

# Evans Model 1050 T-Edge Applicator



## Operations Manual

April 2008



### EVANS MACHINERY, INC.

5530 N. 51ST AVENUE, GLENDALE, ARIZONA 85301

PO BOX 1406 85311

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PHONE 623-934-7294 FAX 623-934-7384

## **INSTALLATION**

1. Level and shim legs as required and anchor machine to floor.
2. POWER REQUIREMENTS : 220 Volts, 1 Phase, 60 hz, 20 Amp service  
(optional: 220 Volts, 1 Phase, 50 Hz)
3. AIR REQUIREMENT : 80-100 PSI

**CAUTION:** *USE A FUSIBLE DISCONNECT AND LOCKOUT WHEN INSTALLING AND SERVICING MACHINE*

## **CONTROL PANEL** (see FIG. 1)

1. POWER ON : activates machine
2. POWER OFF : deactivates all functions of machine
- 3 & 4. CUT OFF - ON/OFF : enables cutoff saw blade to turn on.

**CAUTION:** *THE BLADE WILL NOT ACTIVATE UNTIL CUTOFF FOOT PEDAL IS ENGAGED. THE FOOT PEDAL WILL TURN ON SAW BLADE AND BRING BLADE FORWARD INTO THE CUTTING AREA.*

- 5 & 6. HAMMER ON/OFF : turns HAMMER HEAD on and off
7. HAMMER SPEED : selection dial adjusts frequency of HAMMER action, from 0 - 3600 strokes per minute.

## **ADJUSTMENTS**

1. HAMMER : Travel of hammer per stroke can vary by the size of CAM on HAMMER SPINDLE. The machine is supplied with three cam sizes: 1/16 - 1/8 - 3/16 offsets.

To change the CAM, remove the pivot shoulder bolt on HAMMER HEAD (see FIG 2). Use a slot type screw driver to hold SPINDLE ARBOR and spin off LOCK NUT.

2. DIE HEAD : (see FIG 3) DIE BLOCKS (2) can be adjusted up and down to the T-molding being processed. Loosen DIE FACE adjusting screws (4) and position DIE BLOCKS to allow T-molding to go thru as shown in FIG 3.3. Re-tighten DIE FACE screws.

### **ADJUSTMENTS** (continued)

3. Adjust NYLON BLOCKS (2) and INFEED GUIDE up to the T-molding in position. Do not overadjust. T-molding must feed freely thru DIE BLOCKS.
4. T-molding with offset BARB towards the top might require the CORNER NOTCHER BLADE to be adjusted. This adjustment will require the back panel to be removed.

Loosen screw on the air cylinder CLAMP BLOCK and slide up or down until cutting edge of NOTCHER BLADE sits just above the DIE BLOCK opening. (See FIG 3.2)

