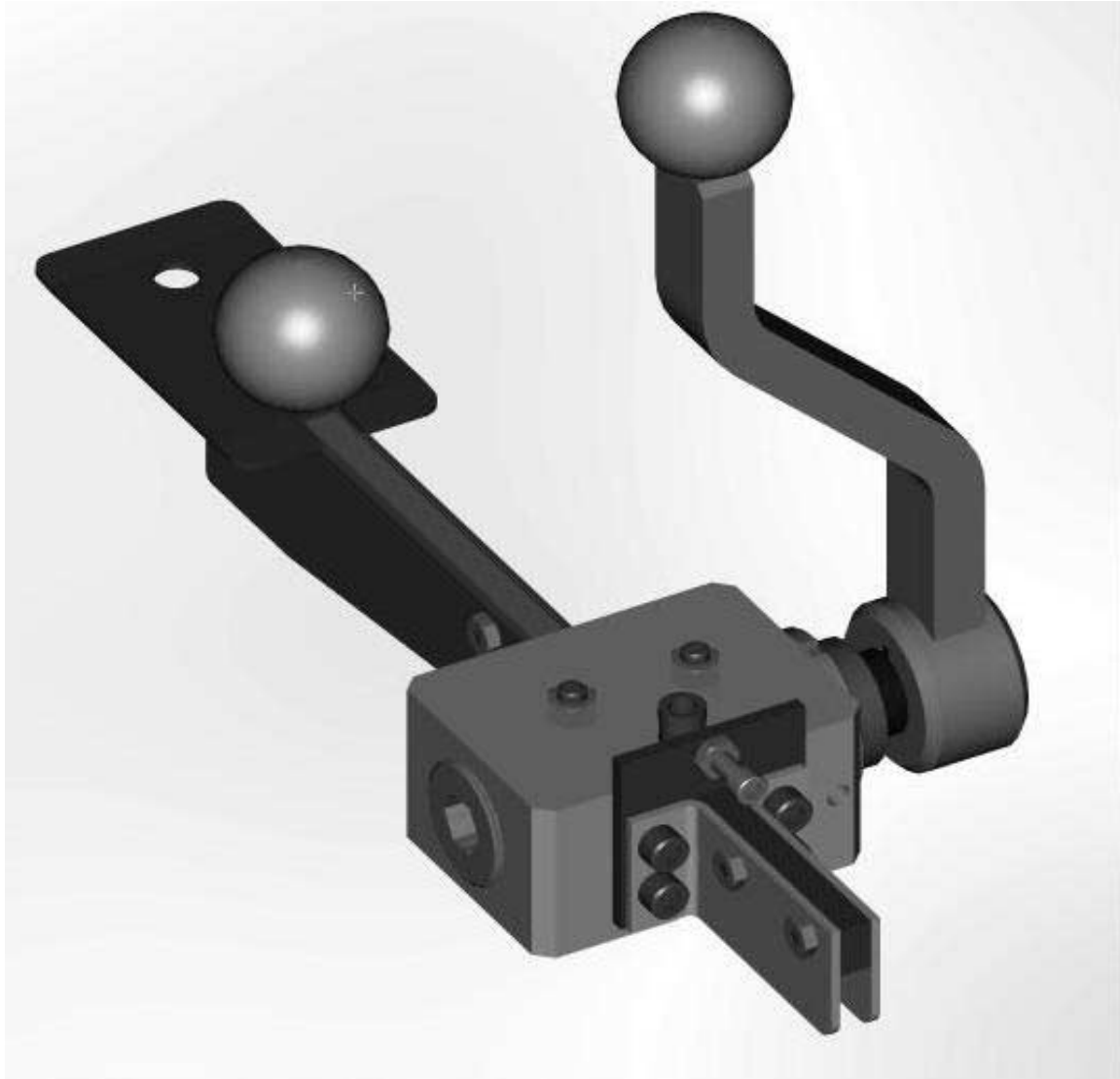


OPERATING INSTRUCTIONS

FOR HANCHETT

9900 BAND SAW SHAPER



HANCHETT MANUFACTURING

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**TAKE A MINUTE TO RECORD THE FOLLOWING INFORMATION.
IT WILL BE HELPFUL TO OUR SALES AND SERVICE STAFF
TO HAVE THIS INFORMATION.**

