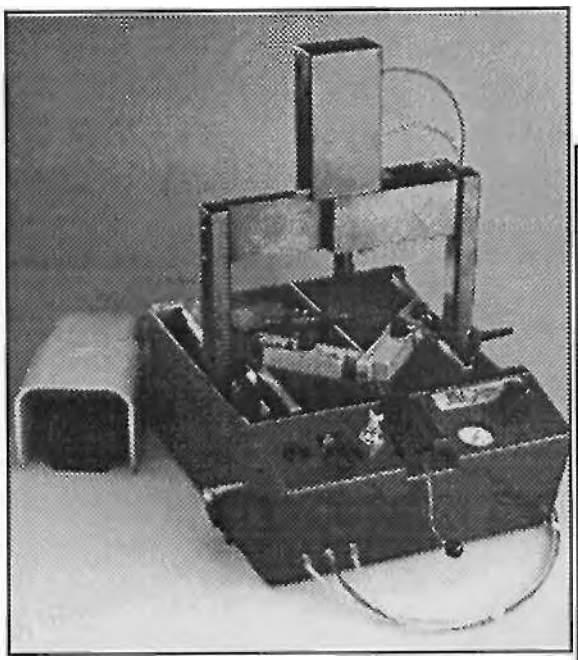
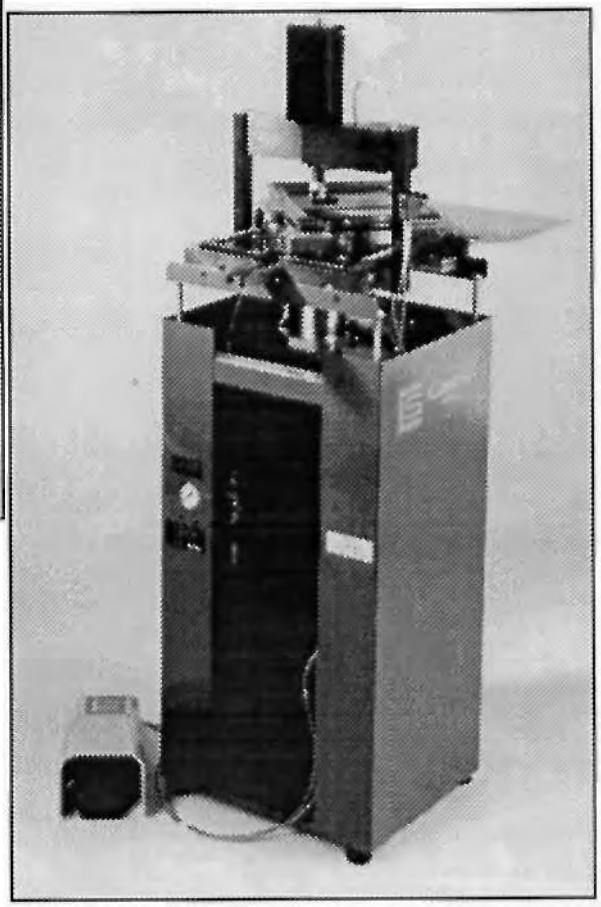
OWNERS MANUEL

Cassese 910 JR Table top

&CS 910 Joining machine





Cassese®

Quality for the world

Zone industrielle 77390 VERNEUIL L'ETANG - FRANCE
Tel : (33 1) 64 06 02 46 - Fax : (33 1) 64 06 04 19
SA250 000F • SIRET .108:105.133 000 38 MB 3309

TABLE OF CONTENTS

INTRODUCTION

Dear Purchaser, please read this note carefully, in addition to the straightforward operating instructions for the machine, because the manuel also includes valuable advice for optimising your manufacturing. Look at this symbol: ☞.

I - INTRODUCTION

We congratulate you on your wise decision and thank you for your trust.
The CS 910 is an underpinner which has been developed through extensive experience gained in the manufacture of the reputable Cassese machines. It enables perfect joining of rectangular frames and also various other forms including hexagons, octagons
Frames are joined by means of metal wedges which are specially designed for perfect locking.

The CS 910 requires minimum maintenance. Please, read the suggestions in section 5 carefully to ensure years of professional use.

IMPORTANT :
USE CASSESE WEDGE MAGAZINES AND NO OTHERS (Trademark : CS)

II - ACCESSORIES BOX (supplied with the machine)

- 4 feet (for Junior model)
- 1 set or spacer bars for small mouldings,
- 1 adjustable triangle top plunger for soft wood,
- 1 Allen key N'.3(for top plunger - P) + 1 Allen key N' 2,5 (for block H)
- 1 spare hammer.
- 1 tube of grease

III- SPECIFICATIONS

- ***Net weight:*** **91 0 JR : 40 kg (85** lbs) **; 91 0 SR : 46 kg (100** lbs)
- ***Power supply***: compressed air.

One power supply only, one setting only (6 - 7 bars) both for clamping pressure and for stapling pressure

- ***Dimensions of frames :*** **mini** : 80 x 80 mm ($3^{1/7}$"x$3^{1/7}$") (bottom of rabbet)
- ***Width of moulding :*** **mini : 5** mm **(1/5") ; maxi : 85** mm **($3^{2/5}$")+** rabbet
- ***Height of moulding :*** **maxi 90** mm **(3 1/2")**
- **Wedge *sizes* :** **5 mm (3/16"), 7 mm (1/4"), 10 mm (3/8"), 12 mm (1/2"), 15 mm (5/8")**
- ***Octogonal/hexagonal frame :*** A special shim is to be located in front of the stops at 90°to produce the correct angle

IV • OPTIONS

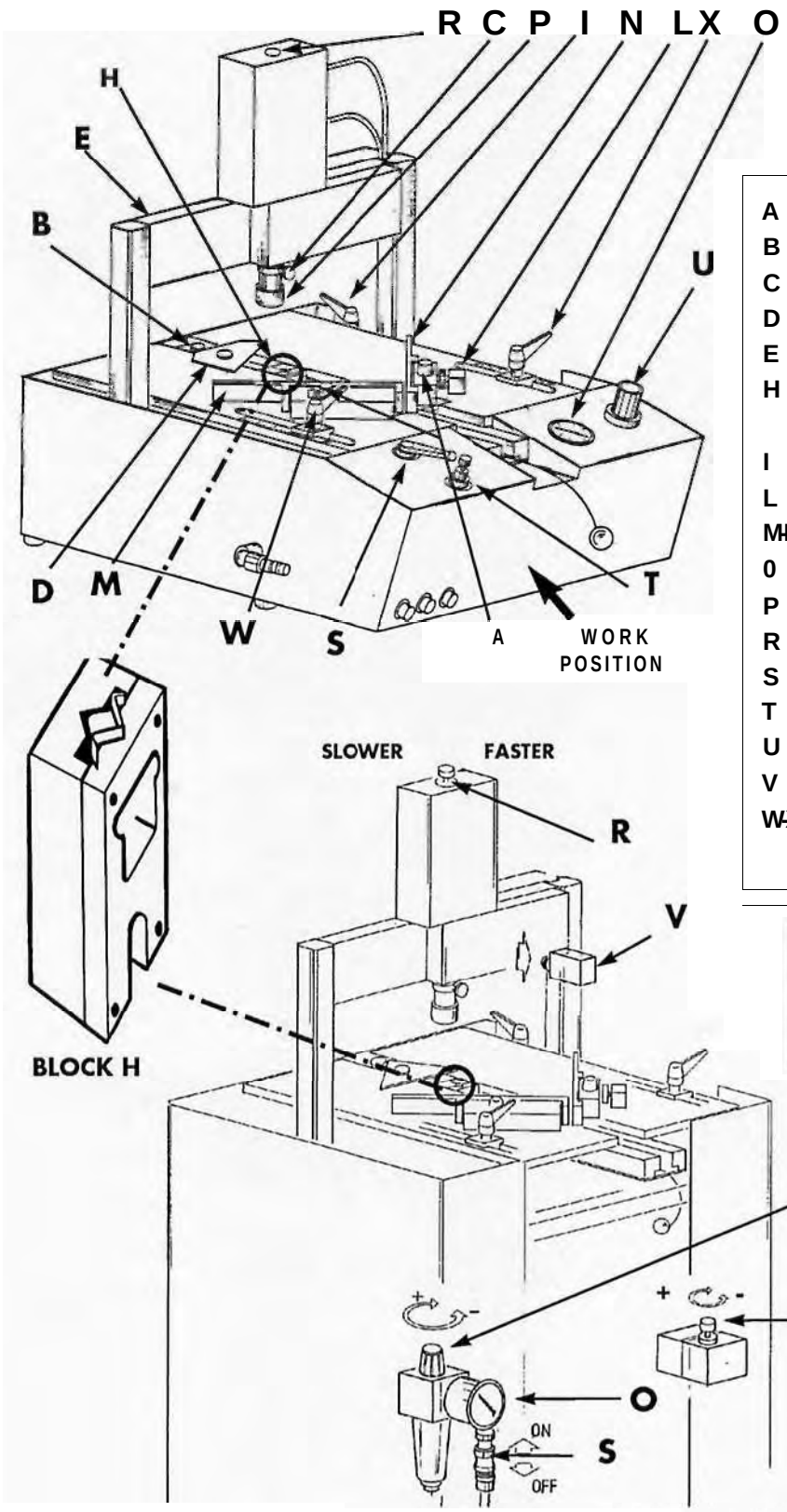
• Table extension.
- 1 angled shim of 135°, 120°, etc...