**CAUTION: REMOVE ALL ELECTRICAL POWER WHEN MAKING THIS THIS OR ANY OTHER ADJUSTMENTS.**

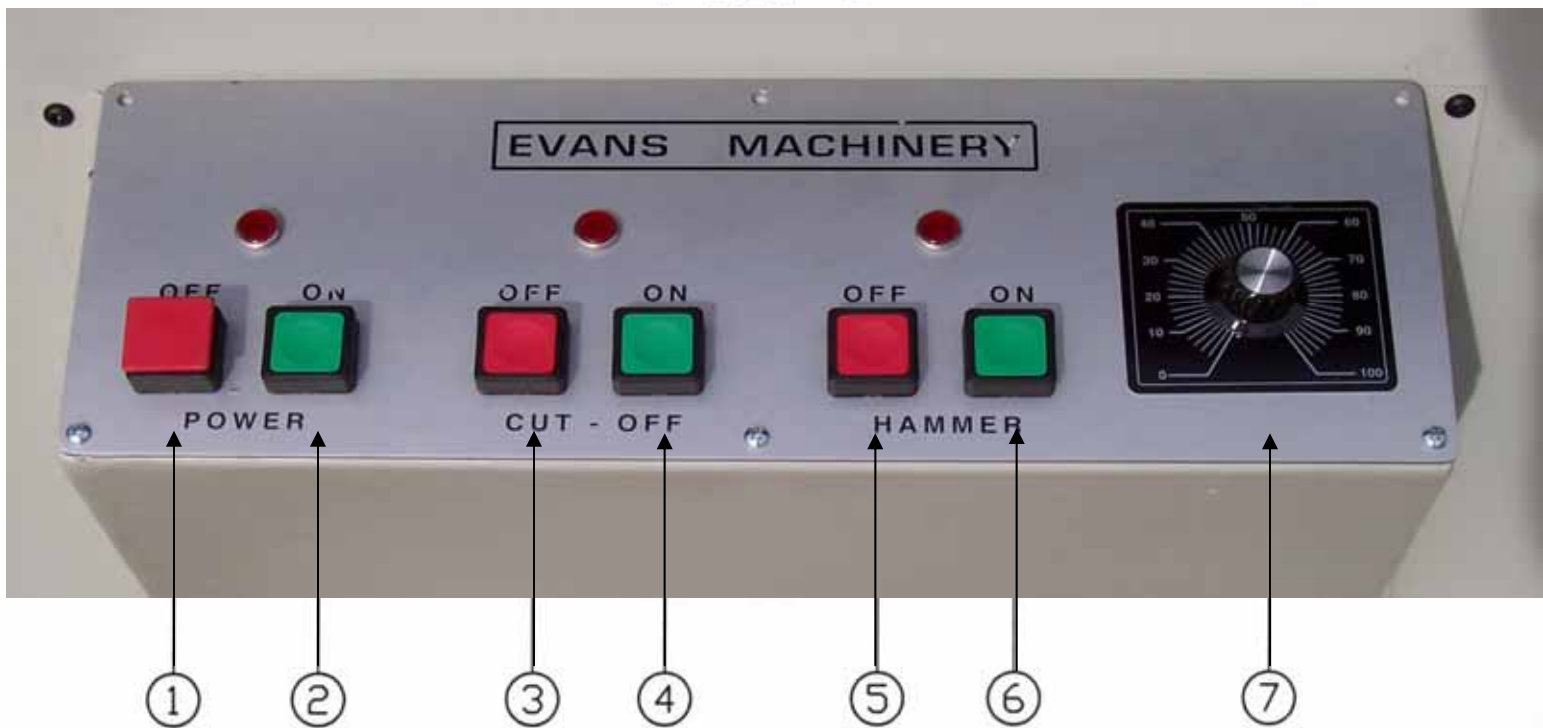
### **OPERATION**

1. Work piece to be T-edged must first be slotted to accept T-molding. (Refer to T-molding manufacturer for required width of slot)
2. Activate power on, CUTOFF and HAMMER switches. Adjust SPEED DIAL to an average speed (50-70).
3. For best results, insert T-molding into DIE and trim off the leading edge, to ensure a straight clean cut.
4. To apply molding refer to drawing on FIG. 4.

### **MAINTENANCE**

1. Keep machine clean.
2. Grease spindle bearings every 30 days.
3. Check and clean filter regulator and oiler unit regularly. Use only air lube type oil.
4. Check operation of oiler by cycling CORNER NOTCHER up and down. Correct setting is one drop of oil every 6-8 activations.

FIG. 1



- ① MAIN POWER SHUT-OFF SWITCH.
- ② MAIN POWER ACTIVATION SWITCH.
- ③ CUT-OFF SAW SHUT-OFF SWITCH.
- ④ CUT-OFF SAW ACTIVATION SWITCH.
- ⑤ HAMMER SHUT-OFF SWITCH.
- ⑥ HAMMER ACTIVATION SWITCH.
- ⑦ HAMMER SPEED SELECTION DIAL.

