

T U N I N G T I P S

Scoop Adjustment

Scope

These instructions apply to all Appleton target style core cutters -regardless of model.

Reliable operation of the target and the core cutter depends on proper scoop and target adjustment. The target assembly is designed to permit optimizing the target position, then independently positioning the scoop to provide proper core support.

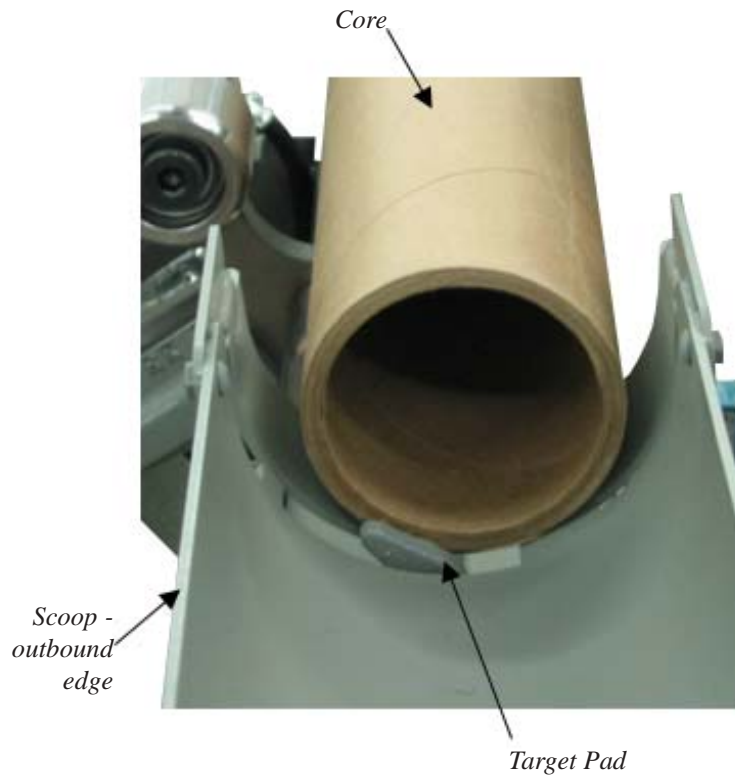


De-power the core cutter before making these adjustments. Contact with solenoid leader will cause electrocution and unexpected machine movement will result in pinched or cut fingers.

Target Position

The target should be adjusted to its proper position before adjusting the scoop. Follow these steps to ensure proper target location:

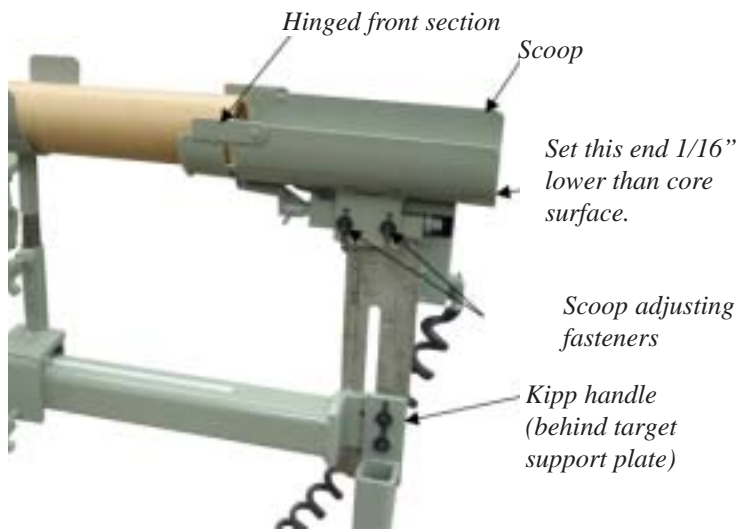
- 1- If the scoop is in place, lower it.
- 2- Slide a length of core on the mandrel for use in aligning the target and scoop.
- 3- Loosen the kipp handle at the base of the target assembly and adjust the target so that it engages the end of the core. Raise the target as high as possible, ensuring that the core will just clear the target when the target retracts. Note: For cores 3/8" and under, the target should cover the full core wall. For core walls over 3/8", the target pad should engage 60% of the core wall.
- 4- Tighten the kipp handle, locking the target in place.



Scoop Position

After the target is set, the scoop must be positioned to properly support the core. Follow these steps:

- 1- Extend the core to the target.
- 2- Raise the scoop on its two slots until it just touches the bottom of the core (do not raise or lower the target assembly to make this adjustment). The outbound end of the scoop should be about 1/16" lower to prevent binding. Note that the target needs to be below the surface of the scoop when the target is retracted.
- 3- Tighten the two hex head fasteners to lock the scoop in place.

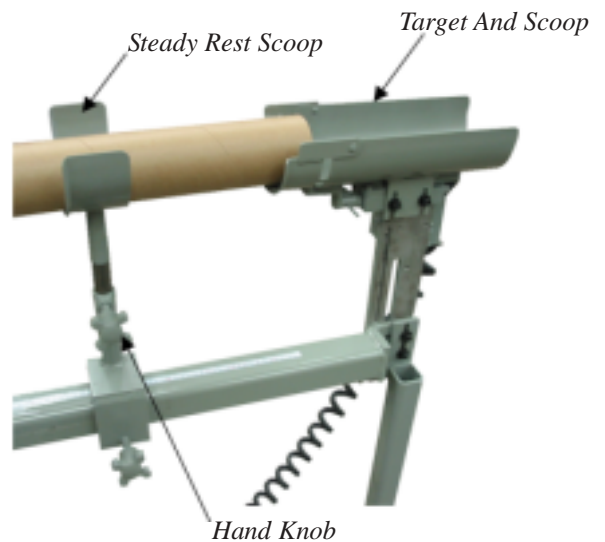


Note that the scoop has a hinged front. This is normally tipped up while cutting cores under 3" in length to allow the target to be set for the shorter lengths. Tip this front section down when the cut length is longer than 3".

Steady Rest Supports

Steady rest scoops are used to support the cut end of the core when the cut core is longer than 20". A second steady rest scoop is recommended when the cut core length is longer than 40". Note that these lengths are approximations and will change with core warp and operator preference.

Steady rest scoop height is set to 1/32" under the core wall.



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