For particular requirements, call in your sales contact.

V - WARRANTY

The CS 910 is guaranteed for parts and labour for one year, against manufacturing defects. Parts worn through normal use and those damaged by operation contrary to the conditions of this manual are excluded from this warranty.

FIGURE 1



CS 910 JUNIOR (JR)

A	BACK FENCES'ANGLE KNOB 1 i
B	SET UP LEVER
C	SETTING RING ||
D	CLAMP \
E	BRACKET
H	WEDGES DISTRIBUTOR (BLOCK H)
I	CLAMP HANDLE
L	ANGLE SET UP SCREW
M-N	FENCES
0	MANOMETER
P	PLUNGER
R	PLUNGER SPEED BUTTON
S	ON/OFF VALVE
T	TIMER BUTTON
U	PRESSURE REGULATOR
V	STAPLING BUTTON
W-X	STAPLING POSITION HANDLES.

CS 910 SENIOR (SR)

SET UP

I - INSPECTION OF CONTENTS

Please, inspect the contents of your box carefully. If you should note any crate damage, please notify the carrier immediately to file a claim.

The following list of items should be found in your box

LIST OF ITEMS :

- 4 feet (for Junior model)
- 1 set of spacer bars for small mouldings,
- 1 adjustable triangle top plunger for normal wood,
- 1 N'.3 Allen key (for top plunger - P) + 1 N' 2,5 Allen key (for block H)
- 1 spare hammer.
- 1 tube of grease

II - ASSEMBLY

1 - For CS 910 Junior model : assemble the 4 feet of the machine (packaged with the accessories).

On the CS 910 Sr (standing) model, the work bench of the machine is adjustable in height (between 800 mm/31"^{2}". - to 1000 mm/39 1/2") to fit any work table you may have in your workshop.

NOTE : Please refer to the operating position as illustrated in Figure 1 for all explanations for start-up and settings.

IMPORTANT ;

IN ORDER TO OBTAIN OPTIMUM OPERATION FROM THE CS 910, WE RECOMMEND THAT YOU PERFORM THE SETTING AND SERVICING OPERATIONS OF THE MACHINE IN THE SEQUENCE SET OUT IN THESE INSTRUCTIONS.

III - CONNECTION OF MACHINE

Connect the CS 910 to a source of compressed, **dry, filtered air,** and check that the pressure gauge reading is at least 6 bars (max 8 bars).

SETTINGS

I - SETTING OF ASSEMBLY ANGLE (FIG 2 & 3) FOR A SQUARE FRAME

Since your frame joiner will always work after a cutting material (your chopper, saw or chop service mouldings), it has to adapt itself to the cutting angle of the machine that was used before.

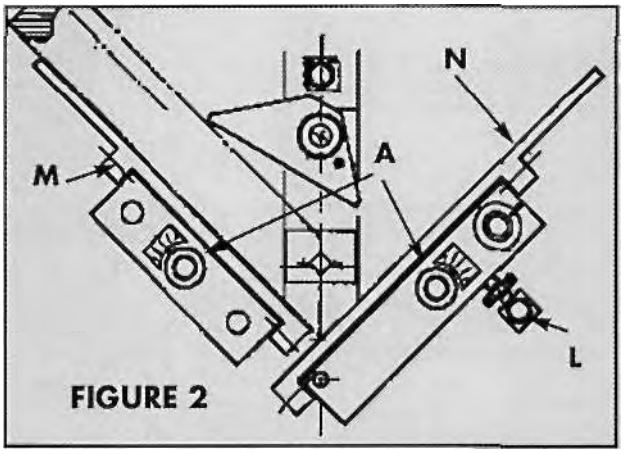


FIGURE 2

If you are cutting yourself your mouldings, you set up only once the joining angle of your CS 910 to the angle of your cutting machine. As long as you do not have your cutting machine or its blade changed or repaired, your CS 910 will always join perfectly at the same angle as your saw is cutting.

• Take one of your widest moulding and cut to pieces of it. Position the two pieces of moulding against the stops fences.

II -SETTING OF BOTH FENCES

Place backs of the moulding, to the fences (M & N).. To flush up fences with mouldings, setting knob A may be adjusted + or - (FIGURE 2) to ensure the mitres meet properly.

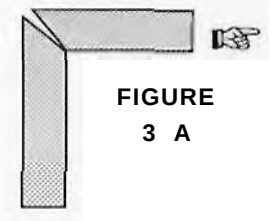
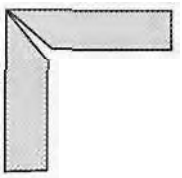


FIGURE 3 A

Set up using setting screw L as follows :

• If the angle is open to outside (FIGURE 3A), screw down setting screw (reference L on FIGURE 2) until the mouldings meet exactly.



If the angle is open on the inside (FIG. 3B) unscrew the angle set screw (REF L, FIGURE 2) until the corners meet exactly.

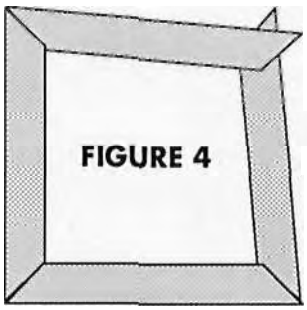


FIGURE 4

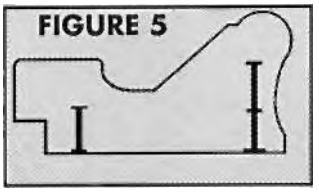
If you obtain this result (FIGURE 4), then your mitres are not exactly 45°. Periodically check your cutting machine for angle accuracy.

SQUARE FRAMES : IT IS IMPOSSIBLE TO MAKE AN ASSEMBLY OF LESS THAN 90°

III - SETTING OF CLAMP D (FIGURE 1)

- Raise lever B to bring clamp D forward slightly,
- Release handle I,
- Position two mouldings against fences M & N,
- Bring the clamp into contact with the moulds, without forcing it,
- Tighten handle I,
- Lower lever

IV - SELECTION OF STAPLING POSITION



The CS 910 is designed to enable wedging of mouldings at 1 or 2 points, with one or several wedges stacked at each of these two positions.
The choice must be made according to the width and the height of the moulding.

NOTE : IN ALL CASES, WEDGES MUST BE INSERTED AS CLOSE AS POSSIBLE TO THE HIGHEST CROWN OR CROWNS OF THE MOULDING (FIGURE 5)

Release operating levers X and W (FIGURE 1)
Place one moulding against fence M and slide it as far as stop N (FIGURE 2)

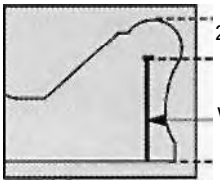
a) First position : inside of frame :
Slide bracket E towards fences M and N until the selected stapling position is reached, and draw operating lever W towards you to the position and lock it.

b) Second position : on the outside of the frame.
Slide bracket E towards fences M and N until the stapling position is reached, and push operating lever X to the position, and lock it.