FIG. 2

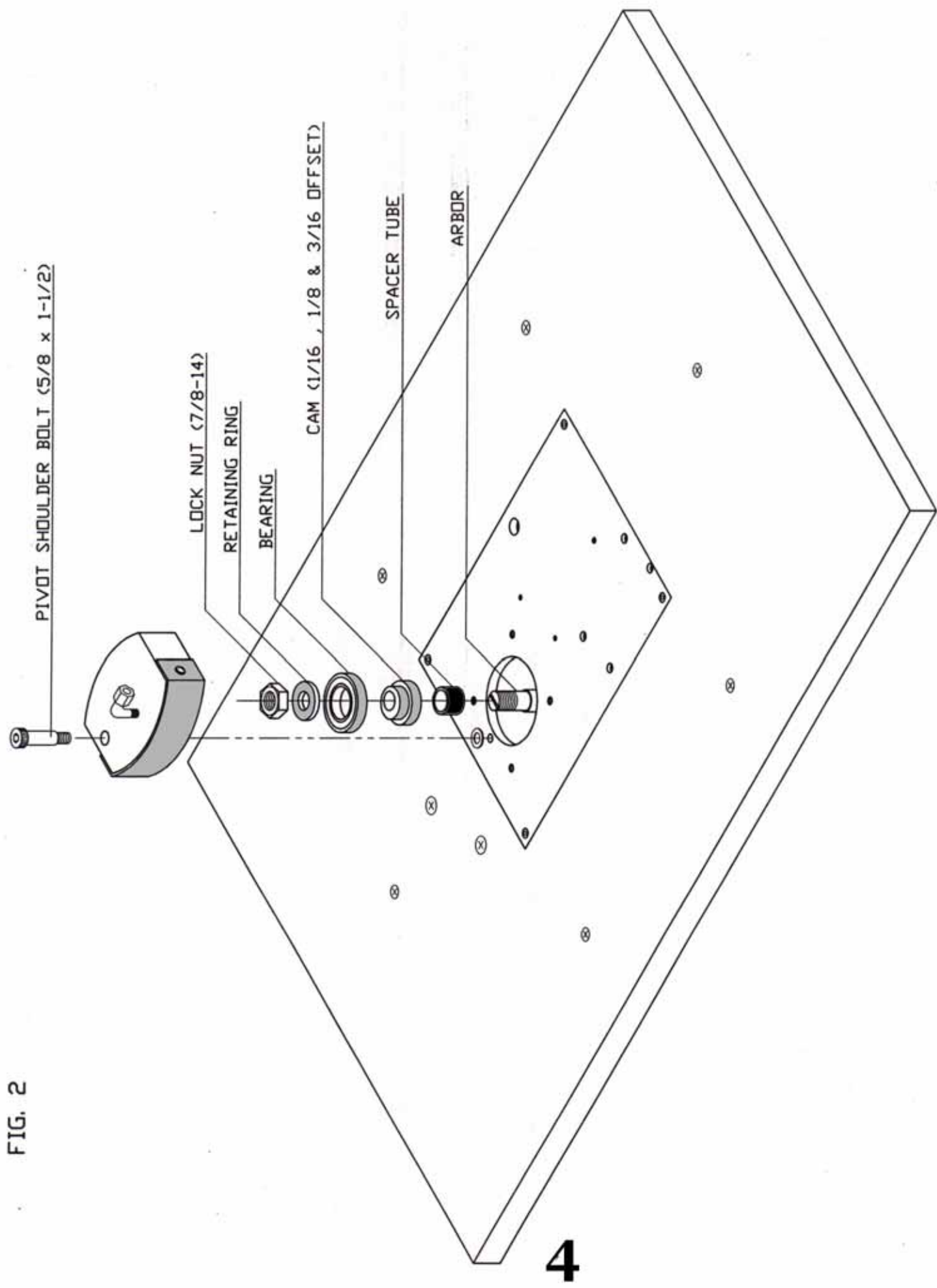
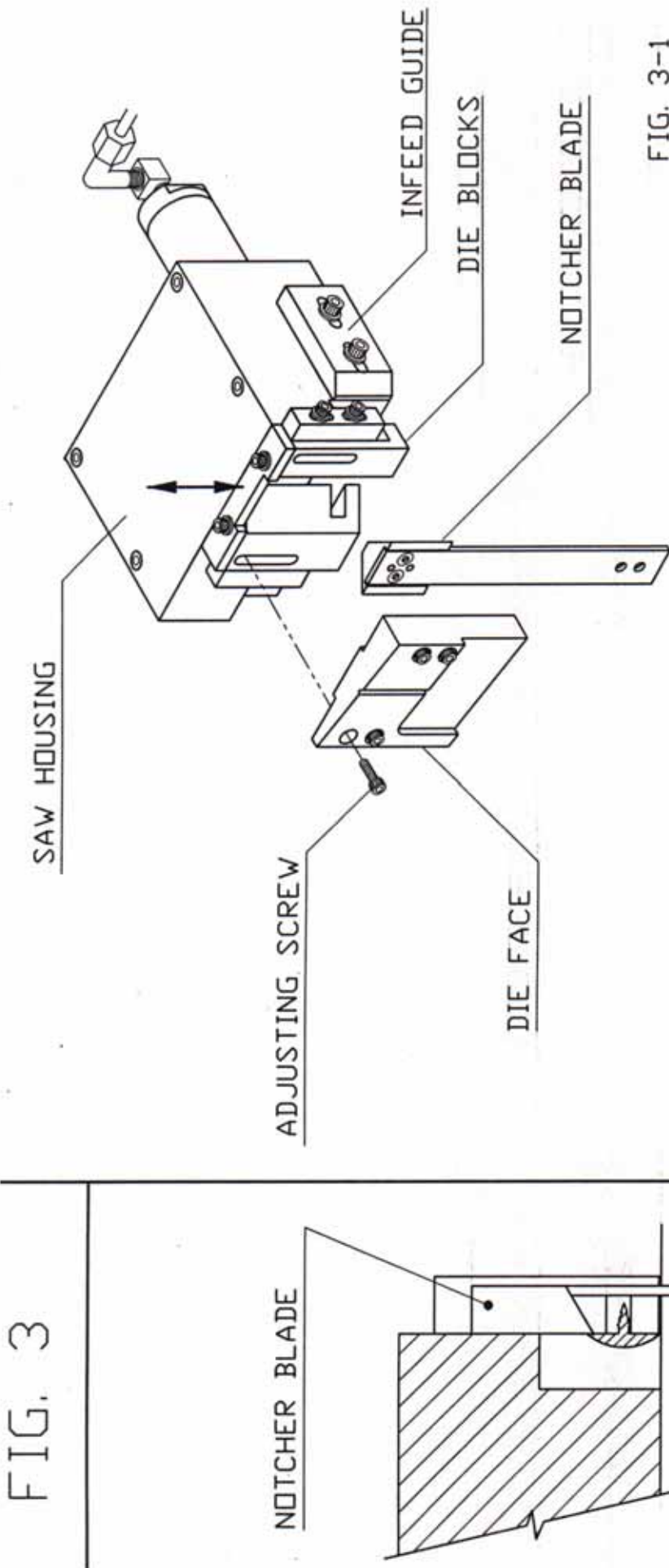


