



CS 93 - CS93 Jr

PNEUMATIC UNDERPINNERS



OWNERS MANUAL

Version au 01/ 94

INTRODUCTION

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I - INTRODUCTION

You have just acquired a CS 93 Junior. We would like to congratulate you on your fine choice and thank you for your confidence.

The CS 93 Jr benefits from the experience of the assembling machines which have made us famous. With the CS 93 Jr, wood frame strips with any type of profile may be assembled (Patent n° 8800188). The CS 93 Jr has been designed to enable the operator to work from the front or rear of the machine. Assembly is done by metal wedges, specially designed for perfect tightening.

IMPORTANT :

**DO NOT USE ANY WEDGE CARTRIDGES OTHER
THAN CASSESE CARTRIDGES (CS registered trade mark)**

II - ACCESSORIES (supplied with the machine)

- 3 Allen wrenches N° 2,3 and 5,
- 1 spare hammer,
- 1 black triangle for normal and hardwood (fitted on the machine),
- 1 triangle holder (fitted on the machine),
- 1 handle to carry the machine.
- 1 tool to push the wedges back into the cartridge

If you ordered the extension table (optional) for your CS 93 Jr, assembly accessories are delivered with the table.

2 ARMS (to attach the machine on the work table)
4 STENTS - 2 SCREWS TO FIX THE ARMS

III- SPECIFICATIONS

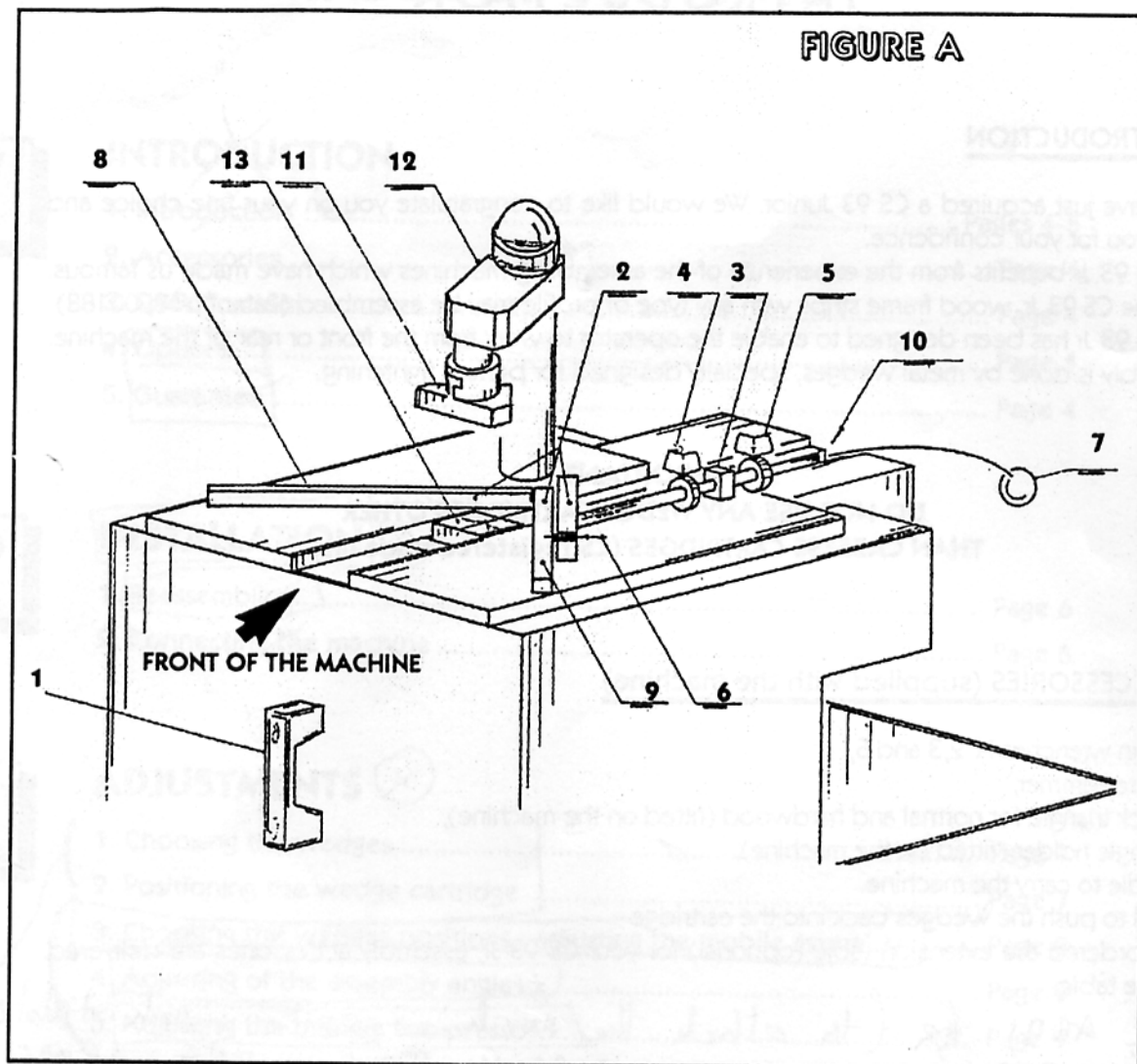
- ✓ - **Minimum width of the moulding :** 5 mm,
- ✓ - **Maximum distance between 2 wedges :** 65 mm,
- ✓ - **Minimum height of the moulding :** 5 mm ; maximum : 55 mm
- **Size of the wedges in a cartridge of 275 :** 5, 7, 10, 12, and 15 mm
- **Two types of wedge :** for soft wood, hardwood
- ✓ - **Net weight :** 18 kg
- ✓ - **Dimensions :**
 - **width :** 230 mm
 - **depth :** 350 mm
 - **height :** 650 mm
- **Supply :** compressed air ; pressure 5 to 7 bars, consumption 3 liters per cycle.
- **Air conditioning :** connection to the pedal by a tube with an interior diameter of 8 mm.

