

# PISTORIUS

## MACHINE CO., INC.

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## MODEL K PRECISION MITER CHOPPER

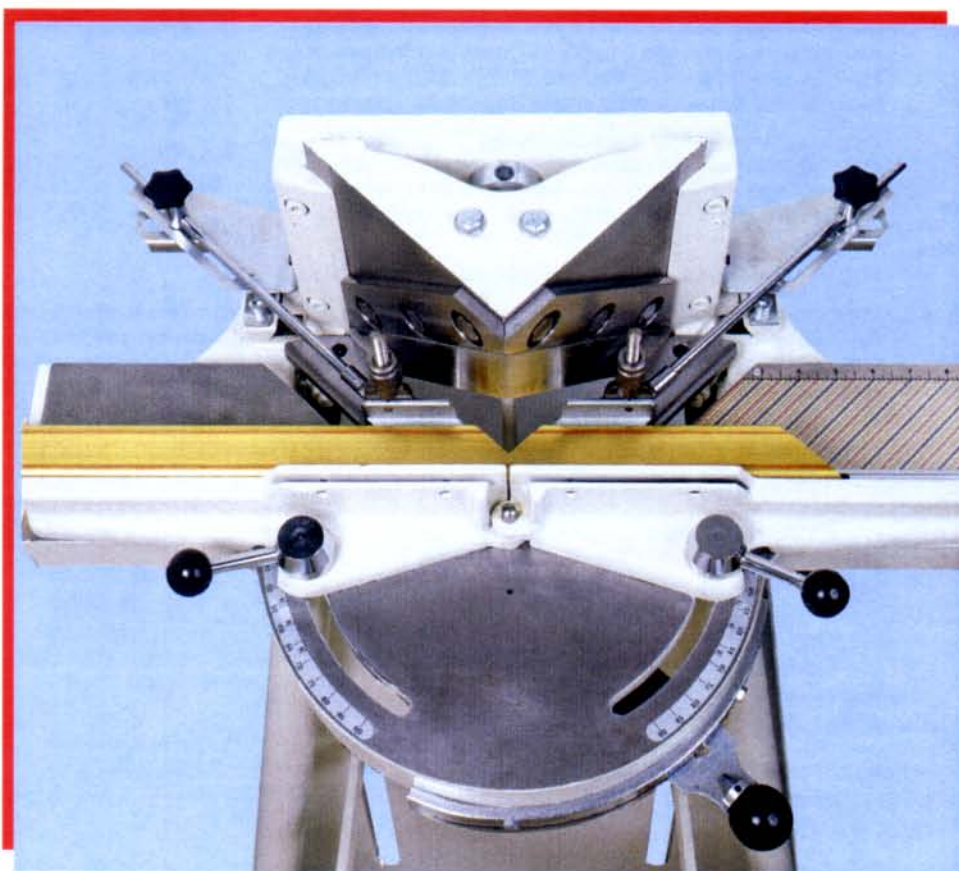
### DESCRIPTION

*Knife choppers are designed for mitering applications where purchase cost, operating noise and dust are a major consideration.*

*In woodworking, many applications exist requiring miters on simple, small profile mouldings such as used for glass bead, furniture decoration, etc. These mouldings can generally be cut more economically on the miter chopper as opposed to a double miter saw.*

### FEATURES

- No compressed air or electrics are required for standard model. Ideal for mall applications.
- Pneumatic model available for high production applications.
- Operation of machine is noise free and virtually maintenance free.
- Produces perfect miters on both hard and soft woods.
- Replacement parts and quality knife resharpening and honing service always available.
- Heavy duty cast iron and steel construction.
- Small investment for owner/operator.
- Cutting produces no dust.
- Wide range of available accessories.



