

PISTORIUS

MACHINE CO., INC.

 **V-NAIL BRAND
FRAME ASSEMBLY
MACHINES**

"GENERATION 2" VEE NAIL BRAND FRAME ASSEMBLY MACHINES ARE NOW AVAILABLE.

DESCRIPTION

Generation 2 Vee Nail™ Brand Frame Assembly Machines are designed, manufactured, tested and packed for a long trouble free life and with up to the minute state-of-the-art technology.

Designed by computer and manufactured on computer-assisted machining centers, these new World Class designs are truly remarkable in their simplicity, reliability and speed.

Although no special skills are required to operate these machines, operators must be provided with operational and safety training prior to use.

The Vee Nail assembly system is specifically designed for high quality joining of unfinished or prefinished materials. Single or multiple nails are inserted into the bottom side of the material where it is not seen in most applications. Bottom joining eliminates marring the exposed finished surfaces and saves the additional labor expense of filling nail holes.

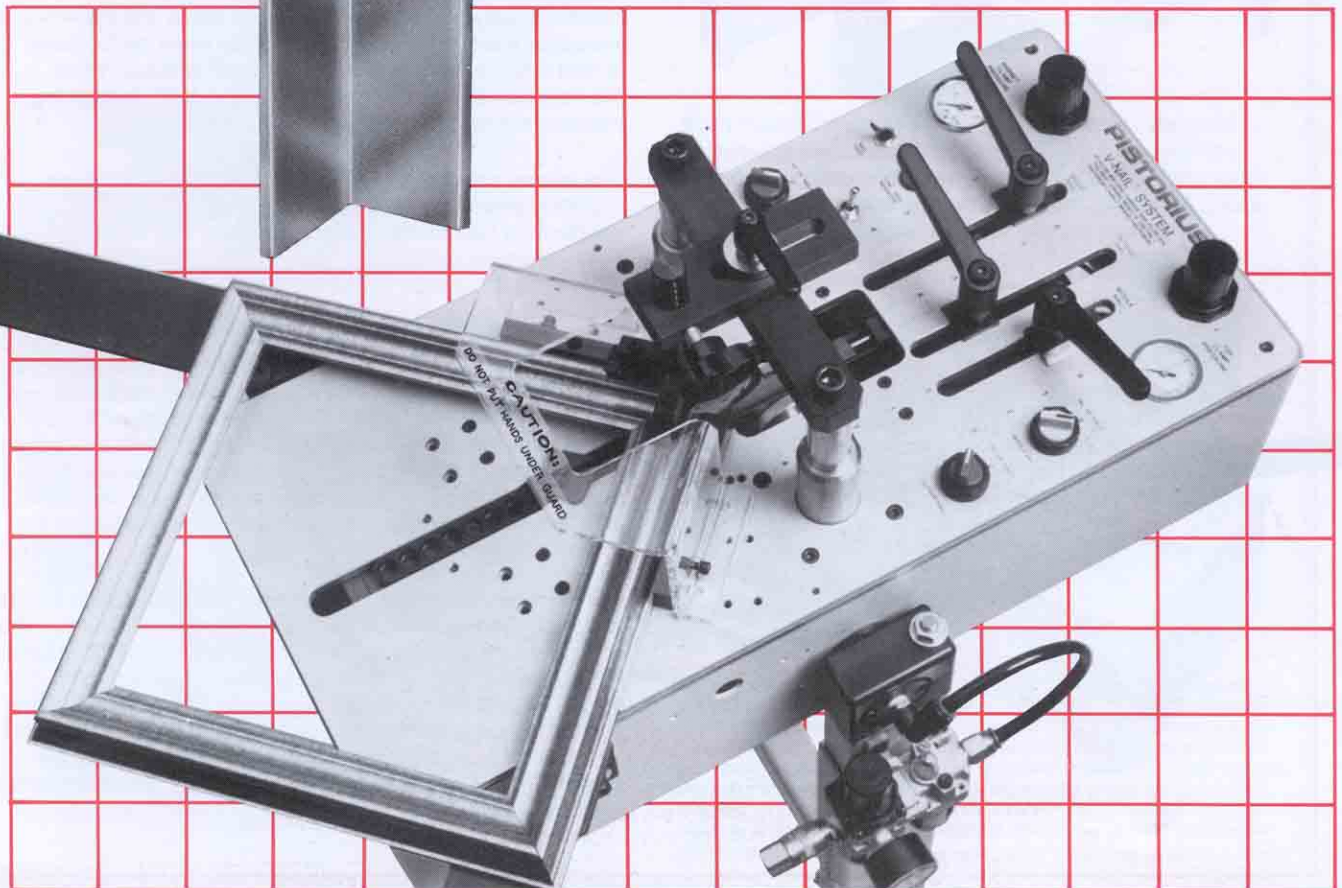
With over 30 years of experience Pistorius offers the ability to produce "Professional Quality" products.