V - GUARANTEE

The CS 93 Jr is guaranteed 1 year, parts and labour against any manufacturing defects. Used parts and parts damaged by use other than according to these instructions will be excluded from this guarantee.

INTRODUCTION

FIGURE A



- 1 - HANDLE TO CARRY
- 2 - MOBILE ASSEMBLY
- 3 - FIX STOP
- 4 - WEDGING STOP
- 5 - WEDGING STOP
- 6 - ANGLE ADJUSTMENT SCREW
- 7 - WEDGE PUSHER WITH BALL
- 8 - LEFT HAND ASSEMBLY FENCE
- 9 - RIGHT HAND ASSEMBLY FENCE
- 10 - WEDGE CARTRIDGE
- 11 - TRIANGLE TOP PRESSOR
- 12 - VERTICAL PRESSOR PLUNGER ARM
- 13 - WEDGE DISTRIBUTOR

INSTALLATION

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I - REASSEMBLING

A - Remove the CS 93 Jr assembling machine from its packaging, then install the handle using the 2 screws and the Allen wrench 5 mm supplied (FIG A, N° 1)

B - Install the CS 93 Jr assembling machine on top of a stable, rigid table. See Fig. B

C - Level the CS 93 Jr assembling machine using the 3 screws + nuts located at the rear of the assembly machine, in the swan-neck (Fig. B)

II - CONNECTING THE CS 93 Jr MACHINE

a - **Installing the pedal :** remove the flexible tube located inside the body and connect it to the small sleeve of the pedal.

b - **Connecting the machine :**

Connect the CS 93 Jr assembling machine to a dry, lubricated compressed air source (5 to 7 bars)

Connect your air inlet to the muff joint of the pedal.

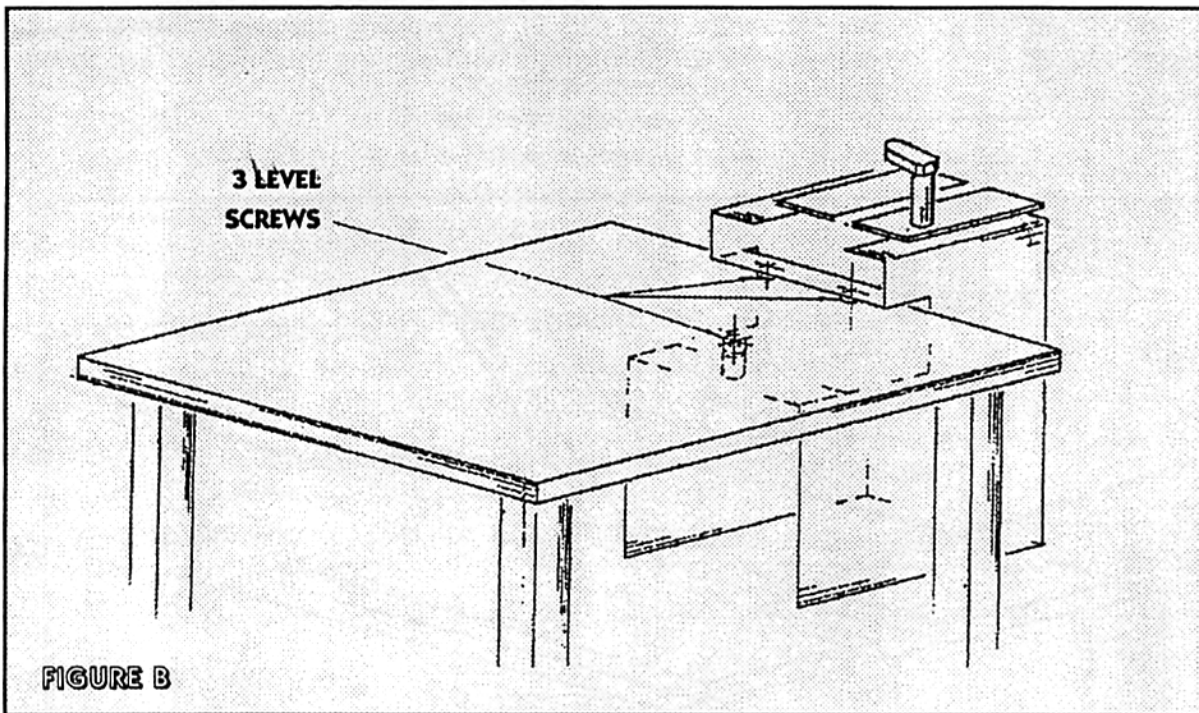
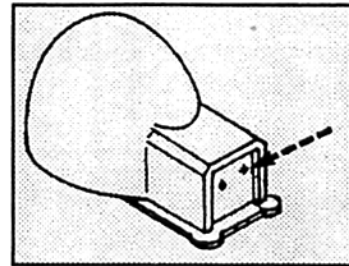


