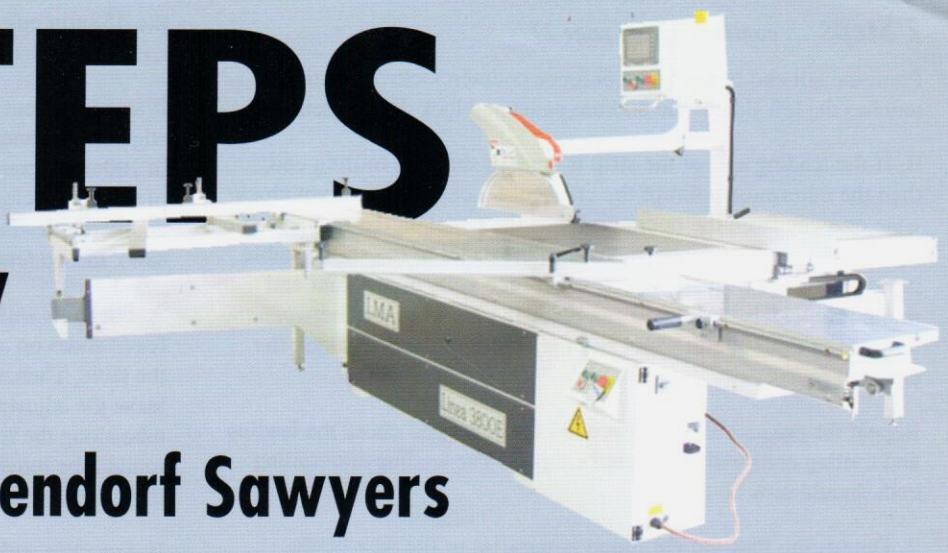
7 STEPS to Highly Effective True32-Altendorf Sawyers



Bob Buckley has kindly shared his sliding panel saw setup instructions with us. Although they may seem Altendorf specific they can easily be adapted for any sliding panel saw. Thanks Bob!

1. Level the saw.

2. Determine that the saw tabletop surface is 90 degrees to the face of the saw blade and that the sliding table is slightly (one sheet of writing paper thickness) higher than the saw tabletop where they meet; leveling mechanisms are located between the tabletop and the saw cabinet.

3. Determine that the sub-rollers are adjusted correctly; the general consensus is that they should start rolling at the third rivet in the phenolic ways. To adjust these you need to make horizontal marks on the rollers so you can see when they begin to turn. Move the sliding table until they begin to turn. If they begin to turn too soon or too late, adjust the rollers by loosening the center screw that runs through the roller and outside face of the rolling table, then use the thin spanner wrench to turn the nut between the roller and the sliding carriage. These rollers are mounted on an eccentric that will raise and lower the roller when you turn it. This is definitely a trial and error process, so be patient and diligent to do it correctly.

4. Determine that the surface of the sliding table is 90 degrees to the face of the saw blade (level with saw tabletop). A long, straight edge laid across both table surfaces is the best way to check this. Your rip fence will work quite well; simply remove it from the saw and lay 2/3 on the slider and let 1/3 run out over the saw table. This adjustment is on the pivot point for the sliding table arm.

5. Determine that the sliding table slides parallel to the blade throughout the entire length of the sliding table. Adjusting mechanisms are located where the sliding beam attaches to the main saw table body. Use a dial indicator to determine that the distance between the blade and the groove in the sliding tabletop is consistent throughout the length of travel. If you desire a little free cut here (slider runs away from back of blade), try to minimize it to .2mm in the length of the slider. By using a dial indicator for this setting and listening to the sound of the cut as the panel passes the back of the blade (You should hear a slight whisper sound.) You can get this setting within the .2mm tolerance.

6. Determine that the crosscut fence is precisely 90 degrees to the blade. To check this setting, use a square panel that is the length of your sliding carriage divided by four (example: 3,200/4 = 800) and mark one of the edges with an X. Using the sliding table, make a cut along the edge with an X on it, holding the panel tight to the crosscut fence (leave 6mm of off fall from each cut). Rotate the panel counter clockwise and make a second cut. Rotate the panel counter clockwise and make a third cut. Rotate the panel counter clockwise and make a fourth cut. The last (fifth) cut will be on the edge you previously marked with an X. Make this last cut leaving a 6mm strip to the right of the blade. Keep this strip in the same orientation it went past the blade. Using a digital caliper, measure both ends of this strip.

A. If the leading end of the strip is larger than the trailing end, then the outermost point of the crosscut fence needs to pivot counterclockwise or towards the operator.

B. If the leading end of the strip is smaller than the trailing end, then the outermost point of the crosscut fence needs to pivot clockwise or away from the operator.

This adjustment is made with a mechanism on the outermost point of the sliding table where the crosscut fence attaches to the sliding table. The difference in the dimensions of the leading and trailing edge is how much out of square your saw is cutting in the total length of the slider. Example: if the difference was 1.2mm, then your saw is out 1.2mm in 3200mm (the panel was 800mm square, and you sawed around it four times 4 x 800 = 3,200).

