

SINGLE AND DOUBLE EDGE SYSTEMS



by Fletcher

FM-45S Single Edge Machine

The Fletcher FM-45S Single Edge Machine is engineered to meet each customer's specifications. With the wide range of available equipment, a complete edge finishing system can be built into one machine. Scoring saws, trim saws, shapers, sandbelts, clean-offs and foilers can be combined to meet the needs of any manufacturing facility. Fletcher's design and construction surpass today's production standards.

To build your single edge system, choose from among these available specifications and options:



- 1 HP to 15 HP top or bottom scoring saw, tilt or non-tilting.
- 1 HP to 15 HP top or bottom trim saw, tilt or non-tilting.
- 1 HP to 10 HP jump scoring saw with 90 degree tilt.
- 7½ HP to 15 HP high speed shape head with 90 degree tilt.
- 7½ HP to 15 HP jump shaper.
- 2 HP to 5 HP shaker sander with 2 or 4 heads.
- 2 HP, 103 inch by 3 inch, 75 degree tilt triangular sandbelt with variable speed drive.
- 3 HP or 5 HP, 146 inch by 4 inch, 75 degree tilt parallel sandbelt with pivot blockholder.
- Oscillation unit for parallel sandbelts.
- Air operated blockholders.
- Abrasive sanding wheel, 2 HP motor.
- Air nozzle blow-off for foilers.
- Clean-off brush with tilt, vertical and horizontal adjustments.
- Single or double wheel foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- Edge foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- Fiber block feed chain with urethane rubber pads.
- Variable speed mechanical feed chain drive.
- Tenon type holddown chain rides on ball bearings; each holddown link has a rubber pad.
- Hopper feed automatically feeds machine.
- Electrical controls, dust hoods and safety guards standard.
- 230/460 volts.



FM-55S Single Edge Machine

The Fletcher FM-55S is another example of Fletcher innovation. Engineered to customer specification to the most exacting standards, a complete edge finishing system can be built into one machine with a wide range of available equipment options. Scoring saws, trim saws, shapers, sandbelts, clean-offs, foilers and rip saw can be combined to meet any manufacturing requirements.

Build the features you need onto your FM-55S with these available equipment specifications:

- 1 HP to 15 HP top or bottom scoring saw, tilt or non-tilting.
- 1 HP to 15 HP top or bottom trim saw, tilt or non-tilting.
- 1 HP to 10 HP jump scoring saw with 90 degree tilt.
- 7½ HP to 15 HP high speed shaper with 90 degree tilt.
- 7½ HP to 15 HP high speed jump shaper.
- 2 HP to 5 HP shaker sander with 2 or 4 heads.
- 3 HP to 5 HP, 146 inch by 4 inch, 75 degree tilt parallel sandbelt with blockholder.
- 3 HP to 5 HP, 220 inch by 4 inch, 75 degree tilt parallel sandbelt with blockholder.
- 2 HP, 103 inch by 3 inch, 75 degree tilt triangular sandbelt with variable speed drive.
- Oscillation unit for parallel sandbelts.
- Air operated blockholder.
- Abrasive sanding wheel, 2 HP motor.
- Air nozzle blow-off for foilers.
- Clean-off brush with tilt, vertical and horizontal adjustments.
- Single or double wheel foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- Edge foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- 1 HP to 15 HP rip saw, tilt or non-tilting.
- Variable speed mechanical feed chain drive.
- Variable speed hydraulic feed chain drive; each feed chain link has serrated rubber pads.
- Tenon-type holddown chain rides on ball bearings; each holddown link has rubber pad.
- Bolt-on dogs.
- Hopper feed.
- All electrical controls, dust hoods and safety guards standard.
- 230/460 volts, 3 phase 6 cycle.
- Other special machining heads quoted upon request.