FIGURE B

For the starting and adjustment explanations in these instructions, we have considered that the user is standing in front of the machine (See Figure A).

IMPORTANT : To obtain optimum operation of the CS 93 Jr, we recommend that you do the machine adjustment and starting operations in the order indicated in these instructions.

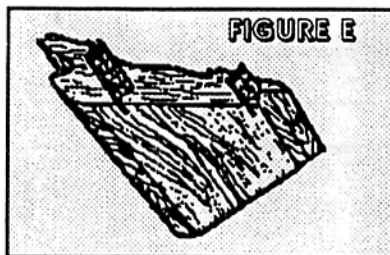
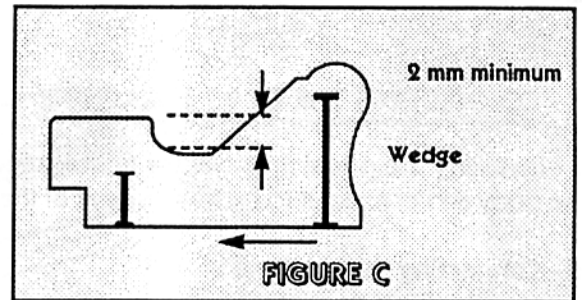
WARNING : DURING INSTALLATION AND ADJUSTMENTS, AS WELL AS DURING MAINTENANCE AND ANY LATER MANIPULATIONS, THE MACHINE MUST ALWAYS BE DISCONNECTED FROM THE COMPRESSED AIR SUPPLY SOURCE.

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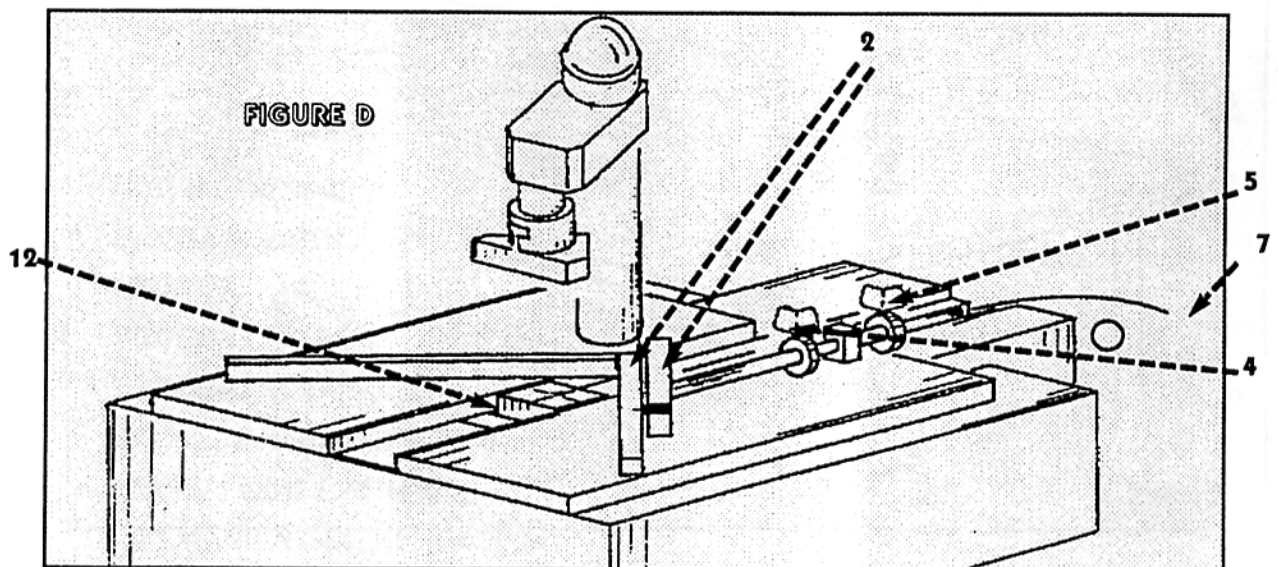
I - CHOOSING THE WEDGES

Selection of the wedge size (5,7,10,12 or 15 mm) depends on the height of the mouldings to be assembled.

As a general rule, leave a guard of at least 2 mm. (FIGURE C)



NOTE : Wedges with the same dimensions may be placed one on top of the other (FIG. E), thus avoiding changing the width of the wedges if mouldings with varying thicknesses are to be assembled.

