

SETUP AND USER INSTRUCTIONS

ACCUFAB PRO

SHEAR BLOCK POSITIONING SYSTEM



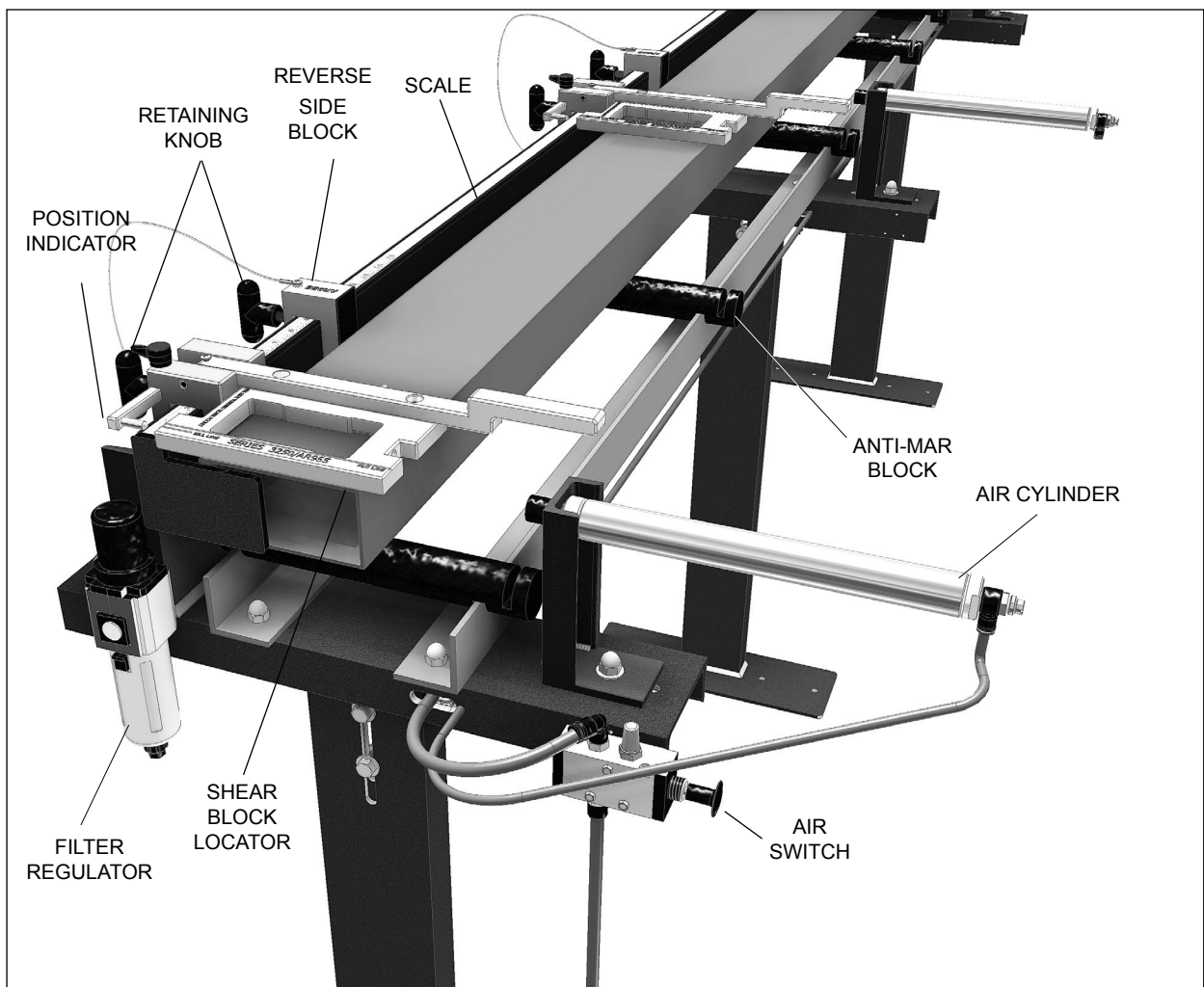
CATALOG NUMBER ACU1



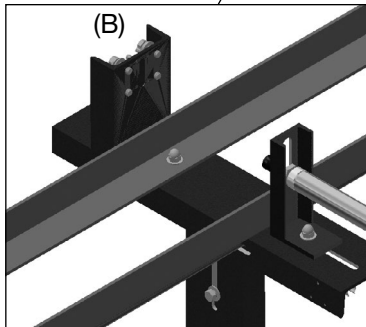
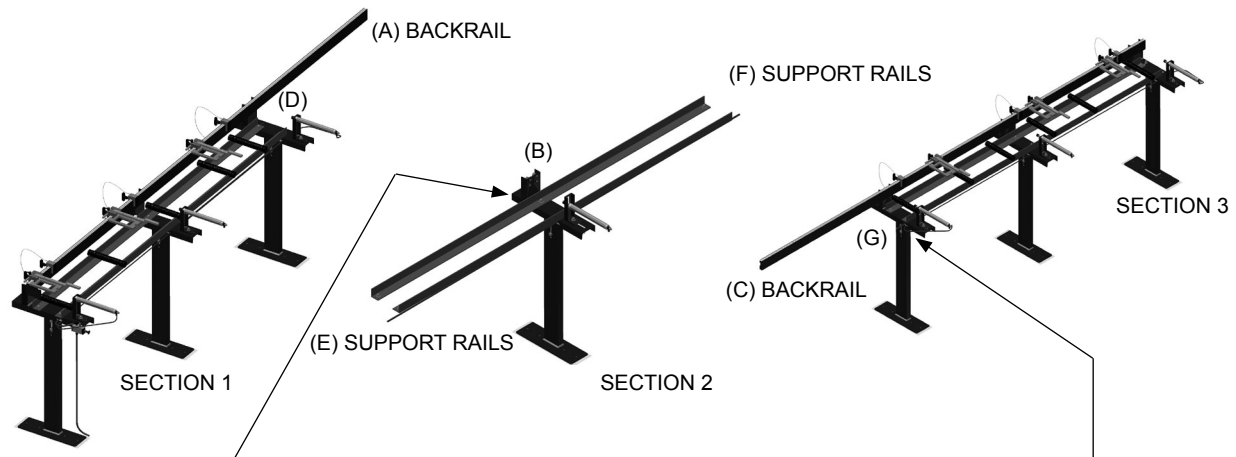
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INTRODUCTION

Congratulations on your purchase of the new Accufab Pro by C.R. Laurence Co., Inc. It has been designed to accurately and quickly locate Shear Block connectors on your storefront verticals. The holding fixtures are easily changed to handle a variety of stock and custom extrusion sizes. The calibrated rear sliding bar allows quick setup and accurate repeatability. In you shop or on the job site, the new Accufab Pro will eliminate misdrilled fasteners, out-of-level horizontal members and costly measurement mistakes.