Using the same 800mm panel, you can make this adjustment in one attempt with confidence. Divide the difference by four and you get the amount that you will need to move your crosscut fence. Example: 1.2mm / 4 = .3mm, depending on which way the fence needed to move you do one of two things:

A. If the leading end of the strip is larger than the trailing end, then the outermost point of the crosscut fence needs to pivot counterclockwise or toward the operator. Place the panel on the sliding table tight to the crosscut fence with .3mm spacer (metric feelers gauge works well for this) between the left end of the panel and the crosscut fence. Clamp the panel to the sliding table in this position. Unlock the crosscut fence at its pivot point and remove the .3mm spacer.

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Pivot the left end of the crosscut fence counterclockwise until it touches the left side of the 800mm panel and lock the crosscut fence.

B. If the leading end of the strip is smaller than the trailing end, then the outermost point of the crosscut fence needs to pivot clockwise or away from the operator. Place the panel on the sliding table tight to the crosscut fence and clamp the panel to the sliding table in this position. Unlock the crosscut fence at its pivot point and rotate it clockwise until you can place the .3mm spacer between the left side of the 800mm panel and the crosscut fence and lock the crosscut fence.

Repeat the process of sawing around the panel and check the leading and trailing ends with the digital calipers. The leading and trailing ends should now be equal.

7. Determine that the rip fence is parallel to the saw blade. To check this, rip a strip 458mm x 2,400mm and rotate the panel 90 degrees so that the long edge is now against the crosscut fence. Make a dust cut (leaving 6mm of off fall) to square one end along the 458mm edge and then turn the saw off. Set the rip fence at 100mm, using the 458mm x 2,400mm panel as a square. Slide it up against the rip fence, making sure the panel is tight to the crosscut fence. If you desire free cut (not recommended), the panel should be tight to the rip fence at the rear end and .05mm away from the rip fence on the front end where the 458mm edge touches it. If no free cut is desired, it should be tight the entire length.

If an adjustment needs to be made, do this by holding the 458mm edge of the panel against the rip fence while moving the rip fence in 100mm increments from left to right. If there is a gap at the front of the panel (closest to saw blade), the rip fence will need to move counterclockwise. If the gap is at the back (closest to the front of the saw), the rip fence will need to rotate clockwise.

A. For saws with a manual rip fence, the round tube that the rip fence slides on attaches to the main saw table at three places along the table. There are two options for adjusting the rip fence. One is to leave the adjustment closest to the blade fixed and pivot the round tube along the remaining two points. A second option is to leave the round tube fixed at the middle attaching position and pivot it across this position by adjusting both outermost points.

B. For saws with a motorized rip fence, you have two sets of Allen head screws in the face of the arm that attaches the rip fence to the mounting plate. The large set of Allen head screws are the locking screws, and the small set are jacking screws. Back the jacking screws out enough to let the rip fence bottom out against the mounting plate. Lightly tighten the locking screws and check the fence for square. Make the desired adjustments with the jacking screws and tighten the locking screws securely.

Now your saw should be cutting True32 square. ❖

Technical Solutions ... *continued from page 20*

Gap Techniques

Reveal (blackened spaces are sometimes considered acceptable)

Moulding (a separate piece may be allowed where the cabinet meets the wall)

Scribed Panel (for higher end cabinets)

Bottom Skin (to cover the gap at the back wall from the shims and the bottom of the cabinets should one wish to give a continuous appearance and not see the separate verticals of the separate cabinets)

Mechanical Fasteners

Screws ("Sheetrock" screws should be avoided as they are not as strong as screws specifically designed for cabinet installation applications. They are too brittle and will snap under load.)

Hanging Systems

Wall Hanging Rails (Make sure these have been properly affixed to studs as sometimes if the corresponding hanging brackets are attached between two affixment points. The cabinet can sag a bit; one way to avoid this is the use of toggle bolts close to the hanging bracket locations. This is frequently the case at the end of the run.)

Cabinet Hanging Brackets (available from different manufactures, may be considered unsightly by some clients)

Cover Caps (available in colors to match basic melamine colors)

French/Interlocking Cleats

Mitered (to pull the cabinet tight against the cleat)

Rebated (to allow for flexibility in fit, yet allow for a single installer)

Square (quickest as installation does not need to be as accurate front to back)

Shims/Adjustment

Shingles (at the bottom of the cabinet, cab be screwed through to hold into place, can "slip")

"Packers" or pieces of solid wood in different thickness (for more accurate installation, hot melt glue can work well with this type of process to hold them in place)

Hardware (easiest, as only a screwdriver is needed)

Site Conditioning

Furring Strips (takes a lot of time, but allows for rapid installation of cabinets after the work is done, especially helpful when wall panels flank the cabinets and for paneled libraries)

Wall Blocking (usually done by the contractor when excessive weights will become a factor)

Other Situations

Cabinet weight when loaded (may require a wall ledger below as relying on the shear strength of a few screws may not be adequate)

Utilities contained in the wall (Use a stud finder with the ability to locate electrical fields, and watch for uneven stud locations — which may not be a stud at all, frequently double checking with a trim nail and hammer is the safest route)

Cabinet back thickness/cleat (Some may choose to use a ½ inch back screwed to the cabinet rather than a ¼ inch back with a nailer. Either way any nailers or cleats must be attached to the verticals.)

Finding the best solution to the variables presented to you, and planning ahead will allow for a quicker installation that will allow you to sleep better at night! ❖