

SERVICE & INSTRUCTION MANUAL

VN-J

MODEL NO. _____

SERIAL NO. _____



PISTORIUS MACHINE CO., INC.

1785 EXPRESS DRIVE NORTH (RT. 495) ■ HAUPPAUGE, NEW YORK 11787



WARRANTY

Seller guarantees all machines and parts of its own manufacture against defects in material and workmanship for a period of six months from date of shipment under normal use and service by buyer. No other warranties are to be implied with respect thereto. The liability of Seller under its warranty is limited to adjustment, in accordance with the Warranty Adjustment Terms set forth below, for products which are found to be defective by Seller in the form in which they were originally shipped. In no event will Seller be liable for collateral, consequential or other damages of any kind or nature.

WARRANTY ADJUSTMENT TERMS

- (a) Adjustments will be limited to claims which are presented promptly after the product is found to be defective, and within the aforesaid warranty period.
- (b) All products claimed to be defective will be subject to inspection and test by Seller. Normally, Seller will request return of products for inspection and test, however, Seller reserves the right to make inspection and test on Buyer's premises. Returns are to be made only as and if authorized in writing by Seller.
- (c) Buyer will pay all packing, inspection, labor, and transportation costs involved. Credit for the transportation costs only will be issued by Seller provided adjustment subsequently is allowed.
- (d) No adjustment will be allowed for products which have been subjected to abuse, improper installation or application, alteration, accident or negligence in use, storage, transportation or handling; nor for products on which original identification markings have been removed, defaced or altered.
- (e) Final determination as to whether any adjustment is allowable, and as to the extent thereof, rests with the Seller. Full adjustment if allowed, normally will be replacement in kind on an exchange basis. Pro rata adjustment if allowed normally will be made by the issuance of credit. In all cases, however, Seller reserves the right to make adjustment by repair, replacement or credit.
- (f) Replacements for products found subject to adjustment, whether new or repaired, will be shipped FOB city of destination with transportation charges prepaid by Seller.

INSTALLATION

Buyer shall install machinery purchased from Seller at Buyer's cost and expense, unless otherwise expressly stipulated, in writing. At the request of Buyer, Seller will recommend competent engineers to supervise the installation, and to instruct the Buyer in the proper operation, of the machinery and equipment. During such period of supervision and instruction, such personnel shall be deemed to be employees of the Buyer who shall pay the wages, remuneration, board and traveling expenses of such personnel shall not make Seller liable, directly or indirectly, in any manner whatsoever, for any damages resulting from any act of commission or omission or any misfeasance or malfeasance, on the part of any said personnel.

CANCELLATIONS OR RETURNS

Buyer shall not cancel any order nor return any equipment without first procuring the written consent of Seller. In any event, in case of refusal or inability of Buyer to accept a delivery, the Buyer shall nevertheless be liable for freight, express, storage, handling, restocking and any other expense resulting. In no event are orders for machines or parts built to customer specifications subject to cancellation and Buyer shall be liable for work done and materials used.



SAFETY RULES

READ BEFORE OPERATING OR MAINTAINING MACHINE

1. Make sure the area is hazard free of contaminated air, chips, debris, grease, oil, anything slippery, obstructions, etc.
2. Do not operate until properly instructed in the safe use of the machine.
3. Do not operate without all guards, shields, covers, etc. securely in place.
4. Make sure the machine is electrically grounded.
5. Remove or confine all loose clothing, hair, jewelry, bracelets, necklaces, etc.
6. Use all applicable safety equipment, goggles, face masks, gloves, etc.
7. Check the machine to be used for improper functioning, worn parts, wrong parts, wrong rotation, secure and correct tooling installed, damaged, etc.
8. Do not alter the machine, operate outside of design limits or use, etc.
9. During use do not put hands, or anything else, under guards, shields, covers, etc.
10. When not using the machine, leaving the area or cleaning the area, turn the machine off.
11. Do not clean, adjust, maintain or service the machine unless it is turned off and all power sources disconnected.
12. Keep the machine in good, safe repair and cleanliness.



