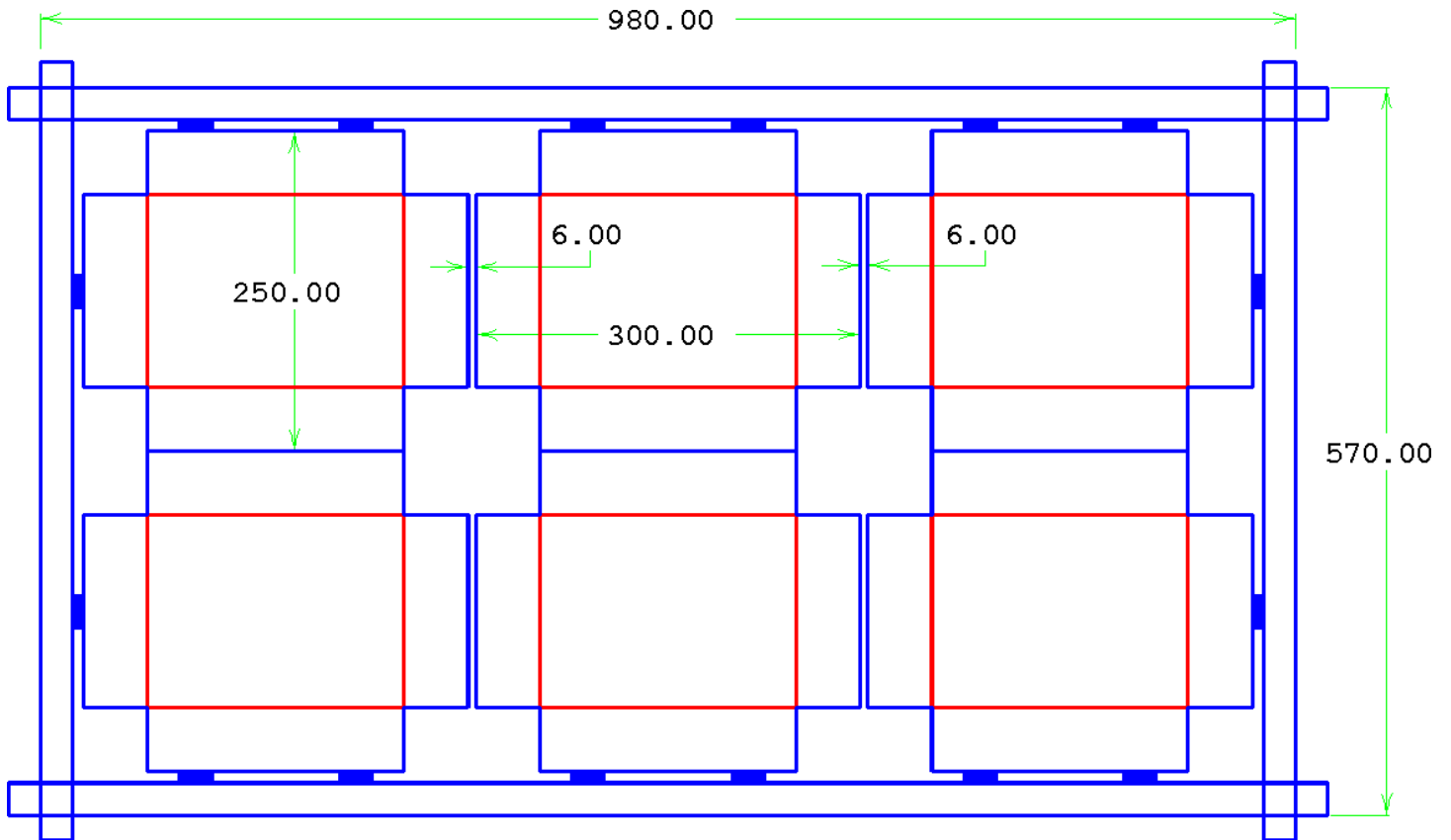


Layout 'B' - Double-Cut in X direction



- Knife – knife dimensions: mm mm
 - Plus allowance for Sliding Joggers (2 x 9mm) 912 x 500
 - Plus allowance for internal stacking 18 18
 - Plus Frame Bar thickness (2 x 25mm) 0 2
- | | |
|---|----------------------|
| | 50 50 |
| This gives us an Outside Frame Dimension of: | 980 x 570 |

Note that no internal stacking allowance is required for double-cutting as this allowance is catered for by the separating bars being thinner (generally 2mm overall) than the actual double-cut dimension.

To assemble Lower Frame for Layout 'B' above

Again taking a Bobst 102 as an example

Specifications: Frame Bar lengths **1090 / 867mm** - 1st Knife (Grip Setting) **88mm**

Front & Rear Bars

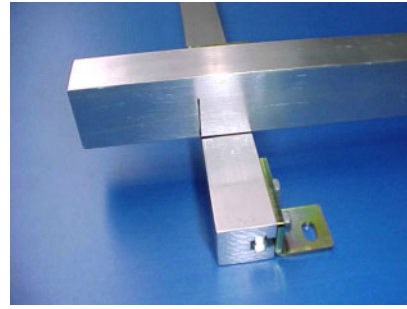
Mark **Outside Frame Dimension** of **930mm** centered on Front and Rear Frame Bars.