TYPICAL APPLICATIONS

- Custom picture frames
- Ready made frames
- Mirror frames
- Advertising display frames
- Clocks
- Door lites
- Kitchen cabinet doors
- Silk screen frames
- Do-it-yourself frame shops
- Custom sign shops
- Occupational training schools
- Photo frames
- Chalk boards
- Needlepoint frames
- Schedule & bulletin boards
- Medicine cabinet doors
- Game tables
- Sheltered workshops
- Glass & mirror shops
- Woodworking shops
- Display manufacturers
- Custom craft hobby shops
- Lighting fixtures
- Trophies
- Window grills and surrounds



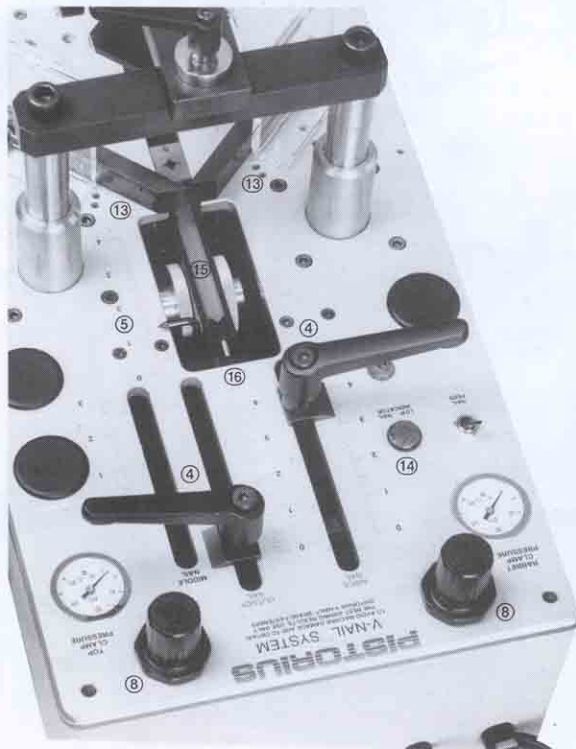
NAILS are precision formed high carbon steel for maximum efficiency and strength. Unique nail design permits assembly of material widths to a minimum of 3/8".



Operating controls are simple, user friendly and well arranged for ease of use. Independent regulators^⑧ with gauges are provided for both the horizontal (rabbet) clamp^⑨ and the vertical clamp^⑩. The powerful tandem cylinder vertical clamp is quickly adjustable for the material height to achieve the shortest possible cycle. A soft face, vee shaped clamp pad^⑪ provides maximum holding power and prevents damage to delicate or soft wood mouldings. The top clamp adjustable rod is provided with multiple detents that provide positive non-slip clamping.

The horizontal (rabbet) clamp^⑨ is a quick set, drop in type that allows assembling frames down to 2-1/2" (64 mm) inside. Spring loaded, serrated jaws provide a powerful gathering force to tightly hold the faces of the miters together during the nailing cycle. The machine is quiet cycling and consumes a nominal amount of compressed air per cycle. For applications where compressed air is not available, Pistorius also manufactures Vee Nail frame assembly machines that are manually operated. For more information on these models see bulletin VN.

The ground steel table^⑫ is nickel plated with a low lustre matte finish to eliminate glare. Fences^⑬ are easily adjustable for 45, 30 and 22½ degree miters and are offset to allow for dirt and glue build up.