INSTRUCTION SHEET

FOR

MODEL "VN-J" VEE NAIL JOINING MACHINE

DELIVERY

Upon receipt of machine, check for a full complement of parts and damage, if any, reporting same to common carrier and Pistorius Machine Co. Carrier is solely responsible for the intact delivery of shipment.

CAUTION

Handle with care to prevent sliding and swinging parts from causing injury.

INSTALLATION

The Model "VN-J" " Junior Nailer" is designed to use the latest blind fastening with our Vee Nails, together with conventional methods, to provide a universal miter joiner for picture frame mouldings. Therefore it would be wise to consider having a nailing gun, glue dispenser, drill, screws, hammer, nails, etc. readily available nearby. At least trays for the four sizes of Vee Nails should be within reach.

Select a suitable location that allows enough working room for the largest frame.

Fasten the unit down via the 3/8" holes in the base mount. Make sure the drive handle is free to hang down vertically and can easily be gripped at the bottom. The working surface of the vise should be about 42" from the floor. Since there is a lifting action, the mounting bench should either be heavy, or bolted to the floor.

If not utilizing work support of your own, beyond the vise, a sub-table can be mounted on the angles at the back and leveled with the vise.

OPERATION

Refer to the diagram for location of the parts named.

- 1- Slide the "Nail Head" out toward the front.
- 2- Bring the "Back Up Rod" up and clamp in this position lightly with the "Clamping Handle".



"VN-J"

- 3- Adjust the movable vise jaws, with the "Speed Handles", to allow insertion of the molding, into the vise. Lay the work pieces in the vise, against the stationary jaws with the mitered faces butted. Bring the movable vise jaws in, to bear against the work lightly. Adjust each molding until the mitered joint is satisfactory then tighten the jaws securely.
- 4- Place the proper length Vee Nail into position on the magnetized "Nail Post", with the ground knife edge up.
- 5- Push the "Sliding Head" backward, underneath the molding, to the position where the first Vee Nail is to be driven. This position should be located by the "Rabbit Stop" or the rule and pointer on the left side of the "Sliding Head".
- 6- Unclamp the "Back Up Rod" and allow it to fall on top of the work. Reclamp it tightly in this position.
- 7- With a smooth, slow motion, pull the "Drive Handle" forward and upward to its factory set stop and return.
- 8- Unclamp the "Back Up Rod" and raise it to the top and reclamp lightly.
- 9- Pull the "Sliding Head" out.

For subsequent nails, repeat the last five steps.

When driving Vee Nails piggy backed, into softer woods, set the "Piggy Back Stop" for the first nail. After loading the second nail, bring the "Sliding Head" against the stop again. Hold the head against the stop firmly, then slowly and smoothly drive in the second nail. Lift stop bar to bypass "Piggy Back Stop".

Due to the large variety of woods and shapes, it is difficult to be specific on Vee Nail locations. Generally, they should go into the thickest portions of the wood, and the "Back Up Rod" should bear on the high points. It is advisable to stay at least 3/16" away from the inside and outside edge to avoid splitting.

Sometimes it is advantageous to use other fasteners, such as on high moldings. The "Clamp Post" can then either be removed or swung out of the way by loosening the 3/8" Allen clamping screw at its base. This provides clearance for use of air guns, screws or nails. On re-inserting the "Clamp Post" bring the "Sliding Head" in, so that the post hole is over the table.



"VN-J"

Optionally, a spring and collar is available that fits over the top of the "Back Up Rod". This effectively causes the rod to always want to go up, and must be pushed down into the work, instead of dropping down under its own weight. Conversely, after nailing, it will go up automatically on releasing the "Clamping Handle".

MAINTENANCE

Keep the sliding parts of the "Nail Post" free of glue and keep well oiled. If the post should ever get stuck in the down position, pull the "Drive Handle" up and hold it there. This will expose the end of the nail post, which has a hollow roll pin. Insert a probe into this hollow roll pin and push up to free the post. The moving parts are all close fitting and must not be allowed to rust.