DATE OF PURCHASE : _____

SERIAL NUMBER OF SHAPER : _____

SETTING UP YOUR SHAPER

CENTERING THE SIDE DIES

- 1) Using the spanner wrench provided, loosen the spanner nut on the knurled bushing.
- 2) With the clamping lever in the vertical position, turn the knurled bushing clockwise until the side die contacts the saw plate in approximately the center of the viewing hole.
- 3) With the clamping lever still in the vertical position, adjust the left hand side die by turning the hollow head cap screw into the shaper head, using the 3/8 allen wrench provided, until the left side die contacts the saw plate.
- 4) Adjust the clamping lever to a comfortable working position by adjusting the same hollow head cap screw. By turning the screw into the head, you will 'raise' the handle or turn the screw out to 'lower' the handle. Raising the handle is to move the handle in the direction of the nose of shaper and lowering the handle is to move the handle toward the tail of the shaper.
- 5) Once all adjustments are complete, tighten the spanner nut with the spanner wrench provided.

ADJUSTING THE WIDTH OF THE POINT

There is some adjustment that can be made to allow you to vary the width shaped point. Moving the tooth stop forward or backward makes this adjustment.

- 1) Loosen the hex nut on the front of the Tooth Stop Adjusting Bracket.
- 2) Using the 3/16" Allen Wrench, turn the hollow head cap screw on the front of the Tooth Stop Adjusting Bracket clockwise to decrease the width of the tooth and counter clockwise to increase the width of the tooth. The standard jaw set that is provided by Hanchett will allow for approximately .020" point variance.
- 3) Adjust the tooth stop to the desired point width and tighten the hex nut against the Tooth Stop Adjusting Bracket.
- 4)

SHAPER ALIGNMENT

One final check needs to be made and that is to make sure that the nose piece, slot in the head, and tail piece are in line with each other. This can be done by using a straight edge. You can move both the tail piece and the nose piece by loosening the 4 hollow head cap screws that hold the respective pieces to the head, using the 1/4" Allen wrench. Align the pieces and retighten the hollow head cap screws.

SHAPING MORE THAN ONE GAUGE OF SAW

Due to the clearances that are ground into the side dies, and the fact that the finished point side clearance is always relative to the gauge of the saw, the 1/8" movement of the tooth stop often makes it possible to use your shaper on more than one gauge of saw without having to adjust the side dies.

Simply adjust the tooth stop as needed to achieve the desired point width of the different gauge saw.

CORRECT SWAGING TECHNIQUES FOR PROPER TOOTH POINT

Your 9900 Shaper has been designed for maximum uniformity with the saw itself acting as the stop for the side dies. As a result, it is important to swage the proper amount. Generally, the amount of swage will be less than is common among older style shapers.

This will give you the advantage of *less work hardening* and *less tooth crumbling* of the tooth point.

In some cases, the corner produced on the tooth may not be as heavy as with older swaging and shaper procedures. This reduction in corner, however, will be more than outweighed by the accuracy and precision provided to you from the Hanchett 9900 shaper and will not be sufficient to cause a problem.

EFFECTS OF IMPROPER SWAGING

Improper swaging of the tooth, that is a point that is too wide or too narrow, will have the following effects:

Too wide a point provides more than enough material to produce the tooth point, as called for by the clearances ground into the side dies. The result is an upward bulge on the tooth, and the width of the point should be reduced.