Close up view illustrating cutting area of machine. Front and top safety guards are removed for illustration purpose

### USES

- Picture frames
- Certificate frames
- Promotional displays
- Cabinet doors
- Door lites
- Glass bead
- Clocks
- Mirror frames
- Medicine cabinets
- Furniture parts
- Linen liners
- Decorative grill works
- Jewelry boxes
- All kinds of trim
- Millwork
- Novelty items
- Window components

# MODEL KF, HEAVY DUTY MANUAL OPERATED KNIFE CHOPPER

- Optional infeed work support. Bolts to end of table casting with holes provided. 5 1/2" wide bed and 30" long. Supports moulding lengths on infeed of machine.
- Clear plastic front knife safety shields.
- Precision machined, cast iron work table.
- Knife advancement handle for progressive miter cuts. Spring tensioned, a series of pre-spaced notches on mating ring, assures the most suitable cutting increments. The last increment is one half the travel to provide a final parting planed cut.
- Cast iron two piece fences can adjust for miter angles other than 45 degrees. When using this standard feature, the gage scale and rabbet supports are not fully functional.
- Pedal adjustment allows quick setting for minimum knife height to suit profile being cut. Knives should always be kept as low as possible.
- Front sheet metal skirt keeps scrap away from operators' feet and prevents accidental pinching by foot treadle mechanism.
- Adjustable dove-tailed knife and head slides for wear adjustment. Always maintains accurate knife movement.
- Exclusive, tabbed, quick-adjusting, smooth-sliding screw type rabbet supports. Additional height adaptors available.
- Precision ground, nick and wear resistant knives, hardened to 56-58 Rockwell. Designed for long life and reduced chipping. Also fits Morso machines. Original specification resharpening and honing is factory available. Optional REVERSIBLE knives are also available that will provide double life between sharpenings.
- Automatic rabbet support width adjustment. The attachment automatically resets the rabbet support to the proper width of the moulding after each cutting cycle, eliminating hand repositioning. Ideal when a larger quantity of frames will be cut of the same moulding.
- Smooth-sliding positive locking stop with vee tongue to protect miter tips.
- Precision, color coded polycarbonate, *Visi Miter™* gage strip is standard on the knife choppers. Identical to the scales that are used on the double miter saws. Measuring lines are color coded for enhanced discrimination and size setting. Each line is numbered and calibrations between the inch lines are divided into 1/8" increments. The visual sighting method is used for measurements of rabbet length, tip to tip or inside.
- Adjustable top safety guard, provides operator protection from contact with the knives. The guard must be adjusted when changing moulding profiles. This standard guard is also available for all older models not so equipped.



Heavy duty cast-iron and welded steel components. Spare parts and service readily available.

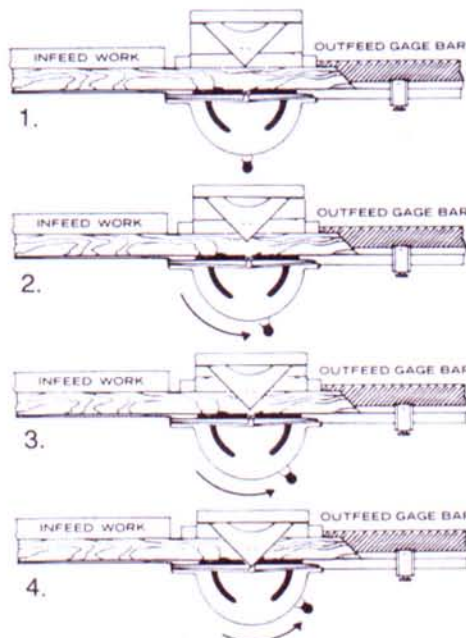
## HOW IT WORKS

Dual razor-sharp knives are used to progressively cut notches in the form of 45 degree miters in the material until it is nearly parted, then a final parting cut is made that cleanly planes the mitered faces of the joint.

In most cases, small profile moulding can be parted in one pass of the chopper knives.

Advancement of the knives for progressive miter "notch" cuts is made by hand adjustment. A series of pre-spaced notches are provided on the machine to assure the most suitable cutting increments.

