. 8.

The rise and fall of the spindle is obtained through a wormwheel on a racked quadrant and has a maximum travel of 2".

The height of the spindle can be efficiently locked in any position of its travel by means of the locking lever "C".

Whilst the rise and fall movement of the spindle provides an immediate adjustment to the cutter height, further adjustment outside the range of this can be effected by re-positioning the collars on the work spindle.

The spindle should be rotated by hand when the belt is fitted before raising or lowering the spindle, to prevent excessive stretch on the belt.

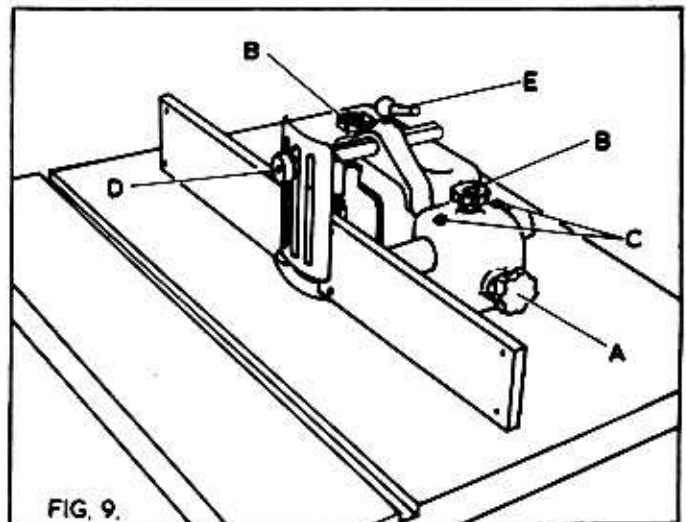
WORK SPINDLE INSTALLATION

Before inserting the work spindle, select which of the three table ring openings you require. The two removable rings give hole sizes of $4\frac{3}{8} \times 3\frac{1}{2}$ " and $2\frac{3}{8}$ " dia.

To insert the work spindle the undermentioned procedure should be followed:-

1. Insert the work spindle "A" in Fig. 7 into the main spindle through the hole in the table top. Great care should be taken to see that the work spindle seatings and the main spindle seatings are completely free from all burrs, dirt and rust. A thin film of oil should be put on the work spindle seating before inserting. Line the peg in the work spindle with the slot in the main spindle and press spindle onto seating.
2. Open access door on left hand side of the machine.
3. Lock main spindle as described in the following section.
4. Insert the spindle drawbolt "B" up the centre of the main spindle into the end of the work spindle and tighten.

NOTE: Drawbolt thread is right hand.
The spindle is now ready to receive the cutter equipment, etc. as required.



FULLY ADJUSTABLE FENCE, TYPE 3

Each fence plate can be independently adjusted by means of the plastic handwheels "A" in Fig. 9. The fence plates can be set to the desired amount and locked in position by the plastic handwheels "B". The front fence plates can be made either of metal or wood and are adjustable endwise.

The fence slide bars rest in accurately machined vee grooves and are held in position by the two brass grub screws "C" on each bar. If the slide bars become slack adjust the grub screws "C" by the required amount and relock in position with the $\frac{1}{8}$ " whit. locknuts. The fence plates should be locked both ways at all times when the machine is in use.

The fence is fitted with a safety guard and a "Shaw" guard can also be fitted if required.

The safety guard is adjustable depending on the section of timber being worked. This guard is shown in position in Fig. 9. To adjust the guard for various sections of timber unscrew the knurled knob "D", set to required position and relock the knurled knob "D".

To adjust the safety guard in relation to the fence plates unscrew the two ball lever screw "E", position the safety guard and relock.

SPINDLE LOCK

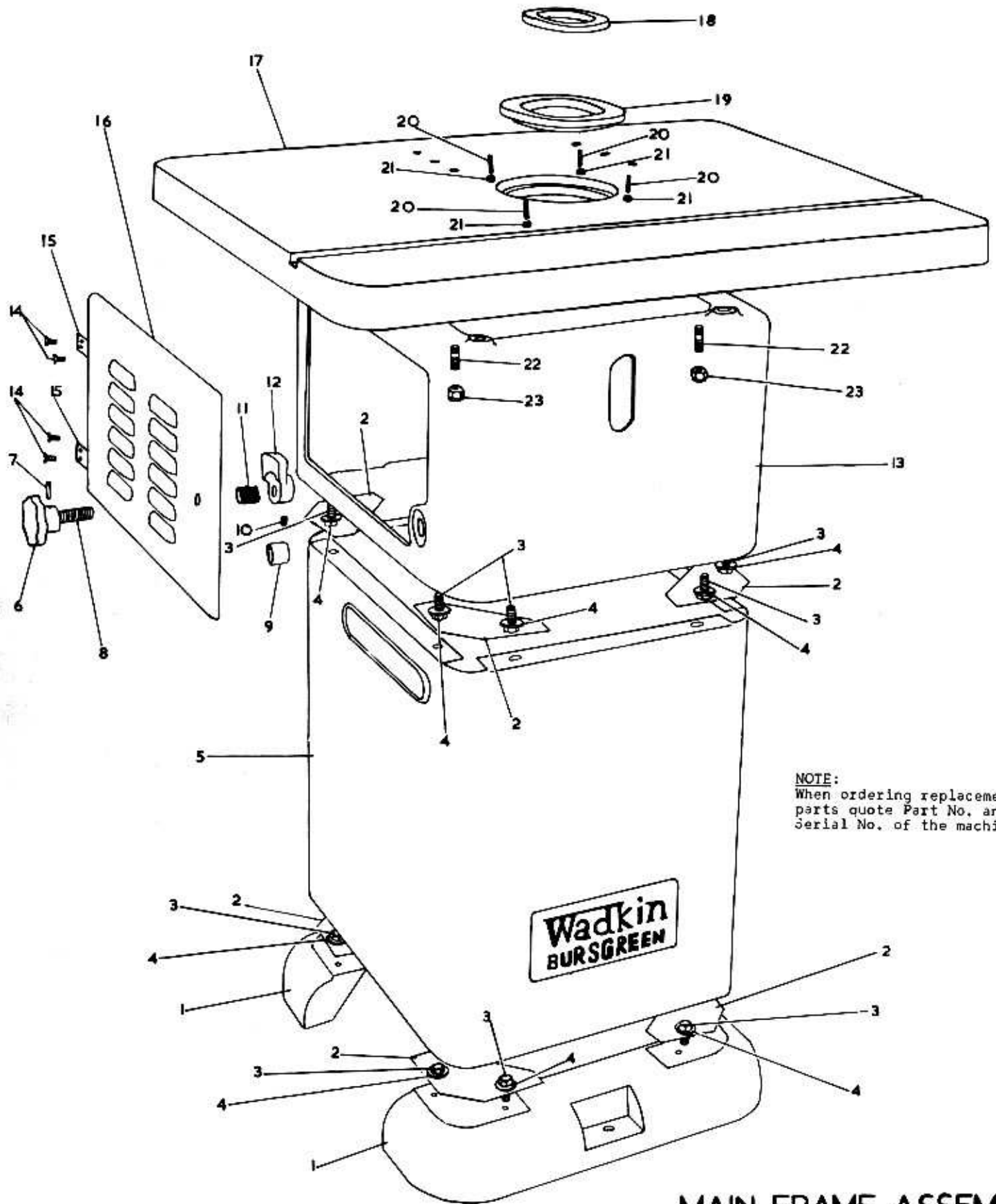
The spindle can be locked by means of the handle "A" in Fig. 8.