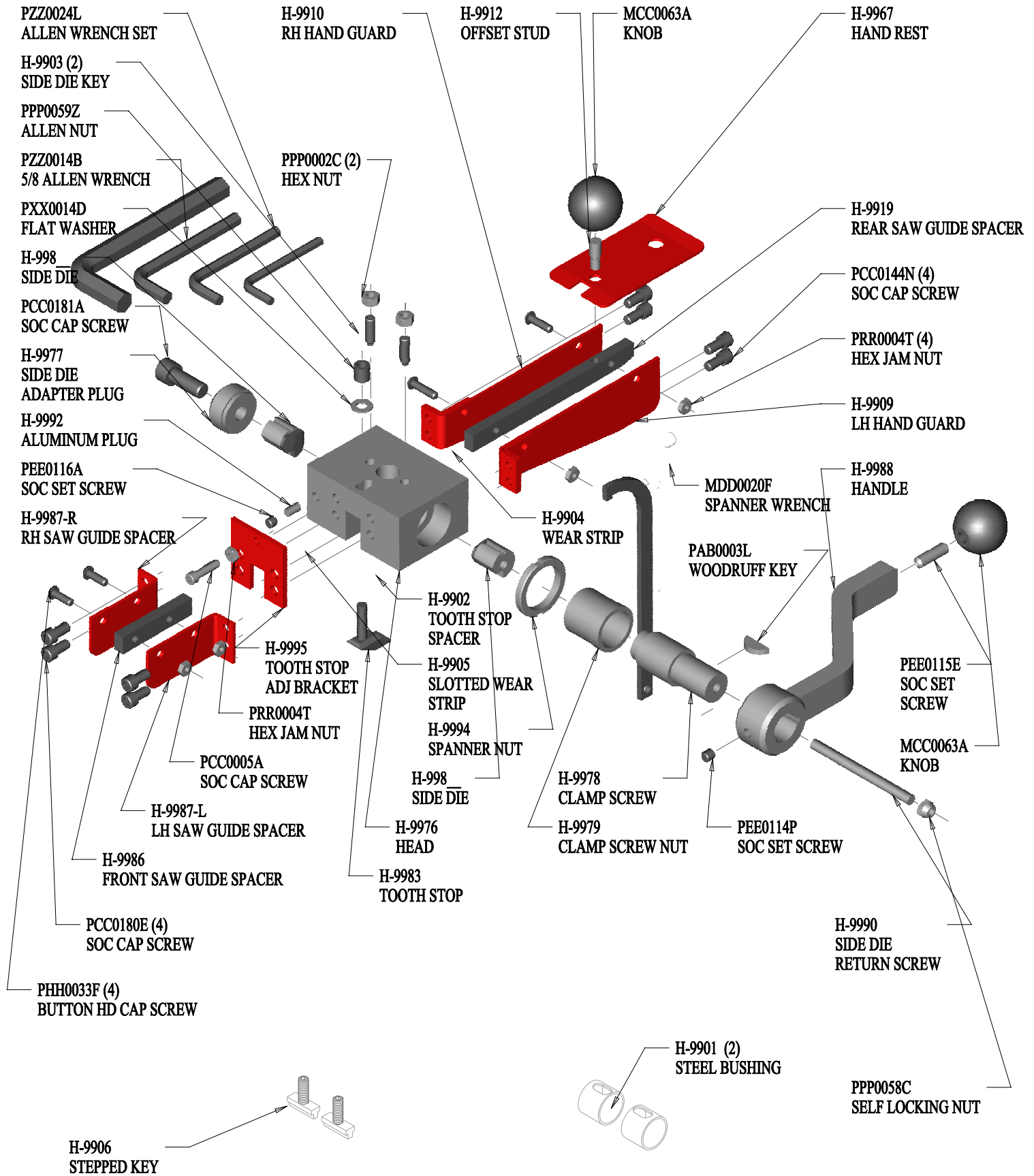
Too narrow a point will also cause an upward bulge or bend on the tooth point. In this case the bend upward is the result of too little material. To correct the bend condition, leave the cutting edge area of the point thicker by rolling the swage die back, or stopping the action of the swage die just ahead of the anvil.

LUBRICATION

All of our swages and shapers are lubricated at the factory. The moving parts, the side dies and clamp screw, will need lubrication with either oil or grease as necessary to help reduce friction and wear.

9900 MHB SHAPER

FOR BAND SAWS



(FOR USE WITH COMPETITORS JAWS)

(USED WITH THE ALUMINUM HEAD)