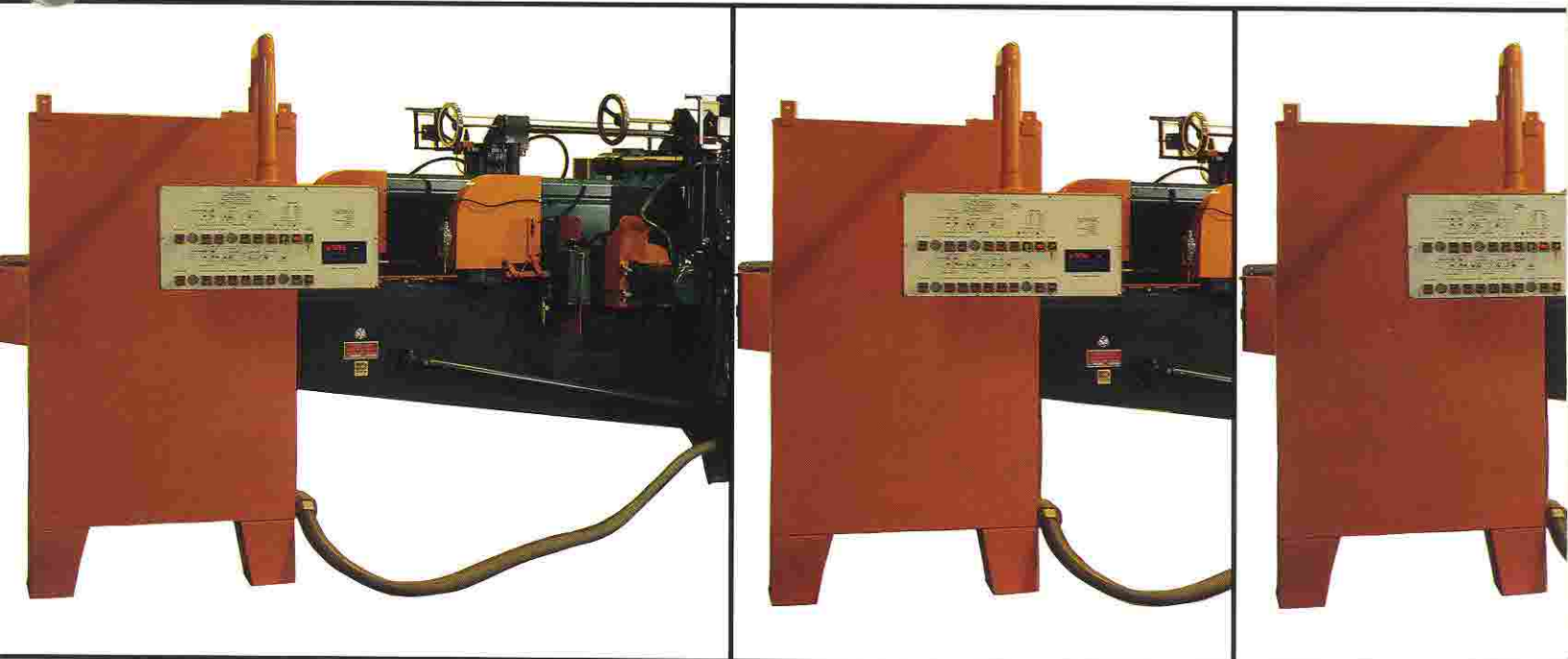


FM-200D Double Edge System

The Fletcher 200-D is an excellent example of Fletcher's Total Requirement Machine. The FM-200D is the starting point for an edge system which will perform score sawing, trimming, tenoning, shaping, overhead grooving, sanding, dadoing, edge foiling, as required.

To build your custom Total Requirement Machine, start with the FM-200D and add the options you need from among the following available specifications and options:

