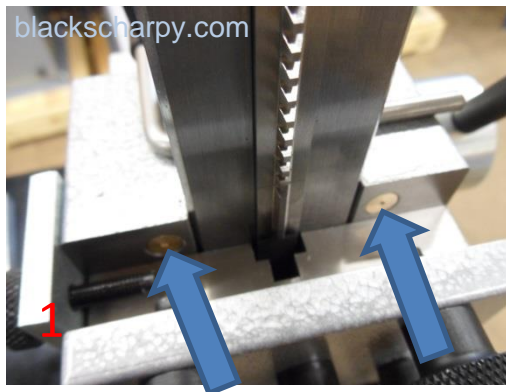


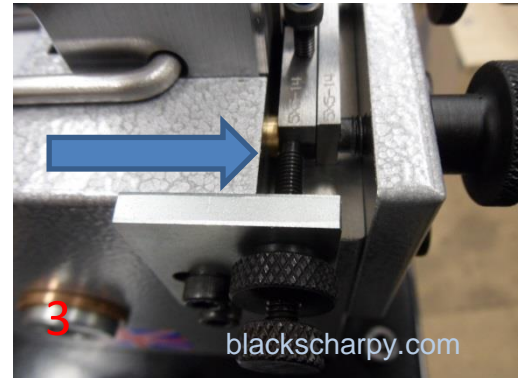
## USER MANUAL

**THE CNB MACHINE USER MANUAL MUST BE READ BEFORE USING THIS MANUAL**

**SETTING THE CNB BROACHING MACHINE**



RETRACT THE CLAMPING PINS, BY TURNING THE CLAMPING HANDLES.



RELEASE THE 2 SCREWS AND SLIDE THE AXIAL SIDE PLATE, SO THE AXIAL SCREW LOCATES ON THE SMALL SPECIMEN CARTRIDGE END FACE. TIGHTEN THE 2 SCREWS.

SET THE BROACH DEPTH AND AXIAL POSITION AS DESCRIBED IN THE CNB MACHINE USER MANUAL.

TO SET THE DEPTH FOR A "M" TYPE BROACH (1mm "V" NOTCH), USE THE 9mm SET UP BLOCK & 5 THOU. FEELER GAUGE.

TO SET THE DEPTH FOR A "C" TYPE BROACH (2mm "V" NOTCH), USE A 10mm SPECIMEN & 5 THOU. FEELER GAUGE.

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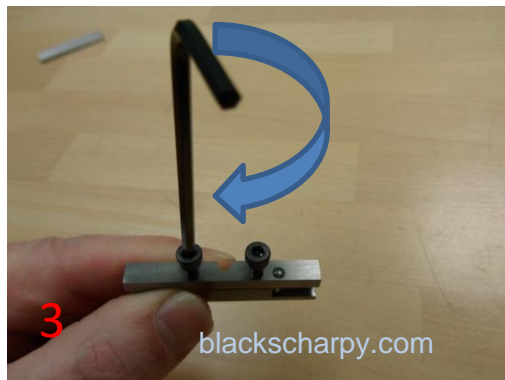
## USER MANUAL

**LOADING SPECIMEN INTO THE CARTRIDGE**

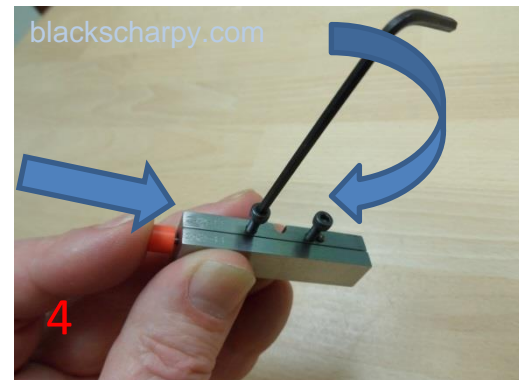
CHOOSE THE CORRECT SMALL SPECIMEN CARTRIDGE FOR THE SPECIMEN BEING BROACHED.