FIG. 3



51

FIG. 3-1

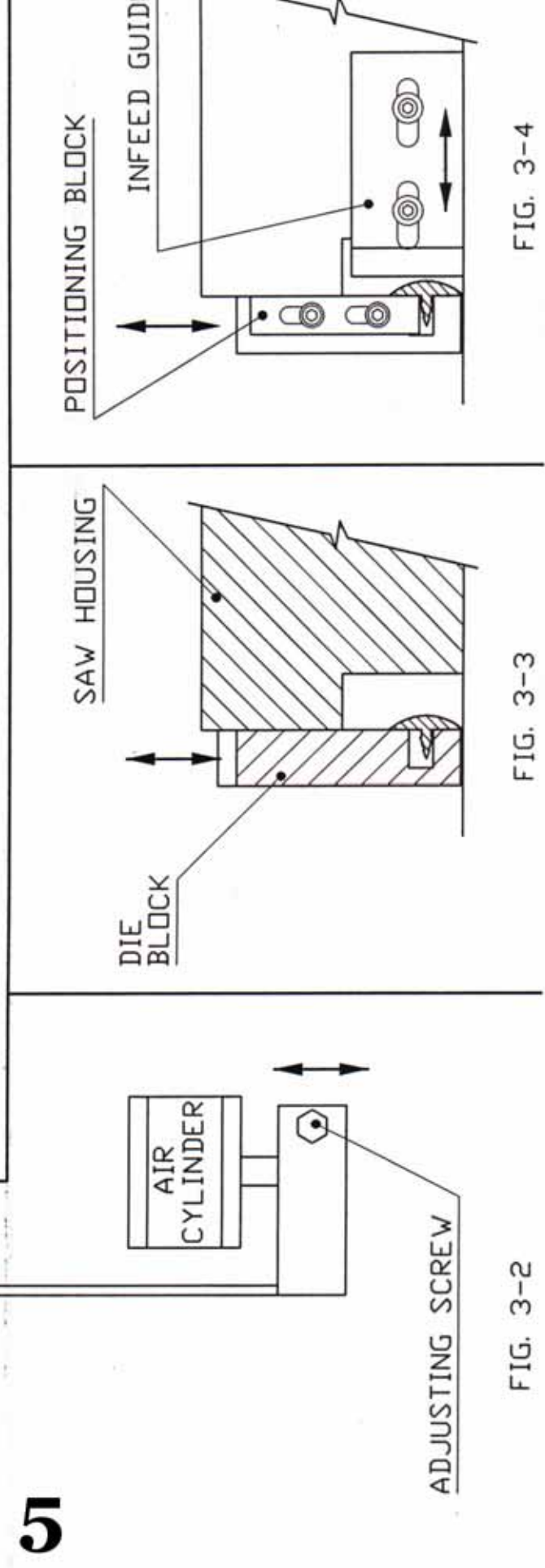
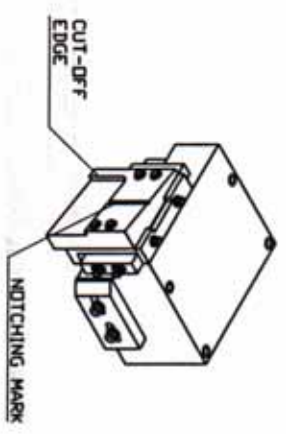