When and if the "Drive Handle" cam should wear excessively, the pivot pin can be removed, the handle turned 180° and the pin reinserted in the alternate pivot hole, thus providing a new wear surface.

Keep the ways for the "Sliding Head" clean and oiled. If excessive wear takes place, remove the two 3/8" Allen bolts which will separate the slide at the table. Separate carefully and look for round, thin shims over the holes. Remove one shim from each hole and re-assemble.

The screws for the movable vise jaws should be kept lightly oiled so that the "Speed Handles" spin freely.

The campling handle for the "Back Up Rod", can be repositioned to suit screw wear or operator preference. Tighten the screw, then pull the handle out, position it to suit then allow the spring action to pull it back to seat in this new position.

SAFETY

Do not load nails on the "Nail Post" unless both pieces of molding are clamped in the vise ready for the nails.

Keep one hand on the "Clamp Post" and the other on the "Drive Handle" when driving in Vee Nails.

Observe all necessary safety precautions when using other fasteners. Pneumatic nailing guns should be equipped with "Safety Triggers" so that they cannot be fired unless positioned over work.

MODEL VN-J HAND/LEVER OPERATED VEE NAIL FRAME ASSEMBLY MACHINE

HERE'S HOW IT WORKS

THE BELOW PROCESS TAKES ONLY SECONDS.

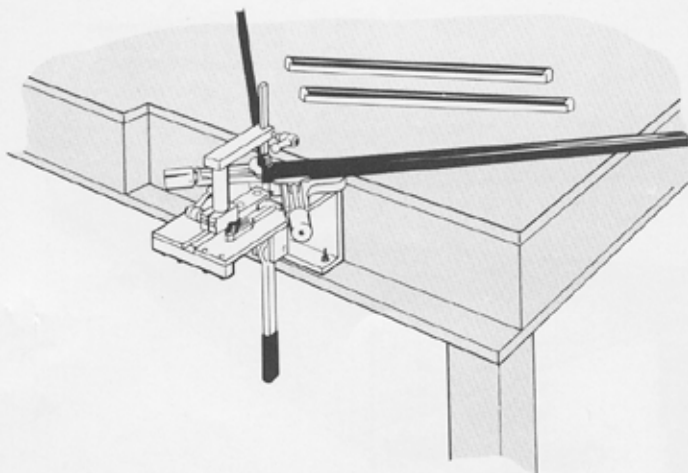
STEP ONE - Place mitered flat back moulding into clamp vise.

Slide nailing mechanism to desired nail position/s and set stop accordingly.

