In this position tip can be cut without cutting veins.

Figure 2

Insert pattern key in right hand wise with tip of blank.

All keys should be set from the tip for spacing.

Figure 1

CUTTING PROCEDURE FOR FRAZON

DBM-1 FLAT KEY MACHINE
WARRENTY CLAIMS PROCEDURE

The cutters used on the first year of production are guaranteed by this warranty. If the cutters fail to perform as promised, the manufacturer will replace any defective cutter free of charge. If the cutter fails to perform as specified, the manufacturer will replace any defective cutter free of charge. If the machine fails to perform as specified, the manufacturer will replace any defective cutter free of charge.

The warranty on the framework is 1 year and is in effect for only replacement of any part of the machine returned.

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WARRANTY & REPAIR

Always use new cutting plates when doing repairs or replacements. There is always the possibility of excessive side pressure. The use of excessive side pressure can cause damage. If the machine is not used properly, the framework may be damaged. Always use new cutting plates when doing repairs or replacements. There is always the possibility of excessive side pressure. The use of excessive side pressure can cause damage. If the machine is not used properly, the framework may be damaged.

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changing guide settings.

guide shaft will align guide. NO adjustmen is required when
guide to cutter width and tighter cap screw. Detent screw in
same time. All of these cutters are solid carbide.

To set guide, simply loosen cap screw (GB200C3). Route
(Left) can be obtained by using an 0.45mm and an 0.65 at the
Cutter used. The DBN-1 is supplied with one 0.45 width cutter.
leave must be set so to same width of
depth rings are in increments of 0.01.

0.03 clockwise and tighten set screw. NOTE: Calibration on
on pattern key, loosen set screw on depth ring. Note ring
key and check depth cut on both pattern key and duplicating key.
Another way to check depth is to make one cut on duplicator

Tighten set screw.

counter clockwise. To measure slope, rotate depth ring
barely touches blank. To make cut, deepen. Route multiplicity
bears that are the same and check depth by using two

As to depth settings, this can be checked by using two

With lip setting for specchtere is no adjustmen needed for

ADJUSTMENTS