FIG. 3-2

FIG. 3-3

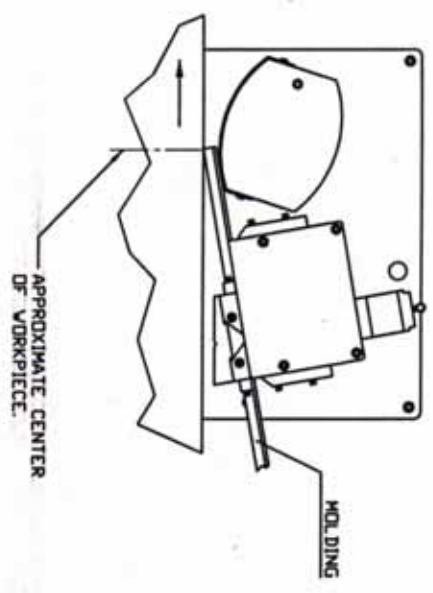
FIG. 3-4

FIG. 4

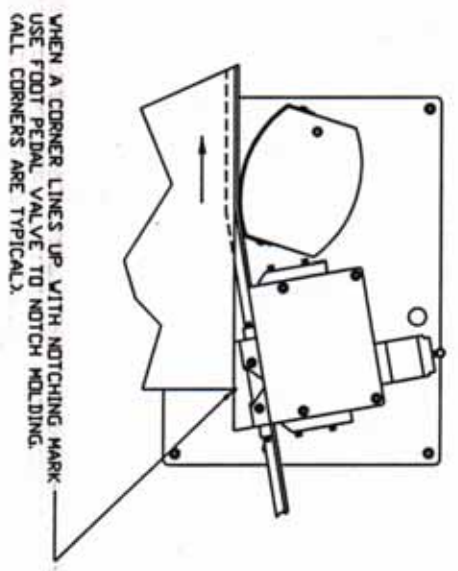


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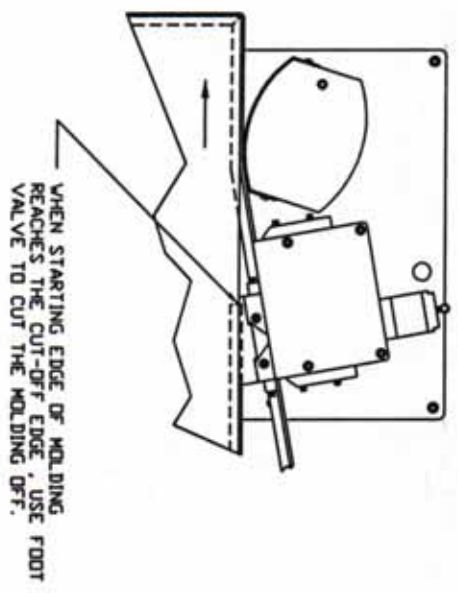
