



Schlitzgerät SG 400 zu LS 103 Ec

Betriebsanleitung und Ersatzteilliste

Slot Mortising Device SG 400 for LS 103 Ec

Operating instructions and spare parts list

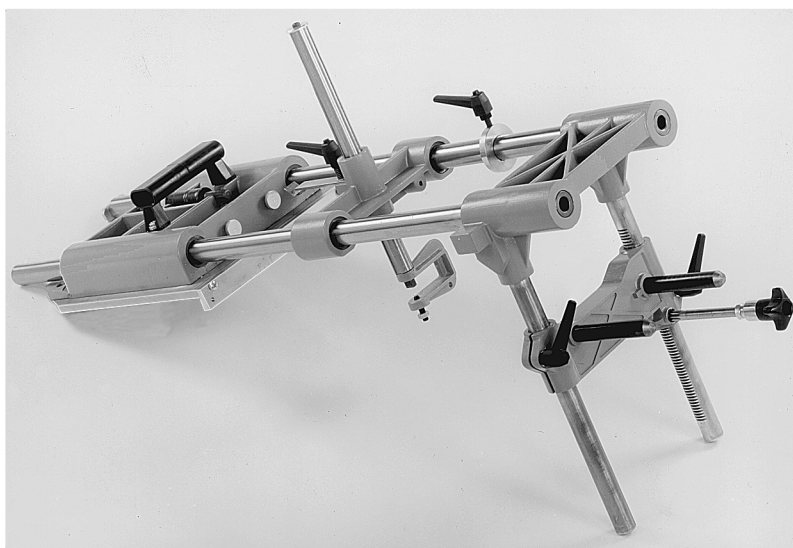
Dispositif d'entailage SG 400 pour LS 103 Ec

Notice d'emploi et liste des pièces détachées

Dispositivo per fresate a catena SG 400 per LS 103 Ec

Istruzioni d'uso e lista delle parti di ricambio

070452.0414/b



MAF00978

ACHTUNG !

Diese Betriebsanleitung enthält Hinweise, die für das sichere Arbeiten mit diesem Gerät wichtig sind. Lesen Sie deshalb unbedingt diese Betriebsanleitung sorgfältig durch!

WARNING !

These operating instructions contain important notes on safe working practices with this device. It is therefore essential that you read these operating instructions carefully!

AVERTISSEMENT !

Cette notice d'emploi contient des indications importantes pour la sécurité du travail avec cet appareil. Veuillez la lire attentivement !

ATTENZIONE !

Le presenti istruzioni per l'uso contengono avvertenze importanti per lavorare con sicurezza con questo apparecchio. Per questo motivo leggete assolutamente le presenti istruzioni per l'uso con la dovuta accuratezza!

This device is an optional accessory to be used with the chain mortising machine LS 103 Ec and is intended for cutting operations on wood. Using the machine for other purposes may lead to accidents.

1 Product information

for slot mortising device SG 400 with Art.-No. 201000

1.1 Manufacturer's data

MAFELL AG
P. O. Box 1180, D-78720 Oberndorf / Neckar
Phone +49 7423 812-0, Fax +49 7423 812-218

1.2 Technical data

- | | |
|------------------|----------------------------------|
| > Cutting depth | 300/400 mm (11 3/4 - 15 3/4 in.) |
| > Cutting width | 6 - 17 mm (1/4 - 11/16 in.) |
| > Cutting length | 50 mm (1 31/32 in.) |
| > Tilttable | up to 45° |
| > Weight | 24.5 kg (54 lbs) |

1.3 Delivery specification

1 slot mortising device
1 operating tool
1 grease gun
2 positioning pins

2 Safety instructions

The safety regulations applicable in the country of use, as well as all other generally accepted rules on safety and occupational medicine, must be observed.

- > Whenever possible, secure the workpiece against slipping, tipping over and springing up (e.g. with screw clamps).
- > Only use tools with the technical data stated in this manual.
- > Only original MAFELL spare parts and accessories must be used. Otherwise the manufacturer does not offer any warranty and does not accept any liability.
- > Adhere to the safety instructions contained in the operating manual of the chain mortising machine LS 103 Ec.

3 Setting up / Adjusting

3.1 Indication on changing the mortising chain set

A groove in the chain bar of the SG 400 provides additional support and guidance for the mortising chain set.

3.2 Installing the LS 103 Ec on the SG 400

- Loosen clamping lever 1 (Fig. 1) and retract the depth stop pin of the chain mortising machine LS 103 Ec completely.
- Tighten clamping lever in such a way that the lever points in the direction opposite to the direction of mortising. (All clamping levers on the LS 103 Ec and SG 400 are adjustable and can be set to the desired position simply by pulling upwards.)
- Remove guide plate 2 and install mortising chain set for slot mortising.
- Fully extend mounting part 3 (Fig. 3) of the slot mortising device from the pivoting plate.
- Slide support bracket 4 forwards until it engages, if necessary release clamping lever 5 and push guide rod 6 upwards.
- Release clamping levers 7 and 8, move guide block 9 upwards as far as it will go by turning handle 10 and retighten clamping levers 7 and 8. Loosen the cylinder head bolt in handle 10 using the hexagonal spanner (SW4) provided with the LS 103 Ec and take off the handle.