To lock the spindle the undermentioned procedure should be followed:-

1. Apply pressure to the handle "A" until it touches the main spindle.
2. Rotate the spindle by hand until the handle "A" drops into a hole in the main spindle. Turn handle "A" through 90° and release the pressure. The main spindle is now locked in position and the work spindle can be removed or cutter equipment mounted as required.

To unlock the spindle apply pressure to the handle "A" and rotate until the handle springs clear of the main spindle. Check the spindle is free to rotate by hand before starting the machine.

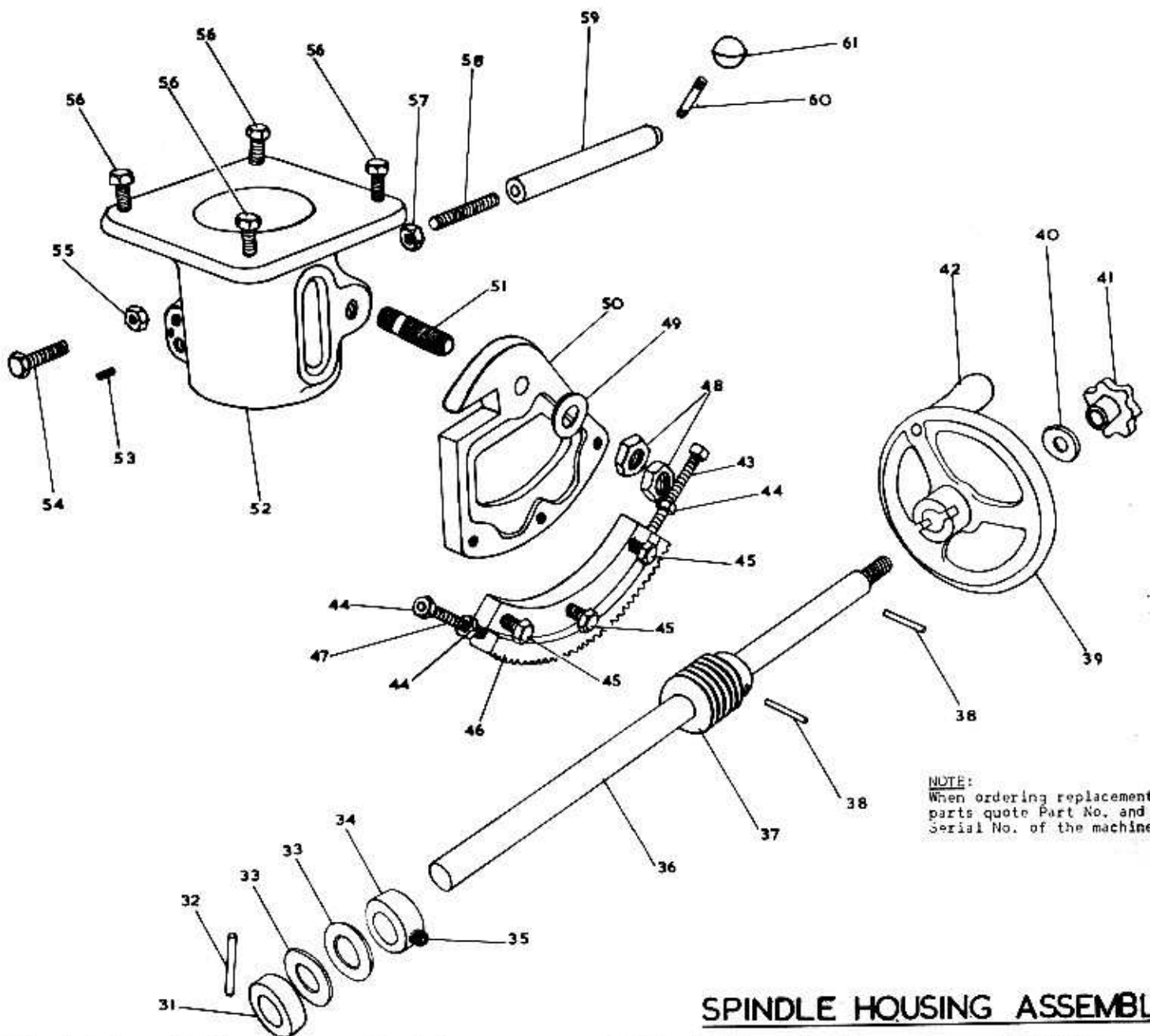
The spindle should be unlocked at all times before attempting to start the machine.



NOTE:
When ordering replacement parts quote Part No. and Serial No. of the machine.

MAIN FRAME ASSEMBLY

Ref. No.	Part No.	No. off.	Description	Ref. No.	Part No.	No. off.	Description.
1.	C-1038/6	2	Foot for base.	12.	A-1037/15	1	Door cam.
2.		8	Fillet for base.	13.	D-1039/1	1	Main frame.
3.		17	$\frac{3}{8}$ " whit. x $\frac{1}{4}$ " long hex. head cadmium bolt.	14.		4	$\frac{3}{16}$ " whit. x $\frac{1}{2}$ " long countersunk screw.
4.		17	$\frac{3}{8}$ " cadmium washer.	15.		2	1" back flaps.
5.	D-1039/17	1	Base.	16.	C-1029/18	1	Door for main frame.
6.	Patt.No.14	1	2" dia. plastic handwheel, $\frac{1}{2}$ " plain bore.	17.	D-1039/2	1	Table.
7.		1	$\frac{3}{16}$ " dia. x $1\frac{1}{4}$ " long groverlok spring dowel.	18.	B-1039/9	1	Small table ring.
8.	A-1039/31	1	Door cam pin.	19.	B-1039/8	1	Large table ring.
9.		2	$\frac{3}{8}$ " bore x $\frac{1}{8}$ " o/d x $\frac{3}{8}$ " long oilite bush.	20.		4	$\frac{3}{16}$ " whit. x $\frac{3}{8}$ " long nicked and pointed grubscrews.
10.		1	$\frac{1}{4}$ " whit x $\frac{3}{8}$ " long Allen grubscrew.	21.		4	$\frac{3}{16}$ " whit. nut.
				22.		4	$\frac{3}{8}$ " whit. x $1\frac{1}{4}$ " long stud.
				23.		4	$\frac{3}{8}$ " whit. aerotight nut.

