



**INSTALLATION
&
OPERATING INSTRUCTIONS**

**MK205
VERTICAL
CUTTING MACHINE**

PACKAGE CONTENTS

Machine head dims 2000 long x 1000 wide x 2500 high x 345 kgs*
head

pack of fixing bolts nuts etc for attaching
inner RHS rail to head

rear spreader to spreader stands

cranked spreader to head and central spreader stand

table centre/joining bolts

rail stand fixing bolts

Rails dims 4700 long x 150 wide x 200 high x 75 kgs*

inner RHS rail

outer rails

spreaders

table rack front

table rack rear

Rail stands dims 700 long x 300 wide x 700 high x 60 kgs*

normal stands

spreader stands identified by **extra hole** near center of stand

2 split stands

Table halves dims 2800 long x 700 wide x 1700 high x 165 kgs*

RHS table

LHS table

table handle

Table fence usually fixed to table halves

*all dimensions are for standard machine ie

2400 x 2400 table

1260 cutting height

1200 throat

no options

INSTALLATION INSTRUCTIONS MK205

Please read these instructions carefully as the final accuracy of the machine depends on correct installation.

These directions relate to a standard right hand machine, ie when the operator stands at front of machine the head is on RHS of table.

The order of assembly is as listed.

CUTTING HEAD

place cutting head in position leaving ample space around machine for removing offcuts etc. see location relative to tracks and overall area required in attached drawing. Level machine in both directions and only bolt head to floor using 3/8" "loxins" or similar once table has been moved(rolled) to ends of tracks to check for overall safe clearance around machine as mentioned below. Fit knife to machine(if not already fitted)

GUIDE RAILS

Fit stands to rails.

the inside rail (RH rail) (identified by **cross hole** near center)has 2 split stands fitted at one end of rail (nearest to the operator) this allows for blade to pass thro when replacement is required, and one normal stand fitted closest to center and one spreader stand at other end.

Outer rails have normal stands fitted apart from far end and center which are spreader stands

Make sure all stands are set to same height from top of rail to base of stand using adjusting screws and lock nut.

Place guide rail LHS of machine nearest to knife using spreader provided off machine frame

Fit rails to head.

Fit RH rail assembly to head using bracket on head lower arm making sure split stands are to the front of machine, and,also that rail is square sideway to head.

Fit LH rail assemblies to head using cranked spreader off head and straight spreader at rear of machine bolted between spreader stands this will maintain correct center distance between all rails. Ensure that rail closest to knife (guide rail) is set square to head and parralell to RH rail.

Rotate all stand feet so they are 90 degree to rail.

Level rails horizontally for and aft (so that table does not move

when left alone)

Place straight edge between rails and set so that they are 90 degrees vertical to knife and flat to one another.

TABLE ASSEMBLY

Assemble table on tracks ensuring that LHS (with side guide rollers) is placed to engage carefully with LH guide rail.

Bolt table sides together

Fasten rails to floor with 3/8" "Loxins" or similar

FENCE ASSEMBLY

The fence has an adjustable handle at the operators end and moves on geared racks attached at both ends of table.

Fit slotted rack to front(operator end) of RH table and other rack to rear of RH table

Remove "L" shaped casting from rear of fence taking care not to dislodge brass rubbing strips.

Place fence on table with "L" shaped casting (operator end) clear of rack then carefully push/slide/giggle assembly and gear pinion into engagement with racks at operator and rear end checking fence face is parallel to knife slot in table.

Refit "L" shaped casting at rear

Use the front(slotted) rack to adjust fence parallel to knife slot

Use nut locked grub screws to adjust fence face square to table top at both ends

INSTALLATION FINISHED

OPERATING INSTRUCTIONS

safety precautions read them carefully

- 1 ensure that area around machine is clear of material not used on machine
- 2 before starting machine make sure nobody stands in operating area
- 3 use steel gloves when changing blades
- 4 check that all guards are closed before starting machine

Fence operation

The PARKEN manual fence can be operated in two modes

(a) continuous operation

in this mode, winding the crank in either direction will move fence towards or away from knife. The knob on the fence can be locked in any position for cutting. The machine is shipped in this mode.

(b) Incremental operation

in this mode, the fence moves a preset distance as set on the dial surrounding the crank handle. Once the desired thickness of cut is set all the operator needs to do is to reverse the crank against the stop and then wind forwards. This will move the fence a preset distance forward and then stop to cut. This mode is selected as follows:-

Rotate the crank until the zero graduation is facing upwards pull the spring loaded knob closest to the center of crank unit outwards. Turn the knob $\frac{1}{2}$ a turn in either direction to prevent knob from returning to index wheel. Screw the other knurled knob inbetween 2 stops located on the graduated dial. Release the 2 "L" levers/knobs at rear of dial. Rotate dial to desired size then tighten knobs. The major graduations on dial represent 10mm of fence travel.

Alternate clockwise/anti-clockwise rotation of crank handle will index fence in steps as selected. To return fence to fixed position release knurled knob from against the stops, and set the graduated dial to zero. Rotate the spring loaded knob to original position and move the crank handle to re engage the knob in the ratchet wheel.

Knife grinding

The knife grinding attachment houses 2 cup grinding wheels, two top knife guides and 1 backup guide.

To install or remove a grinding wheel we recommend removing knife.

Adjust spindle assembly outwards to provide access to retaining nut

When sharpening knife do not apply excessive pressure to grinding wheels as this may cause uneven edge to knife. These grinding wheels self rotate on contact with blade.

Knife replacement

- 1 open all knife guards around cutting head
- 2 move table so that knife is located closest to front table join
- 3 release blade tension using handle at top RH corner of cutting head
- 4 backoff grinding wheels located under table
- 5 using steel mesh gloves or equivalent remove blade carefully starting from lower guards then sides to top
- 6 open table join at front enough to slide blade through
- 7 dispose of blade carefully
- 8 remove new blade from container and release/unroll in clear area make sure sharp edge faces downwards
- 9 install blade is reverse of removal
- 10 if **twisted blade**(doubled sided cutting) is used make sure twist is placed in outside guard
- 11 before closing guards move blade by hand to check that knife tracks near center of wheels/pulleys
- 12 close guards and readjust grinders
- 13 if **twisted blade** back off rear blade guide to limit blunting edge
- 14 side guides should be adjusted so that there is paper thickness clearance