



*Quality for the world*

# CS 55M



Version 1 : 02 / 99

# Technical and User Manual

# WARNING

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**NEVER LEAVE YOUR FOOT  
ON THE PEDAL DURING ADJUSTMENT OPERATIONS  
NOR YOUR HANDS  
UNDER KNIVES OR CHIP SECTION**

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## **PUTTING INTO OPERATION**

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### 1) Fittings

- 1 x 17 mm monkey wrench
- 1 x 5 mm Allen wrench.

### 2) Table extension assembly



Make sure the both sides coming into contact are cleaned, especially in place of the two pins and of the threaded hole so that the table extension lies level with the table.

The presence of coarse dust particles should result in a faulty positioning of the extension table compared to the table.

### 3) Cleaning

After table extension is assembled, clean the machine with a petroleum impregnated mob or swab to dissolve the rust preventive.

### 4) How to use the machine

Cutting operation : never remove the protective screen



Before every cutting operation bring the protective screen as near as possible to the moulding to cut. Before pressing down and releasing the pedal, never forget to put the two hands on both sides of the shielding caps, on the moulding, far from the knives in order to get a sustained pressure on the moulding while maintaining rabbet ( rebate ) holders.

# CS 55 M OPERATION

## 1) Rabbet holders adjustment

### SELF ADJUSTING RABBET HOLDER



A) rabbet holder rod

B) locking screw

C) rabbet holder sash angle



Unlock locking screw (B), push down rod (A) to bring sash angle ( C ) close to cutting plane....



.....while maintaining the moulding flat on machine's table, then slip the support under the rabbet and release it...



Finally lock screw (B). It is essential to maintain the moulding until rod (A) is locked.

**It is absolutely essential to follow the procedure , then the rabbet holders must be adjusted so that the rabbet remains maintained at the time of cutting ; further more, the moulding shall not be raised by the rabbet holder to prevent defective cuts.**

## 2) Adjustment of the cutting head position

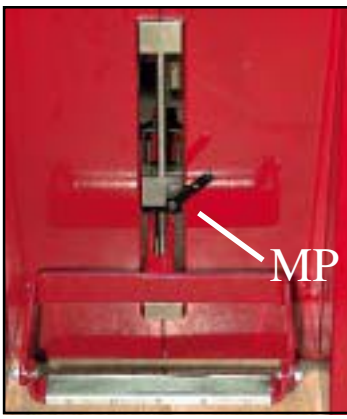
Handle (B) controls the cutting head position (TC).



When handle (B) located in the front part of the table is in right end position, the cut is carried out in a single pedal stroke.

In the event of a larger moulding with an important section, move handle (B) to the left to reduce cutting force.

The moulding cut can be carried out in several pedal strokes by changing the handle position (B) - that is to say the position of the knives - related to the guides (E) in front of which the moulding is being maintained.



The pedal can be adjusted at the required height.  
 While putting the foot on the pedal, release the operating handle (MP).  
 With the foot, release the pedal up to the height required.  
 Lock the handle again (MP).

## MACHINE MAINTENANCE

### 1) Cleaning

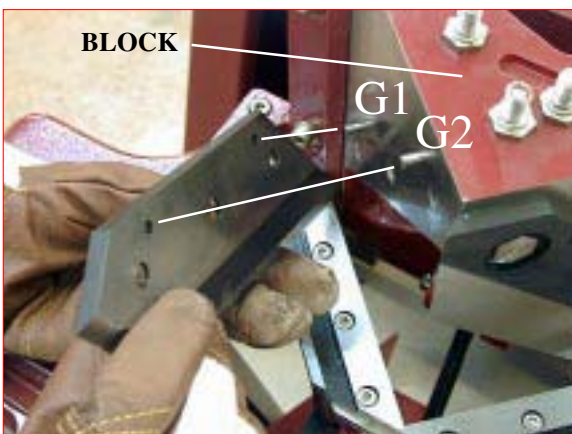
Push the knives back as far as possible ( operating handle B to the left, see page 2) and remove wood scraps which may be in the way of the rabbet holders when sliding, with a blow gun. The cleaning frequency depends on the installation conditions of the machine and on its use rate. We should recommend to carry out a maintenance once a day.

### 2) Knives grinding

The knives mounted on the machine are standard ( irreversible ) ones that have a larger cutting capacity. Customers are advised to permanently have two sets of knives for the machine at their disposal , one mounted on it and one as spare knives to prevent production breakdowns when a set of knives needs to be re-sharpened.