TIP : **Use the measuring stickers next to both stops W & X to determine the best selections of wedging positions for your mouldings.**

V - SELECTION OF WEDGES

The size of the wedges (5, 7, 10, 12 or 15 mm - 3/16", 1/4", 3/8", 1/7", 5/8") must be selected on the basis of the height of the moulding . As a general rule a minimum allowance of 2 mm (2/25") is made above the wedge.
E.g.: Moulding thickness 12 mm (1/2") : 10 mm (3/8") wedge (see below)



WEDGES' SIZES	CARTRIDGE COLORS
5 mm (3/16")	ORANGE
7 mm (1/4")	PINK
10 mm (3/8"	BRIGHT BLUE
12 mm (1/2"	DARK BLUE
15 mm (5/8"	WHITE

*Two types of wedges : for normal and hardwood (see bellow NOTE 2)

NOTE 1 : Wedges of the same size may be **stacked** (FIGURE 6), in order to avoid the need for changing the cartridge, if you are joining frames of different thicknesses.

NOTE 2 *:* There are also **wedges made especially** for hard woods (BD).where standard wedges would not be adequate, i.e. they would bend, break or fail to penetrate entirely.

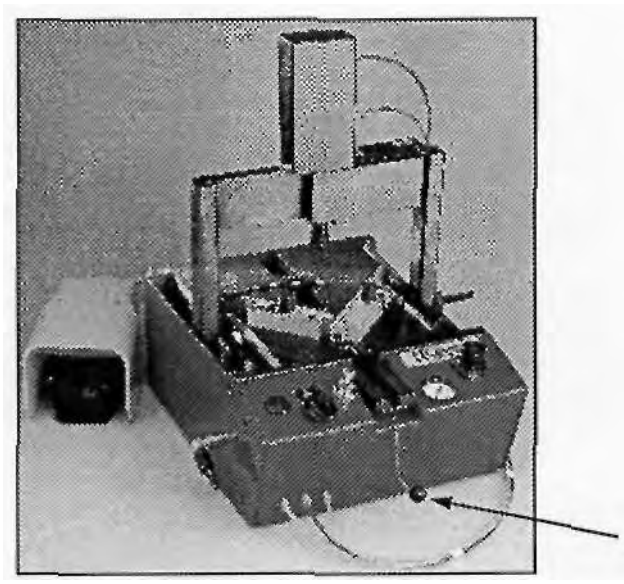


FIGURE 7

VI- CHANGING THE CARTRIDGE (FIG 7)

1 - Pull back the wedge pusher spring (FIGURE 7- F)
2 - Remove the empty cartridge
3 - Insert the new cartridge in the wedge distributor's window making sure the cartridge is firmly against the distributor block.
4 - Release slowly wire (F).

VII - LOCATION OF PLUNGER

The vertical plunger can operate without setting at all ring heights but the height of the plunger can be adjusted by the setting ring (reference C in FIGURE 1)

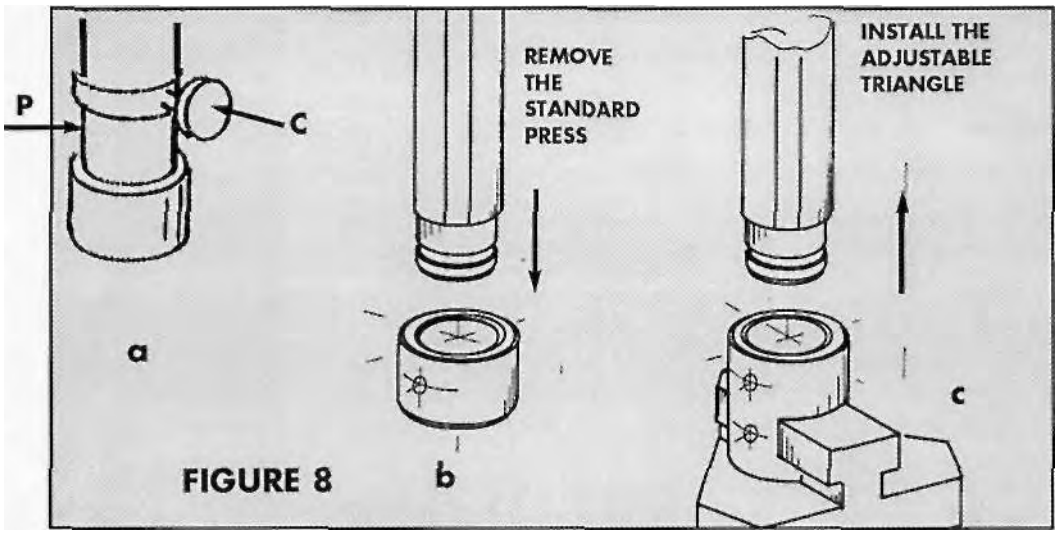


FIGURE 8

NOTE : In a general way you should use the metal round plunger end. Only if the plunger makes marks on very soft the mouldings, then use the adjustable triangle. (FIGURES 8 a, b, c)

IMPORTANT : If working with small mouldings, the vertical plunger can be set so that the distance between the moulding and plunger in minimized.

TIP/HINT : For production joining, it is recommended to reduce the distance of plunger P to approx 3/8" from the moulding, using screw C, and to accelerate the firing of wedges by adjusting button T (towards +) (see FIGURE 1).

It is also possible to control the firing rate of plunger P using the knurled button R located at the top of the machine.

USE

II- ASSEMBLY OF FRAME (FIGURE 9)

Follow these steps after settings have been made the fences adjusted, appropriate wedges insert.

CS 910 Jr (TABLE TOP)

1 - Place the first moulding against left fence M, and slide it as far as right as fence N,

2 - While holding the first moulding, place the second moulding against right fence N and slide it until it touches the first one,

3 - Slide bracket E to the first position .

4 - Gently press on the pedal to lock both mouldings by means of clamp D,

5 - Then press the pedal fully to fire the first wedge.

Where several wedges might be stacked, slightly withdraw pedal pressure in order to keep the mouldings clamped, then fully press once again and the second wedge will be located to reinforce the first one.

6 - When firing wedge at the second position, slightly withdraw pressure on the pedal, move the bracket to the other position, then press fully once again in order to insert a wedge,

7 - Fully release the pedal.

CS 910 Sr (SENIOR)

1 - Place the first moulding against left hand fence M, and slide it as far as right fence N,

2 - While holding the first moulding, place the second moulding against right hand fence N and slide it until it touches the first one,

3 - Slide bracket E to the first position.

4 • Press on the pedal to lock both mouldings by means of clamp D,

5 - Then press the firing button (FIG 1 - PART V) to fire the first wedge. If you wish to stack a second wedge in the same position (one on top of the other), press the button once again.

6 • For a second wedge, move the bracket assembly to the second position, keeping the pedal pressed (mouldings clamped). Press the stapling button to insert wedge (s).

7 - Releasing the pedal will release the corner.

