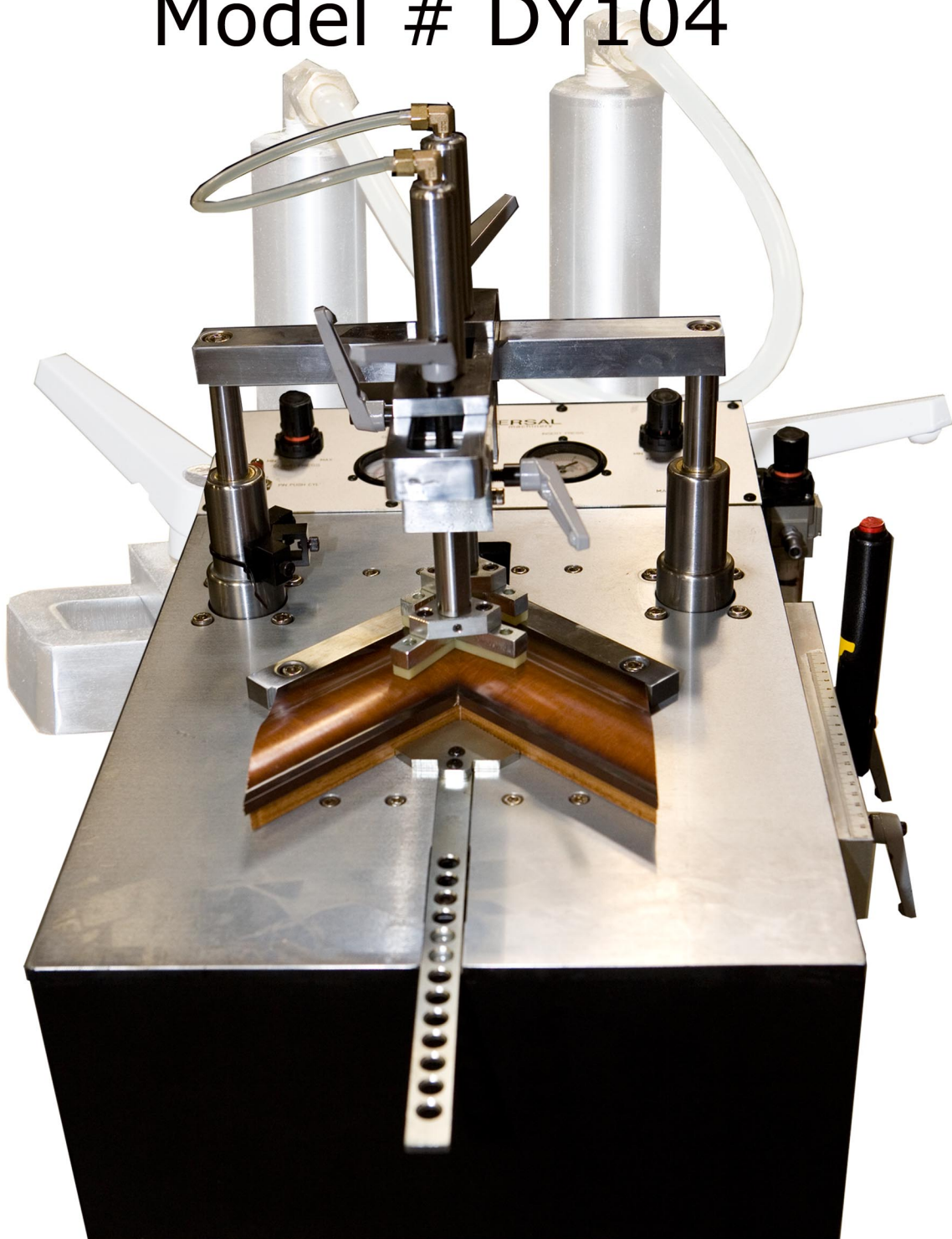


# Pneumatic Underpinner

## Model # DY104



21139 Centre Pointe Pkwy. | Santa Clarita, CA 91350 | P: (800) 668-3627 | F: (866) 239-1349  
[www.universalframing.com](http://www.universalframing.com)

## GETTING STARTED

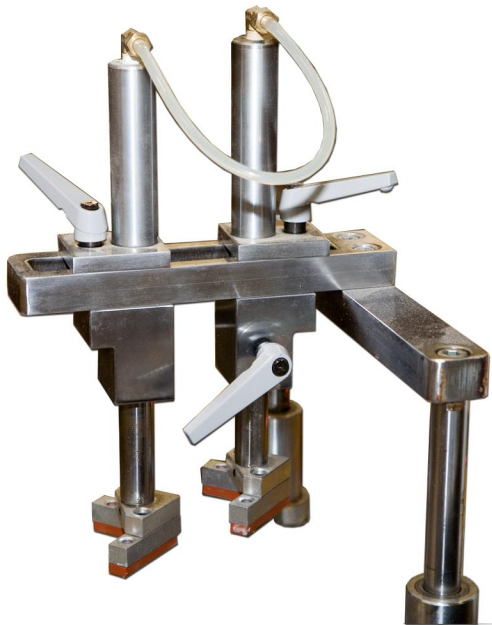
Plug transformer into a 110-120 volt connection. Plug the underpinner power cable into the 220-volt socket on the transformer.