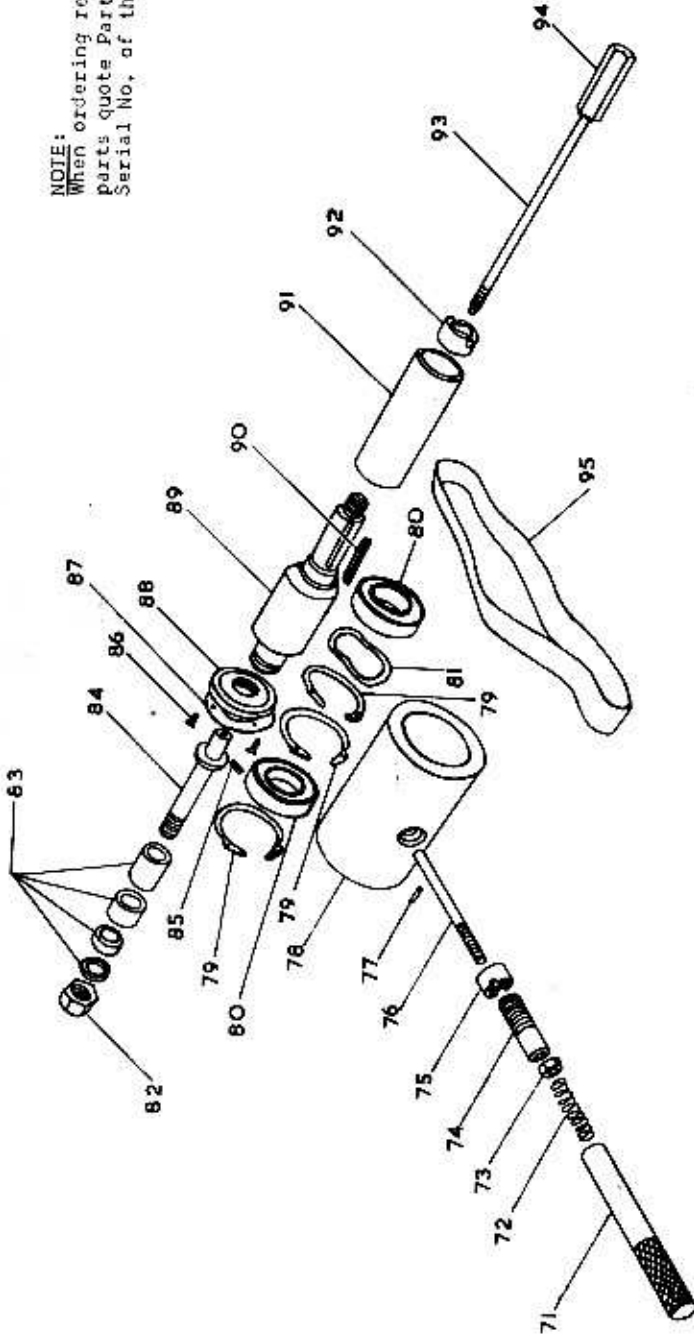


NOTE:
When ordering replacement
parts quote Part No. and
Serial No. of the machine.

SPINDLE HOUSING ASSEMBLY

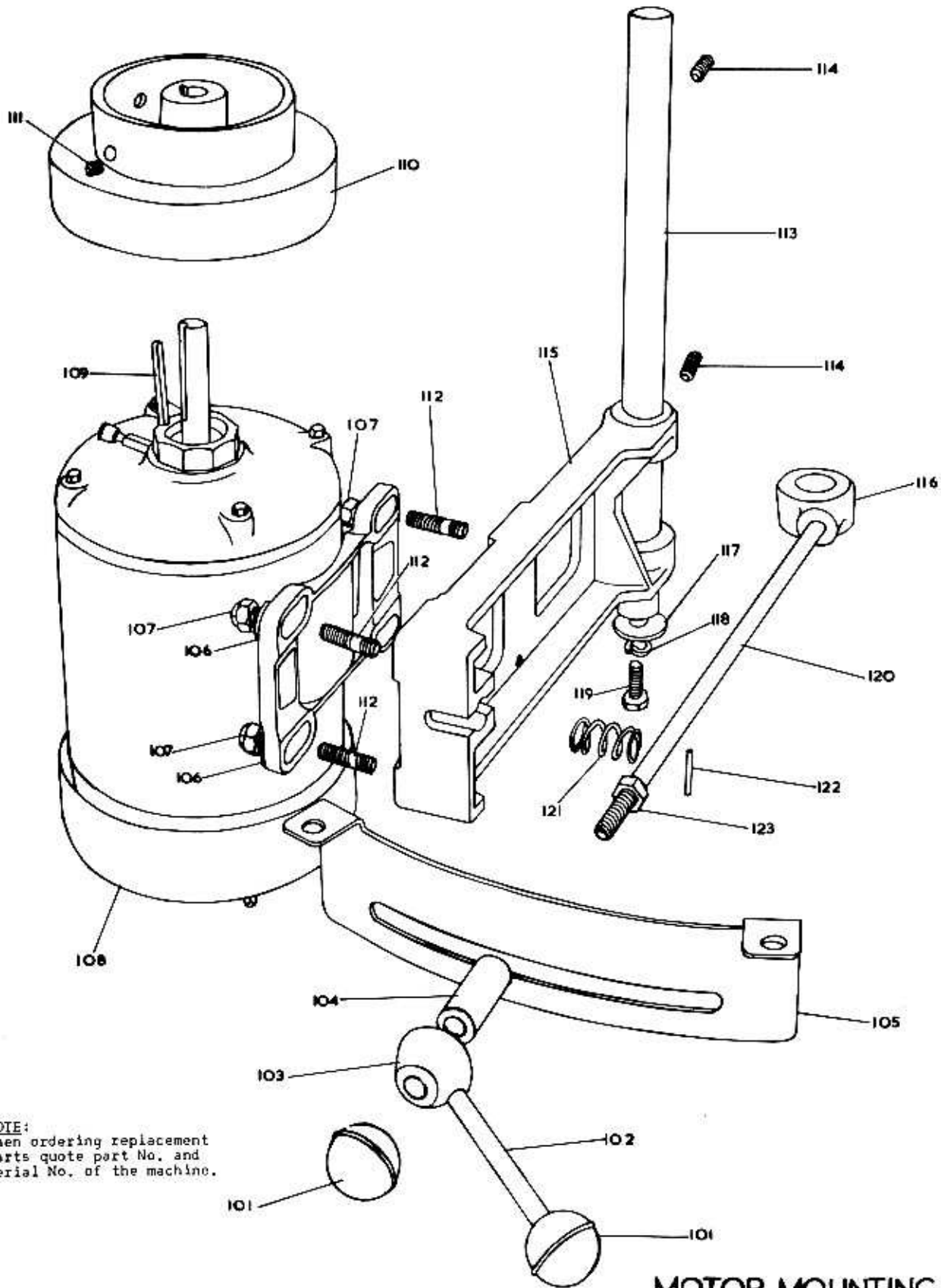
Ref.No	Part No.	No.off	Description.	Ref.No	Part No.	No.off	Description.
31.	A-1039/35	1	Collar for rise and fall shaft.	46.	B-1039/42A	1	Raked quadrant for rise and fall.
32.		1	3/16" dia. 1 1/8" long groverlok spring dowel.	47.		1	5/16" whit. x 3" long stud.
33.	A-1026/65	2	Fibre washer for rise and fall shaft.	48.		2	5/8" whit. locknut.
34.	A-1026/29	1	Collar for rise and fall shaft.	49.		1	5/8" washer.
35.		1	3/8" whit. x 3/8" long Allen grub screw.	50.	C-1039/5	1	Rise and fall bracket.
36.	B-1039/34	1	Rise and fall shaft.	51.		1	3/8" whit x 2 1/2" long stud.
37.	A-1026/32	1	Worm for rise and fall.	52.	D-1039/3	1	Rise and fall housing.
38.		2	3/16" dia. x 1 1/4" long groverlok spring dowel.	53.		1	1/4" whit. x 3/4" long Allen grub screw.
39.	B-1026/8	1	Rise and fall handwheel.	54.		1	5/16" whit. x 2 1/4" long hex. head bolt.
40.	A-1026/22	1	Washer for handwheel.	55.		1	1/2" whit. nut.
41.	Patt.No.14	1	2" dia. plastic handwheel, 1/2" whit. tapped right through.	56.		4	3/8" whit. x 1" long hex. head bolt.
42.	Patt.No. 4	1	3" long plastic handle.	57.		1	1/2" whit. lock nut.
43.		1	5/16" whit. x 1 1/2" long Hex. head bolt.	58.	A-1039/41	1	Stud for rise and fall lock.
44.		3	5/16" whit. nut.	59.	A-1039/63	1	Rise and fall locking shaft.
45.		3	3/8" whit. x 1" long Hex. head cadmium bolt.	60.	A-1038/33	1	Quill locking handle.
				61.		1	1 1/2" dia. plastic ball, 3/8" whit.