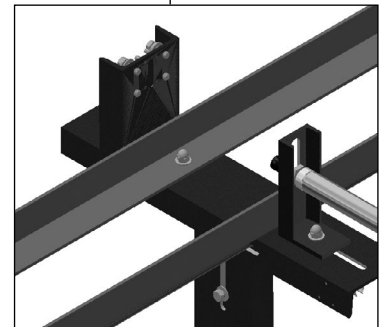


SETUP



2. Attach the Back Rail (A) to left bolts at (B) and Back Rail (C) to right bolts at (B).

1. Attach the legs to all sections allowing for height adjustment as shown below.



3. Attach the Support Rails (E) to Cross Member (D) and Support Rails (F) to Cross Member (G).



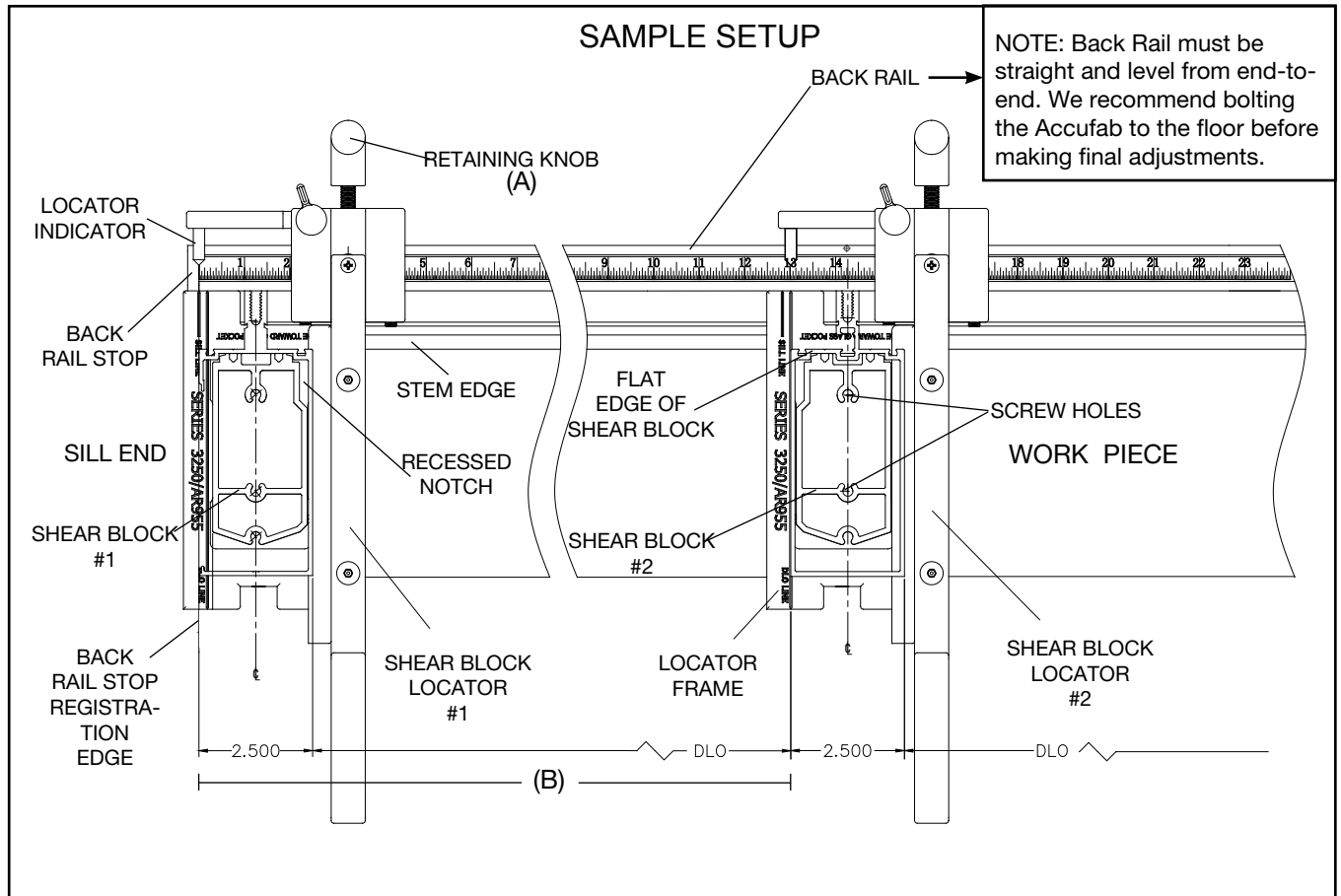
4. Level the Accufab Pro across the full length and adjust each leg height to correct for any center sag due to floor variations. We recommend checking the level and sag with a full size work piece in the unit. Adjust the legs to eliminate any gap between the material bottom side and the Anti-Mar Blocks.

5. Install the measuring scale supplied. (Refer to adjacent illustration)



Important Note: It is critical that the AccuFab Pro be properly installed before using. The Back Rail should be straight and level from end-to-end. Any distortion will be reflected in the finished part. We recommend bolting the unit to the floor once machine is properly positioned and before making final adjustments. See Sample Setup Illustration on next page.