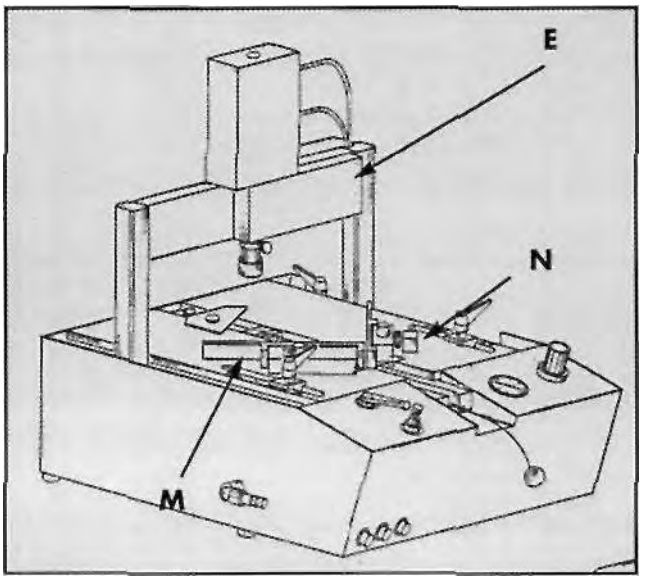


FIGURE 9

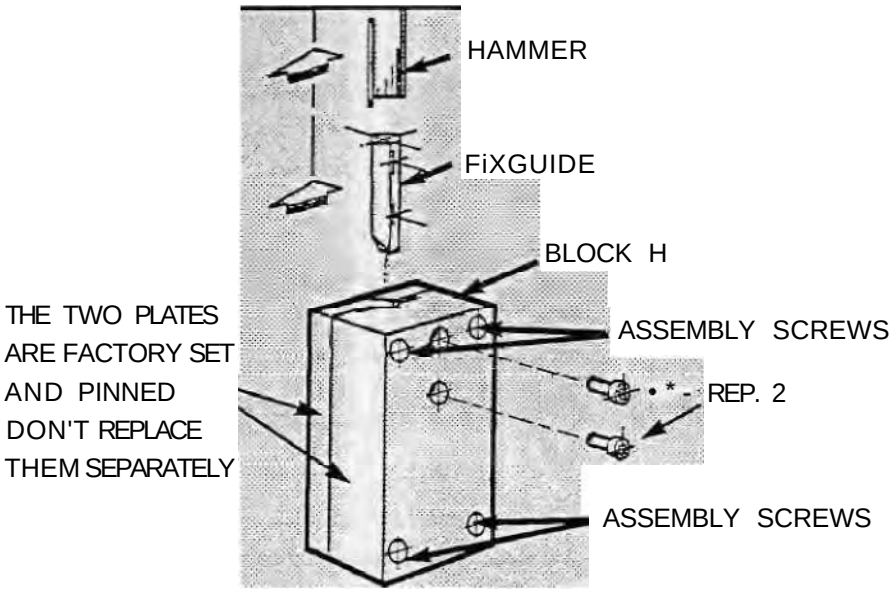


FIGURE 10

PROCEDURE :

1 - Remove the present wedge cartridge,

2 - Using the 3 mm Allen key, loosen the retaining screw from the bar at the front of block H, (see FIGURE 1) (from the side of the horizontal clamp) and remove the block H,

3 - A/ IF HAMMER IS BROKEN : It will have remained in block H, and in this case :

a) Using a 2,5 mm Allen key, unscrew the 2 central screws (reference 2 in FIGURE 10) which hold the fix guide in position,

b) Remove the fix guide completely, then remove the broken hammer. If the hammer will not come out, remove the assembly screws of block H. Remove hammer.

c) Re-assembly the block H (The two plates of the block H are factory set and pinned. Don't replace them separately. Relocate the fixed guide and tighten its two screws (R E P . 2) ,

d) Relocate the block in its housing in the correct direction, i.e. with the window facing the wedge cartridge ; check with your finger that the block H is not higher than the machine's work table.

e) Lock the block H retaining screw using the Allen key,

f) Fit the new hammer (with the hole downwards) in block H from the top until it no longer protrudes,

g) Switch the machine on, insert a bracket or two moulding pieces and **simulate** a stapling operation, (without wedge cartridge)

h) The new hammer will automatically take the correct position in the machine,

i) Reload the cartridge.

3 - B/ THE HAMMER IS NOT BROKEN BUT YOU WISH TO CHANGE IT :

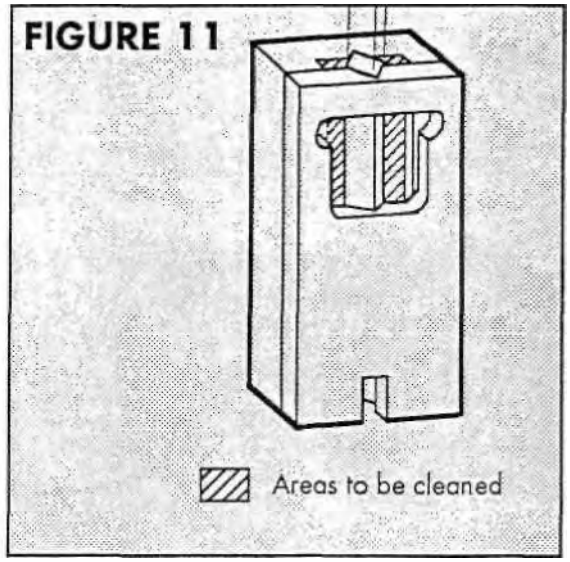
a) Perform the same operation as in Procedures 1 and 2,

b) Using pliers, remove the hammer from its mounting by pulling vertically,

c) Repeat steps " e" to " i " above.

II - MAINTENANCE OF "WEDGES DISTRIBUTION" SECTION (bloc H)

At regular intervals remove bloc H from the machine and clean it using compressed air (Figure 1 1).
Lubricate the hammer slightly before re-assembly



III - MAINTENANCE & LUBRICATION

If the horizontal travel of the bracket (FIGURE 1, reference E) is no longer smooth, then lubricate the horizontal shafts (use 2 0 / 4 0 SAE oil).

If glue is used, lightly spray the plates with silicone oil (aerosol can), which will make it easier to clean off spots of glue after drying.

Clean the table top periodically, preferably with a non-scratching material. Remove all excess glue as fast as possible.

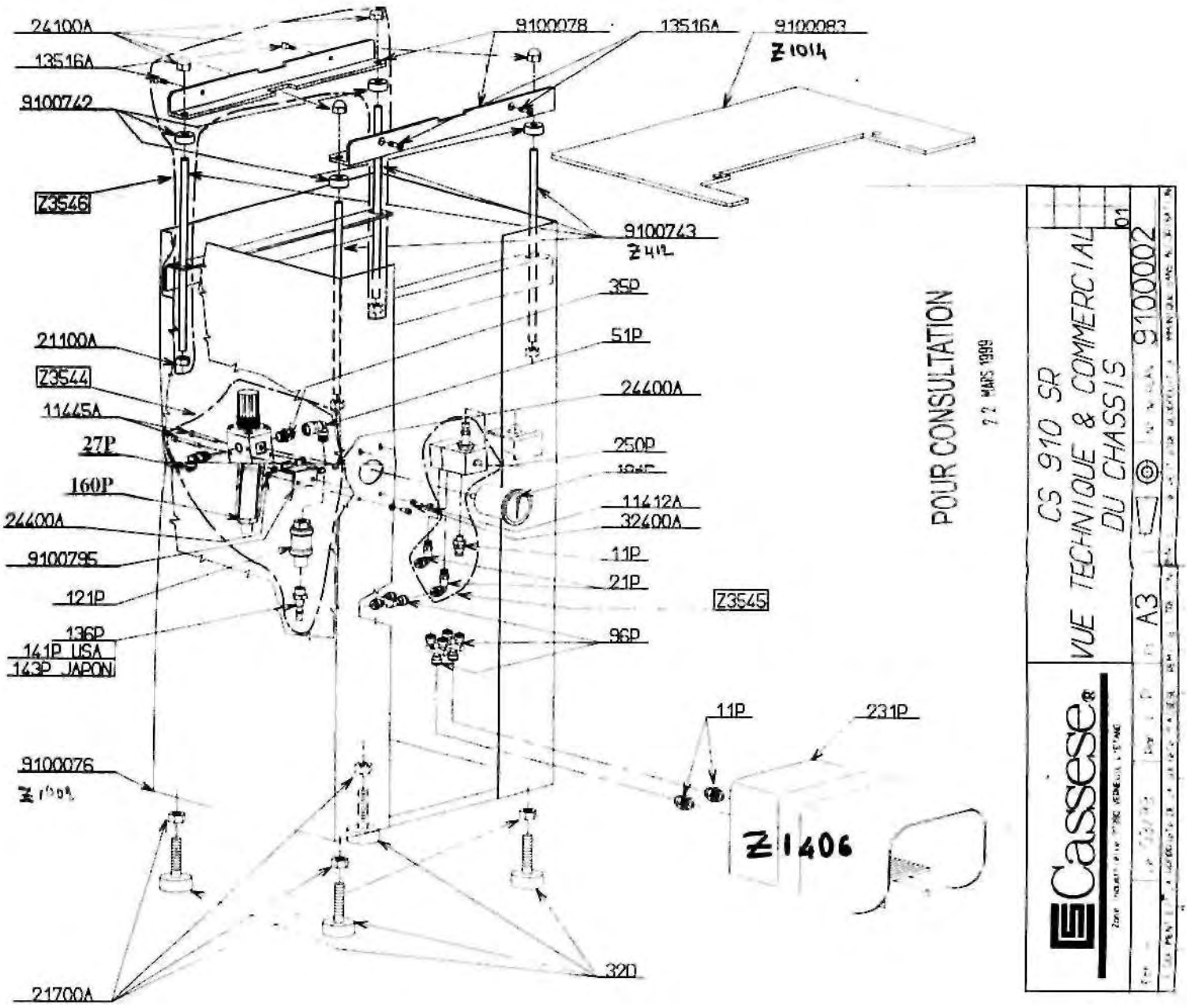
IMPORTANT NOTE :

