

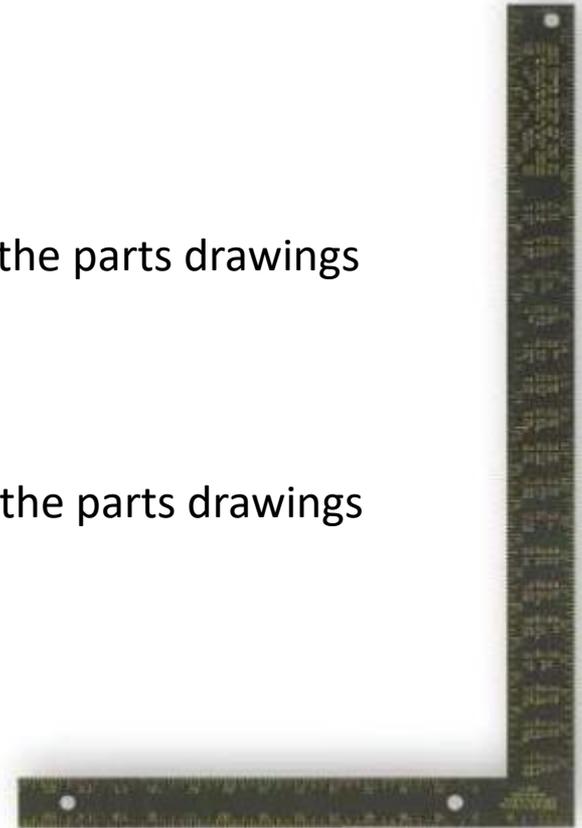
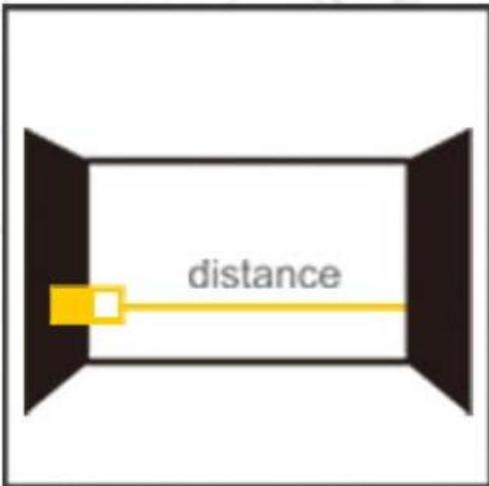
Checking Cut Parts Dimensions

First Parts Cut for the Shift

Measure each part and compare to dimensions on the parts drawings
Check each part to make sure cuts are square

Last Parts Cut for the Shift

Measure each part and compare to dimensions on the parts drawings
Check each part to make sure cuts are square



CNC Router Machine Operation for Lockdowel Manufacturing



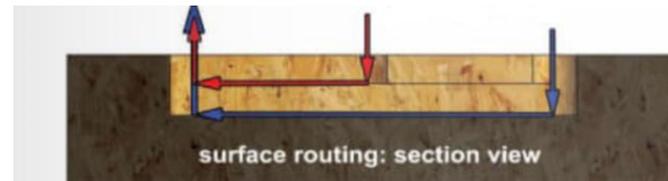
Router bit must be checked every 2,000 cuts
Change the router bit if the dimension is
under 8.1 mm



Router Bit Path

1st cut at 4.5 mm

2nd cut at 9.0 mm



■ Plunge Cut: Z: -4.5 Slot Cut: X: 0 to 34
■ Plunge Cut: Z: -9.0 Key Slot: X: -30 to 34
(Allowable Depth Range is -9.0 to -9.3)