USER INSTRUCTIONS

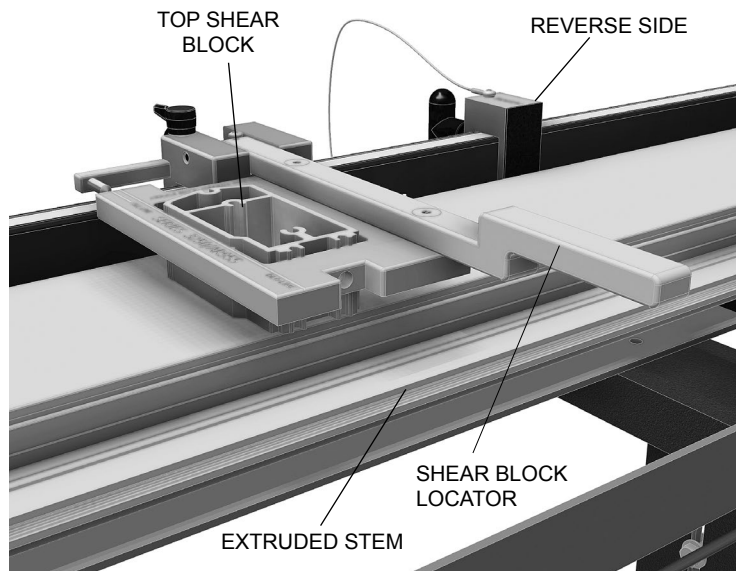


SAMPLE SETUP PROCEDURE

1. Place the work piece on the Accufab work table with the Stem Edge to the back.
2. Slide the work piece to the left until it is against the Back Rail Stop and tight against the Back Rail.
3. Deploy the Air Cylinders and adjust to 75 lbs.
4. Lower Shear Block Locator #1 and place a Shear Block inside the Locator Frame as illustrated. (Note the recessed notch)
5. Slide the Locator Indicator to Zero and tighten the Retaining Knob. (A)
6. Fasten the Shear Block with #12 x 2-1/2" Hex Washer Head Tek Screws.(CRL Part #1214X212TEK)
7. Position Shear Block #2 using the Indicator. Set to: (DLO + 2-1/2") (B)
8. Insert a new Shear Block (Note notch position), check the spacing with a tape measure, tighten the Retaining Knob and fasten.
9. Repeat the procedure for the remaining Shear Blocks.

FLIP SIDE FABRICATION

1. Release the pressure on the Air Cylinders and raise all of the Shear Block Locators to their resting position.
2. Slide the work piece away from the Back Rail and turn it over so that the Shear Blocks are on the bottom side and the Extruded Stem is toward the operator.
3. Push the material hard to the Back Rail and the Back Rail Stop. Note that the Reverse Side Blocks maintain a precise gap along the Back Rail controlling the alignment of the top-side Shear Blocks.



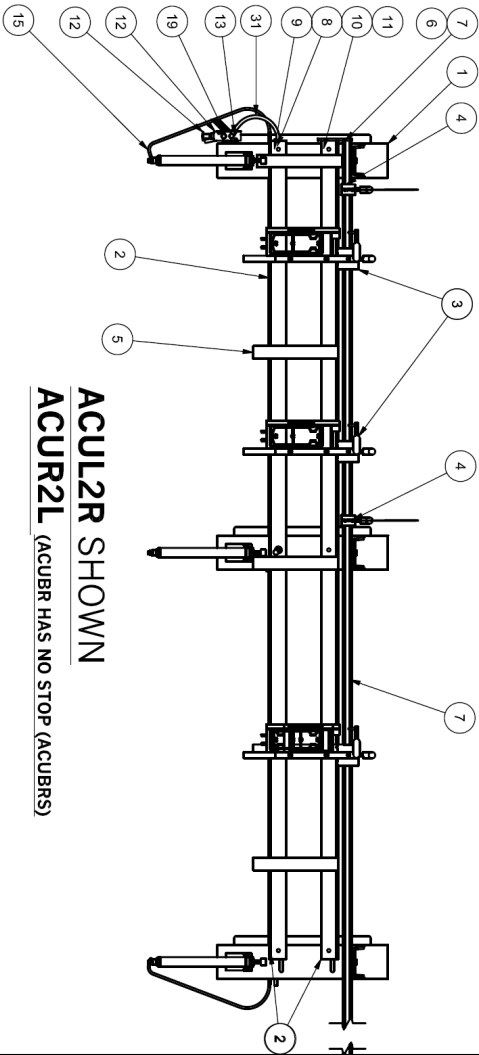
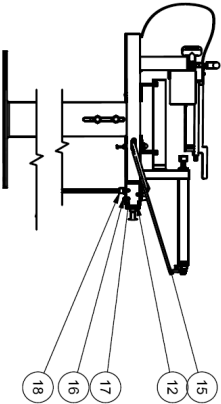
4. Lower the first Shear Block Locator and insert a Shear Block. Remember to mirror the orientation of the bottom Shear Blocks.
5. Fasten the Shear Block to the work piece with two self tapping screws
6. Since you did not move the Shear Block Locators, the top Shear Blocks should align with the bottom blocks. Insert the second Shear Block and check the Spacing with a tape measure.
7. Proceed with mounting the remaining Shear Blocks.
8. Release the Air Pressure before raising the Shear Block Locators and removing the work piece.

ADDITIONAL FLIP STOP FRAMES

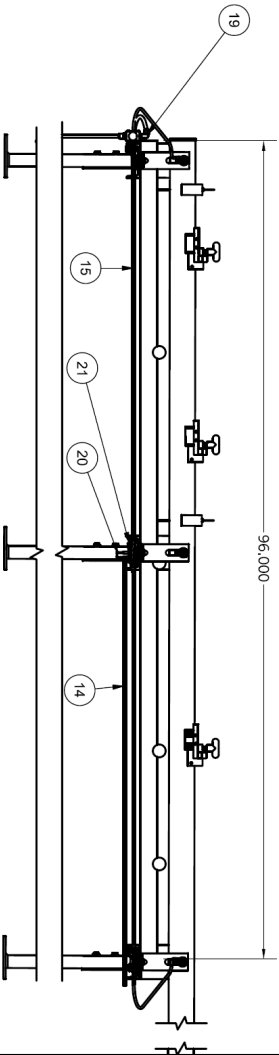
Additional Locator Frames for standard and custom Shear Blocks are always available from C.R. Laurence Co., Inc.

