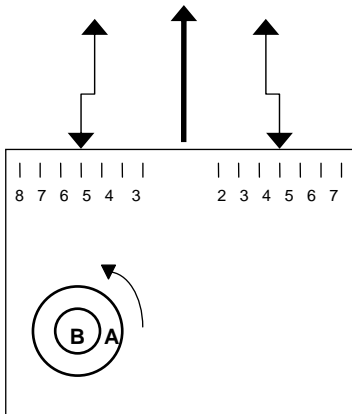
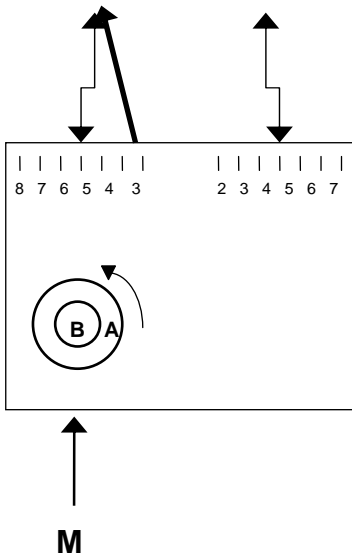


ALTERNAX MORTISING MACHINE

METHODE TO SET THE TOOLS

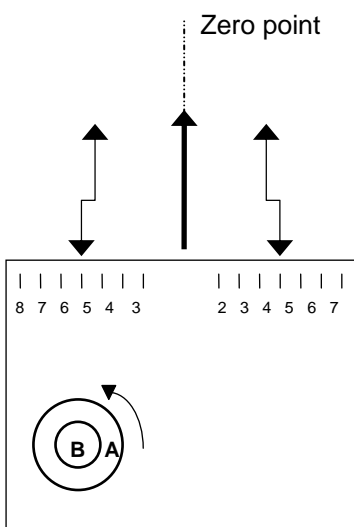


1/ The setting should be done, the operator placed at the rear of the machine.



2/ Turn A to bring the central tool to its maximum travel to the left side.

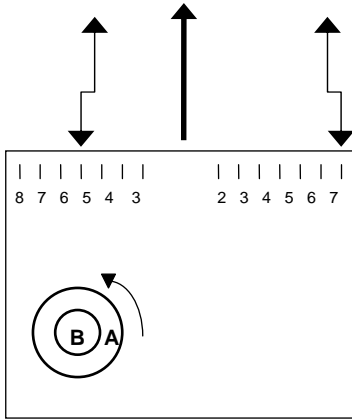
3/ Lock by pushing on M.



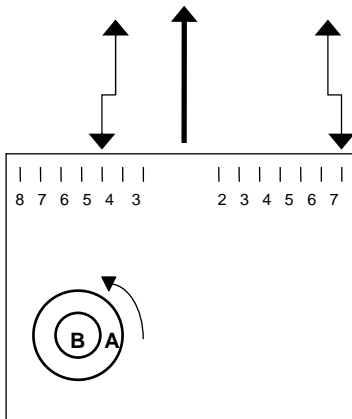
4/ Unlock B.

5/ Turn A in the way of the arrow to bring the central tool to the centre until it reaches its zero point.

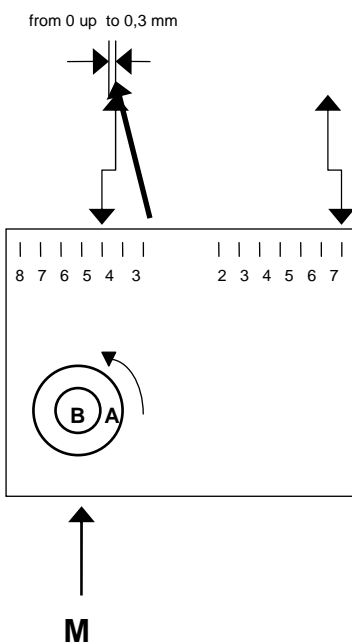
6/ Release M and do not touch A anymore.