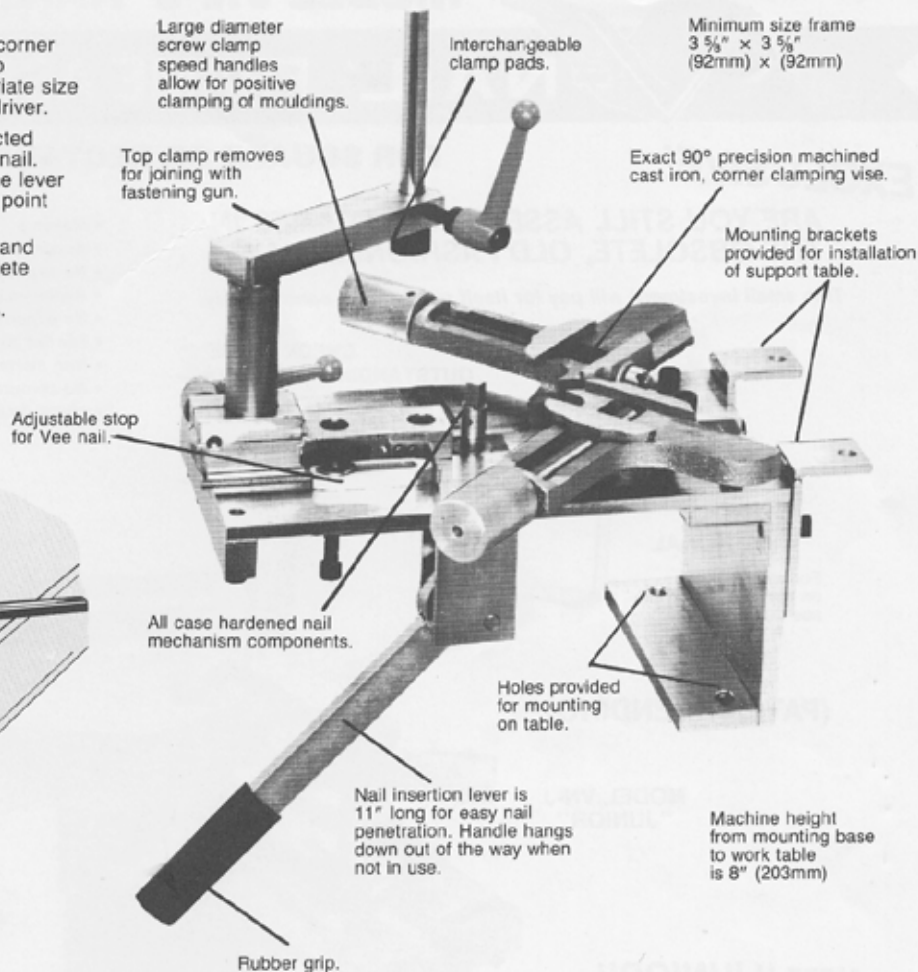
STEP TWO - Apply glue to miters if desired. Adjust frame corner in clamp vise until the miters match perfectly. Slide top clamp bar into position and tighten. Select the appropriate size Vee nail and place it into position on the magnetized driver.

STEP THREE - With the nailing mechanism in the preselected position, grasp and lift the lever to fully insert the Vee nail. If stacking, place a second nail on the driver and lift the lever a second time. If a second nail is desired at any other point along the miter, repeat this step.

The corner is now finished. Open the top and side clamps and remove the corner. Repeat the above steps until the complete frame is finished. The machine operation is so simple that anyone can professionally assemble custom quality frames.



Typical installation showing Model VN-J machine built into framing table. (Table not supplied).



SPECIFICATIONS — MODEL VN-J

Weight	— Standard without accessories	Minimum width moulding	— 3/8" (10mm)
Crated (domestic)	— 57 lbs. (26 kg)	Maximum width moulding	— 3 1/2" (89mm)
Crated (export)	— 57 lbs. (26 kg)	Nail location adjustment range relative to rabbet	— 1/8" (3mm) (at rabbet) to 4 1/4" (108mm)
Uncrated	— 42 lbs. (19 kg)	Maximum height moulding	— 2 1/4" (57mm)
Electrics	— None required	Minimum height moulding	— 3/8" (10mm)
Air consumption	— None	Nail length range	— 1/4" 3/8" 1/2" 3/4" (6mm) (10mm) (13mm) (16mm)
Work table positions	— Horizontal only	Overall size	— 14 1/2" W x 15 1/2" L x 17 1/2" H (368mm) (394mm) (445mm)
Minimum size frame (rabbet size)	— 3 5/8" x 3 5/8" (92mm x 92mm)	Actuation	— Clamping via screws with hand knobs, nail insertion via hand lever.
Maximum size frame	— Unlimited (frame parts must be supported)		

Subject to specification and engineering changes without notice.

IMPORTANT NOTICE TO PURCHASER AND USER

All material contained herein is based on tests and information we believe to be reliable, but the accuracy or completeness thereof is not guaranteed. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct or consequential arising out of the use or the inability to use the product described herein. Manufacturer offers inspection by buyer and user of product prior to shipment from factory with adequate notice. Before using, user shall solely determine the suitability of the product for his intended use and user assumes all risk and liability whatsoever in connection with strict compliance with all Federal, State and Local health and safety ordinances to its intended use.