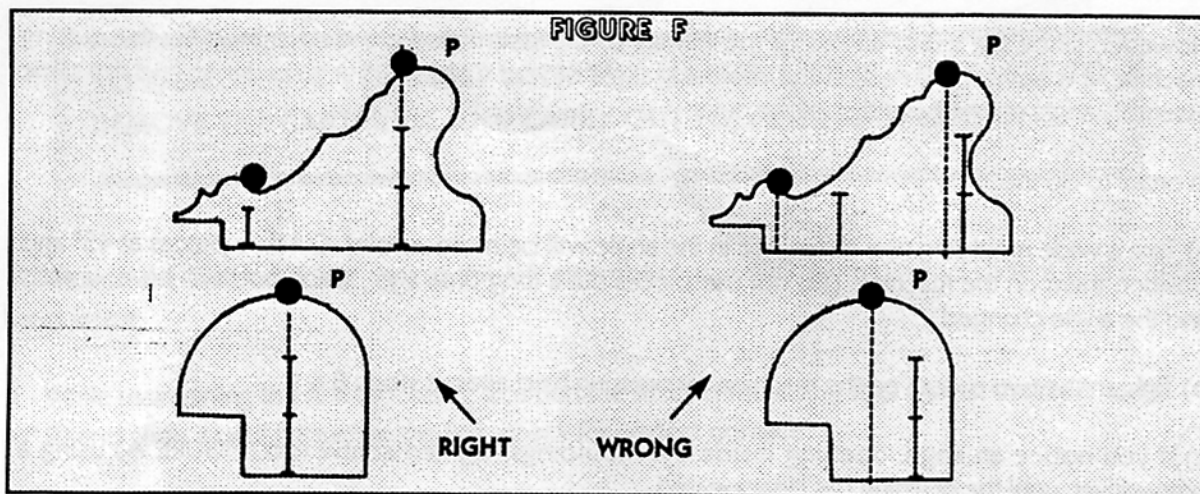


II - POSITIONING THE WEDGES CARTRIDGE (FIGURE D)

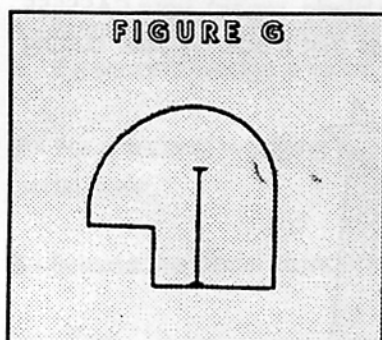
- A - Loosen the n° 4 & 5 butterfly screws of the wedging stops (Figure D).
- B - Slide the mobile assembly (N° 2) towards the front, to clear access to the cartridge.
- C - Pull the wedge pusher back using the ball.
- D - Fit the cartridge completely into the window of wedge distributor n° 12.
- E - Slowly release wedge pusher n° 7.

III - CHOOSING WEDGE POSITIONS : ADJUSTING THE MOBILE ASSEMBLY (FIG A N°2)

Wedging should be done perpendicular to the thickest part (s) of the moulding (FIG F POINTS P).



A - FRAMES ASSEMBLED WITH A SINGLE WEDGE (FIGURE G)



- Position the left moulding strip against the assembly fence n°8,
- Slide the mobile assembly (FIG A - n° 2) until the wedge outlet is located perpendicular to the chosen position, taking the above advice into consideration.
- While maintaining the moulding strip in the chosen position, slide stops n°4 and 5 to part n°3 and tighten the butterfly screws (N° 4 & 5).

The mobile assembly must be immobilised in the only chosen wedging position.

B - FRAMES TO BE ASSEMBLED WITH TWO WEDGING POSITIONS (FIGURE H)

- Position the left moulding strip against the assembly fence n°8 (FIG A)

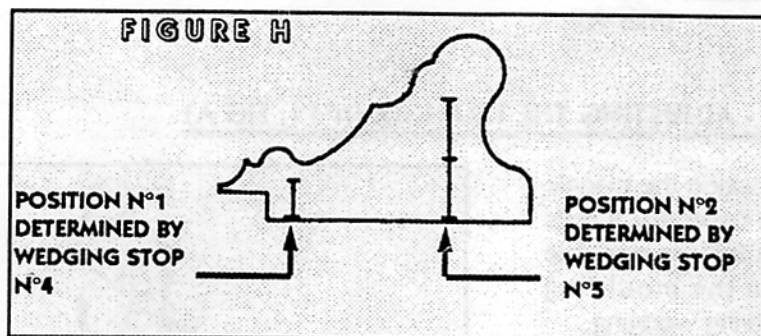
- Slide the mobile assembly (FIG A N° 2) to the chosen position for wedging N°1.

- Bring stop N°4 in contact with Fix Stop and tighten the butterfly screw.

- Slide the mobile assembly to wedging position N°2.

- Bring stop N°5 in contact with 3 and tighten the butterfly screws

In this case, the mobile assembly should have room to move between the 2 wedging positions.



IV - ADJUSTING THE ASSEMBLY ANGLE

The CS 93 Jr has been adjusted in our factory to assemble exact 90° angles.

