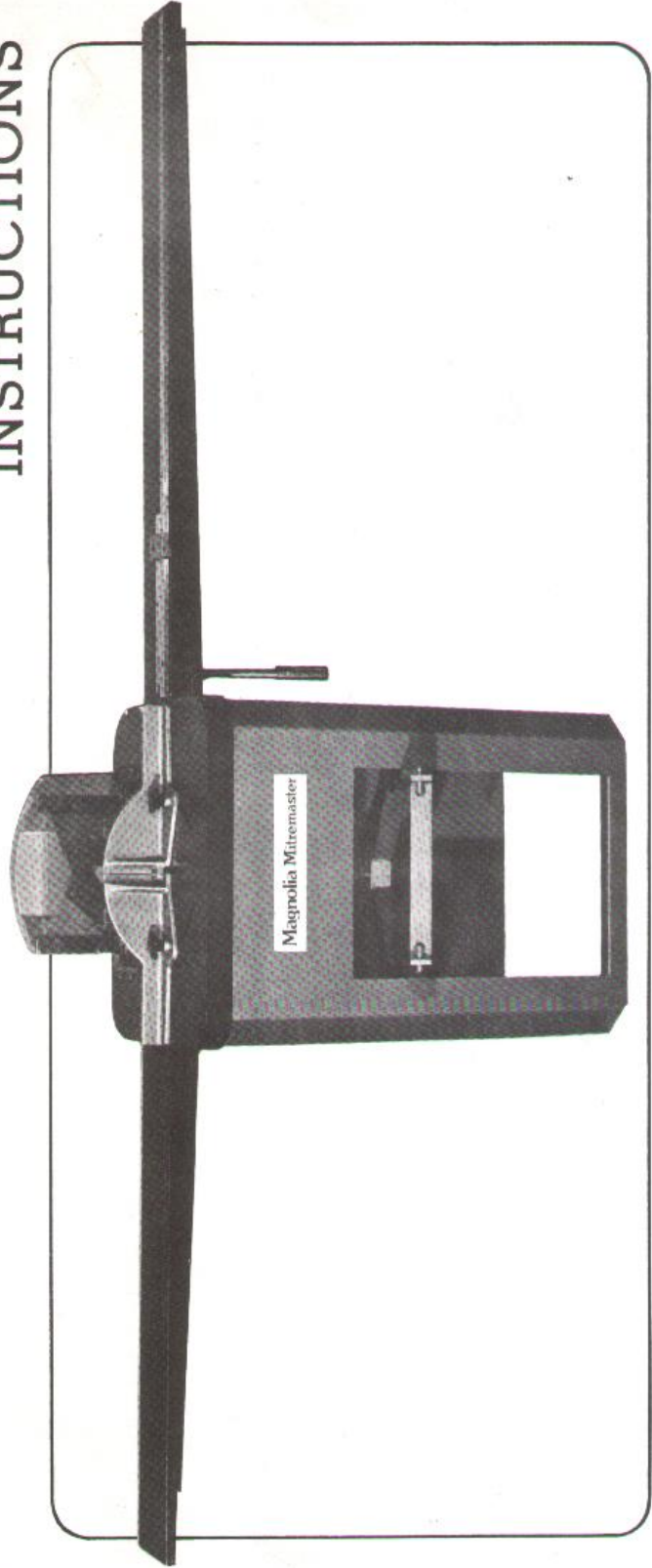
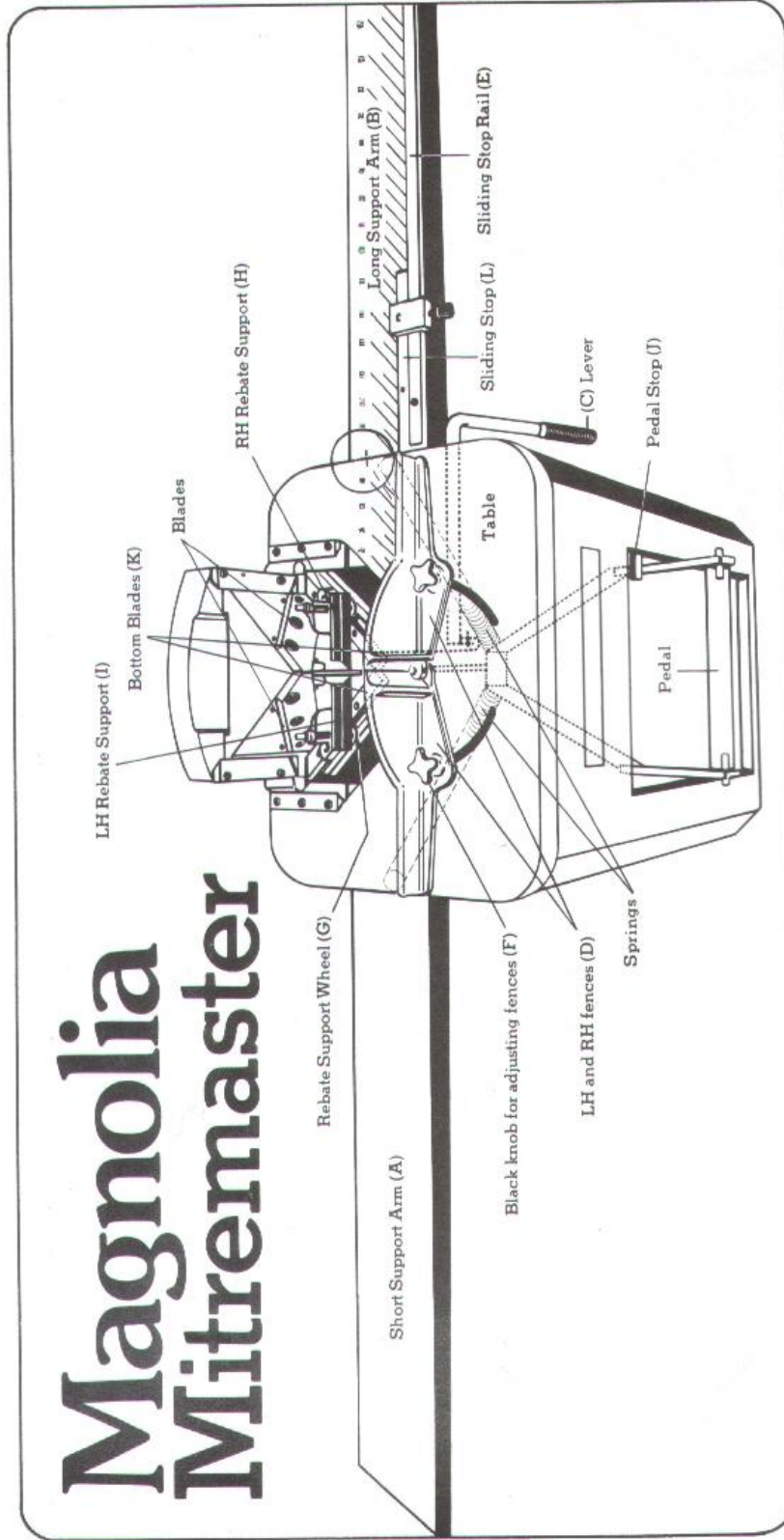