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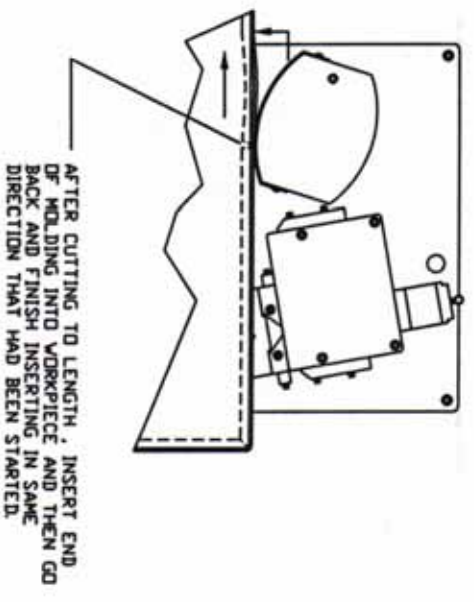
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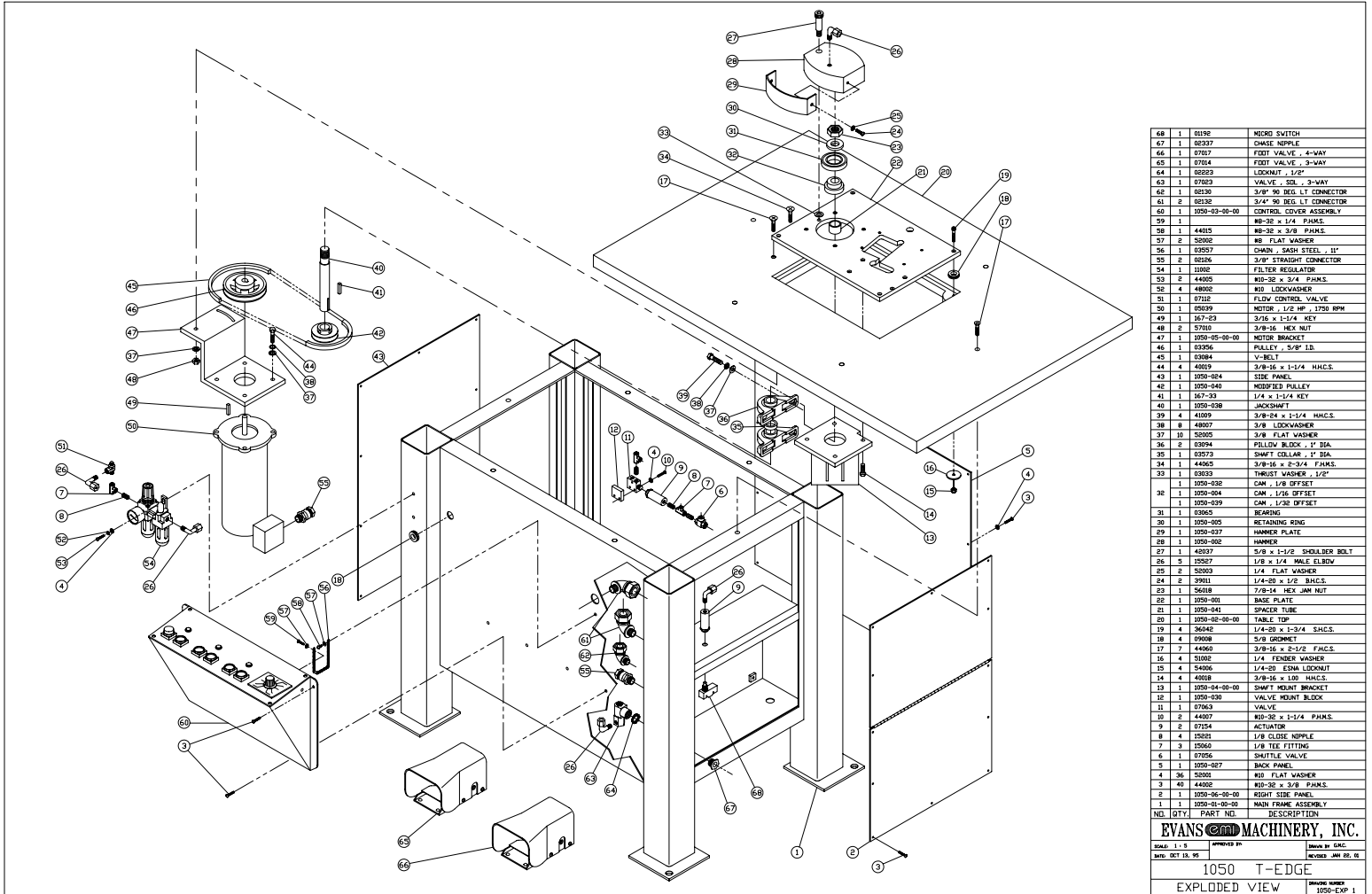
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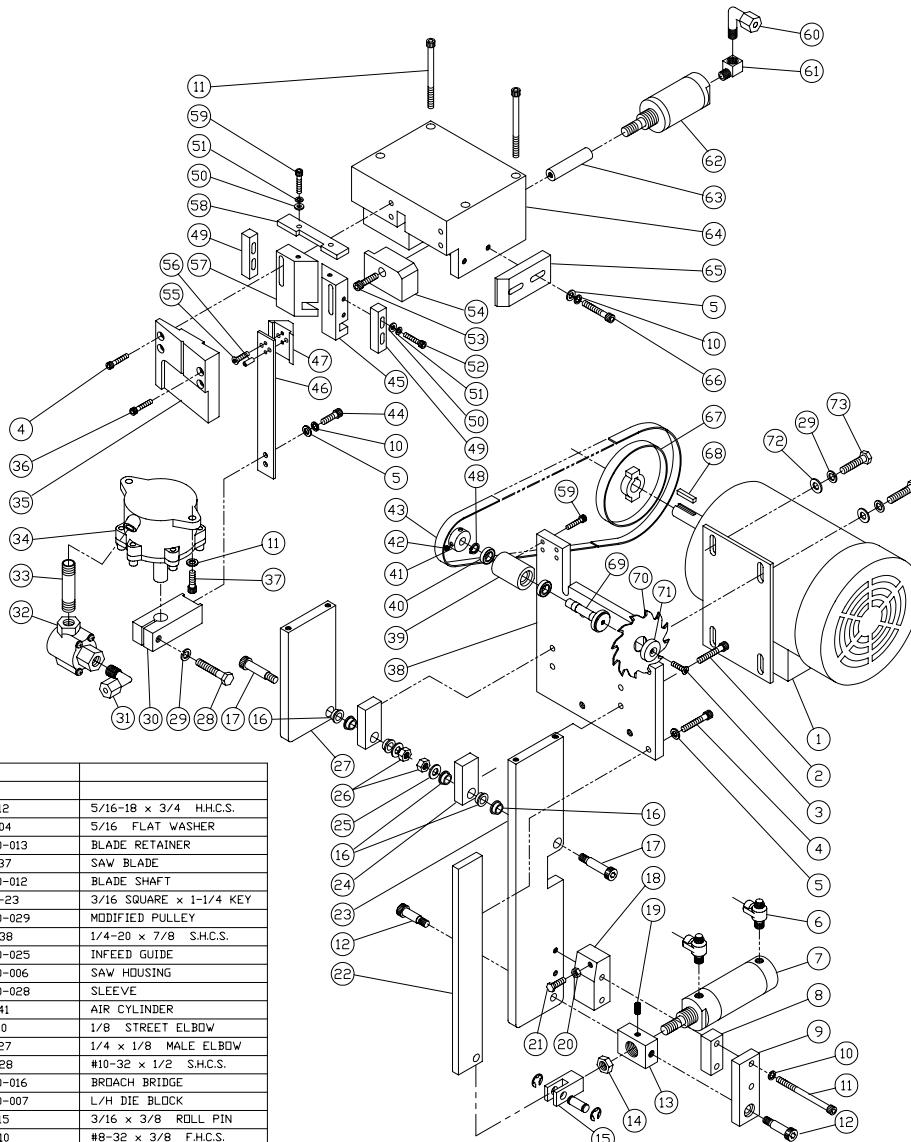
4