However, since the exact angles of the frames to be assembled are determined by the cutting machine, it is advisable to adjust the assembly angle of your Casseese 93 Jr, in order to find the same assembly angle reference as that of the cut.

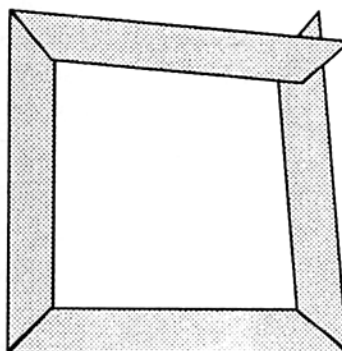
In order to do this,

- a) Take a wide moulding (the difference in the angle will be more visible). Cut two pieces at 45° and position them on the machine. (Do not use pieces cut a long time ago ; the wood will have worked and the angle changed).
- b) Tighten the two pieces on the machine by pressing hard against stops 8 & 9.
- c) If you notice an angle opening inside the mouldings, tighten screw n°6 (FIGURE A) using a screwdriver, until the opening has disappeared.
- d) If you notice an angle opening outside the mouldings, loosen this same screw to compensate for the difference and eliminate the opening of your angle.

As long as you do not touch your cutting machine (adjust, change the blade, repair), your CASSESE 93 Jr will assemble your mouldings with the same angle reference as that made by your cutting machine.

ADVICE :

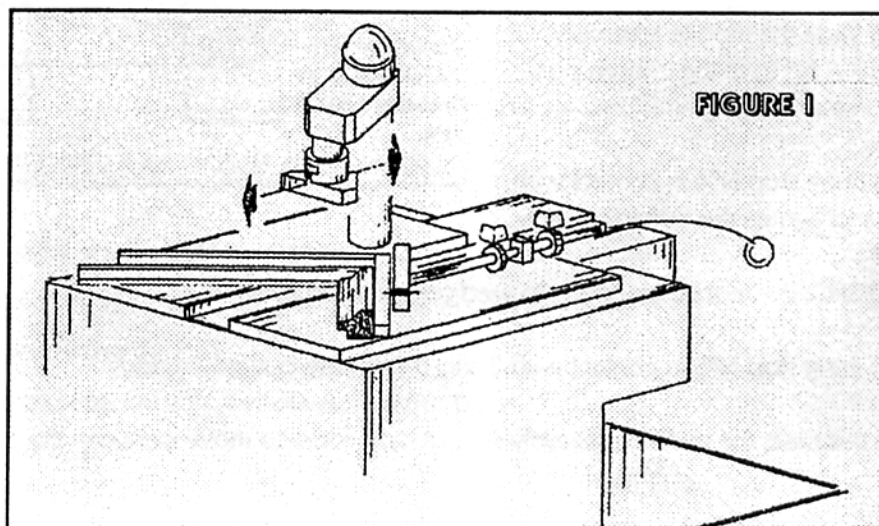
If you obtain this result,
your cutting machine has been
disturbed. Adjust it.



NOTE : *Because of its construction, a rectangular or square frame cannot have angle less than 90°.*

V - ADJUSTING THE TRIANGLE (n°11, FIG A)

Position the triangle
in order that it rests
as fully as possible
on the moulding
during wedging.



USE

4

TO FAMILIARISE YOURSELF WITH THE MACHINE, IT IS ADVISABLE TO REMOVE THE CARTRIDGE AND CARRY OUT FOLLOWING OPERATIONS.

- 1 - Position the first moulding against the left assembly fence (FIG A - n°.8) and slide it to the right hand fence.
- 2 - While maintaining the first moulding, position the second moulding strip against the right fence (n° 9) and slide it until it touches the first, check for perfect contact.
- 3 - Slide the mobile assembly (n°.2) to the position chosen for the wedges.
- 4 - While supporting the mouldings in their positions, press the pedal to insert the first wedge.
- 5 - Release the pedal completely.
- 6 - If a second wedge is to be placed over the first in the same position, press pedal again,
- 7 - For a second wedging position, move the mobile assembly to the other position, and press the pedal again,
- 8 - Release the pedal completely.

**E
S
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MAINTENANCE

WARNING : BEFORE ANY SERVICING, DISCONNECT THE MACHINE FROM THE COMPRESSED AIR SOURCE.