Router Bit Speed

18,000 Revolutions Per Minute RPM

Feed Rate

15,000 mm per minute

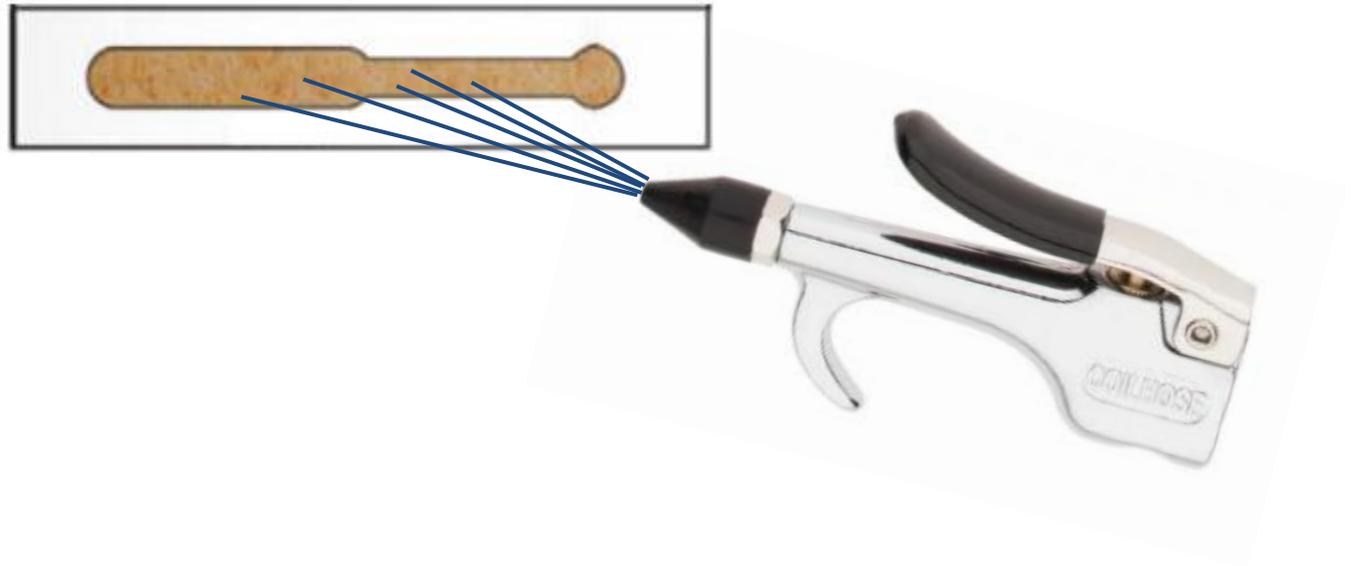
Plunge Rate

4,000 mm per minute

CLEANING EVERY Keyhole ROUTE

Every Keyhole route MUST be clean with **NO saw dust left in the route**

Use an Air Hose to blow out any sawdust left in the route after machining



CHECKING the Keyhole Slot Depth EVERY HOUR

#1



Power Button

#2



Compress Depth Pin against the panel as shown

PRESS Yellow Zero Button



#3



Slide the depth gauge over the Keyhole slot

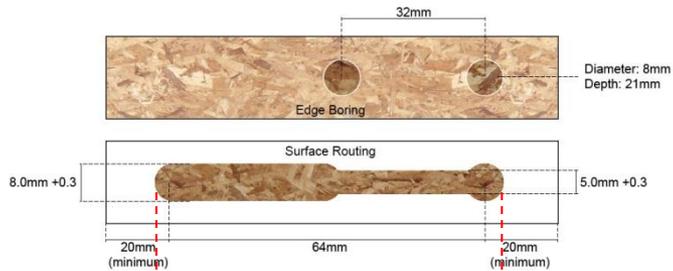
Read the Display

Depth must be between 9.0 – 9.3 mm

CHECK every 100 pieces



CHECKING the Keyhole Slot Size EVERY HOUR



Use Caliper to check the Keyhole slot length
Push Red Power Button
Compress forks and push Yellow Zero Button
Measure the Keyhole slot length