WHEN ORDERING ANY SPARE PARTS, EVEN THOSE REPRESENTED WITH LETTERS OR NUMBERS IN THE "FIGURES", PLEASE SPECIFY ITS REFERENCE NUMBER WHICH YOU WILL FIND ON THE EXPLODED VIEWS OF THE MACHINES (SEE END OF THIS MANUAL)

TROUBLE SHOOTING

PROBLEM	POSSIBLES CAUSES	SOLUTIONS	PAGE
THE CLAMP DOES NOT CLAMPTHEM0ULDING	C 1 : Moulding clamp setting is incorrect	S. 1: Repeat setting and ensure clamping of operating lever 1	P4-SIII
THE RIGHT MOULDING IS NOT CLAMPED	C. 2 : excessive distance between moulding and clamp	S.2: Repeat setting of operating lever using lever H	P4-§III
THE LEFT MOULDING IS NOT CLAMPED	C 3: Clamp setting is incorrect C .4: Assembly angle is too wide	S. 3: Repeat setting of moulding clamp with lever H S .4: Repeat setting of assembly angle	P4-§III P4§II fig 3B
ANGLE OPEN ABOVE/BELOW	C. 5: Incorrect setting of back fences M & N	S. 5: Repeal setting of two fences M & N	P4-SI/II
TOP ANGLE OF CORNER IS OPEN	C. 6 : Plunger speed and wedge firing are not synchronised	S.6: Repeat setting of synchronisation button (turn a little clockwise)	P7 "TIP"
THE PRESS LEAVES A MARK ON THE MOULDINGS	C.7: Plunger coming down too fast C.8: Distance between plunger and moulding is too big C.9: Moulding is delicate	S. 7: Repeat setting of top pressor descent speed S. 8: Repeat distance setting S. 9 : Repeat distance setting and use the joining jigs	P.7 TIP P6 'NOTE" P6 § VI
WEDGES WILL NOT FIRE	C1O: The cartridge is empty C 1 1: The cartridge is incorrectly positioned C 1 2: The hammer is broken	S.10: Insert a full cartridge S.11 : Withdraw wire F and position the cartridge fully in, then release gently S.12: Replace the hammer	P6-§V P6-§V P 8 § 1
WEDGES DO NOT PENETRATE INTO THE WOOD	C 13: Using incorrect wedges C14: Inadequate stapling pressure C15: Plunger speed & wedge firing not synchronized C.16: The plunger is not in contact with the moulding but resting at fences M & N C17: The hammer is broken C18: Sub-assembly is clogged C19: The tension spring is broken or over-extended C.20: Loss in pressure at moment of firing	S.13: Use hard wood wedges S.14: Check pressure gauge readings S.15: Repeal setting using button T (clockwise) S.16: Use side bars for small mouldings (accessories) S. 17: Replace the hammer S. 18 : Have the hammer cleaned S.19: Replace the spring (PART 6520) S. 20: Check compressor pressure & hose connections - including foot-pedal	P5-NB2 P3-§II P7 "ADVICE" PI §11 P 8 §1 P 9 § II
WEDGES WILL NOT STACK	C 21: Incorrect positioning of wedge in the moulding, causing it to till and preventing stacking C 22: Hammer is blunt or jagged (dry clattering noise is heard on stapling) C 23: Trying to stock in hardwoods C 24: Serious drop of pressure in the compressor: defect in blow-off valve: serious inaccrocy in reference 0 pressure gauge needle (e.g. from 7 to 3 bars, and very slow rise of needle].	S. 21: Repeat setting of stapling position S. 22: Replace the hammer S. 23: Use taller wedges (HW) S. 24: Replace the blow-off valve	P5-SIII P 8 § I P5-SIII

FOR TECHNICAL ASSISTANCE CALL YOUR SALES DISTRIBUTOR


24100A
13516A
9100742
Z3546
21100A
Z3544
11445A
27P
160P
24400A
9100795
121P
136P
141P USA
143P JAPON
9100076
Z1404
21700A
9100078
13516A
9100083
Z1014
9100743
Z412
35P
51P
24400A
250P
11412A
32400A
11P
21P
Z3545
96P
11P
231P
Z1406
320
POUR CONSULTATION
22 MARS 1999
CS 910 SR
VUE TECHNIQUE & COMMERCIAL
DU CHASSIS
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9100002
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Cassese

PLUNGER SUB-ASSEMBLY
(FIG 1-P)

BRAKE CYLINDER
(Part 177 P)

STAPLING CYLINDER
SUB ASSEMBLY
CLAMP CYLINDER
(Part 197 P°

PLUNGER SPEED KNOB
(FIG 1-R, Part 125P)

STAPLING DELAY SWITCH
(FIG 1-T, Part 250 P)

STAPLING DISTRIBUTOR
(Part 243 P)

PEDAL
(Part 230 P)

STAPLING BUTTON
(FIG 1 V, Part 218 P)

PRESSURE GAUGE
(FIG 1 - 0, Part 159 P)

PRESSURE REGULATOR
(FIG 1 - U, Part 161 P

ON/OFF SWITCH
(FIG 1 - S, Part 121 P)

AIR SUPPLY

PLUNGER SUB-ASSEMBLY
(FIG 1 P)

BRAKE CYLINDER
(Part 177 P)

STAPLING CYLINDER
SUB ASSEMBLY
CLAMP CYLINDER
(Part 197 P)

PLUNGER SPEED KNOB
(FIG 1-R, Part 125P)

STAPLING DELAY SWITCH
(FIG 1-T, Part 250 P)

STAPLING DISTRIBUTOR
(Part 243 P)

PEDAL
(Part 231 P)

STAPLING BUTTON
(FIG 1 V, Part 218 P)

PRESSURE GAUGE
(FIG 1 - 0, Part 159 P)

PRESSURE REGULATOR
(FIG 1 - U, Part 161 P

ON/OFF SWITCH
(FIG 1 -S, Part 124 P)