EVANS  MACHINERY, INC.  
 SCALE 1:1 = 4  
 DATE 7 JAN 18, 79  
 APPROVED BY  
 DRAWN BY G.H.C.  
 1050 T-EDGE  
 OPERATING INSTRUCTIONS  
 DRAWING NUMBER  
 1050-1 3



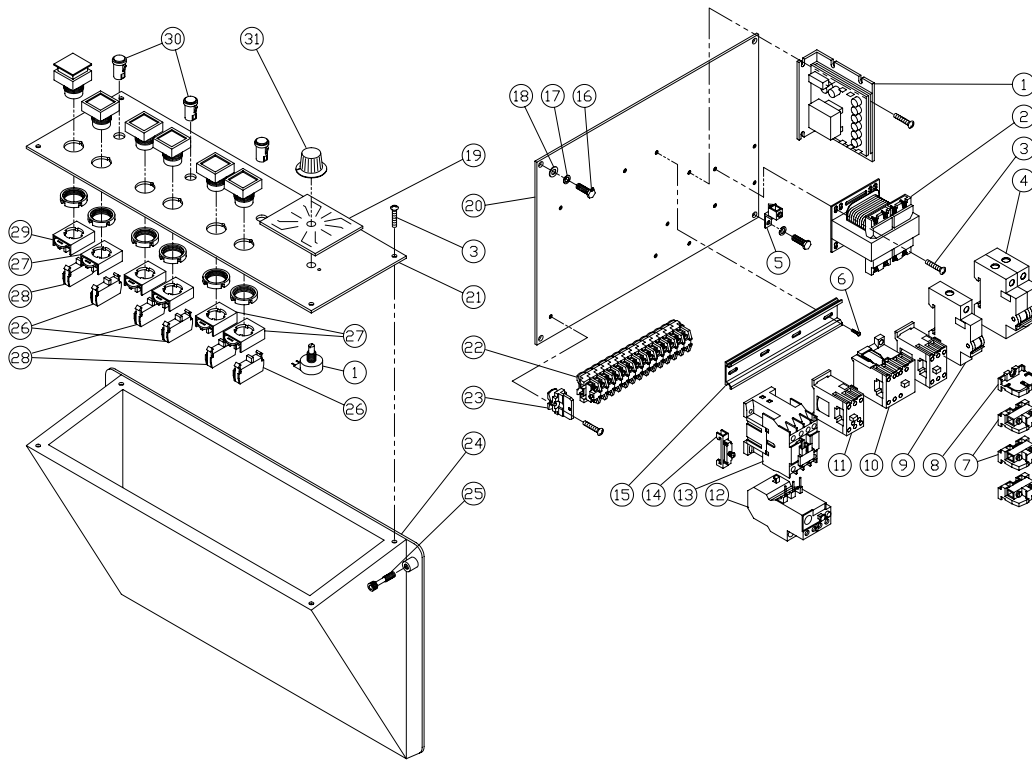
68	1	0198	MICRO SWITCH
67	1	0237	CHASE NIPPLE
66	1	0707	FOOT VALVE - 4-WAY
65	1	0704	FOOT VALVE - 3-WAY
64	1	0223	LOCKNUT, 1/2"
63	1	0703	VALVE - 3-WAY
62	1	0230	3/8" 90 DEG. LT. CONNECTOR
61	2	0232	3/4" 90 DEG. LT. CONNECTOR
60	1	1050-03-00	CONTROL COVER ASSEMBLY
59	1		MB-32 x 1/4 P.H.K.S.
58	1	4403	MB-32 x 3/8 P.H.K.S.
57	2	52002	MB FLAT WASHER
56	1	02527	CHAIN, SAE STEEL, 11"
55	2	02126	3/8" STRAIGHT CONNECTOR
54	1	71002	FILTER REGULATOR
53	2	44003	MB-32 x 3/4 P.H.K.S.
52	4	48002	MB LOCKWASHER
51	1	07115	FLWV CONTROL VALVE
50	1	15009	MOTOR, 1/2 HP., 1750 RPM
49	1	367-23	3/8" x 1/2" KEY
48	2	37100	3/8-16 HEX NUT
47	1	1050-05-00	MOTOR BRACKET
46	1	03096	PULLEY, 5/8" I.D.
45	1	03084	V-BELT
44	4	40017	3/8-16 x 1-1/4 H.H.C.S.
43	1	1050-084	SIDE PANEL
42	1	1050-040	MODIFIED PULLEY
41	1	367-23	1/4 x 1-1/4 KEY
40	1	1050-038	JACKSCREW
39	4	41005	3/8-24 x 1-1/4 H.H.C.S.
38	8	48007	3/8 LOCKWASHER
37	8	52005	3/8 FLAT WASHER
36	2	03954	PILLOW BLOCK, 1" DIA.
35	1	03573	SHAFT COLLAR, 1" DIA.
34	1	44005	3/8-16 x 2-3/4 P.H.K.S.
33	1	03033	THRUST WASHER, 1/2"
32	1	1050-032	CAM, 1/8 OFFSET
31	1	1050-034	CAM, 1/16 OFFSET
30	1	1050-039	CAM, 1/8 OFFSET
29	1	03065	BEARING
28	1	1050-009	RETAINING RING
27	1	1050-037	HAMMER PLATE
26	1	48037	5/8 x 1-1/2 SHOULDER BOLT
25	2	02027	1/8 x 1/4 WAVE ELEVEN
24	2	52003	1/4 FLAT WASHER
23	1	39011	1/4-20 x 1/2 S.H.C.S.
22	1	55019	7/8-14 HEX JAW NUT
21	1	1050-001	BASE PLATE
20	1	1050-041	SPACER TUBE
19	4	36048	1/4-20 x 1-3/4 S.H.C.S.
18	4	07008	5/8 GROMMET
17	7	44000	3/8-16 x 2-1/2 P.H.K.S.
16	4	31002	1/4 FENDER WASHER
15	4	34006	1/4-20 EDNA LOCKNUT
14	4	40018	3/8-16 x 100 H.H.C.S.
13	1	1050-04-00	SWAY MOUNT BRACKET
12	1	1050-030	VALVE MOUNT BLOCK
11	1	07063	VALVE
10	2	44027	MB-32 x 1-1/4 P.H.K.S.
9	2	07154	ACTUATOR
8	4	35221	1/8 CLOSE NIPPLE
7	2	05060	1/8 TEE FITTING
6	1	07056	SHUTTLE VALVE
5	1	1050-027	BACK PANEL
4	20	52000	MB FLAT WASHER
3	40	44002	MB-32 x 3/8 P.H.K.S.
2	1	1050-06-00	RIGHT SIDE PANEL
1	1	1050-01-00	MAIN FRAME ASSEMBLY
NDL QTY. PART NO. DESCRIPTION			
<b>EVANS MACHINERY, INC.</b>			
1050 T-EDGE			
EXPLODED VIEW			
DRAWN: L. S.		APPROVED BY:	ISSUED BY: G.H.C.
DATE: OCT 15, 95			REVISED: JAN 20, 96
			REVISION NUMBER: 1050-EXP 1



75			
74			
73	4	40012	5/16-18 x 3/4 H.H.C.S.
72	4	52004	5/16 FLAT WASHER
71	1	1050-013	BLADE RETAINER
70	1	08037	SAW BLADE
69	1	1050-012	BLADE SHAFT
68	1	167-23	3/16 SQUARE x 1-1/4 KEY
67	1	1050-029	MODIFIED PULLEY
66	2	36038	1/4-20 x 7/8 S.H.C.S.
65	1	1050-025	INFEED GUIDE
64	1	1050-006	SAW HOUSING
63	1	1050-028	SLEEVE
62	1	06041	AIR CYLINDER
61	1	15010	1/8 STREET ELBOW
60	1	15527	1/4 x 1/8 MALE ELBOW
59	6	36028	#10-32 x 1/2 S.H.C.S.
58	1	1050-016	BRDACH BRIDGE
57	1	1050-007	L/H DIE BLOCK
56	2	30015	3/16 x 3/8 ROLL PIN
55	2	35010	#8-32 x 3/8 F.H.C.S.
54	1	1050-021	PRESSURE PAD