- 1 HP to 15 HP top or bottom scoring saws, tilt or non-tilting.
- 1 HP to 10 HP jump scoring saw with 90 degree tilt.
- 1 HP to 15 HP top or bottom trim saw, tilt or non-tilting.
- 7½ HP overhead jump groovers mounted on overhead beam.
- 15 HP vertical or horizontal saws with reversing drum switches.
- 7½ HP to 15 HP high speed shape heads with 180 degree tilt.
- 7½ HP to 15 HP high speed jump shapers.
- 7½ HP to 10 HP jump or stationary dados.
- 2 HP to 5 HP shaker sander with 2 or 4 heads.
- 3 HP to 5 HP, 146 inch by 4 inch parallel sandbelts with 75 degree tilt and blockholders.
- 3 HP to 5 HP, 220 inch by 4 inch parallel sandbelts with 75 degree tilt and blockholders.
- 2 HP, 103 inch by 3 inch, 75 degree tilt triangular sandbelt with variable speed drive.
- Oscillation unit for parallel sandbelts.
- Air operated blockholders.
- Abrasive sanding wheels, 2 HP motor.
- Air nozzle blow-off for foilers.
- Clean-off brush cleans board prior to foiling applications.
- Single or double wheel foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- Edge foiler unit with 80 degree tilt; each foiler unit independent with its own adjustments and controls.
- 1 HP to 15 HP rip saw, tilt or non-tilting.
- Variable speed mechanical feed chain drive.
- Variable speed hydraulic feed chain drive; each feed chain link has serrated rubber pads.
- Riser block for feed chains.
- Tenon-type holddown chain rides on ball bearings; each holddown link has a rubber pad.
- Bolt-on dogs.
- Snap-up dogs on 20-inch centers; available on any centers in multiples of 5 inches.
- Hopper feed.
- Sound enclosures designed to cover all cutting tool stations except dado arbor.
- Straightedge for either side of machine.
- Staggered holddowns (motorized) for running narrow parts.
- Digital readouts.
- Jog cable, allows operator to jog the feed chain.
- Computerized line control on all dimensional setups and jump timing.
- All electrical controls, dust hoods and safety guards standard.
- Electrical: 230/460 volts, 3 phase, 60 cycle.
- Other special machining heads quoted upon request.



Standard Specifications:

FEED CHAIN: Solid machined steel link with serrated rubber pads; each link joined by $\frac{3}{8}$ -inch diameter pin; chains ride in a V-groove UHMW plastic track to reduce friction.

DRIVE SPROCKETS: Each chain link individually driven with sprockets with 8 teeth.

DOGS: Standard 20-inch centers, but can be ordered on any centers in 5-inch multiples; dogs snap back against chain link with a cutout shoulder to support dog.

LUBRICATION: Each feed chain equipped with automatic lubricator providing constant oil flow when chains are running; built-in sensor automatically stops lubricators when chains are stopped; oil flows to felt wipers continuously clean and lubricate bottom V of chains with each revolution around sprockets.

HOLDDOWNS: Minimum friction holddown chains ride directly over feed chains; each link has heavy duty bearing and a link wear spacer mounted on each side to eliminate friction in holddown track; 1 by 1 by $\frac{3}{4}$ -inch V-shaped UHMW Tufflex rubber block attached to holding face of each link prevents slipping or marking of stock;

safety wobble stick microswitch mounted at infeed end of holddown to prevent jam-ups or operator accident — acts as emergency stop and immediately shuts down machine.

TRAVERSE: Digital readout indicator shows width adjustments in .001-inch graduations; limit switch mounted on traverse screw to prevent opening beyond capacity; minimum opening: $4\frac{3}{4}$ -inch; maximum opening: 80 inches.

JOG CABLE: Allows the operator to jog the feed chain from any station on the machine for easy setup; can also be used as feed chain emergency stop.

CONTROL PANEL: Individual illuminated start-stop buttons located on freestanding control panel at infeed end; master stop buttons on control panel and at outfeed end to stop machine; master lockout system with removeable key ensures that machine cannot be started during setup.

