

INSTRUCTIONS FOR ATTACHING GS-2-1 GUIDE SYSTEM

Item # GS-2-1

Issue Date: January 2021

Included:

- (1) GS-01-1 Guide System Hardware Bag *
- (1) GS-50 Guide, Flex, Baltic Birch (set of 2)
- (1) GS-83 Rev A Plate, Sub, 9/32" Slots, Textured 1/2" HDPE, Black

*Hardware Bag includes:

- (6) EJ-39; Washer, Flat, 1/4"
- (1) EJ-42; Wrench, Allen, 5/32"
- (2) GS-81 Screw, BHSCS, 1/4"-20 X 3/4"
- (4) GS-90; Handles, Adjustable
- (4) GS-91; Bolt, Elevator

1. Both the molder bed and the GS-83 Rev A sub plate should be wiped clean before installation.
2. Lay the GS-83 Rev A; sub plate down on the molder bed with the tube clearance side adjacent to the vertical molder tubes. The two counter bored mounting holes should be facing up. Align the two counter bores holes in the sub plate to the holes in the molder bed.
3. Screw (2) EJ-39; 1/4" flat washers and (2) GS-81 BHSCS 1/4"-20 x 3/4" through the counter bored holes in the molder bed.
4. Attach the GS-50 guides. The flex guide is normally positioned on the side of the profile that is the least deep. This preserves the life of the flex guide.
5. The bevel side of the flex guide should be facing the stock flowing through the machine.
6. Attach both guides using the (4) GS-90 adjustable handles, (4) EJ-39; 1/4" flat washers and (4) GS-91 elevator bolts. A washer goes between each of the adjustable handles and the top of the guides. The elevator bolt threads from the underside of the sub plate with the squared collar engaged in the slot of the sub plate.

See the reverse side for operation of the GS-2-1 guide system.

INSTRUCTIONS FOR OPERATING THE GS-2-1 GUIDE SYSTEM

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1. Your GS-2-1 guide system includes a flex guide, and a solid guide to guide your stock. **To set these guides**, first attach your knives to the knife arbor in the **position** you have chosen, often a place where you can get the most out of your roller surfaces. Panel knives would go to the far right. Smaller knives to the post side half of the mounting area and larger knives to the central positions.
2. Roll one knife down pointing to the machine bed and place a sample piece of stock you are going to mold on the bed. **Align the stock** to the knife profile and carefully lower the machine head until the roller puts pressure on your stock to hold it securely.
3. **Attach your flex guide** to the side of the profile that will cut the least deep into your stock. This will give the longest possible life to your flex guide. The beveled portion of the guide should be facing the stock. Put about a 1/32" amount of pressure on the flex part of the guide. This will keep you stock from wandering within the glide path. Tighten the handles and pull them up and away from the stock path.
4. **Attach your solid guide** on the other side of the stock. Push it up firmly against the stock and tighten the handles angling them away from the stock path.
5. **Remove your set up piece of stock** by raising the machine head and pulling the stock out from the bed.
6. **Your knives will usually cut into one or both guides.** This is normal and expected. The guides are effective and last a long time after being cut into many times.