Many thoughtful conveniences are included as standard features. A low nail level light^⑭ alerts the operator to reload. Easy access to load Vee Nails^⑮. Reloading takes seconds. Vee Nails are advanced by air cylinder^⑯, not a spring, for a positive jam free nail feed. A light weight, compact machine, easily portable and ships via UPS for the lowest possible shipping costs.

The machine is provided as standard with all facilities to upgrade to the more automated models. All pneumatic, electric and mechanical components are enclosed within the 1/8" (3 mm) thick steel cabinet and are modular in design for quick, easy replacement and maintenance. The machine cabinet and optional floor stand are painted in a neutral tone, highly durable, baked on powder coat finish.

IMPORTANT WARNING

It is extremely important that operators be thoroughly instructed in the proper and safe operation of the machine prior to use. Vee Nail stampings have sharp edges and can cause serious injury. Hands and fingers must be kept out of the clamping and nail driving area at all times. When the machine is not in use or is undergoing maintenance or adjustments, disconnect and lock out electrical and pneumatic service. Safety guards must never be removed except during maintenance. The machine must not be operated unless in perfect operating condition and all guards and safety devices are securely in place and in proper adjustment.

MODEL VN-A2, SEMI AUTOMATIC AIR OPERATED VEE NAIL FRAME ASSEMBLY MACHINE



Optional totally enclosed pressure feed glue dispenser is available for all models. For information see page 7.

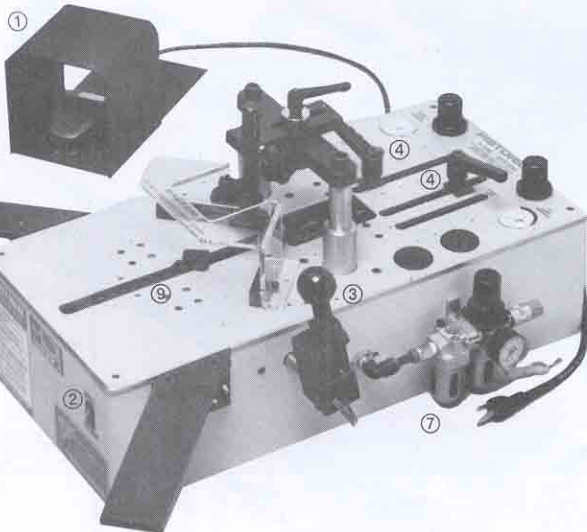
Model VN-A2 shown with optional floor stand and pressure feed glue dispenser.

Generation 2 Model VN-A2 Vee Nail Frame assembly machine is designed for medium to high production requirements where compressed air is available. Adjustments for Vee Nail positions are fast and positive assuring repetitive nail positions. Most hardwoods, softwoods, fiberboard and solid plastic extrusions can be assembled with ease.

The machine is equipped with a shielded footpedal ① which simultaneously actuates the vertical top clamp and the horizontal inside or "rabbet clamp". Only when the footpedal is held down is the Vee Nail driving circuit enabled. When the front mounted power switch ② is in the "off" position the machine will not function.

The unique and exclusive "power handle" ③ performs two important and time saving functions. Moving the power handle from front to rear, positions the Vee Nail driver. Fully adjustable nail position stops ④ with calibrated scales are provided. A pointer ⑤ and scale are provided for reference when inserting nails between the two stop positions. A slight left pressure on the power handle drives the Vee Nail into the joint. Vee Nails can be inserted at any point along the miter joint and can be stacked at will by driving more than one nail in a given position. Once the material is clamped it never moves. The Vee Nail unit moves below the material for multiple nail positions to assure the highest quality, tightest possible miter joint. Unlike pneumatic staple and nail guns, Vee Nails are driven with high pressure and low velocity, eliminating the danger of flying nails.

The machine is available in both bench and floor models to meet individual space, operational and budgetary requirements. The optional floor stand ⑥ is adjustable vertically within a 6" (152 mm) range for the best working height to suit the operator. The optional floor stand allows the machine to be swivelled within a 180 degree range for ease of use (vertical or horizontal) and for accessibility to working components located in the machine cabinet. Flared legs provide greater stability and less interference with the operators feet.



Model VN-A2 bench model shown with optional airline filter, regulator and lubricator ⑦. Unit is provided with pneumatic lock out device.