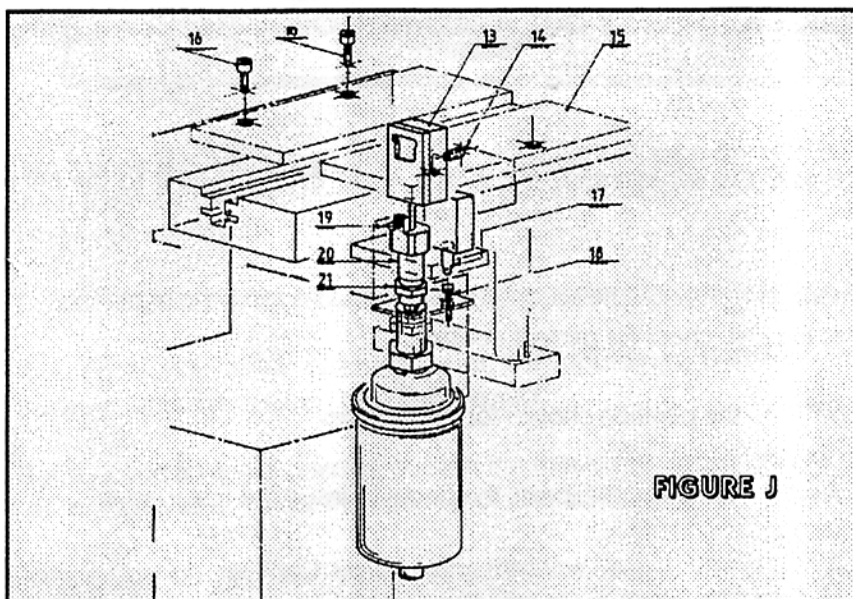


FIGURE J

I - CHANGING THE HAMMER (FIGURE J)

- Remove the four screws that fix the machine's mechanism to the casing, (n°16)
- Remove the mechanism and put on a table,
- Release the nut of the screw n°19 using the n°2 Allen wrench, unscrew it in order to free the hammer, (the hammer is the long part similar to a wedge)
- Loosen the tightening screw (n°14) which holds the distribution block (n°13), using the n°3 Allen wrench,
- Lift and remove the distribution block,
- Remove the hammer,
- Place a new hammer on support screw n°19 and screw it down without tightening, then tighten the counternut,
- Lightly grease the hammer,
- Put back the distribution block and screw it by n°14 without tightening
- Put back the mechanism into the casing and fix the four screws.

II - MAINTENANCE OF WEDGE DISTRIBUTOR (FIG K)

Periodically pull the wedge distributor block out of the machine and remove the fix guide by loosening the screws n°22 FIG K.

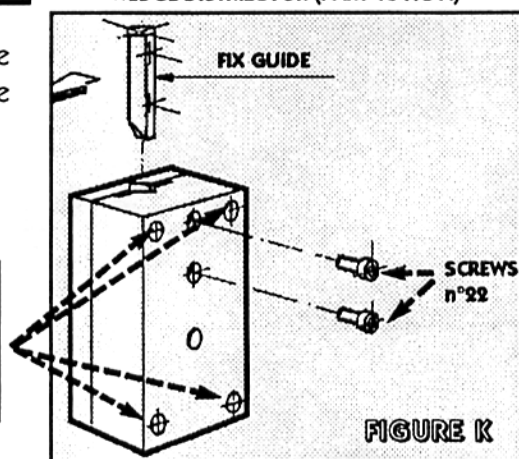
Clean it by blowing on it (also inside)

Don't loosen or remove the four angle screws of the wedge distributor ; they are factory set.

Lubricate the hammer a little before putting the block back into the machine.