7/ Unlock the handful of the carriage of the right lateral chisel and bring the carriage to its maximum travel to the right.



8/ Unlock the handful of the carriage of the left lateral chisel and bring the carriage to the dimension you want to realize (ex. 40 mm). Re-lock the handful.



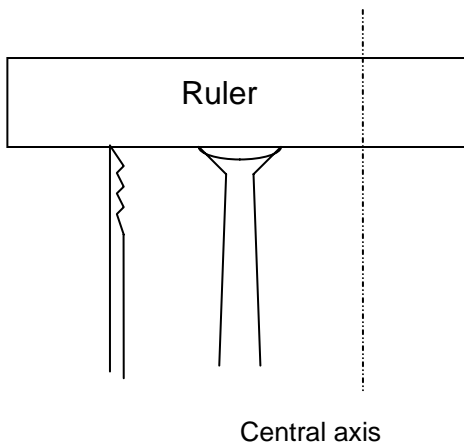
9/ Push on M.

10/ Turn A in the opposite way of the arrow to position the central tool to the left side until it reaches the left lateral chisel.

11/ Bring back slowly the central tool to the centre by turning A in the way of the arrow (this takes off the mechanical looseness). Make it over pass a bit compared to the left lateral chisel (0 mm for tools N°0 / 0,1 mm for tools N°1 / 0,2 mm for tools N°2 / 0,3 mm for tools N°3).

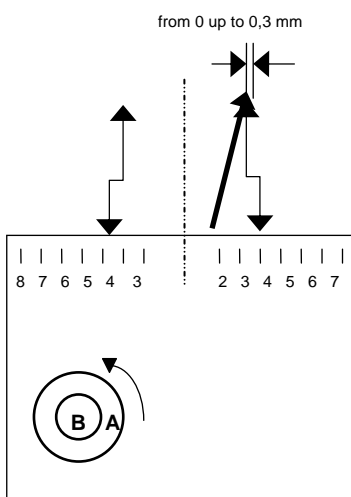
12/ Tie B.

13/ Release M.



14/ Proceed to the setting of the left lateral chisel compare to the central tool by using a small ruler. Placer the ruler flat on the face of the central tool and move A until you found the position where the left lateral chisel is the most forward compared to the ruler. Then unlock slowly the nut (screw) of the bolt that holds the chisel and bring the lateral chisel against the ruler. Put the lateral chisel even or lightly back compared to the central tool (0 mm for tools N°0 and N°1 / set back of 0,2 mm for tools N°2 and N°3).

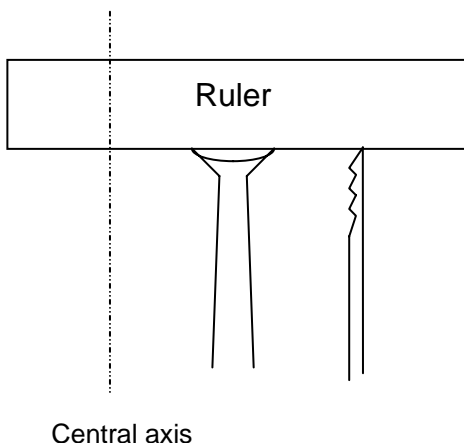
15/ Tie the screw of the bolt that holds the chisel.



16/ Bring the central tool to its maximum travel to the right.

17/ Bring the right lateral chisel to penetrate a bit to the inside right lip of the central tool (0 mm for tools N°0 / 0,1 mm for tools N°1 / 0,2 mm for tools N°2 / 0,3 mm for tools N°3).

Be careful ! Don't position the right lateral chisel by reading graduations.



18/ Proceed to the setting of the right lateral chisel compare to the central tool by using a small ruler (see point 14).

19/ Tie the nut of the bolt of the chisel holder.

20/ Before to machine any mortise, make sure everything is well tied (bolts of the chisel holders and central tool).