Magnolia Mitremaster

ASSEMBLY AND OPERATING
INSTRUCTIONS



Magnolia Mitremaster

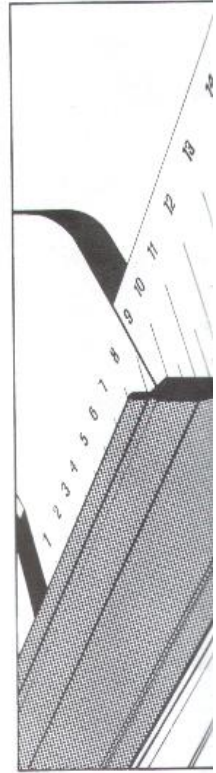


ASSEMBLY AND OPERATING INSTRUCTIONS

I ASSEMBLY INSTRUCTIONS

Ensure the machine is set on a firm, level floor. Fix the shorter support arm (A) to the left hand side of the machine; the longer arm (B) to the right hand side, checking that the alignment marks (see circled area in diagram) on the table of the

blade and fix it on right hand side of blade holder, and make bolts linger tight. Similarly fix other blade on left hand side of blade holder. Now adjust both blades carefully so that they are up against the two dowel pins on both sides of blade holder, and so that they are perfectly aligned at the V-point where they meet. When satisfied



machine and on the arm are in line. Ensure all bolts are completely tight, and check that the arms have not been bent or otherwise damaged in transit. Remove excess grease from bright metal parts with paraffin, and oil lightly.

2 SETTING UP

Your machine has been set for accurate cutting before leaving the factory, but if, after cutting and joining the first frame the joint is incorrect you should check the settings again as follows:

(a) Push down the lever (C) on right hand side of the machine so that the blades move to the back.

REMEMBER THE BLADES ARE EXTREMELY SHARP AND KEEP HANDS AND FINGERS AWAY FROM THEM.

(b) Take a 3 ft. (1 metre) or longer straight edge and lay it across the table of the machine, with the edge against the fences. (D) and the sliding stop rail (E) on the long support arm (B). Hold the straight edge firmly against the rail, and check that both fences are absolutely in line with the straight edge. If either fence is out of line, slacken off the corresponding black knob, (F) and bring the fence into line. Re-tighten the knob.

3 CUTTING

(a) Check that the small wheels (G) are in position under the rebate supports. If they are lost the supports will not move back freely.

(b) Practice moving blades backwards and forwards by pushing the lever (C) on right hand side up and down.