This is easily done by calculating the **required dimension** which is half the difference of the Bar length (1090mm) minus the Outside Frame dimension (980mm)

Calculation: (1090 minus 980 = 110) divided by 2 = **55mm**

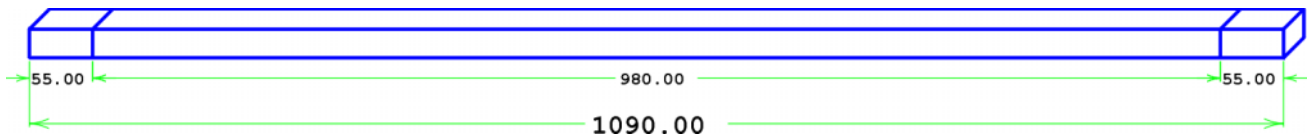


Scribing Position Marks



Bars in Position

Set this dimension of **55mm** on an adjustable square as shown and use a scribe to mark the ends of Front and Rear Frame Bars.



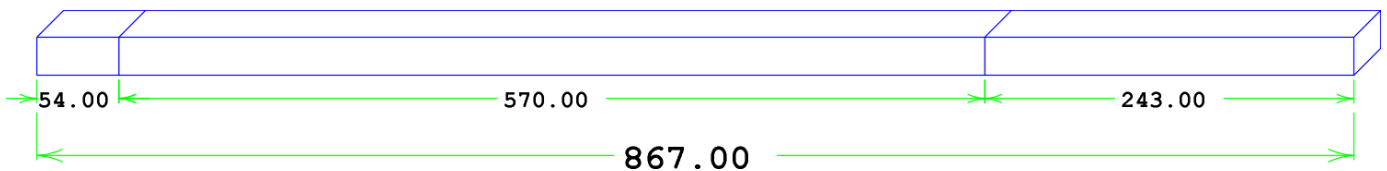
Side Bars

To establish the position of **Front Frame Bar** on Side Bars take the 1st knife / Grip Setting dimension of the machine (in the case of the Bobst 102 this dimension is **88mm**). Deducting our Sliding Jogger Dimension (including clearance) of 9mm and Frame Bar thickness of 25mm the dimension for positioning the outside of the Front Bar on the Side Bars would be (88 minus 9 minus 25) = **54mm**.

Use the adjustable square to scribe this dimension on the front ends of the Side Bars.

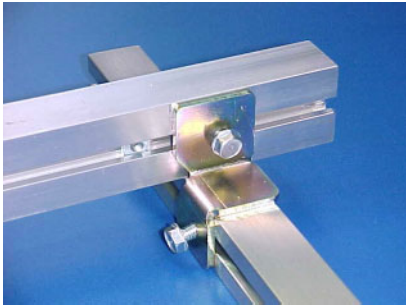
Now scribe position marks for the Rear Bar. This dimension is calculated by taking the above dimension of **54mm** and adding the **Outside Frame Dimension** of **570mm**. This dimension of **624mm** is deducted from the Side Bar length of **867mm** giving us **243mm**.

Please note that the Grip Setting calculations are based on standard gripper margins and optimum machine condition.



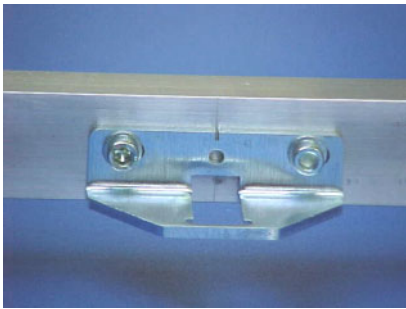
To assemble Lower Frame:

1. Ensure that sufficient Slide-Nuts to accommodate all components which will be attached to Frame Bars are fitted into the Bar recesses.
2. Lay the 4 Bars in their approximate positions.
3. Attach the 4 **Corner Brackets** loosely (Note that these are supplied in left and right-hand pairs with 2 distinctive finishes) by hand-tightening the hex set-screws.



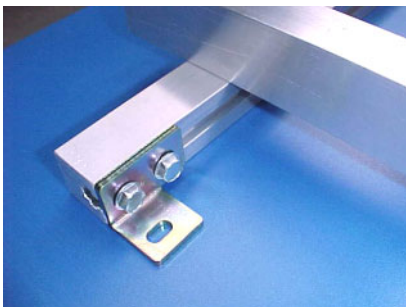
Corner Bracket Assembly

4. Use the scribe marks already made on the Frame Bars to position the Bars accurately and tighten all Corner Bracket screws securely (10mm spanner required).
5. Fit **Centre-Bracket** to Front Bar. Line-up by accurately matching scribed **centre-line** on Bar with **centre-notch** on Bracket.



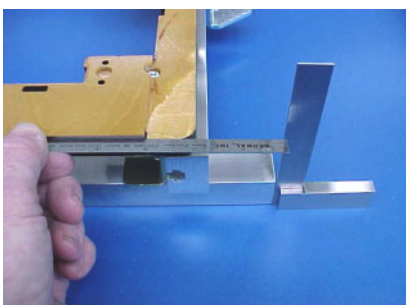
Centre-Bracket in Position

6. Fit 4 **Machine Mounting Brackets** in position by lining-up with outside edges of Bars. Note that these Brackets are supplied in left and right-hand pairs.



Machine Mounting Brackets

7. Check actual **1st Knife / Grip Setting Dimension** with Female Wood-Top in position. Any small adjustments if required should be made at this point by moving Front Bar (Rear Bar will also need to be moved to maintain correct Outside-Outside Bar Position).



Checking 1st Knife Position