AIR SUPPLY

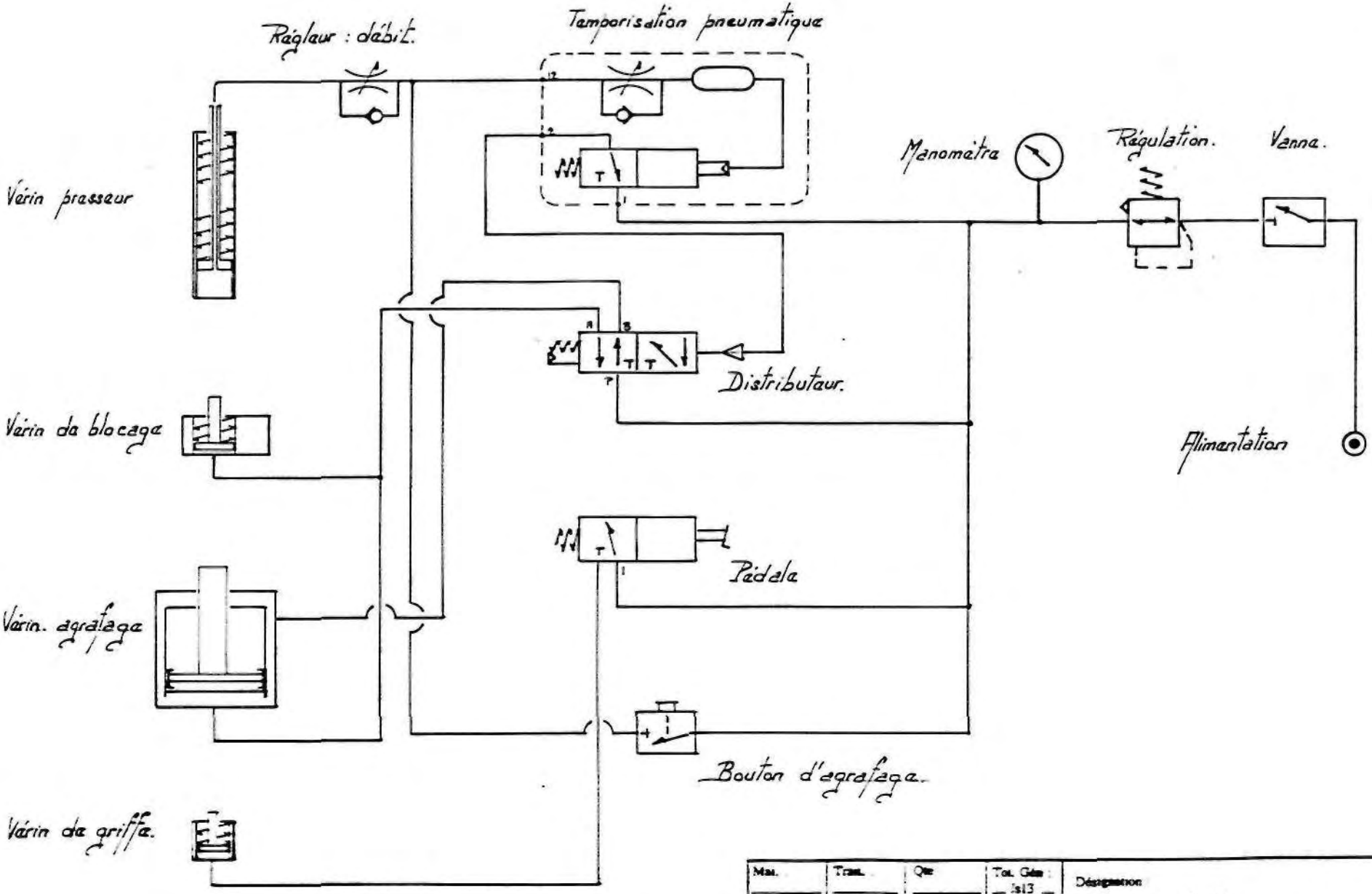
PNEUMATIC DIAGRAM
OF THE CS 910 JUNIOR

PNEUMATIC DIAGRAM
OF THE CS 910 SENIOR

PNEUMATIC DIAGRAM
OF THE CS 910 SENIOR

PNEUMATIC DIAGRAM
OF THE CS 910 JUNIOR

PNEUMATIC DIAGRAM
OF THE CS 910 JUNIOR



Mat.	Trait.	Qte	Tol. Gén. ±1/3
Ech. 1	Le 06.94	Par S.	

Désignation

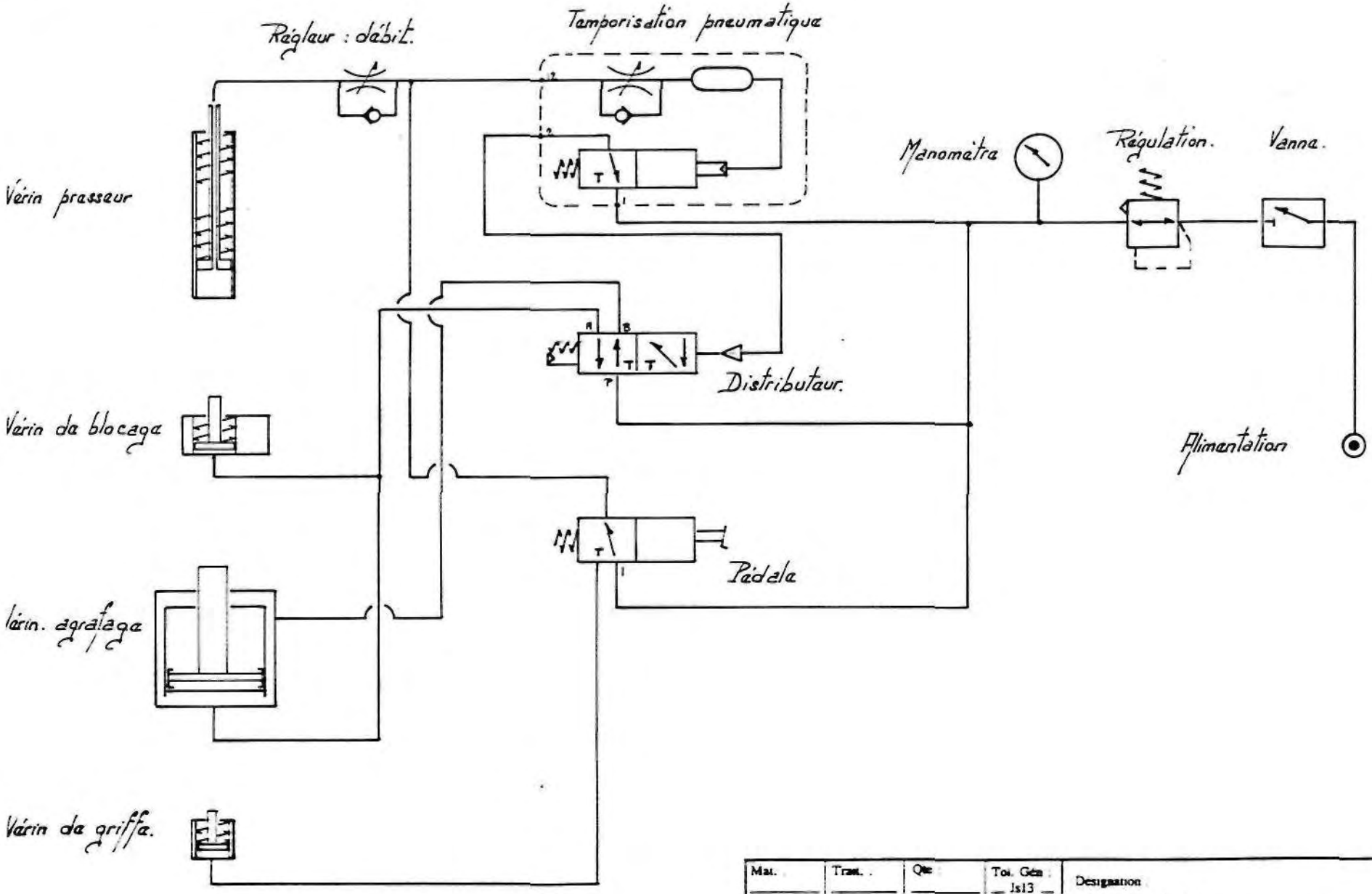
Schéma pneumatique Principe.

Cassese.