Read the Display

Length must be 72 mm

Check all dimensions at the start and end of each shift

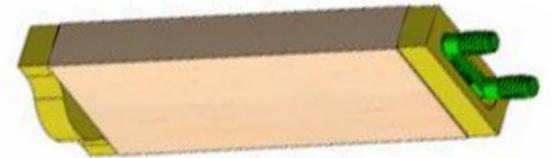
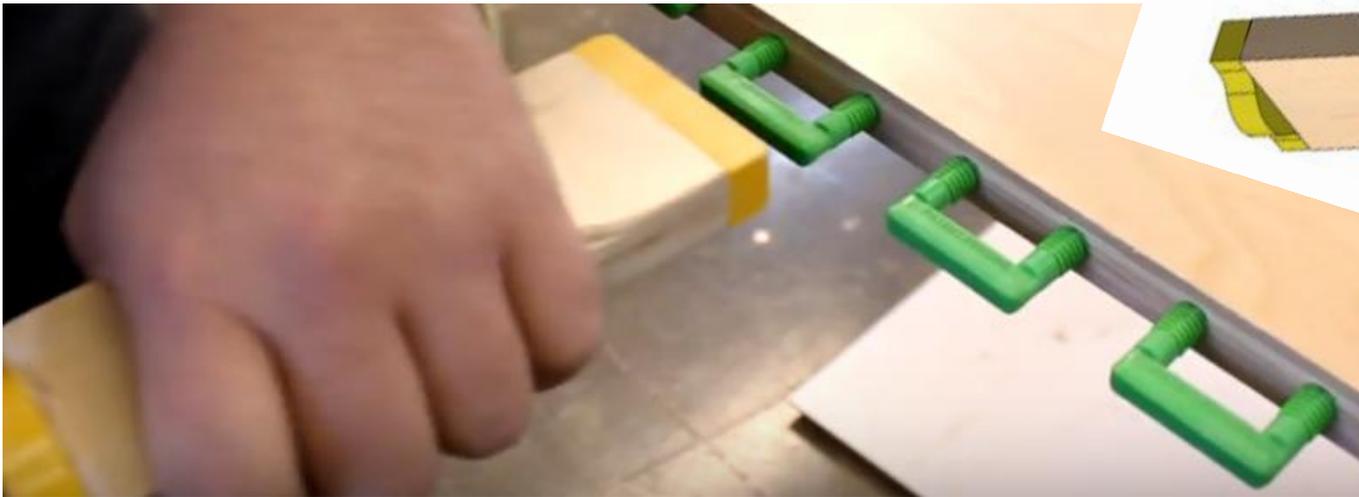
INSERTING the Channel Lock Fasteners

Use the hand insertion tool and a electric or pneumatic hammer

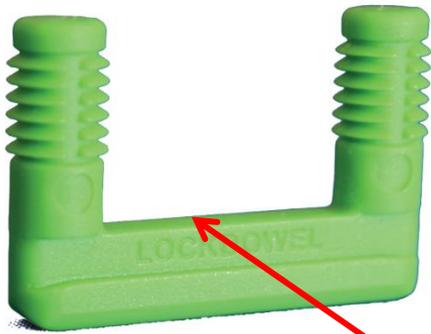
STACK the panels

INSERT Fastener by hand into the 8 mm holes

Use the insertion tool to **PUSH THE FASTENERS INTO PLACE**



INSERTING the Channel Lock Fasteners



Insert straight until the shoulder rests on the edge of the wood

Check Every Fastener on Every Part

Inserted too DEEP



Inserted CROOKED



MANUAL checking the Keyhole Route



Every 20 pieces use this hand tool to manually check each route in the panel

The hand tool should insert smoothly with medium resistance

Checking Assembly of Products

First Products made for the Shift

Attach a **FIRST PIECE Label** to all parts of the first production for a shift
Fully Assemble the first piece completed for the shift



Last Products made for the Shift

Attach a **LAST PIECE Label** to all parts of the first production for a shift
Fully Assemble the LAST piece completed for the shift

