THE PINSKE EDGE

#5200
Drawer Notcher

This machine is designed to notch your cabinet drawer boxes for undermount hardware. It is specifically designed for Blum®, but it also works with many other brands. This machine cuts the recess and drills the hole in the drawer box all at one time. You simply set the drawer box over the cutter and against a side fence. Push the drawer box back against the back fence activating the machine. Step on a foot control which moves the cutter up into the bottom of the drawer box at the same time as the drill moves inward to drill the holes in the drawer's back. You will be able to do all of this in approximately 10 seconds!

- After uncrating your machine, you may either install the (4) leg levelers and have your machine free stand or bolt the machine to the floor in a permanent spot.
- Hook your air supply to the Tee located by the air gauge.
- You will need 80 PSI minimum input to operate the Drawer Notcher. The regulators on the machine are preset.
- The machine is pre-wired according to your electrical specifications. We recommend that a qualified shop electrician hook it up to your electrical supply. The cutter must rotate TOWARD the fence (clockwise).
- The Drawer Notcher comes equipped with an automatic oiler that lubricates the pneumatic drill that is located on the back of the machine. Adjust the automatic oiler for proper lubrication.
- We have preset the drawer notch height to your specification, but you may need to fine tune this as required. The notch depth adjustment is done at the motor plate. Loosen the bolt to raise or lower the cutter. Retighten after adjusting. The drill height is adjusted by loosening the (2) cap screws in front of the machine. Retighten after adjusting. REFER TO DRAWING #012123
- The hardware mounting hole is drilled with a hi-speed air drill that can run at 20,000 RPM and has a .250" carbide drill bit. It requires 60-90 PSI and has a 3/8" chuck.
- All other air settings and feeds are factory set.

The Pinske Edge
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Fax – 320-238-2385 - Phone 320-238-2196 or 1-800-TPINSKE
www.pinske-edge.com – info@pinske-edge.com

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ROUTINE MAINTENANCE –

We recommend that the motor shaft bearing be greased every 200-use hours.

Check oil level in the Hydraulic Reservoir – if it needs to be added to or replaced, we suggest Hydraulic Oil AW ISO 32.

Check Inserts for wear and service accordingly. The cutter should be removed when rotating or replacing the carbide inserts. (Each carbide insert has four cutting edges that can be rotated when dull.) Loosen and remove the Allen head cap screw to lift out the cutter. When reinstalling the cutter, you must turn it clockwise against the locating stops. When firm, retighten the Allen head cap screw.

Extra inserts can be bought in packages of 10…

#5298 (square shaped) – (Cutter uses 30 inserts) - uses #5289 screws
#5299 (diamond shaped) – (Cutter uses 20 inserts) – uses #5288 screws

Check and adjust the drive belt every 500-use hours.

Remove Dust Collection Shroud behind Drill Mechanism and blow off with air.

Inspect Backer Block and replace if necessary.

Check Drill Components for excessive wear.

Replace all safety and dust shrouds if damaged.

Inspect the entire machine for damaged or broken parts.

Check fence for squareness.

Reconnect power supply and check operation.

Check buttons for smooth operation.

Inspect your Phenolic Fence Surface periodically for wear; and if there is too much clearance between the cutter and the notch in the fence surface, then it should be replaced. When installing a new Phenolic Fence Surface, you should slow down the flow control for your first cut. This will let the cutter make a nice clean cut in your new phenolic fence. When you are done, you can turn the flow control back to the desired speed.

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MAINTENANCE (EVERY 3 TO 4 MONTHS) –

Remove Belt Cover.

Inspect Belt for wear and damage. Adjust to ½" deflection.

Adjust Motor Mount if Belt needs tightening.

Check and adjust cutting tool and drill height, using caliper to check and adjust off sample piece.

Check and adjust cutting tool and drill side to side, using caliper to check and adjust off sample piece.

Check and adjust drill cutting depth, using caliper to check and adjust off sample piece.

OPERATING INSTRUCTIONS –

- Place the drawer box over the 1-1/4" locating buttons and push drawer box up against the back fence. This will activate the roller actuator in the fence which will start the drill. The system is now activated. Step on the foot control – the cutter will rise and the drill will move forward.

- Repeat above steps to notch and drill the opposite side of the drawer.

<u>Drill Height Gauge</u>

The Drill Height Gauge has three holes in it to accommodate a drill height of 13/16", 15/16" or 1-1/16".

The 13/16" hole is set for 3/8" Cutter Height.
The 15/16" hole is set for ½" Cutter Height.
The 1-1/16" hole is set for 5/8" Cutter Height.

The machine comes standard with a 1-1/4" cutter. Special cutters can be custom ordered. Multiple Pass Models are also available (for wider cuts, you'll make multiple passes).

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Drawer Notcher Specifications

1. Dimension “C” varies as the thickness of the wood used for the drawer side changes. It has ranged from 3/8” to ¾”.
2. Dimension “A” can be a minimum of 5/32”. It is factory set to 9/32”
3. If Dimension “A” is set to 5/32”, then the travel left to right needed by the drill will be 15/16”. The maximum travel available from standard configuration is 1.00. When set at factory setting 9/32”, the the travel needed is 11/16”. An additional 1 inch of travel can be gained if a longer slide is installed.
4. The current hold depth is set to 3/8”, but could go deeper to about ¾”.
5. Current slot width (Dimension B) is set for 1-1/4”. If any size other than that is needed, a special order cutter is needed. Wider cutters require other slight modifications of the machine. Narrower cutter only needs spacers to locate them on the spindle properly.
6. Dimension “C” represents the width of the Drawer Box side. The cutter lines up with that. If the notch needs to be offset from the drawer side any further, new alignment buttons are required.
7. Dimension “D” represents the notch height. It is currently set to customer specifications and could go as high as 7/8” or as low as 3/8”.
8. Dimension “E” represents the height of the hole location from the tabletop. It also is currently set to customer specifications. It could go as low as 7/8” or as high as 1-7/32”.
9. Dimension “F” represents the height of the hole location from the top of the notch. Our factory setting is 7/16”. It can vary from that if necessary.

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