Zone Industrielle 77390 PERNEUIL L'ETANG

Génior CS 910

Ind. | Le | Par | Objet de la modification



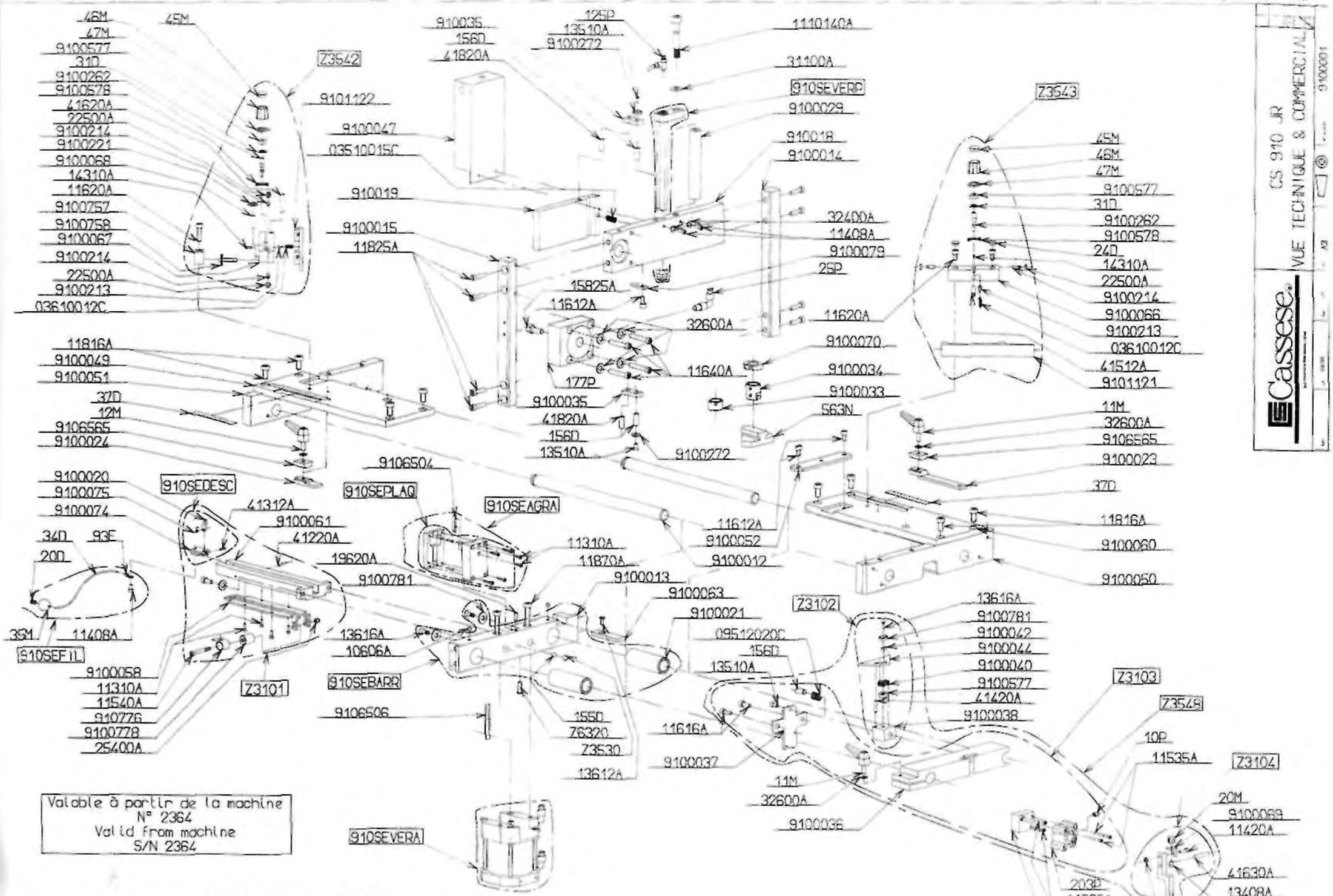
Mat.	Trait.	Qte	Toi. Gén. Is13
Ech : /	Le : 06.94	Par : S	

Designation : Schéma pneumatique Principe.

Cassese.
Zone Industrielle 77390 VERNEUIL L'ETANG

Junior. CS.910

Ind.	Le	Par	Objet de la modification


CS 910 JR
VUE TECHNIQUE & COMMERCIALE
Cassese
46M
47M
9100577
31D
9100262
9100578
41620A
22500A
9100214
9100221
9100068
14310A
11620A
9100757
9100758
9100067
9100214
22500A
9100213
03610012C
45M
Z3542
9101122
9100047
03510015C
910019
9100015
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9100035
156D
41820A
125P
13510A
9100272
1110140A
31100A
910SEVERP
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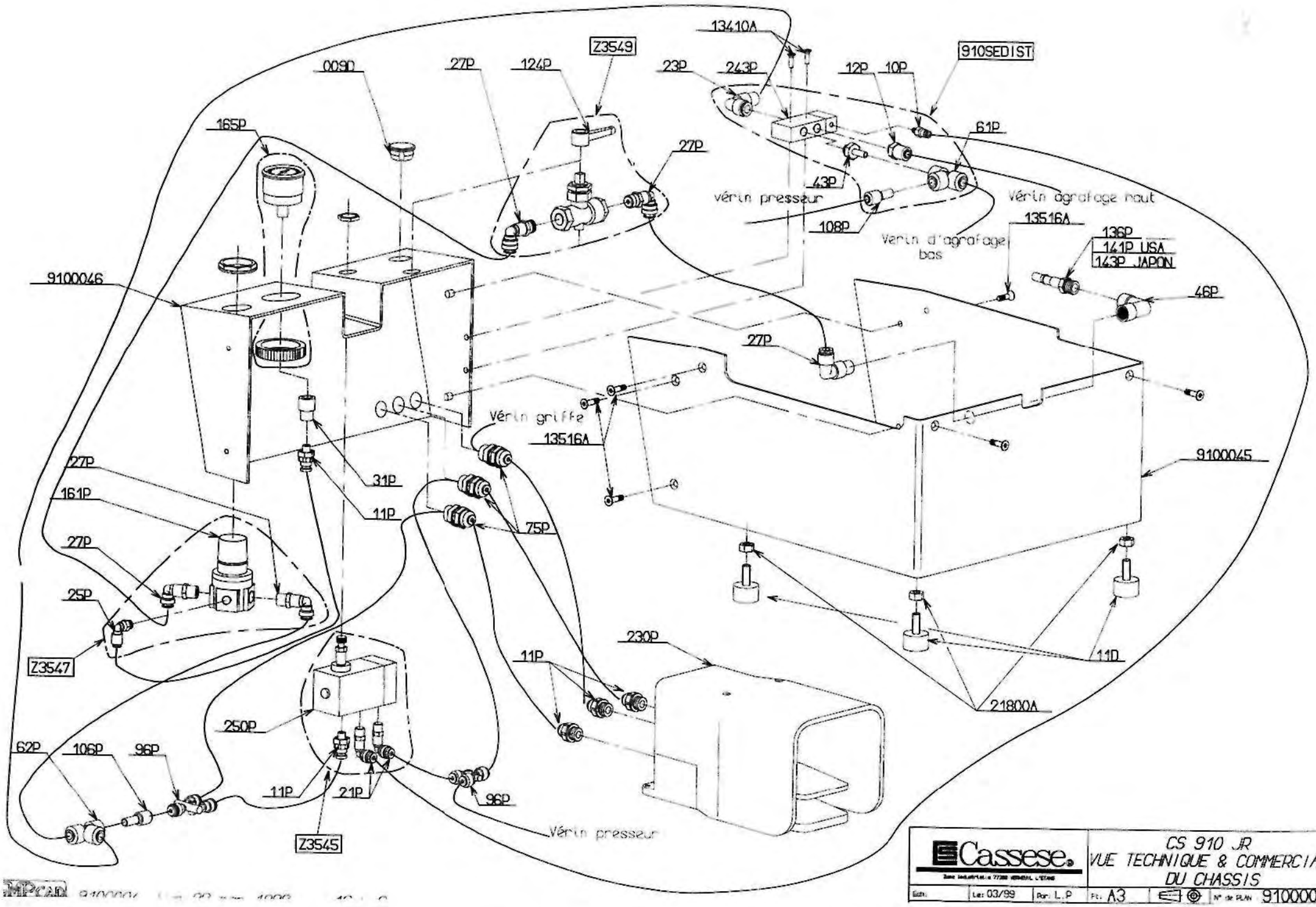