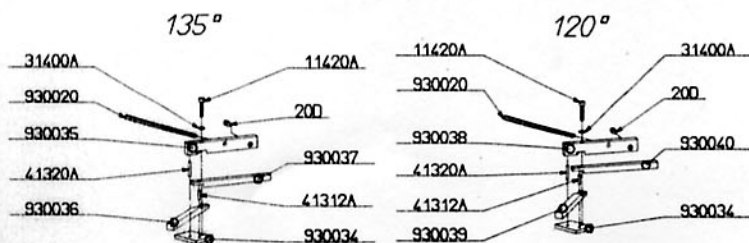
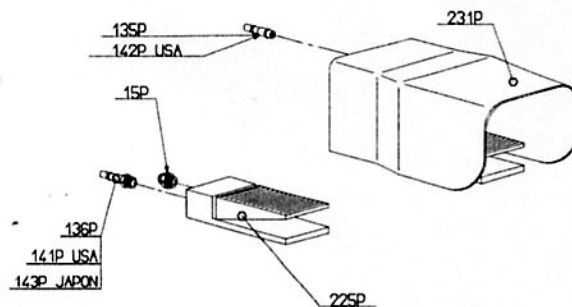
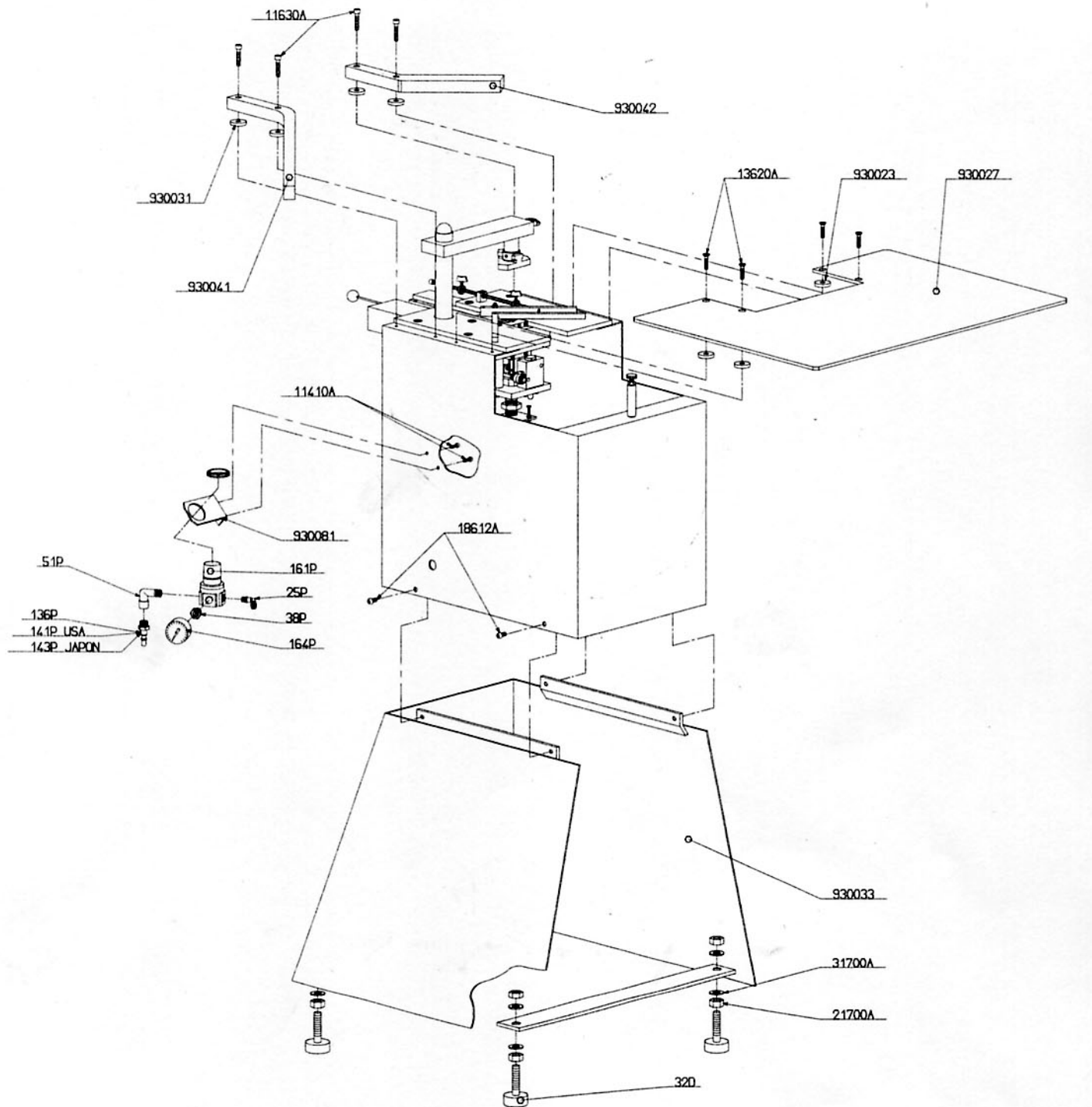
**WARNING :
NEVER REMOVE
THESE FOUR
SCREWS
(FACTORY SET)**

WEDGE DISTRIBUTOR (PART 13 FIG A)