NOTE:
When ordering replacement
Parts Quote Part No. and
Serial No. of the machine.



SPINDLE ASSEMBLY

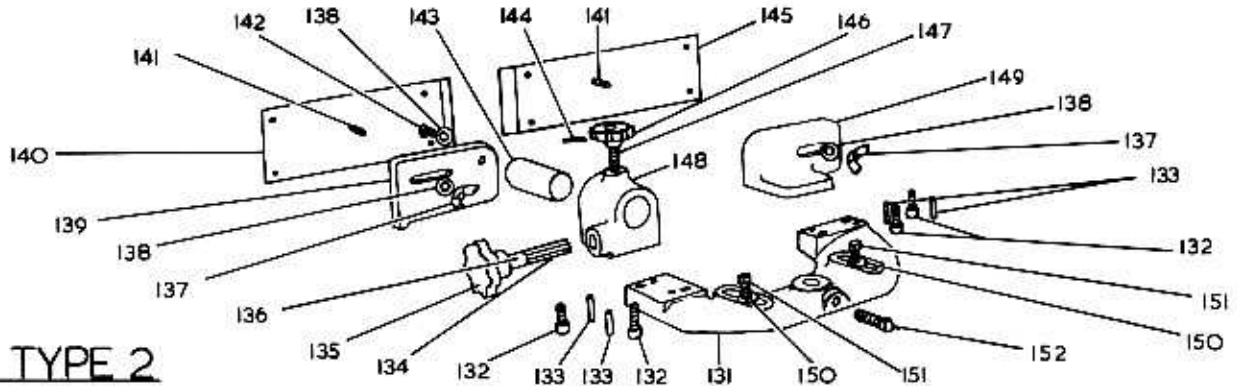
Ref. No.	Part No.	No. off	Description.	Ref. No.	Part No.	No. off	Description.
71.	A-1039/25	1	Handle for locking plunger.	90.	B-1039/21	1	1/4" wide x 2" long feather key.
72.	A-1033/196	1	Spring for locking plunger.	91.	B-1039/51	1	Spindle pulley for 10,000 and 7,000 rpm (3PH and 1PH, 50 cycles).
73.	A-1039/23	1	3/8" whit. nut		B-1039/52	1	Spindle pulley for 7,000 and 5,000 rpm (3PH and 1PH, 50 cycles).
74.	A-1039/22	1	Rise and fall peg for spindle quill.		B-1039/53	1	Spindle pulley for 10,000 and 7,000 rpm (3PH and 1PH, 60 cycles).
75.	A-1039/24	1	Rise and fall peg locknut.		A-1039/28	1	Spindle pulley locknut.
76.	A-1039/24	1	Locking plunger for spindle.		A-1039/43	1	Stud for work spindle drawbolt.
77.		1	3/8" dia. x 3/8" long groverlok spring dowel.		A-1039/44	1	Hexagon for workspindle drawbolt.
78.	C-1039/4	1	Spindle quill.	92.		1	Meteor flat belt 23 1/2" long x 1 1/2" wide for 10,000 and 7,000 rpm (3PH, 50 cycles).
79.	5008-243	3	62m/m Iiurac internal circlips.	93.		1	Meteor flat belt 24 1/2" long x 1 1/2" wide for 7,000 and 5,000 rpm (3PH, 50 cycles).
80.	6206-2P	2	SKF sealed for life bearings.	94.		2	Meteor flat belts 24 1/2" long x 1 1/2" wide and 20 1/2" long x 1 1/2" wide for 10,000 and 7,000 rpm (1PH, 50 cycles).
81.	A-1023/80	1	"Bump" Thrust washer.	95.		2	Meteor flat belts 25 1/2" long x 1 1/2" wide and 22" long x 1 1/2" wide for 7,000 and 5,000 rpm (1PH 50 cycles).
82.	A-1039/61	1	3/4" RH. BSF nut (Standard).			1	Meteor flat belt 24 1/2" long x 1 1/2" wide for 10,000 and 7,000 rpm (3PH 60 cycles).
83.	D-1792/22	1	20m/m workspindle nut (special).			1	Meteor flat belt 25 1/2" long x 1 1/2" wide for 7,000 and 5,000 rpm (3PH, 60 cycles).
	D-1792/22	1	spindle collars, 3/8" bore (Standard).			1	
		1	spindle collars, 20m/m bore (Special).			1	
84.	A-1039/78	1	Spindle collars, 3/8" bore (special).			1	
	A-1039/29	1	3/8" dia. work spindle (Standard).			1	
	A-1039/62	1	20m/m dia. work spindle (special).			1	
85.	A-1039/77	1	3/16" dia. work spindle (special).			1	
		1	3/16" dia. x 1/2" long groverlok spring dowel.			1	
86.		3	3/16" x 3/8" long countersunk head screw.			1	
87.	A-1039/73	1	Fliinger for spindle locknut.			1	
88.	A-1039/26	1	Top locknut for main spindle.			1	
89.	B-1039/20	1	Main spindle.			1	