Standard models are manually operated via foot treadle. Pressure is applied to the cutting knives by foot pressure on the front foot treadle.



## SEQUENCE OF CUTTING

1. Set knife head to full rear position with knife advancement handle. Slide rabbet support assemblies forward and adjust to contact underside of rabbet lip. Make trim off to 45 degrees on end of moulding length. Rabbet supports are only necessary for mouldings with a rabbet. Note: Not all mouldings need a rabbet support.
2. Set stop for desired length cut by reading off visi scale. Using the knife advancement handle, bring knife block forward to make first notch cut.
3. Further advance knife block forward to make second, third, and any subsequent cuts required depending on material.
4. Advance knife block to the full forward position to make final plane cut to complete material.

# MODEL KA, HEAVY DUTY PNEUMATICALLY OPERATED KNIFE CHOPPER



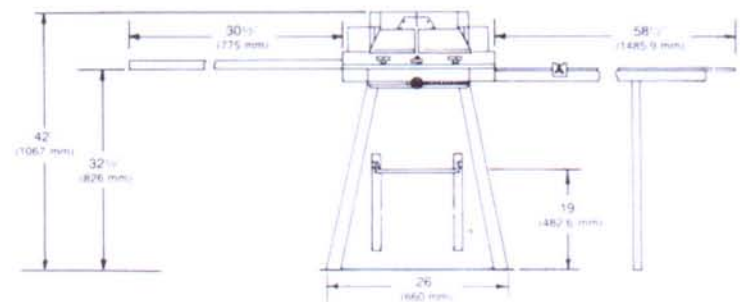
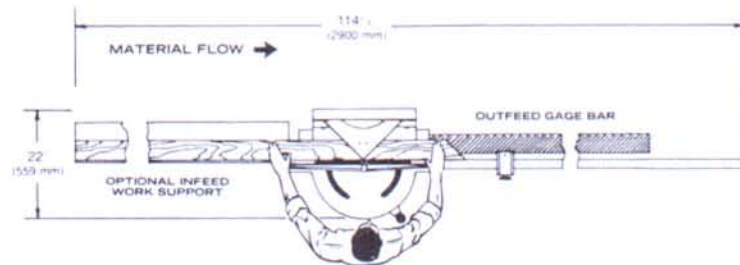
As production increases and requires a higher level of miter cutting, pneumatic power fed models, as shown, will allow greater output from the same machine with greatly reduced operator fatigue. Because of controllable feed rates on the knives, a greater uniformity of cut is realized. When cutting hardwoods or large profile mouldings, the high power pneumatic cylinder will allow a smooth, easy cut, with no unnecessary strain on the machine.

Machines are provided with a specially designed safety circuit. On each machine, the cycling of the knives is accomplished by simultaneously pressing hand operated controls. These controls are so located to prevent the operator from cycling the machine with hands anywhere near the knives.



## SPECIFICATIONS MODEL KF MODEL KA

<b>Weight</b>		
Uncrated	217 lbs. (98 kg)	242 lbs. (109 kg)
Crated (domestic)	267 lbs. (12 kg)	292 lbs. (132 kg)
Crated (export)	317 lbs. (143 kg)	342 lbs. (154 kg)
<b>Table Height</b>		
from floor	32 1/2" (826mm)	32 1/2" (826mm)
<b>Overall Size</b>	26" (660mm) x 22" (559mm) x 42" (1067mm)	
<b>Electrics</b>	None	None
<b>Amps</b>	None	None
<b>Air Consumption</b>		1.0 SCFM based on 8 cycles per minute
+ 3/8" air line minimum	None	
<b>Air Pressure</b>	None	100 psi
<b>Actuation</b>	Foot lever	Anti tie down dual hand controls
<b>Width Cutting Capacity</b>	Up to 4" (102mm) Wide	
<b>Length Cutting Capacity</b>		
Minimum	4" (102mm)	4" (102mm)
Maximum	60" (1525mm)	60" (1525mm)
<b>Maximum Pedal Height</b>		N/A
from floor	19" (483mm)	



Subject to specification and engineering changes without notice.