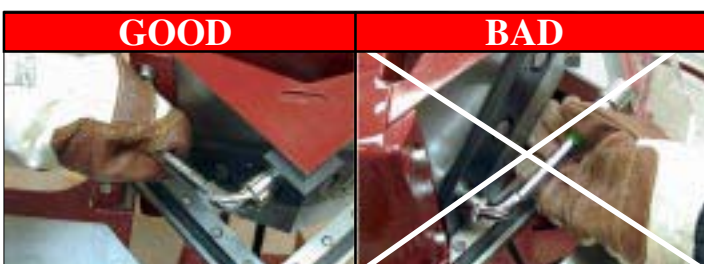
### 3) Knives replacement

The best way to replace knives is to change them the one after the other, so that the new knife is adjusted according to the old one. Then replace the second old knife .  
 Clean sides in contact to avoid the presence of coarse dust particles which might jeopardise the correct positioning of the knives.



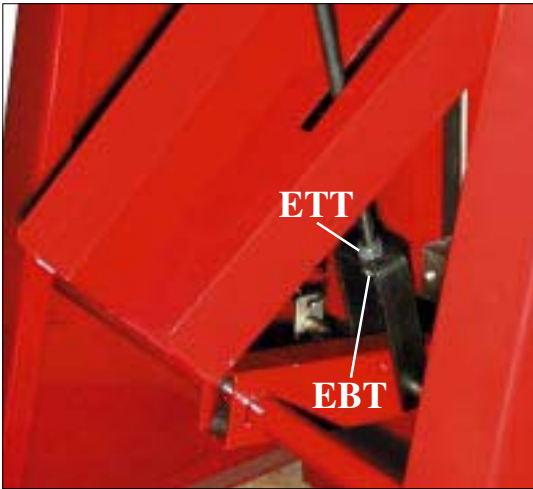
**WARNING : VERY SHARP KNIVES !  
 NEVER TOUCH KNIVES  
 WITH NAKED HANDS .  
 ALWAYS HANDLE KNIVES WITH  
 CONVENIENT GLOVES.**

When removing the knives, it is not necessary to support them because they are inserted in two pins G1 and G2 located in the **block**.  
 To reassemble the knives, put them onto pins **G1, G2** , replace the locking screws and press them against the block.



**It is mandatory to place the monkey wrench in such a position that the hand cannot come into contact with the cutting part of the knife.**





After many sharpening operations, knives might become too short, that means the position of the knife holder related to the pedal has to be adjusted. Press down the pedal and lock it with the aid of the operating handle (MP) ( see page 3).

Unscrew the adjusting nut (ETT) ( 19 mm wrench maintaining the con-rod located at the clamp top and screw on the nut (EBT) until the knife edge 4-6 mm projects from under the edge of the lower knives. Screw down the adjusting nut (ETT) against the bottom part of the clamp and drive in.

### TECHNICAL DATA

<b>Bevel cut</b>	45°
<b>Max. Width of cut</b>	- 85 mm (3 3/8") with reversible knife ( option) - 100 mm ( 4" )with irreversible knife ( standard)
<b>Graduations</b>	0 to max.100 centimetres ( 40" ) to the nearest 2.5 mm
<b>Dimensions</b>	H : 1070 mm x D : 650 mm x L : 2240 mm
<b>Weight</b>	80 kg ( 170 lbs )

### OPTIONS

Imperial measuring scales ( in inches )

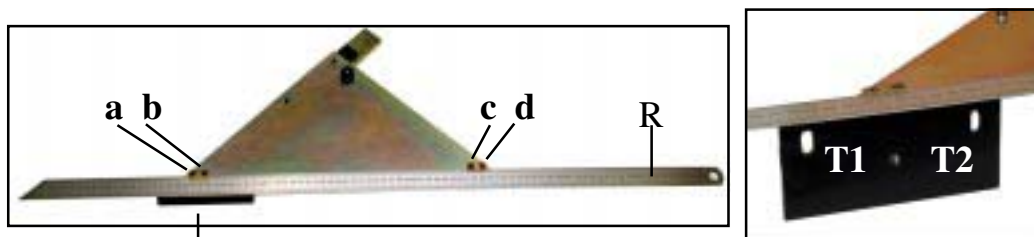
Exclusive measuring device at the rabbet bottom , to the nearest millimetre ( see below)

Reversible knives

Extension table, left side

Additional extension table, right side, with measurement device ( + 800 mm)( 32" )

### Optional measuring device assembly and adjustment



The measuring device is fixed by two threaded holes located on the back side of the table extension.

Before screwing down the two locking screws, make sure the whole triangle set surface is in contact with the table . Then unscrew screws **a, b, c, d** fixing the rule R .

Adjust meter position related to knives with the aid of a setting rule to replace missing graduation.

Refine the adjustment by carrying out a first cut and by shifting the meter rule the difference between the length displayed and the length resulting from the first cut.