NOTE:
When ordering replacement parts quote part No. and serial No. of the machine.

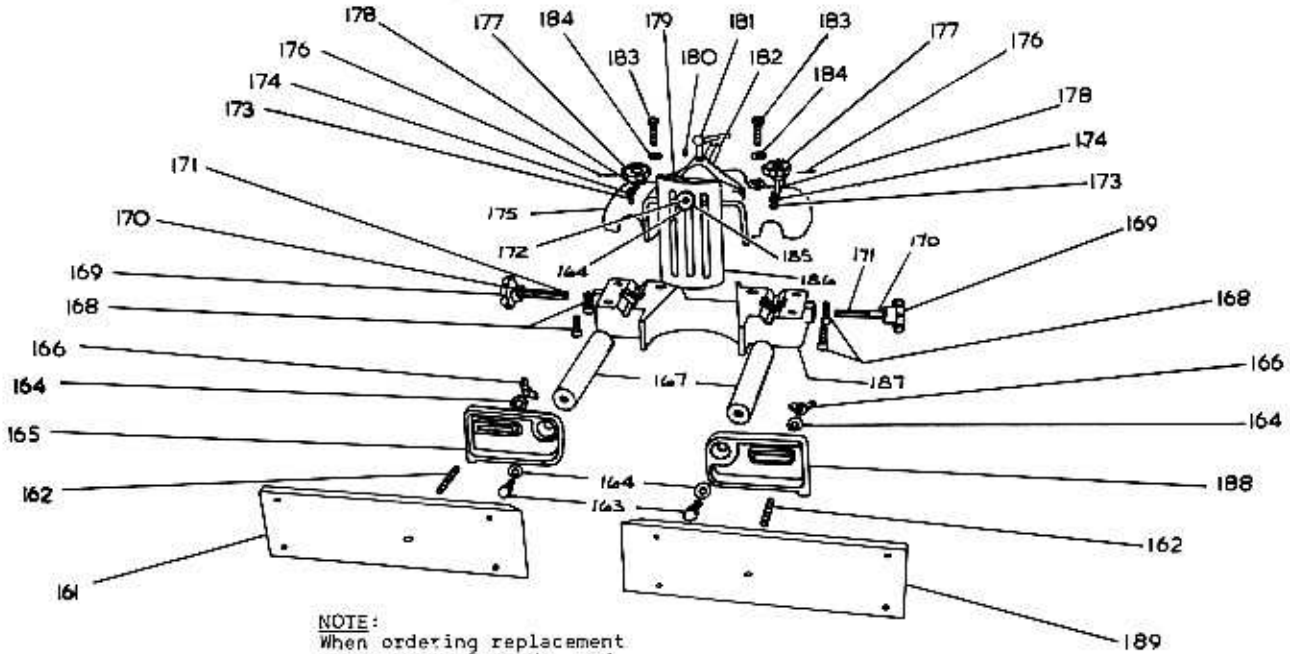
MOTOR MOUNTING ASSEMBLY

Ref. No	Part No.	No. off	Description	Ref. No.	Part No.	No. off	Description
101.		2	1 1/4" dia. plastic ball, 3/8" whit.	110.	B-1039/7	1	Motor pulley.
102.	A-1002/90A	1	Stud for motor pivot locking nut.	111.		2	3/8" gas x 1/2" long Allen grub screw.
103.	A-1039/79	1	Motor pivot locking nut.	112.		4	5/16" whit. x 1 1/8" long stud.
104.	A-1039/80	1	Distance piece for motor lock.	113.	A-1039/30	1	Motor pivot bar.
105.	C-1039/19	1	Adjusting bracket for motor.	114.		2	3/8" whit. x 1" long Allen grub screw.
106.		4	5/16" washer.	115.	C-1039/6	1	Motor platform.
107.		4	5/16" whit. aerotight nut.	116.	A-1039/45	1	Pivot boss for motor locking bar.
108.		1	Brook motor, T.14 TEFC 2HP 2840rpm 3PH, 50 cycle.	117.	A-1024/58	1	Washer for motor pivot bar.
		1	Brook motor, M.66 TEFC 2HP 2840rpm 1PH, 50 cycle.	118.		1	3/8" spring washer.
		1	Brook motor, T.14 TEFC 2HP 3480rpm 3PH, 60 cycle.	119.		1	3/8" whit. x 1" long hex. head bolt.
		1	Brook motor, M.66 TEFC 2HP 3480rpm 1PH, 60 cycle.	120.	A-1039/46	1	Motor locking bar.
109.		1	3/16" wide x 2" long feather key.	121.	A-1024/21	1	Motor pivot locking handle spring.
				122.		1	1/4" dia. x 1" long groverlok spring dowel.
				123.		1	3/8" whit. nut.



