

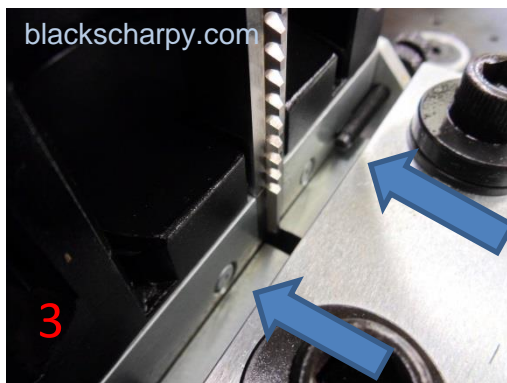
USER MANUAL

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

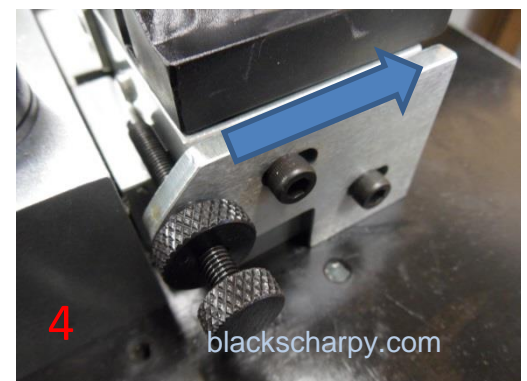
REMOVE THE LARGE CLAMPING HANDLE. THE LARGE CLAMPING HANDLE SHOULD ONLY BE USED FOR 10 mm SPECIMENS.



FIT THE SMALL CLAMPING HANDLE. THE SMALL CLAMPING HANDLE IS USED FOR SMALL SPECIMENS ONLY.



RETRACT THE CLAMPING PINS, BY TURNING THE SMALL CLAMPING HANDLE.



RELEASE THE 2 SCREWS AND SLIDE THE AXIAL SIDE PLATE BACK. THE AXIAL SCREW WILL THEN LOCATE 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.

PLEASE VIEW OUR WEBSITE www.blackscharpy.com for consumables & spare parts

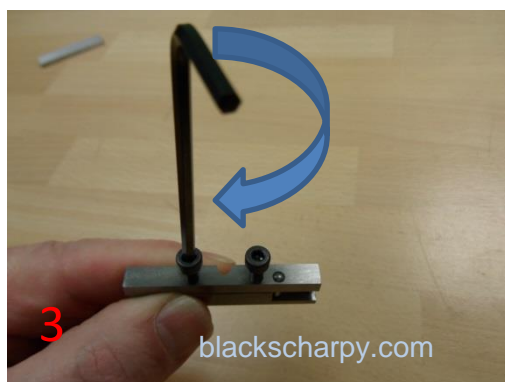
USER MANUAL

LOADING SPECIMEN INTO THE CARTRIDGE

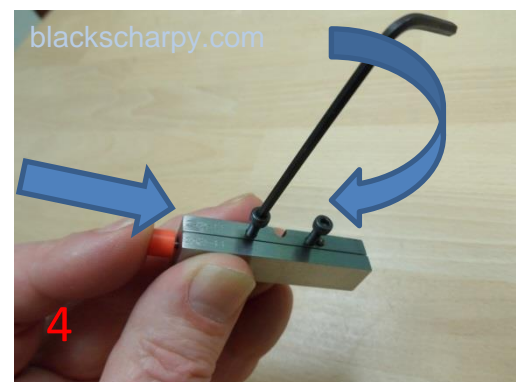
1 CHOOSE THE CORRECT SMALL SPECIMEN CARTRIDGE FOR THE SPECIMEN BEING BROACHED.



2 SLIDE THE SPECIMEN INTO THE CARTRIDGE.



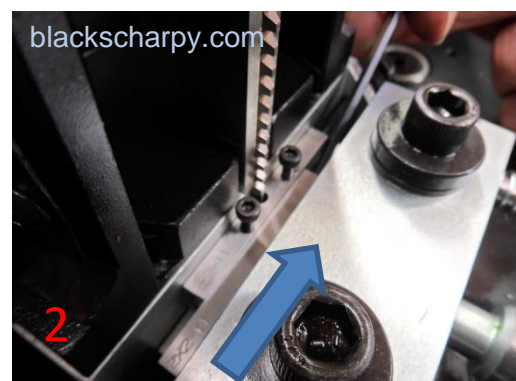
3 LIGHTLY TIGHTEN SCREWS, WHILST PUSHING THE SPECIMEN AGAINST THE PIN AND BACK FACE OF THE CARTRIDGE.



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

LOADING CARTRIDGE INTO THE MACHINE

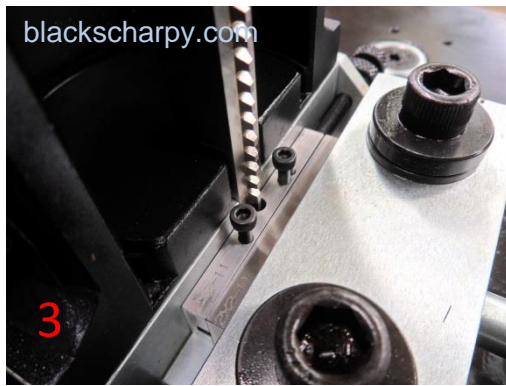
1 LOAD CARTRIDGE INTO THE MACHINE.



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

PLEASE VIEW OUR WEBSITE www.blackscharpy.com for consumables & spare parts

USER MANUAL



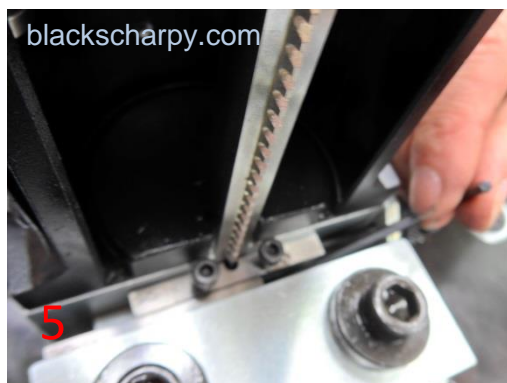
ENSURE THE CARTRIDGE IS PUSHED UP AGAINST AXIAL STOP.



TIGHTEN THE CLAMP HANDLE.

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 HANDLE 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.

PLEASE VIEW OUR WEBSITE www.blackscharpy.com for consumables & spare parts