Shearblock Locator

Parts List		
ITEM	QTY	PART NUMBER DESCRIPTION
1	3	ACUSTAN Standard Vertical Assy
2	2	ACUGT Horiz frame and guide track
3	3	ACUFSTOP Shearblock Locator Frame
4	2	ACUREVSTOP Backside Shearblock Locator Frame
5	5	ACUDEBLK Anti mar block
6	1	ACU241APEMEAS 24" Tape Measure
7	1	ACUBR Back Rail
8	17	3816FW 3/8" Washer
9	8	3816X1HDCS 3/8" - 16 x 1" lg hx hd bolt
10	8	3816ACNUT 3/8" Acorn Nut
11	8	3816LW 3/8" Lock washer
12	1	ACUPBVALVE VALVE 1/4in NPT Cv=1.39 (6859K62)
13	1	ACU90ELBOW MALE ELBOW, 125NPT, .38 TUBING
14	10'	5097T632 3/8" dia tubing, blue
15	14'	5097T413 1/4" dia tubing, blue
16	2	ACUALPLUG14 1/4" Alum threaded plug
17	3	832X112SHCSS 8-32 x 1 1/2 lg hnd ms
18	1	5779K116 3/75 tube to 1/4 NPT straight conn
19	1	ACU14MUFFLER 1/4" Air muffler
20	2	ACUPLUG14 1/4" Air Plug
21	1	ACU3PUN 1/4 NPT 3 port union



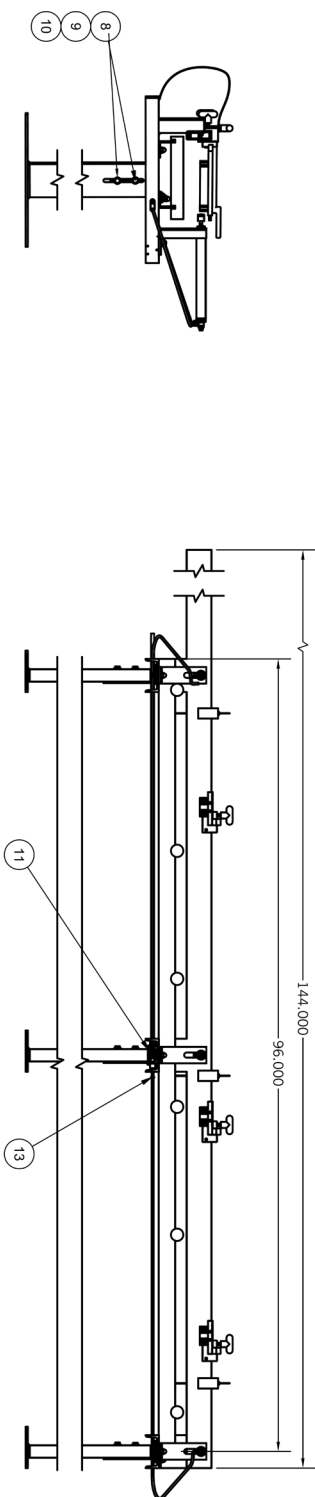
ACUL2R SHOWN
ACUR2L (ACUBR HAS NO STOP (ACUBRS))



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Frac.		FAX: (323) 232.2240	
XX		DIVISION	
XXX		BRN R 1/12 8/30/2012	
Angles		PART NUMBER	
Radial		ACCUFAB24 LEFT HAND ASSY	
REV		DESCRIPTION	
DATE		BY	
PART		ACCUFAB 24	
NOTE		ACUL2R	

ACUR2L SHOWN

ACUL2R (ACUBR IS OPPOSITE with ACUBS (STOP))



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES:		2100 E. 38th STREET VERNON HJ. 90058 PH: (323) 888-1281 FAX: (323) 242-2240	
Part:		PART NUMBER	
XX		UNITED STATES ALUMINUM	
XXX		ACURL	
Angles			
Radial			
REV	DESCRIPTION	DATE	BY PART
		8/30/2012	Brian R
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PRODUCT: ACURFAB 24		DRAWN BY	
ACURL			