FENCE TYPE 2

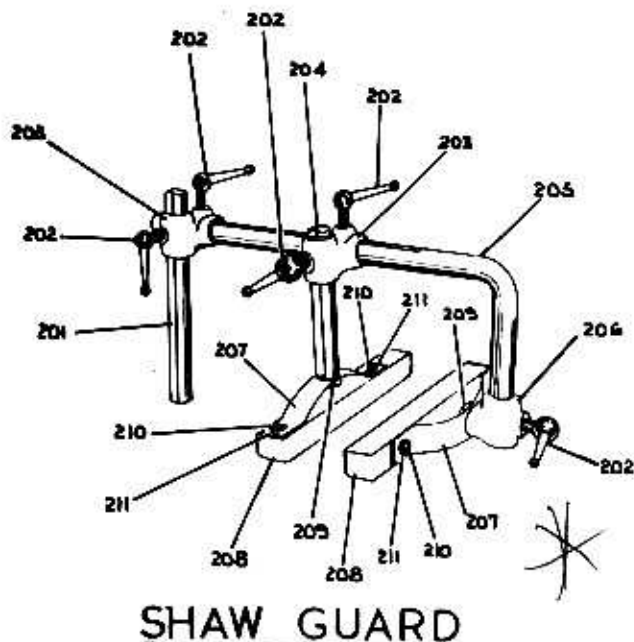
Ref. No.	Part No.	No. off	Description	Ref. No.	Part No.	No. off	Description
131.	C-1039/10	1	Fence Frame.	142.		1	3/8" whit x 1" long bolt.
132.		4	3/8" whit. x 3/4" long cup head Allen screw.	143.	A-1039/40	1	Fence rack bar (3 1/2" long)
133.		4	1/4" dia. x 1" long Groverlok dowels.	144.		1	1/4" dia. x 3/4" long groverlok spring dowel.
134.	A-1029/41	1	Fence adjusting pinion.	145.	B-1039/47	1	Fence front plate (left hand).
135.	Patt.No.14	1	2" dia. plastic handwheel, 5/16" plain bore.	146.	Patt.No.32	1	1 1/2" dia. plastic handwheel, 3/8" whit. bore.
136.		1	5/16" bore x 1/2" o/dia. and 3/4" long oilite bush.	147.		1	3/8" whit x 1 1/2" long brass stud.
137.		2	3/8" whit. wing nut.	148.	B-1039/58	1	Adjustment boss for fence.
138.		3	3/8" washer.	149.	B-1039/59	1	Fixed bracket for fence.
139.	C-1039/16	1	Fence front adjustment bracket (right hand)	150.		2	1/2" washer.
140.	B-1039/47	1	Fence front plate (right hand)	151.		2	1/2" whit x 1 1/2" long hex. head bolts.
141.		2	3/8" whit. x 1 1/4" long stud.	152.		1	3/8" whit x 1 1/4" long square head bolt.



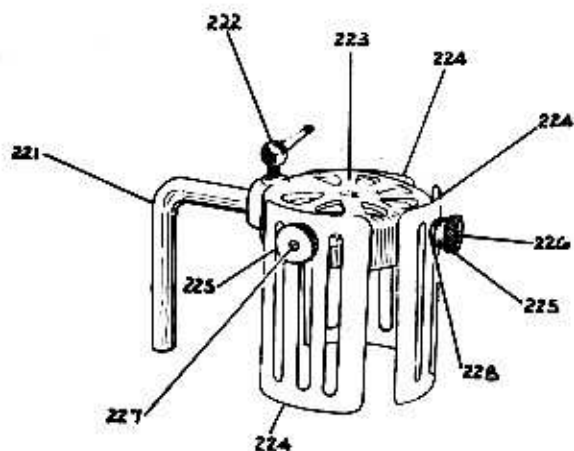
NOTE:
When ordering replacement parts quote Part No. and Serial No. of the machine.

FENCE TYPE 3

Ref. No.	Part No.	No. off	Description	Ref. No.	Part No.	No. off	Description
161.	B-1039/47	1	Fence plate (left hand).	175.	D-1039/15	1	Cover for fence.
162.		2	3/8" whit x 1 1/4" long stud.	176.		2	1/4" dia. x 3/4" long groverlok spring dowel.
163.		2	3/8" whit x 1" long hex. head bolt.	177.	Patt.No.32	2	1 1/2" dia. plastic handwheel, 3/8" whit. bore.
164.		5	3/8" washer.	178.		2	3/8" whit. x 1 1/2" long brass stud.
165.	C-1039/16	1	Fence front adjusting bracket (left hand).	179.	B-1039/32	1	Guard support casting.
166.		2	3/8" whit. wing nut.	180.		1	3/8" whit. x 1/2" long Allen grub screw.
167.	B-1039/40	2	Fence rack bar (7" long).	181.	B-S-1-B	1	3/8" whit. ball lever screw.
168.		4	3/8" whit. x 1" long cup head Allen screw.	182.	A-1039/55	1	Arm for guard.
169.	Patt.No.14	2	2" dia. plastic handwheel, 5/16" plain bore.	183.		2	1/2" whit. x 4 1/2" long hex. head bolt.
170.		2	5/16" bore x 1/2" o/dia. x 3/4" long oilite bush.	184.		2	1/2" washer.
171.	A-1029/41	2	Fence adjusting pinion.	185.	A-1029/59	1	Knurled knob for guard.
172.		1	3/8" whit. x 1" long stud.	186.	B-1039/33	1	Shield for guard casting.
173.		4	3/8" whit. x 1" long nicked brass grub screw.	187.	D-1039/11	1	Adjusting fence frame.
174.		4	3/8" whit. locknut.	188.	C-1039/16	1	Fence front adjusting bracket (right hand).
				189.	B-1039/47	1	Fence plate (right hand).



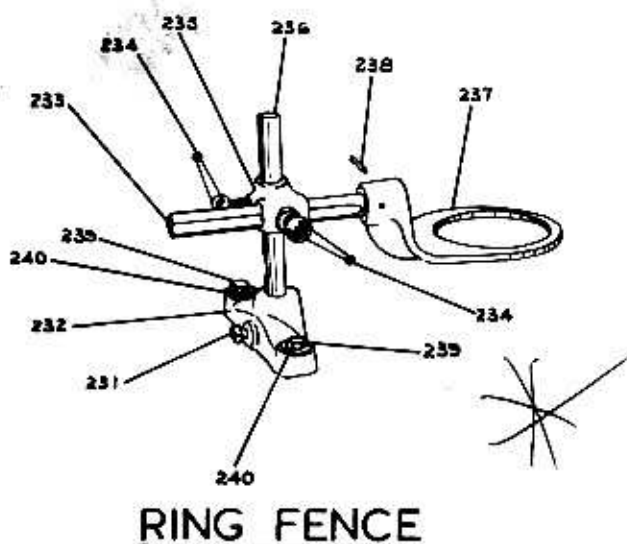
Ref.No.	Part No.	No. off	Description
201.	A-1039/38	1	Shaw guard column (only required for fences type 1 and 2).
202.	B-S-1-B	3	(For fence type 3) $\frac{3}{8}$ " whit. ball lever screw.
		5	(For fence type 1 and 2) $\frac{3}{8}$ " whit. ball lever screw.
203.	D-1792/65	1	(For fence type 3) $\frac{3}{4}$ " x $\frac{3}{4}$ " Filboe.
		2	(For fence type 1 and 2) $\frac{3}{4}$ " x $\frac{3}{4}$ " Filboe.
204.	A-1039/36	1	Shaw guard top pressure bar.
205.	A-1039/37	1	Shaw guard cantilever arm.
206.	A-1039/14	1	Front pressure bracket for Shaw guard.
207.	D-1792/45	2	Shaw guard pressure springs.
208.	D-1792/44	2	Wood shoes for Shaw guard.
209.		2	$\frac{5}{16}$ " whit. x $\frac{3}{4}$ " long hex. head bolt and spring washer.
210.		4	No. 8 x $\frac{1}{2}$ " long black japanned wood screw.
211.		4	$\frac{3}{16}$ " washers.



