



# *orteguil (u.k.) Ltd.*

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## GP81 OPERATING INSTRUCTIONS

- a) Connect the machine (15) to air supply and adjust air pressure regulator (13) to between 6 and 7 bar.
- b) Adjust the overhead clamps (no 9 +10) to suit the thickness and profile of the moulding.
- c) Set the rebate clamp (14) about 15/20mm from the vertical flat edge of the rebate.
- d) Place the chosen strip of pins into the magazine by pulling out rod no 8 and putting the strip (16) into the groove (5) in the direction shown. Make sure that the number on the plate (pictures top left) is the same as the size of pin ie 5mm pin with plate stamped 5. There are 4 plates altogether nos 5,7,10 or 12.  
Rod no 7 is to extract unused pins when you want to change to another size.
- e) Set the clamp (9) pressure on dial (11) 2 bars less than the pressure you set on dial (13) which controls the ram.
- f) Depending on the width of the moulding you may want fire pins in the outer and inner edges and even in between on wide mouldings. To set the inner and outer positions use sliding stops (2). You can keep firing pins so long as you keep your foot on the pedal (12)
- g) With some moulding in the machine press the foot pedal (12) and hold it down. This will operate both the overhead clamps and the rebate clamp (14). If the joint looks correct press button (1) which will fire the pin.

The oil in air system (13) should feed itself slowly into the pipes to stop the cylinders drying out. When it is getting low top up with SAE 30 oil.

Suppliers of machinery for mitreing wood, and underpinners for the picture framing industry

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