- Now put the chain mortising machine LS 103 Ec on guide columns 11 and secure by means of knurled nut 12. Re-fasten handle 10 with the cylinder head bolt.
- To mount the chain bar support unscrew threaded pin 13 (Fig. 3) after slackening off wing nut 14 so that the mortising chain can be moved between threaded pin 13 and bearing journal 15 (Fig. 3).
- Then release clamping lever 5, pull back support bracket 4 and insert bearing journal 15 in the groove of the chain bar.
- Tighten threaded pin 13 so that support bracket 4 can be moved back- and forwards without play.
- Finally, secure threaded pin 13 (Fig. 3) with wing nut 14.

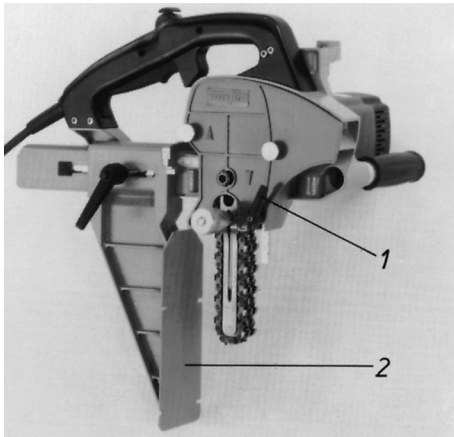


Fig. 1

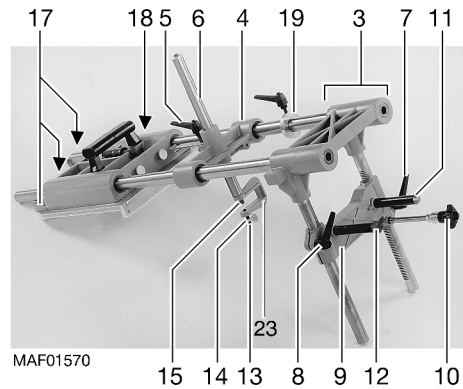


Fig. 2

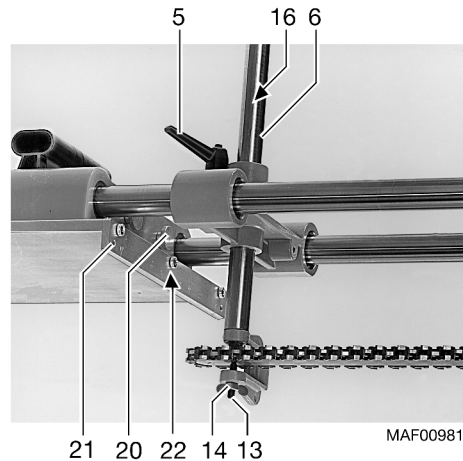


Fig. 3

3.3 Slot mortise distance from top edge of timber

- Pull back support bracket 4 (Fig. 3).
- Release clamping levers 5, 7 and 8.
- Set desired distance according to scale 16 (Fig. 3) by turning handle 10 (Fig. 3) and then retighten clamping levers 5, 7 and 8.

3.4 Pivoting range

To cut slots at an angle the slot mortising device can be pivoted up to 45° to either side.

- Turn bracket 23 (Fig. 2) 180° if required.
- Loosen screws 17 and 18 (Fig. 3) which hold the pivoting plate and tighten them again when the angle required is reached.

3.5 Adjusting the cutting depth

The depth of the slot can be preselected by means of depth stop 19 (Fig. 3).

4 Operation

4.1 Operating instructions

After setting the slot mortise distance, slide support bracket 4 (Fig. 3) forwards as far as it will go to give the chain bar optimum support and engage it.



With slot lengths exceeding 50 mm (1 31/32 in.) begin mortising at the **right** marking. When the first cut has been completed, pull out the machine, move it sideways to the left and make the second cut.

4.2 Securing the machine against moving sideways

Remove positioning pins 20 (Fig. 3) from the pivoting plate and screw them into threaded holes 21 of the stop plate. Position the machine as required using scale 22 and press the stop plate firmly against the timber.

5 Maintenance

The roller bearing of the chain bar should be kept well greased. The grease gun is provided for this purpose which should be pressed into the hole at the tip of the bar (**only acid-free ball bearing grease of good quality should be used!**)

The chain should be immersed in thin oil every time it has been resharpened. When the chain is being used very frequently it should be oiled several times a day!

Before re-tensioning the chain let it cool down.



MAFELL machines are designed to be low in maintenance. After a prolonged period of operation, users are recommended to have the device checked by an authorized MAFELL customer service shop.