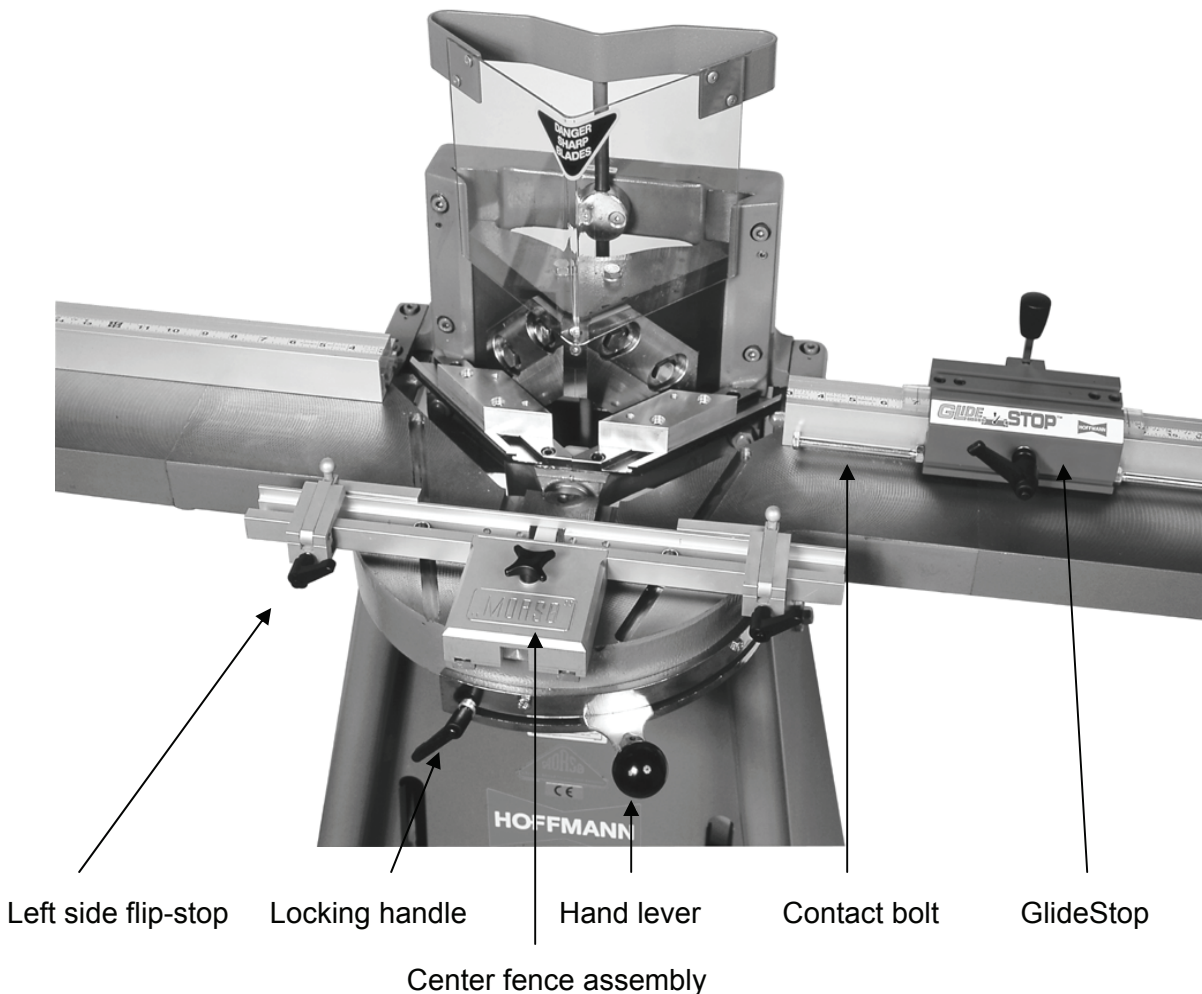


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Installation Instructions for DGS 1000 Fence System on MORSO NFXL and NXLEH notching machines



MORSO NFXL manual notching machine with DGS 1000 fence system shown

Installation and set-up is identical on MORSO NXLEH electro-hydraulic model.

Questions??

Toll – free Technical Support Line (866) 248 – 0100

Monday – Friday 8.00 AM – 5.00 PM EST

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The DGS 1000 Fence System contains the following items:

- (2) Five foot heavy-duty fence rails, silver anodized finish
- (1) Left hand self adhesive tape scale
- (1) Right hand self adhesive tape scale
- (1) Red GlideStop with two 5" long contact bolts and locking handle
- (4) Aluminum mounting brackets to install fence rails on machine extension tables
- (8) M6 x 20 bolts and washers to bolt brackets to tables
- (8) ¼"-20 x 1" hex head screws, washers and nuts to install fences to brackets
- (1) Instruction manual for GlideStop

Installation:

