

# INDUSTRIAL PRODUCTS

## Option Manual

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**A22513 Gauge Kit**

**Rev. D**

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**Safety is our #1 concern!** Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

**November 1994**

*Form #708*

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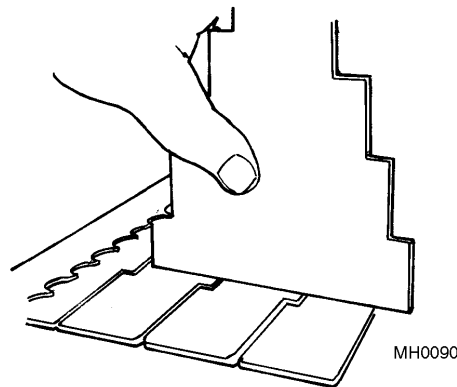
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## SECTION 1 GAUGE KIT OPTION

The gauge kit contains one set of thirteen blade height gauges and one board thickness gauge. The blade height gauges allow you to determine the thickness of the boards you will cut. The board thickness gauge allows you to measure the thickness of the boards you have already cut.

### 1.1 Blade Height Gauges

**See Figure 1-1.** Each template is labeled with a U.S. measurement on the left and a metric measurement on the right. This measurement describes the step height on that particular template. The smallest template has steps every 1/4" (6 mm). The largest template has steps every 1" (30 mm).



**FIG. 1-1. BLADE HEIGHT GAUGE.**

There are six steps on each template. These steps are guides for setting the blade height on up to six saw heads.

To use the templates, first decide the thickness of the boards you want to cut. Then take the template with that step height. Set the bottom of the template on the feed track directly under the last blade the wood will pass through.

Adjust the blade until the lowest point on the blade is even with the top of the lowest step on the template. (The lowest point on the blade will be the tip of any tooth set downward.)

Move the template under the next to the last blade the wood will pass through. Adjust this blade until the lowest point on the blade is even with the top of the second lowest step. Continue until all blades have been adjusted.

**For example,** if you want to cut 1/4" (6 mm) thick boards, take the 1/4" (6 mm) template. Set this template under the last blade the wood will pass through. Adjust the blade until the tip of any tooth set downward is even with the top of the lowest step, 1/4" (6 mm).

# 1 Gauge Kit Option

## Board Thickness Gauge

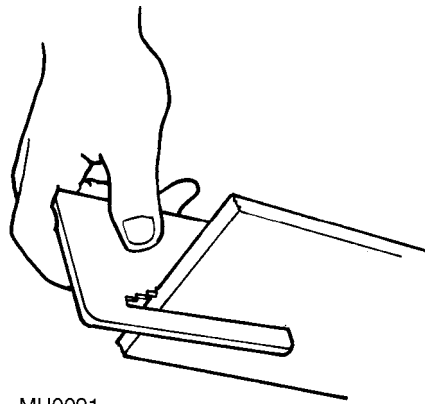
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Move the template under the next to the last blade the wood will pass through. Adjust this blade until the tip of any tooth set downward is even with the top of the second lowest step, 1/2" (12.5 mm), and so on. Continue until all blades have been adjusted.

## 1.2 Board Thickness Gauge

**See Figure 1-2.** The board thickness gauge has notches which measure board thickness. Each notch is labeled with a U.S. measurement. The smallest notch measures a thickness of 1/4". The largest notch measures a thickness of 1 1/2".

To use the board thickness gauge, take a piece of finished stock. Slide the gauge over the thickness of the board until the board fits into one of the notches. The measurement for that notch is the thickness of the board.



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**FIG. 1-2. BOARD THICKNESS GAUGE.**