Ref.No.	Part No.	No. off	Description
221.	A-1039/39	1	Ring guard arm.
222.	B-S-1-B	1	$\frac{3}{8}$ " whit. ball lever screw.
223.	C-1039/12	1	Ring guard top piece.
224.	B-1039/33	3	Shield for ring guard.
225.	A-1029/59	3	Knurled knob for ring guard.
226.		1	$\frac{3}{8}$ " whit. x 1" long stud.
227.		2	$\frac{3}{8}$ " whit. x 1" long coach bolt.
228.		3	$\frac{3}{8}$ " washer.

RING GUARD

RING FENCE

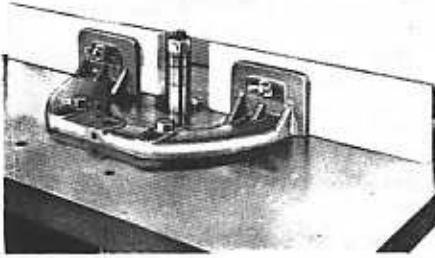


Ref.No.	Part No.	No. off	Description
231.		1	$\frac{3}{8}$ " whit. x $1\frac{1}{4}$ " long square head bolt.
232.	B-1039/13	1	Bracket for ring fence column.
233.	A-1039/54	1	Ring fence arm.
234.	B-S-1-B	2	$\frac{3}{8}$ " whit. ball lever screw.
235.	D-1792/65	1	$\frac{3}{4}$ " x $\frac{3}{4}$ " Filboe.
236.	A-1039/38	1	Ring fence column.
237.	D-1792/56	1	Ring fence.
238.		1	No. 3 taper pin.
239.		2	$\frac{1}{2}$ " whit. x $1\frac{1}{2}$ " long hexagon head bolt.
240.		2	$\frac{1}{2}$ " washer.

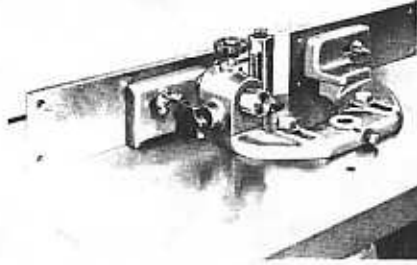
NOTE:

When ordering replacement parts quote Part No. and Serial No. of the machine.

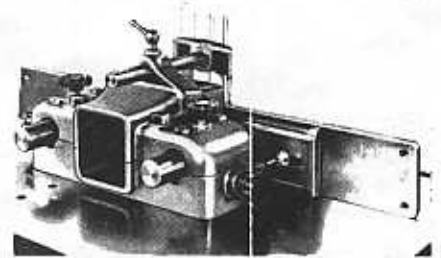
EXTRA EQUIPMENT



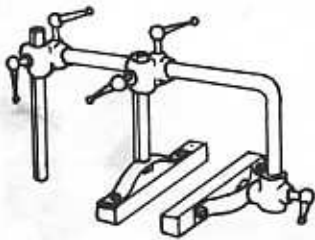
Type 1:- Plain horse shoe fence to take wood or metal front plates.



Type 2:- Horse shoe fence to take wood or metal front plates with the infeed side adjustable.



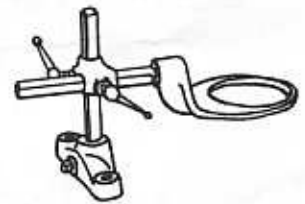
Type 3:- Combined fence, dust hood and guard with independent adjustment to both sides.



SHAW GUARD

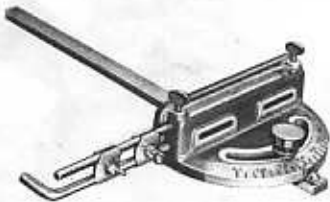


RING GUARD



RING FENCE

MITRE FENCE



Slotted collars 2 1/4" dia. for 1/2" thick cutters.



Collar type slotted French Spindle for 3/16" thick cutters.



Collett type router cutter adaptor.



3 1/2" dia. cutterblock



3 1/2" dia. Serrated back cutterblock type EZ272 1 1/4" thick.



Ball bearing slotted collar.



Ball bearing guide for QR type cutterblock



Router Cutters



4" dia. Dado set for grooves 1/8" to 5/8" wide.



4" dia. wobble saw to cut grooves 1/8" to 1/2" wide.



4" dia. Saw.

A FULL RANGE OF SOLID PROFILE CUTTERS CAN BE PROFITABLY USED



These solid profile cutters cut a true shape indefinitely; resharpening does not alter the original profile. No setting is required, they slip straight onto the spindle. May be used singly or stacked. Safest of all cutters in use.



No. 1 1" Square edge Cutter.



No. 10 1/2" Tonguing Cutter.



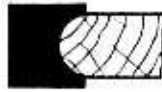
No. 11 1/2" Grooving Cutter.



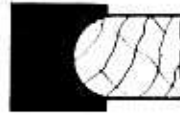
No. 12 Reversible Glue Joint.



No. 20 1/2" Rad. Ovolo Cutter.



No. 25 1" dia. Nosing Cutter.



No. 26 1" dia. Nosing Cutter.



No. 30 1" Rad. Cutter.



No. 35 1" Rad. Oggee Cutter.



No. 40 45° Angle Cutter.



No. 41 30° Angle Cutter.



No. 50 Table edge Cutter.

INSTRUCTION FOR REGRINDING PROFILE CUTTERS

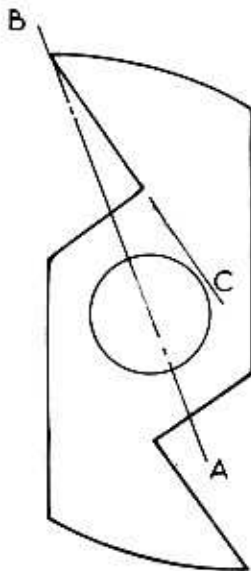


FIG. 1.

There are two methods of grinding these cutters.

1. With Precision tool grinder.

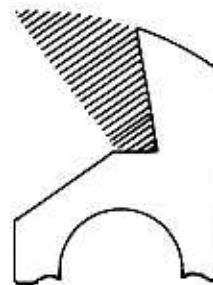
This method involves grinding the cutter on an arbor between centres. The machine should be set to grind the face of the cutter so that angle ABC, in Fig. 1 is the same after grinding as it was originally.