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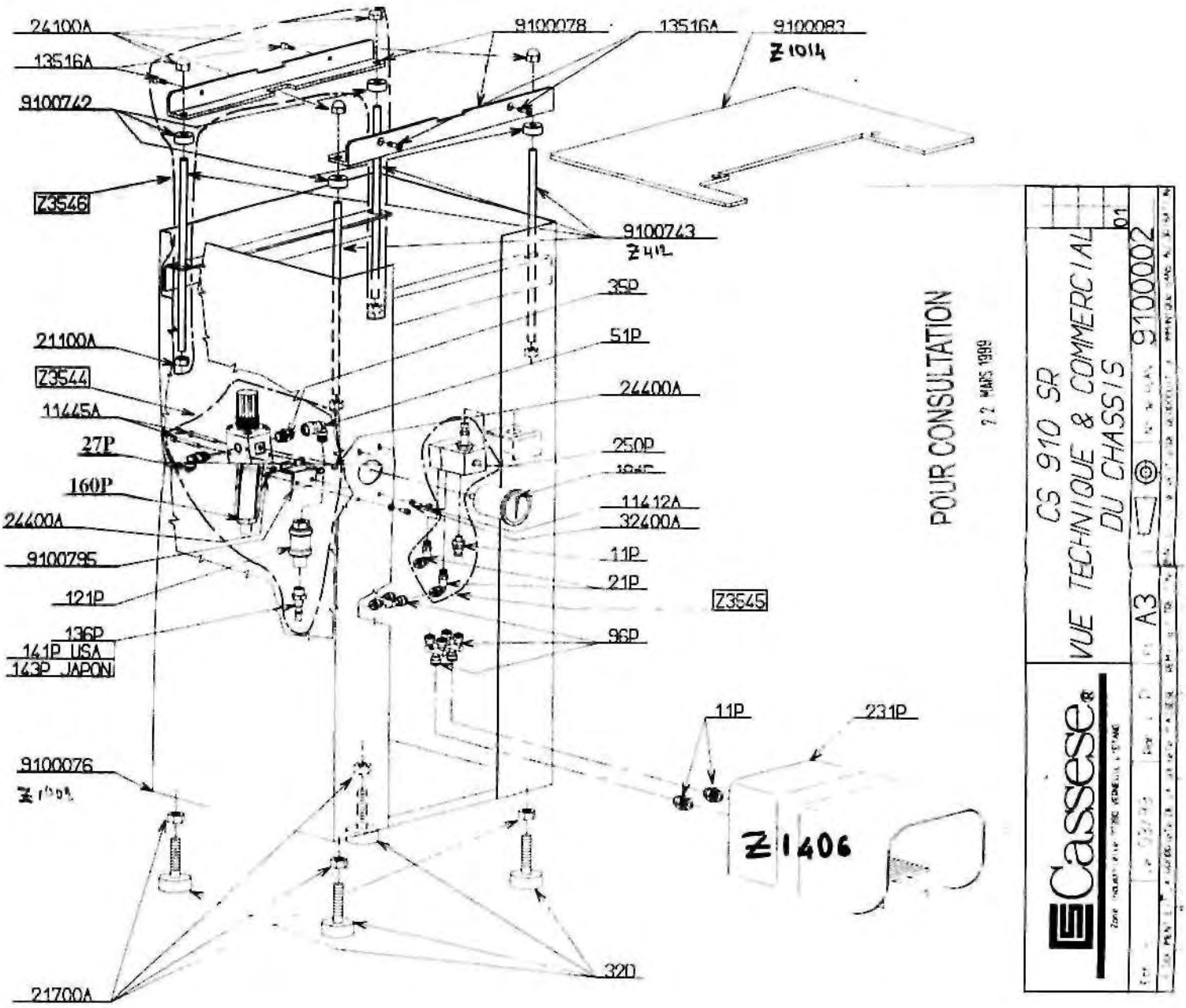
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POUR CONSULTATION
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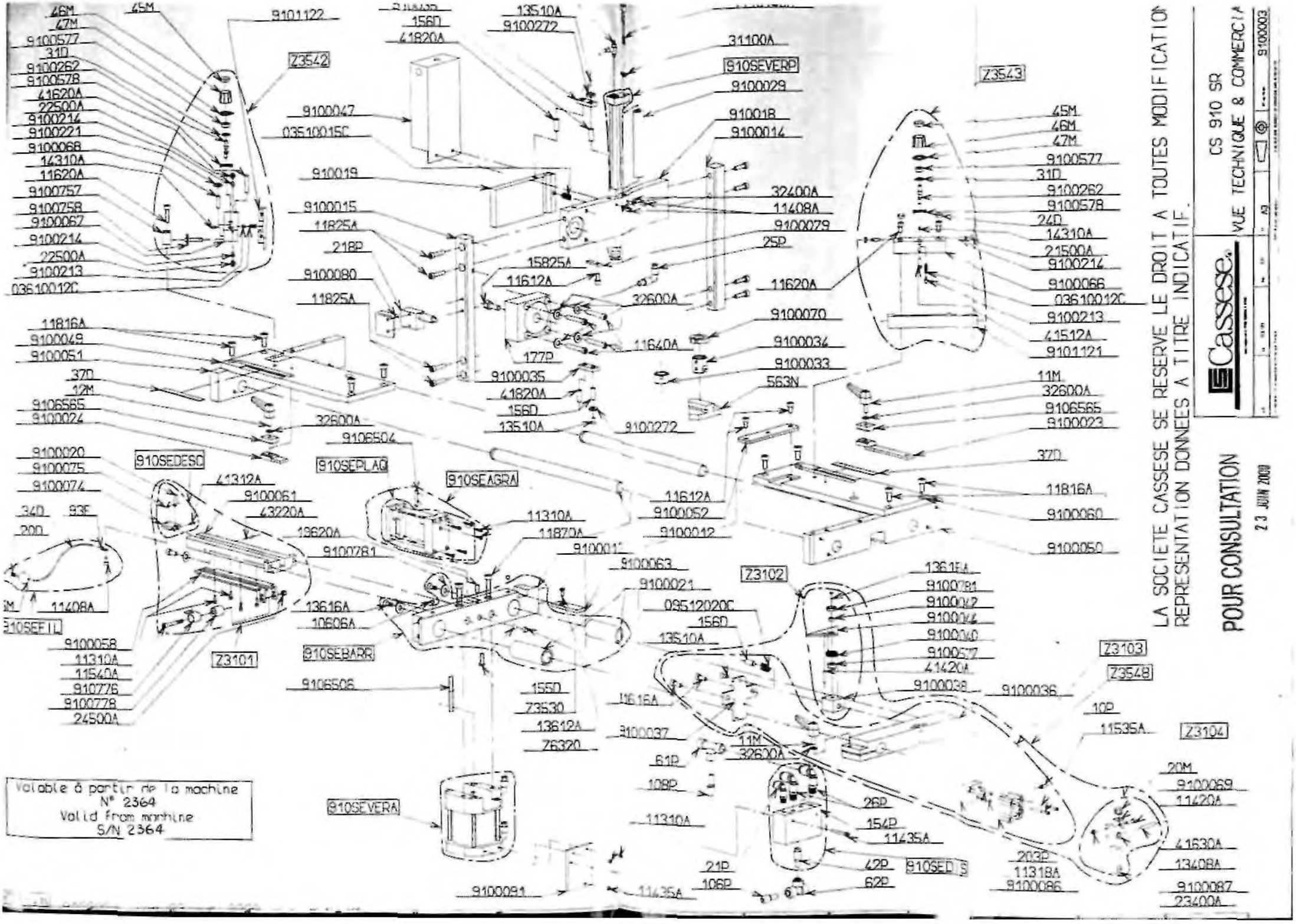
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REPRESENTATION DONNEES A TITRE INDICATIF.
Valable à partir de la machine
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