SCHEDULE OF SPARE PARTS FOR CS 93 Jr

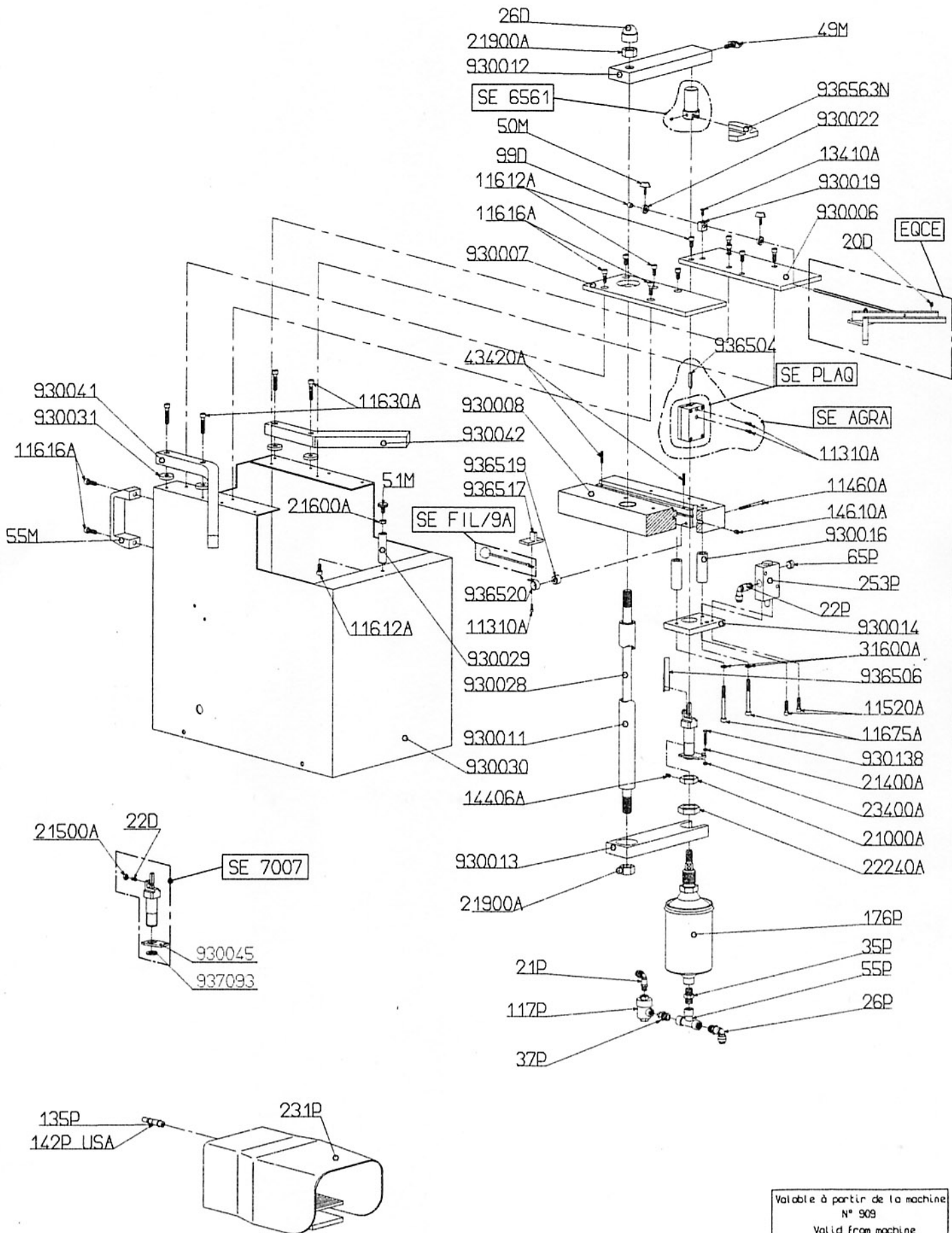
REF	DESCRIPTION	Qty	REF	DESCRIPTION	Qty
006	RIGHT PLATE	1	26P	ELBOW FITTING	1
007	LEFT PLATE	1	35P	NIPPLE	1
008	BASE	1	37P	REDUCER	1
009	RIGHT MOBILE STOP	1	55P	T - FITTING	1
010	COUNTER STOP	1	117P	FAST EXHAUST	1
011	COLUMN	1	135P	MALE END FITTING (FRANCE)	1
012	BRACKET	1	175P	CYLINDER	1
013	JACK SUPPORT	2	239P	PEDAL	1
014	STAPLING STOP	1	253P	END OF TRAVEL	1
016	STRUT	2	10R	HARD RING	1
017	FIXED STOP	1	563N	ADJUSTABLE TRIANGLE	1
018	STOP GUIDE	1	21 000A	NUT	1
019	ROD SUPPORT	1	21 400A	NUT	1
020	ROD	1	21 900A	NUT	1
022	DEPTH STOP	1	41 312A	PIN	2
027	TABLE (OPTIONAL)	1	41 420A	PIN	2
028	SCREW ROD	1	886 503	BACK PLATE	1
029	SUPPORT STRUT	1	886 504	FIXED GUIDE	1
030	CASING	1	886 506	HAMMER	1
031	TABLE STRUT (OPTIONAL)	4	886 517	SLIDING BLOCK	1
14D	RUBBER STOP	2	886 519	DRUM	1
20D	NYLON SCREW	1	886 520	STAPLING SPRING	1
21D	BALL PUSHER	1	886 561	TRIANGLE HOLDER	1
26D	PLUG FOR NUT	1	897 005	PUSHER	1
50M	BUTTERFLY SCREW	2	897 007	HAMMER SUPPORT	1
51M	CRENELATED BUTTON	1	897 072	RETAINING FINGER	1
55M	HANDLE	1	897 074	END OF TRAVEL STOP	1
11P	STRAIGHT FITTING	1	SE81 019	WIRE W/BALL ASSEMBLY	1
22P	ELBOW FITTING	1	9100 048	PLATE	1





REPRESENTATION DONNEE A TITRE INDICATIF.
LA SOCIETE CASSESE
SE RESERVE LE DROIT A TOUTES MODIFICATIONS.

Valable à partir de la machine
N° 594
Valid from machine
S / N° 594

Mat. :	Trait. :	Dé. :	Rs. :	✓	TOLERANCES GENERALES : 1/100°	VLSO :
				ASSEMBLEUSE CS 93 VUE ECLATEE OPTION		
Ech: 1/5	Le: 01/97	Par: D.G	Ft: A2	N° de PLAN : 93-0004		



REPRESENTATION DONNEE A TITRE INDICATIF.
LA SOCIETE CASSESE
SE RESERVE LE DROIT A TOUTES MODIFICATIONS.

Mod.	Travail	Qte	Dis	✓	REVISIONS ANTERIEURES	100796	Visa
				CS 93 VUE ECLATEE COMMERCIALE			
Ech:	Del: 01/97	Par: D.G	Re:			N° de PLAN: 93-0002	

LE PRESENT DOCUMENT EST LA PROPRIETE DE LA SOCIETE CASSESE. IL NE DOIT ETRE REPRODUIT OU COMMUNIQUE SANS AUTORISATION.