2. With hand or bench grinder.

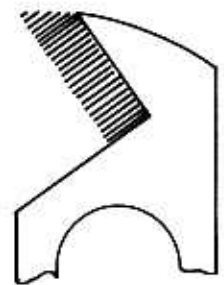
Before regrinding the cutters by this method ensure that the check chart supplied with the cutters is to hand. To check the angle of the cutters, place the new ground face, i.e. line BC, in Fig. 1, against that of the check chart and when the angle is correct the bore of the cutter should correspond to that of the check chart. This ensures that the correct angle is maintained at all time.

NOTES

1. A slight variation in the angle ABC, in Fig. 1 on opposite wings of the cutter is not too important, but for the best results avoid having the point "B" in Fig. 1 or its opposite on a different radius. This would cause one cutting edge to do all the cutting and would make the cutter out of balance and cause vibration.



CORRECT
FIG. 2.



WRONG
FIG. 3.

2. When making single cuts with more than one cutter in the set up always STAGGER the cutting edges rather than line them up. Doing this improves the quality of the work and reduces vibration and chatter. Staggered cutters require less power than "in line" cutters.

3. Cutters must always be ground in the root of the tooth, as shown in Fig. 2. never as in Fig. 3. Otherwise the cutters will drag or fail to cut the complete shape. Failure in observing this point results in weakening the tooth form and shortening the usable life of the cutter.

4. REGRINDING SERVICE

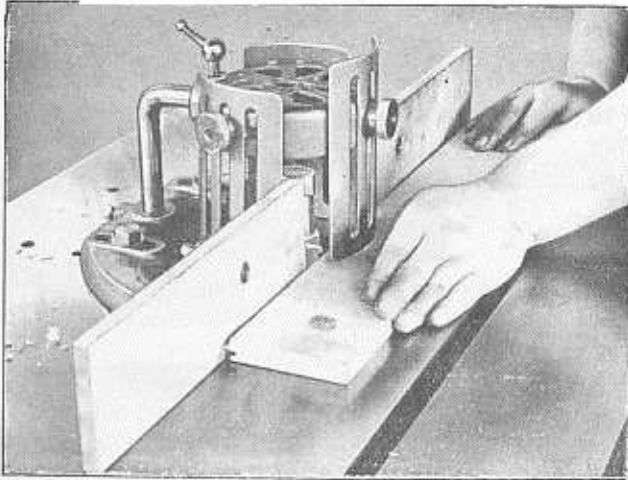
We offer precision regrinding service and the charges are moderate and the service prompt.

RETURN THE CUTTERS TO:

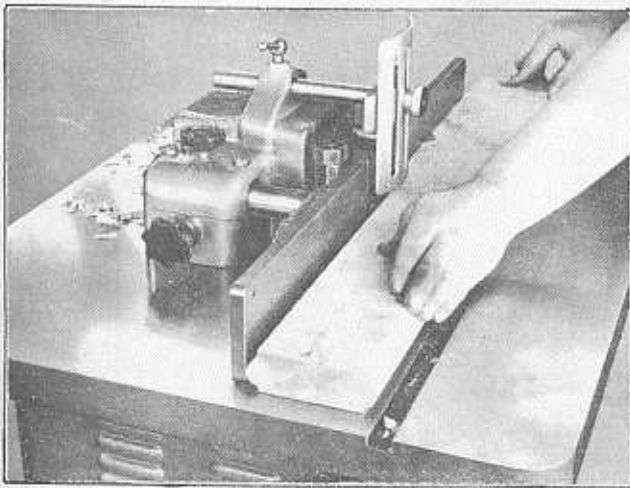
BURSGREEN (DURHAM) LIMITED,
FENCE HOUSES, HOUGHTON-LE-SPRING, CO. DURHAM, ENGLAND.

CAUTION

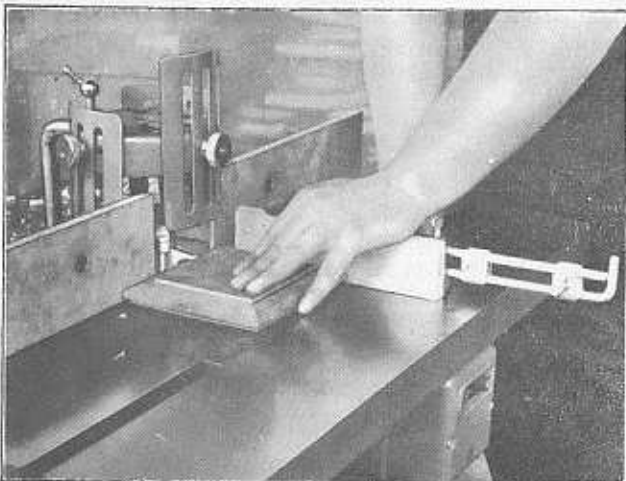
We do not recommend these cutters to be used on anything but short runs of plywood or resin bonded wood substitutes, because resinous glues used in making plywood etc. are extremely hard and abrasive. This causes the cutters to overheat and soften if not of the Tungsten Carbide Tipped variety. Write for prices of special tipped cutters for such materials.



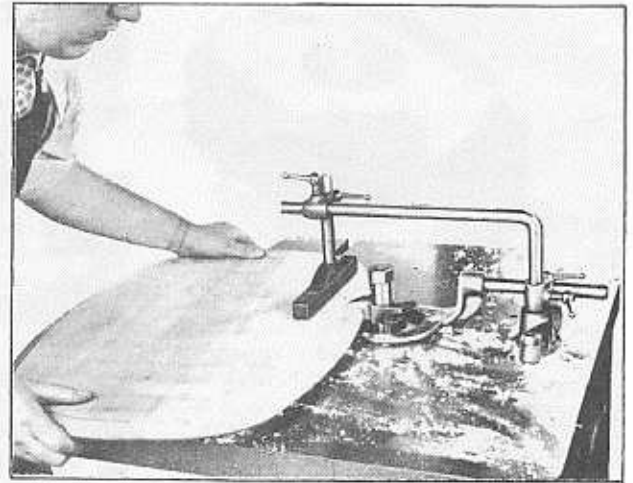
Machining a reversible glue joint using plain wood fence plates and universal guard. Cutter is a solid profile type No. 12.



This adjustable precision metal fence, combining dust hood and guard ensures maximum efficiency and safety on all straight work.



Small components such as this newel cap can be moulded with speed, accuracy and complete safety with the aid of the sliding fence shown.



Moulding table edge with solid profile Cutter No. 50, using template and ring fence with top pressure Shaw guard.



Shaping with slotted collars. (Universal guard removed to show detail).



Dovetailing can be easily and efficiently performed on this machine.