

CARE & USAGE OF MORTICE GEAR

GENERAL

We know you will be most anxious to obtain maximum life and good service from your mortice chain gear. Intelligent and careful maintenance on correct lines will ensure that this precision built equipment has an excellent chance of paying dividends.

NOTES OF IMPORTANCE TO USERS

Fit the chain slack, oil and run for half a minute, stop and adjust chain if necessary to give 1/4" free movement when pulled away from bar at centre of chain, run for a further half minute and should the bar end be warm the chain is still tight. A chain that is over tensioned will cause undue stress and wear on the rivets and create heat in both the chain and guide bar bearing. Many bar ends are ruined by running the chain too tight.

MOUNTING

Take care when mounting guide bar that clamping faces are free from dirt or sawdust before tightening bolt nut and we recommend that where a tensioning screw is fitted, this be slackened back a turn after chain has been satisfactorily tensioned without disturbing the bar.

LUBRICATION

Frequent application of oil to inside downrun of chain when operating or in the case of grease gun bars two or three shots at slightly less intervals. This will depend on the continuity and rate of cuts, but under average conditions, apply every 15 minutes in the case of oil.

The machine should be stopped occasionally and the heat of the bar end felt, under no circumstances should this be allowed to reach a higher temperature than can be borne by the fingers.

A small container of oil should be handy and applied up to the bar end, immersing same and turning the chain by hand, distribute oil round the chain without disturbing setup, if running hot.

Remember that if discolouration occurs through heat that bearing is softened and ruined. In addition to the above always store chains in a bath of oil when not in use.

LUBRICANTS

Good quality 30 S.A.E. motor oil or medium motor grease or Graphited types.

OPERATING

With hand feed the vertical stops should be set to reduce unnecessary free travel above work, the chain should be made to enter the wood easily without shock before sinking through to predetermine depth by steady pressure. Considerable risk of breakage and harm is done by snatch in the initial feeding, especially in the case of the lighter pitches of chain. When lengthening out holes always work downrun of chain into the next cut and only traverse work for cleaning out after cuts have been made by downward movements.

SHARPENING

We strongly recommend an independent chain sharpener mounted where this important operation can best be performed (preferably the tool room) for accurately ground chains only can give first class results. Care must be exercised to ensure that all cutting edges are similar in height, i.e. all teeth finish ground to one final setting of grinder. It is important that any new links inserted are ground back in the gullet to match with existing links of chain, otherwise new link will take all the stress of cut.

FINALLY

Replace bearings or sprockets immediately there is any indication that the underside of side links are rubbing, either against the bar plates or sprocket boss.

Do not allow your chains, guide bars or sprockets to become too badly worn before repair or replacement: a regrind, new sprocket or bearing may be the means of prolonging the life of your gear considerably and we are here to serve you promptly and efficiently.

REMEMBER

The information above, used intelligently, will prevent premature failure of gear and consequent difficulties, while providing you with equipment giving considerable service and long life with excellent results.