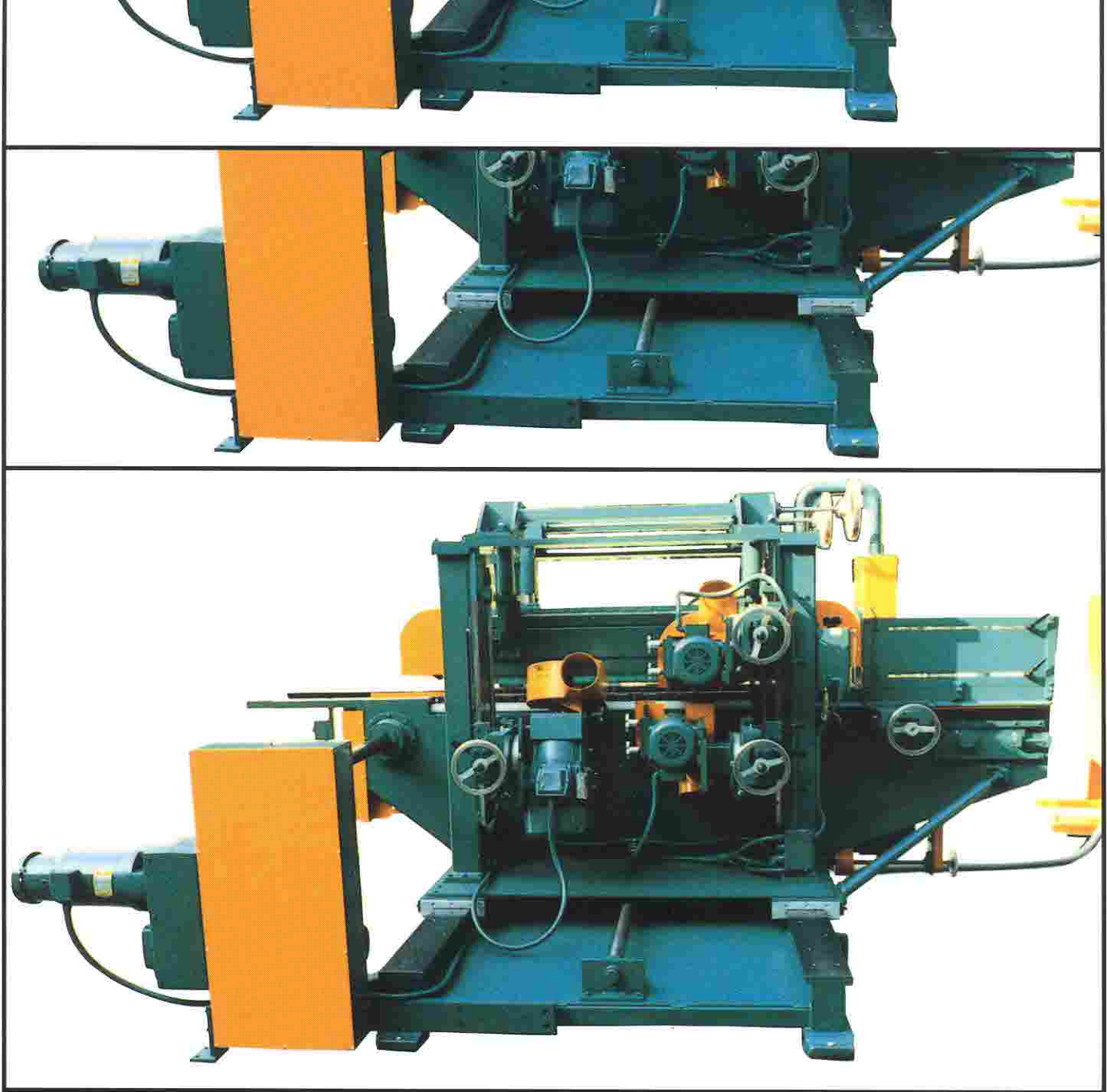
GUARDS, DUST HOODS: All moving parts covered by heavy duty guards or dust collectors guards painted bright Caution Orange; machining stations with 6-inch dust hood opening and sandbelts with 4-inch openings.

WIRING: Standard wiring either 230 or 460.

INCLUDED WITH MACHINE: One set of steel shape blocks for each sandbelt station (shape per customer requirement); all tools, operators' manuals, spare parts lists; customer specifications kept in computer.

NOT INCLUDED: Saw blades, abrasive wheels, sandbelts, leveling materials. Diamond tooled cutterheads quoted upon request.

FLETCHER MACHINE INC. RECOMMENDS TRANSIT LEVELLING OF MACHINE AND SHOULD BE ADVISED IF TRANSIT IS NOT OBTAINABLE.



FM-210 Panel Sizer

The Fletcher FM-210 Panel Sizer trims and shapes doors, drawer fronts, table tops with precision and consistency.

Specifications:

- 40-inch traverse opening.
- Hopper infeed.
- Four open machining stations.
- Top trim saws: 7 ½ HP, 3600 RPM, TEFC motor.
- Top and bottom tenon heads: 7 ½ HP, 3600 RPM, TEFC motor; tilting, right side of machine.
- Top and bottom tenon heads: 7 ½ HP, 3600 RPM, TEFC motor; tilting left side of machine.
- Variable speed hydraulic drive.
- Variable speed mechanical drive.
- 230/460 volts.