- Carefully remove all three knives (one nose knife and two side knives) from the notching machine before starting any cleaning or assembly work
CAUTION: Knives are very sharp!!
- Remove majority of rust protection grease with a plastic spatula or piece of scrap wood, then thoroughly clean machine with mineral spirits. Do not use lacquer thinner – damage to machine finish will occur!
- Apply a light coat of wax (beeswax or butcher block wax) or other suitable rust inhibitor to all exposed cast-iron surfaces to prevent surface rust.
- Install the cast-iron extension tables on both sides of the machine, making sure the bolts and pins for the standard fence rails are along the back edge of the tables (away from the operator).
- Remove the steel pins (five per side) by pulling them out with wire cutters, then remove the small socket head bolts and washers (five per side) from the top surface of the extension tables.
- Locate the tapped holes along the back edge of extension tables and install mounting brackets with M6 x 20 bolts and washers. Align the brackets flush with table surface.
- Place two ¼"-20 x 1" bolts in each of the four brackets and loosely install lock washers and nuts.
- Slide the fence rails onto brackets, making sure the heads of the ¼"-20 bolts slide into the rearmost T-channel on the underside of the fence rail.
- Pull the fence rails toward the operator so that the front edge of the DGS 1000 fence rails is in approximately the same position as the original MORSO fences and tighten the ¼" nuts.
- Install the two long contact bolts and lock nuts on the red GlideStop, then place the GlideStop on the right hand fence rail.
- Carefully install a nose knife, lower the cutting head and with a steel ruler adjust the GlideStop for a 12" distance between the center mark on the knife and the contact bolt. Using a pencil, mark the hairline pointer location on the fence rail, clean the rail with alcohol and place the self adhesive tape scale in the center of the rail.
- Repeat on left side fence rail.
- Make a test cut and use the contact bolts to adjust the measurement if necessary.
- Install the indexes (short socket head bolts and square nuts) in the rear channel of the fence rails.

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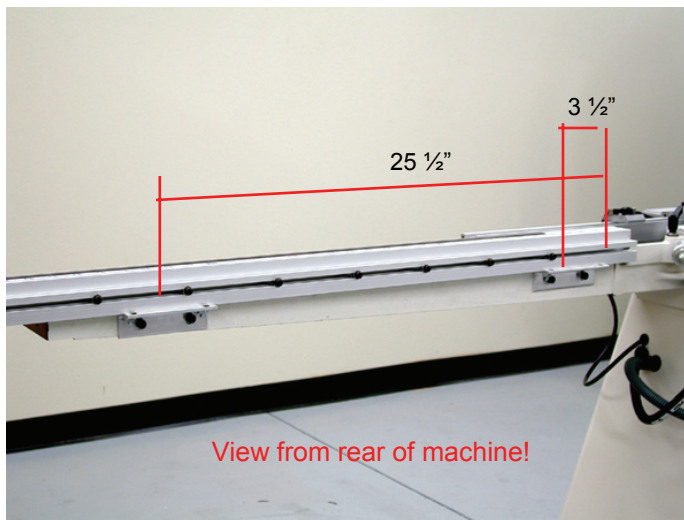
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Helpful Hints:

- **NEVER TRY TO CUT A NOTCH IN ONE PASS!!**

This will result in a torn-out cut, excessive strain on the machine and greatly reduced knife life. Depending on the thickness and hardness of the moulding, between 2- 5 cuts are used for a clean result.

- The left and right hand fence rails are used on the machine solely for the installation of the tape scales, the GlideStop and the stop indexes. Do not rest the moulding against the rear fence rails – the only reference plane for the moulding is the 17 1/2" long center fence rail.
- With moulding placed against the center fence, adjust the center fence assembly for a gap of about 3/8" between the beaded moulding edge and the rear fence rails. This setting will still allow the end of the moulding to touch the contact bolt on the GlideStop.
- Always try to size the cross rails (beaded on both sides) with the flat portion in between the beads matching the width of the nose knife! With the cross rails matched to the nose knife, a notch can be completed in 2-4 down strokes, without having to move the moulding sideways and re-cutting for a wider rail.
- If wide cross rails are needed, it is best to make a small spacer block. The spacer can be fixed in width or with a small screw for fine adjustment. The spacer is placed between the end of the moulding and the GlideStop. After the notch is cut, the spacer is removed and the moulding pushed against the GlideStop bolts for the second cut.
- The lateral movement of the cutting head is controlled with a hand lever on the front of the machine. This lever is secured during shipping with a small, black locking handle. To achieve maximum rearward travel of the head, the small locking handle must be removed. For storage, it can be installed to the far right side of the hand lever.
- To assure the end of the moulding makes secure contact with the GlideStop, always make end cuts on the stiles (for the top and bottom rails) last. Use the flip-stops on the center fence assembly for end cuts. For cuts wider than 5" (for tall top rails or toe-kick bottom rails), switch the flip-stops and use the right flip-stop on the left side of the center fence and vice versa.
- When it becomes necessary to sharpen the knives, return them to Hoffmann Machine Company, Inc. for service. We have a specialized grinding machine to duplicate the factory hollow-ground angle and we hand-hone the knives to MORSO specs. Flat grinding will ruin the knives and void the warranty.



GlideStop fence rail on NXLEH

Approximate distance from machine end of extension table to center of angle brackets is 3 1/2" and 25 1/2"

If machine is not pre-drilled for brackets, hold brackets at above distance and mark center of holes.

Drill and tap for 6mm socket head cap bolts (included) or for 1/4"-20 bolts (not included) and install brackets flush with table surface.