### IMPORTANT WARNING

Chopper knives are extremely sharp and can cause serious injury if the machine is not used in a cautious manner. Hands and fingers must avoid the knives at all times. The knife head should be locked down at all times when the machine is not in use. Knives should be adjusted to the minimum height setting necessary to cut the material in use. Because of the cutting pressure generated by the knives, any unsupported surface will be subject to tear-out or breaking. In most instances more than one chop with the knives will be necessary to obtain a clean miter. Note: Hardwoods and compo or jesso covered plastic mouldings are extremely abrasive and substantially reduce the cutting life of the knives between sharpening. Additional fixtures, spacers or support blocks may be necessary to properly cut some shapes and sizes. Send samples to the factory for analysis of your cutting requirements and specific recommendations.

## OTHER AVAILABLE PISTORIUS MACHINES

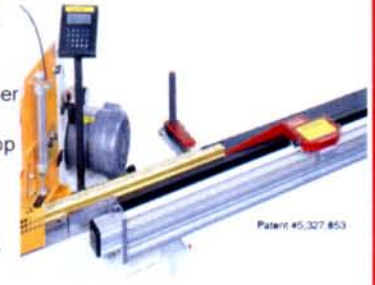
### VEE NAIL<sup>®</sup> FRAME ASSEMBLY MACHINE

Unique vee shaped fasteners are driven into the back of flat back frame type components. Provides strong joints without the necessity to fill or putty staple or nail holes. Fastener is internally concealed. Performs custom frame quality. See bulletins VN & VN2.



### ELECTRONIC AUTOMATED DIGI-MITER™ GAGE

Designed to allow virtually any operator to make error free stop settings, the model 10G Electronic Digi-Miter gage will eliminate incorrectly cut parts and improve quality control. Ideal for chop services and high volume custom framing. Fast, powered stop positioning at 40" per second, auto locking at desired size. Does not require manual stop positioning or locking. Accurate, repetitive sizing via digital electronics. LCD display mode selection in decimals, millimeters, or fractions. See bulletin 10G.



### DOUBLE MITER SAWS

For fast accurate double mitering with 45 degree cuts at both ends. Manual and air operated models available. Ideal for mitering all types of wood, aluminum and vinyl materials. A full range of measurement gages are also available. Details in bulletin MN.



### ELECTRONIC DIGI-MITER™ GAGE

The model 9G Electronic Digi-Miter™ gage, will allow virtually any operator to make error free stop settings. This will dramatically improve control and eliminate incorrect cut parts. LCD display mode selection in fractions, decimals or millimeters. Battery operated, no electrical connections. Designed originally to fit the Pistorius line of double miter saws, it can also be used on nearly all machines of a similar design. See bulletin 9G.



### BENCH TYPE DOUBLE MITER SAW

For the economy minded. Provides big machine performance at a price that even the smallest frame, cabinet, or woodworking shop can afford. Ideal for making "chevron" cuts for displaying moulding corner samples. See bulletin BMS.



### FRAMERS POINT TOOL

The Framers Point tool is ideal for all frame fitting. The point tool is compressed air operated and uses high grade, black painted flat steel points that will repeatedly bend without breaking. See bulletin FPG.



#### IMPORTANT NOTICE TO PURCHASER AND USER

All material contained herein is based on tests and information we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential arising out of the use or the inability to use the product described herein. Manufacturer offers inspection by buyer and user of product prior to shipment from factory with adequate notice. Before using, user shall solely determine the suitability of the product for his intended use and user assumes all risk and liability whatsoever in connection with strict compliance with all Federal, State and Local health and safety ordinances to its intended use.

*Manufacturer of quality machinery since 1937*

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