Attach an airline, at least 80 pounds of pressure, to the regulator on the right side of the machine.

Flip the toggle switch to the on position; a beeping sound indicates if there are very few or no nails loaded into the machine.

To load nails into the machine flip off the toggle switch causing the nail pusher to retract. Load the proper size nail into the track glue side up and the bottom of the V facing the nail pusher.

## CLAMP ADJUSTMENT



Loosen the upper two handles and move the clamps over the parts of the moulding that you want the clamps to make contact with, usually the highest and lowest points of the moulding.

After the clamps are set to where you want them to contact the moulding, tighten the two upper handles then loosen the two lower handles and press the foot pedal - the clamps will come down and conform to the profile of the moulding.

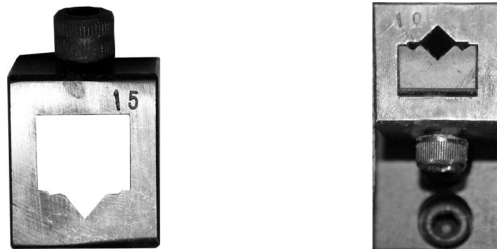
It is important to tighten the two lower handles after the clamps are set for the profile being joined. Leaving the clamp handles loose will put pressure on the oil line connecting the two clamps every time the clamps are lowered and possible causing an oil leak over time.

### CLAMP PRESSURE ADJUSTMENT

Pull the black knob up to unlock, turn clockwise to increase clamp pressure, turn counterclockwise to decrease clamp pressure.

Setting the clamp pressure to 4 atmospheres will work well for most mouldings, if the moulding is very hard and inserting nails lifts the moulding off of the table increase the clamp pressure, if the clamps are marking a softer moulding decrease the clamp pressure.

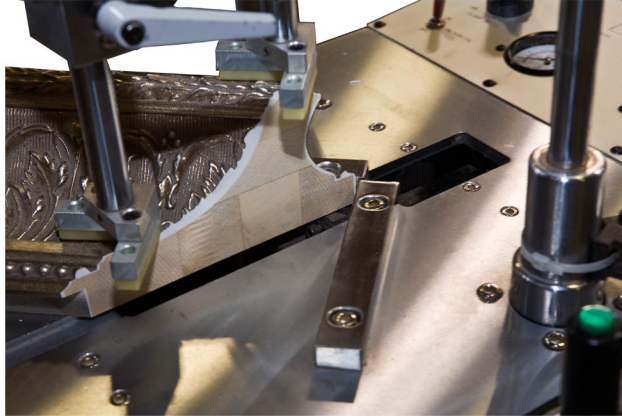
### CHANGING NAIL SIZES



Each underpinner comes with four driver-heads with either 7, 10, 12, or 15 stamped on the driver head, the number corresponds to the size of millimeter V-nail to be used with that driver head.

To change the V-nail use the toggle switch to turn the machine off - that will retract the pin pusher allowing you to remove the remaining V-nails. Then using a 6mm Allen wrench remove the driver-head and replace it with the driver-head that corresponds to the V-nail size you are changing to.

Remember nails are always placed in the machine with the point of the V facing away from the machine operator, toward the pressure gauge.



### JOINING A CORNER

Set the first and last nail position by placing one side of the corner to be joined against one side of the 90-degree fence. Moving the vertical handle moves the driver head assembly. Move the handle forward until the driver head is in the position that you want to place the first nail.

Slide the front stop back until it makes contact with the vertical handle, and then lock it into position by tightening the grey handle.

Move the driver head to the last nail position, slide the front stop back until it makes contact with the vertical handle, and then lock it into position by tightening the grey handle.

Put the corner to be joined against the 90-degree fence, press the foot pedal, confirm the clamps are set correctly and check the corner for tight and proper fit.

Starting at the top of the corner, press the button on top of the vertical handle to insert a nail into the corner, nails can be stacked by pressing the button multiple times without moving the handle.

Move the vertical handle towards the inside of the corner stopping to insert nails where desired.