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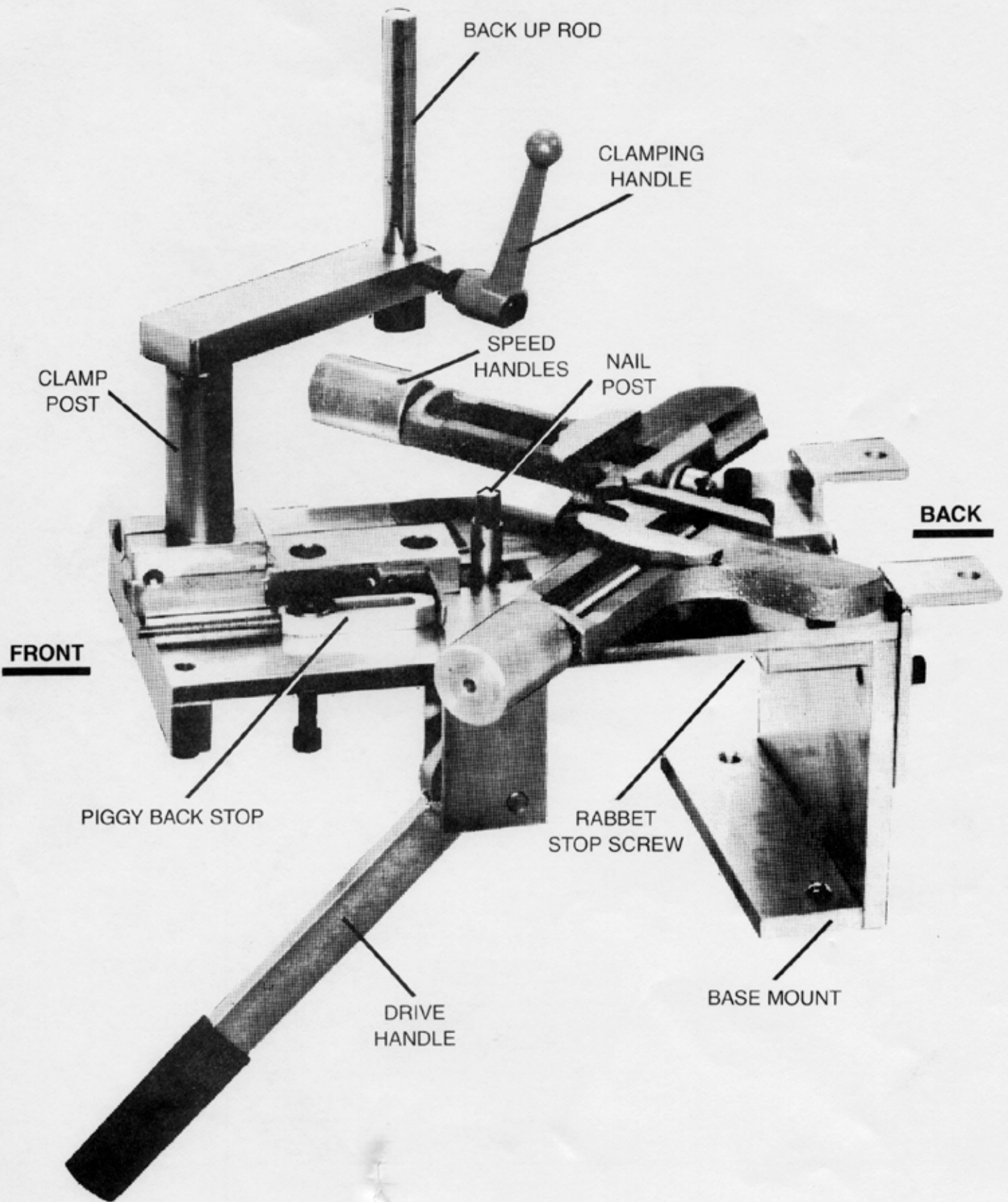
A full range of machinery for MITERING • JOINING • FINISHING

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