(c) Push the right hand rebate support (H) right back (i.e. away from you). Introduce a length of moulding from the left. Bring left hand rebate support (I) forward and adjust the height to fit snugly under the rebate of



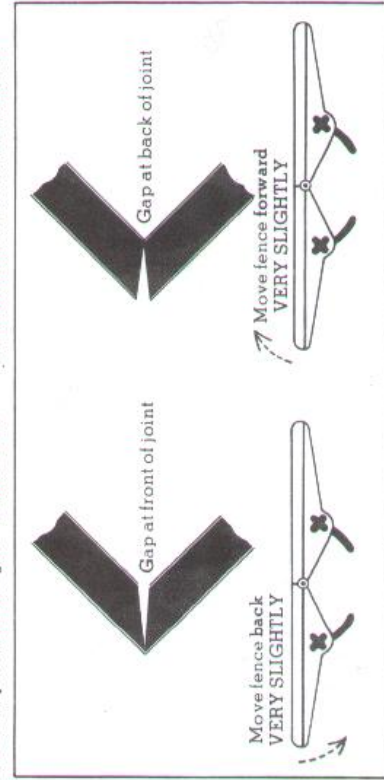
(8 or 10 cms) and cut 4 pieces. Hold the 4 pieces together as if making a frame. If the fourth joint shows a gap at either the front or back of the joint, you must make a **VERY SMALL** adjustment to the **LEFT HAND FENCE ONLY** as shown below.

Make another frame, and if necessary make further adjustments until a perfect result is achieved.

5 CHANGING BLADES
Normally only the front half of the blade is used, and they have been designed so that they can be reversed, in order to obtain double the life before they need completely re-sharpening. Follow this procedure:- Move blades to back position. Raise pedal stop (J) under pedal to secure blades to full cutting height and put spanner provided. Carefully remove right hand blade, and put down on left of machine. Remove left hand

4 CHECKING THE MITRE ANGLE

(a) Take a length of 3 in x 1 in (75 x 25 mm) board planed all round. Mitre the right hand edge of the board. Set the length stop at the shortest possible length - 3 in or 4 in



tighten the six bolts. Check that the bottom blades (K) are still close up against the cutting blades. If necessary use the Allen Key to loosen and re-position them as close to the moving blades as possible without causing the blades to bind.

6 BLADE SHARPENING

When the blades are suspected of being blunt, carefully check by running your thumbnail lightly up the sharp edge. You will feel any imperfections in the blade.

Blades need to be hollow ground on a jig. We offer a 24-hour sharpening service at the factory. Ideally blades should be bolted back-to-back on a piece of hardboard larger than the size of the blades. They must then be very heavily protected before posting.

Hints for Better Cutting

1. When cutting small mouldings save yourself effort by setting the pedal stop (J) for the pedal at a lower point.
2. The sliding stop (L) has three holes for you to adjust for very small and very large frames. The normal position is centre hole.
3. Make quite sure there are no nails in the moulding you cut. If you put a nick in a blade (identifiable by a noticeable line down the edge of the cut moulding), hone it out at once, as the tightness of your joint may be affected. In serious cases you will have to get the blades fully sharpened to remove the nick.
4. When cutting aluminium covered mouldings it sometimes helps to place a piece of square wood between the fence and the moulding to avoid indenting the aluminium. With flat mouldings it is even possible to cut them upside down.
5. Keep machine clear of wood chips, oil weekly with light oil in rebate support channel and all moving parts.

SPECIFICATION

Overall Height	41" (104 cm)
Height of Working Table	33" (84 cm)
Depth	24" (61 cm)
Overall Length	108" (274 cm)
Length of Left Hand Support Arm	36" (91 cm)
Length of Right Hand Support Arm	48" (122 cm)
Max. Width of Moulding	3 1/2" (8.9 cm)
Max. Height of Moulding	3" (7.6 cm)
Accessories - Box Spanner with Tommy Bar, 2 Allen Keys, 1 Pair Blades	

PARTS LIST

B002	Ratchet Shaft	Handlegrip
B063	Spring (Specify model No.)	Box Spanner
B070	Blades (pair)	Tommy Bar
B071	Blade Bolt	Knurled Nut, Long, for Rebate Support
B077	Fork	Knurled Nut, Short, for Rebate Support
B081/1	Bottom Blade L.H.	3/16" Allen Key for Bottom Blade
B081/2	Bottom Blade R.H.	5/32" Allen Key for Sliding Stop
B083	Fence L.H.	Oilite Bush 1" diameter (25.4 cm)
B084	Fence R.H.	Oilite Bush 3/8" diameter (15.9 cm)
	Fence Knob	Oilite Bush 3/8" diameter (9.5 cm)
B091	Rebate Support Block L.H.	Oilite Bush 1/4" diameter (6.4 cm)
B092	Rebate Support Block R.H.	Pedal Stop
B094	Rebate Support Wheel	
B098	Rebate Support Angle with Screw (L.H. or R.H.)	
B101/1	Rebate Casting L.H.	
B101/2	Rebate Casting R.H.	
B116	Rail	
B122	Sliding Stop	
B123	Saddle Casting	
	Engraved Support Arm R.H. (inches or metric)	
	Support Arm L.H.	



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