

Quick Tips

Leveling Blades

It's important to make sure that both blades on a double miter saw come down at the same time. If one blade comes down before the other, it can cause the material to twist and produce a poor cut. To prevent this, the blades need to be leveled. Place a piece of wood about 2" wide into the saw. Bring the blades down into the material, but only cut half way through. Then remove the material and look

at the cuts made by each blade. The two cuts should be the same length. If they aren't, correct the problem by adjusting the pull arms below the table to raise or lower the cutting heads individually. Repeat the process until the cuts are even.

*Eric Pistorius
Vice President
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Maximizing MDF Use

MDF moulding is one of the best choices for OEM framers. It is perfectly smooth with virtually zero waste. It's available in countless profiles and in a variety of popular finishes. Laminated MDF is so consistent that framers can supplement existing stock with new moulding that will be an exact match.

When ordering larger quantities, request it to be packed in crates (approximately 5,000 to 10,000 feet per crate depending upon profile), which will provide enhanced efficiency.

Standard cutting practices are the rule of thumb for MDF. Use carbide tip wood blades. Keep the blades sharp, and keep the fence square. A 12" saw blade with 80

to 100 teeth is recommended, and it should be run between 3500 and 5800 RPM. The higher the RPM, the fewer the teeth necessary on the blade.

Joining is also simple. Use regular white glue with MDF or "hardwood" V-shaped nails. These nails are thicker and will crush their way through the denser MDF to create a tight joint. Recommended air pressure is 100 PSI going into the joining machine and 80 PSI for the top hold down clamp.

*Todd Hranicka
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Get the Water Out

Water in air lines can be a curse. It shortens the life of air cylinders, air valves, and foot pedals. Aside from the cost of replacement parts, there's also downtime while machines are being repaired.

Commercial air dryers that are installed after the compressors work well—if you have the money to invest in them.

An inexpensive solution is to trap the water before it gets to the machinery. Water filters on equipment don't do the whole job—and very little if drain bowls aren't emptied regularly. Water also gets into the oil lubricators and mixes with the oil, making it ineffectual and sometimes damaging.

Drop lines or down traps (with easily removed covers or drain cocks) installed in overhead lines just before the machinery can separate water from the air for regular draining. Even a short drop pipe on the infeed side of air equipment can work if properly sized and drained regularly. These can be made from ordinary pipe from a hardware store using a Tee connector with a short pipe nipple at each end and a 6" to 8" piece of pipe on the bottom of the Tee with a drain at the bottom. The bottom pipe should point down so gravity can do its job. All threads should be sealed with Teflon tape or thread sealer.

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Contributors to this column are industry members who have experience in the operation of a production framing facility. If you have a tip of your own, please send it to Production Tips, PFM Production, P.O. Box 102, Morganville, NJ 07751.