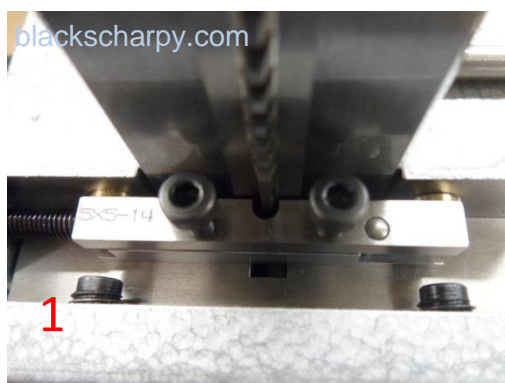
SLIDE THE SPECIMEN INTO THE CARTRIDGE.



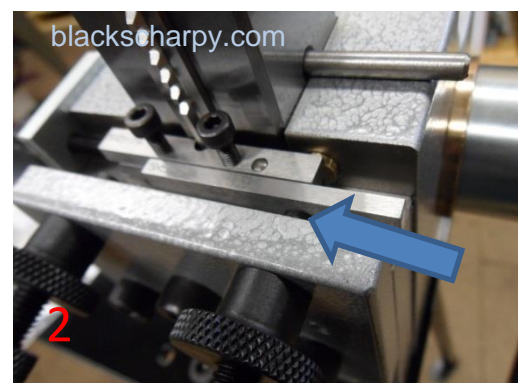
LIGHTLY TIGHTEN SCREWS, WHILST PUSHING THE SPECIMEN AGAINST THE PIN AND BACK FACE OF THE CARTRIDGE.



FOR SPECIMENS LESS THAN 3mm, USE THE PUSHER & BACK PLATE TO HELP WHILST LIGHTLY TIGHTENING THE SCREWS.

**LOADING CARTRIDGE INTO THE MACHINE**

LOAD CARTRIDGE INTO THE MACHINE.



SLIDE THE BACK PLATE, BEHIND THE CARTRIDGE, UNTIL IT IS IN LINE WITH THE CARTRIDGE.

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## USER MANUAL



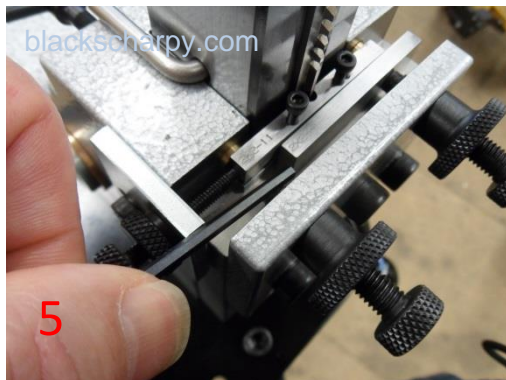
ENSURE THE CARTRIDGE IS PUSHED UP AGAINST AXIAL STOP.



TIGHTEN THE CLAMP HANDLES.

THE SMALL SPECIMEN IS NOW READY FOR BROACHING.

**NOTE: ENSURE THE BROACH WILL PASS THROUGH THE NOTCH IN THE CARTRIDGE. THE CARTRIDGE IS HARDENED AND IF THE BROACH DOES NOT CLEAR THE CARTRIDGE, THE BROACH WILL BE DAMAGED.**



RELEASE THE CLAMP HANDLES AND USE THE HEXAGON WRENCH TO PUSH THE BACK PLATE FREE. REMOVE THE CARTRIDGE AND RELEASE THE SPECIMEN. CLEAN ALL AREAS AND YOU ARE READY TO BROACH ANOTHER SMALL SPECIMEN.



OPTIONAL EXTRA:

CHECK THE NOTCH DEPTH TO BACK FACE (LIGAMENT LENGTH), USING RJW GAUGE.

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