53	1	36039	1/4-20 X 1.00 S.H.C.S.
52	4	36031	#10-32 x 1.00 S.H.C.S.
51	6	48002	#10 LOCKWASHER
50	6	52001	#10 FLAT WASHER
49	2	1050-026	POSITIONING BLOCK
48	1	03449	RETAINING RING
47	1	1050-031	NOTCHER
46	1	1021-01-00-20	ACTUATOR ARM
45	1	1050-008	R/H DIE BLOCK
44	1	36035	1/4-20 x 1/2 S.H.C.S.
43	1	03077	DRIVE BELT
42	2	33018	#10-32 x 1/4 SET SCREW
41	1	1050-011	SMALL PULLEY
40	2	03064	BEARING
39	1	1050-014	BEARING MOUNT
38	1	1050-010	MOTOR MOUNT
37	2	36037	1/4-20 x 3/4 S.H.C.S.
36	2	36042	1/4-20 x 1-3/4 S.H.C.S.
35	1	1050-009	DIE FACE
34	1	1020-04-01-00	MODIFIED AIR CYLINDER
33	1	15233	BRASS NIPPLE
32	1	07071	DUMP VALVE
31	1	15528	1/4 x 1/4 MALE ELBOW
30	1	1020-04-00-02	ACTUATOR CLAMP
29	5	48006	5/16 LOCKWASHER
28	1	40014	5/16-18 x 1-1/4 H.H.C.S.
27	1	1050-018	HINGE ARM
26	2	54007	5/16-18 ESNA LOCKNUT
25	2	52005	3/8 FLAT WASHER
24	2	1050-019	HINGE MOUNT
23	1	1050-017	LONG CAM ARM
22	1	1050-020	CYLINDER ARM
21	1	40002	1/4-20 x 1.00 H.H.C.S.
20	1	57008	1/4-20 HEX NUT
19	1	33077	1/4-20 x 3/8 BRASS SET SCREW
18	1	1050-034	STOP BLOCK
17	2	42021	3/8 x 1-1/4 SHOULDER BOLT
16	6	03140	BUSHING
15	1	06070	ROD CLEVIS
14	1	56017	3/4-16 HEX JAM NUT
13	1	1050-044	CYLINDER MOUNT
12	2	42016	3/8 x 3/8 SHOULDER BOLT
11	6	36047	1/4-20 x 3.00 S.H.C.S.
10	8	48005	1/4 LOCKWASHER
9	1	1050-042	PIVOT BLOCK
8	1	1050-043	SPACER BLOCK
7	1	06040	AIR CYLINDER
6	2	07112	VALVE , FLDW CONTROL
5	7	52003	1/4 FLAT WASHER
4	6	36040	1/4-20 x 1-1/4 S.H.C.S.
3	1	35016	#10-32 x 5/8 F.H.C.S.
2	4	36038	1/4-20 x 7/8 S.H.C.S.
1	1	05006	MOTOR , 1/2 HP , 220 VAC , 50 Hz
1	1	05003	MOTOR , 1/2 HP , 220 VAC , 60 Hz

NO.	QTY.	PART NO.	DESCRIPTION
<b>EVANS MACHINERY, INC.</b>			
SCALE 1 : 4		APPROVED BY:	DRAWN BY G.M.C.
DATE OCT 24, 95			REVISED APR 13, 06
1050 T-EDGE			
NOTCHER/CUT-OFF ASSY			DRAWING NUMBER 1050-EXP 2



NO.	QTY.	PART NO.	DESCRIPTION
31	1	10262	KNOB
30	3	01111	PILOT LIGHT
29	1	01161	SWITCH , EMERGENCY STOP
28	3	02669	CONTACT BLOCK , N.C.
27	5	01165	SWITCH , PUSHBUTTON
26	3	02668	CONTACT BLOCK , N.D.
25	2	3100-087	CONTROL PANEL KNOB
24	1	1050-03-00-00	CONTROL COVER ASSEMBLY
23	1	02160	END PIECE
22	14	02303	TERMINAL SECTION
21	1	1050-022	CONTROL PANEL
20	1	1050-023	ELECTRICAL PANEL
19	1	02423	SPEED DIAL
18	3	52003	1/4 FLAT WASHER
17	4	48005	1/4 LOCKWASHER
16	4	40002	1/4-20 x 1.00 H.H.C.S.
15	1	02070	DINRAIL , 10"
14	1	02068	END CLAMP
13	1	01523	CONTACTOR
12	1	01524	OVERLOAD RELAY , 2.5-4 A
11	1	01130	RELAY , 2 POLE , 10 A
10	2	01130	RELAY , 2 P , 10 A (FOR 50 HZ)
9	2	01128	RELAY , 4 P , 10 A (FOR 60 HZ)
8	1	01072	CIRCUIT BREAKER , 1 POLE , 3 AMP
7	1	02158	END PIECE
6	3	02300	TERMINAL SECTION
5	1	44001	#6-32 x 3/8 P.H.M.S.
4	2	02073	GROUND LUG
3	2	01074	CIRCUIT BREAKER , 1 P , 6 A (FOR 50 HZ)
2	2	01081	CIRCUIT BREAKER , 2 P , 6 A (FOR 60 HZ)
1	16	44002	#10-32 x 3/8 P.H.M.S.
1	1	01349	TRANSFORMER
1	1	01660	SPEED CONTROL W/ POTENTIOMETER

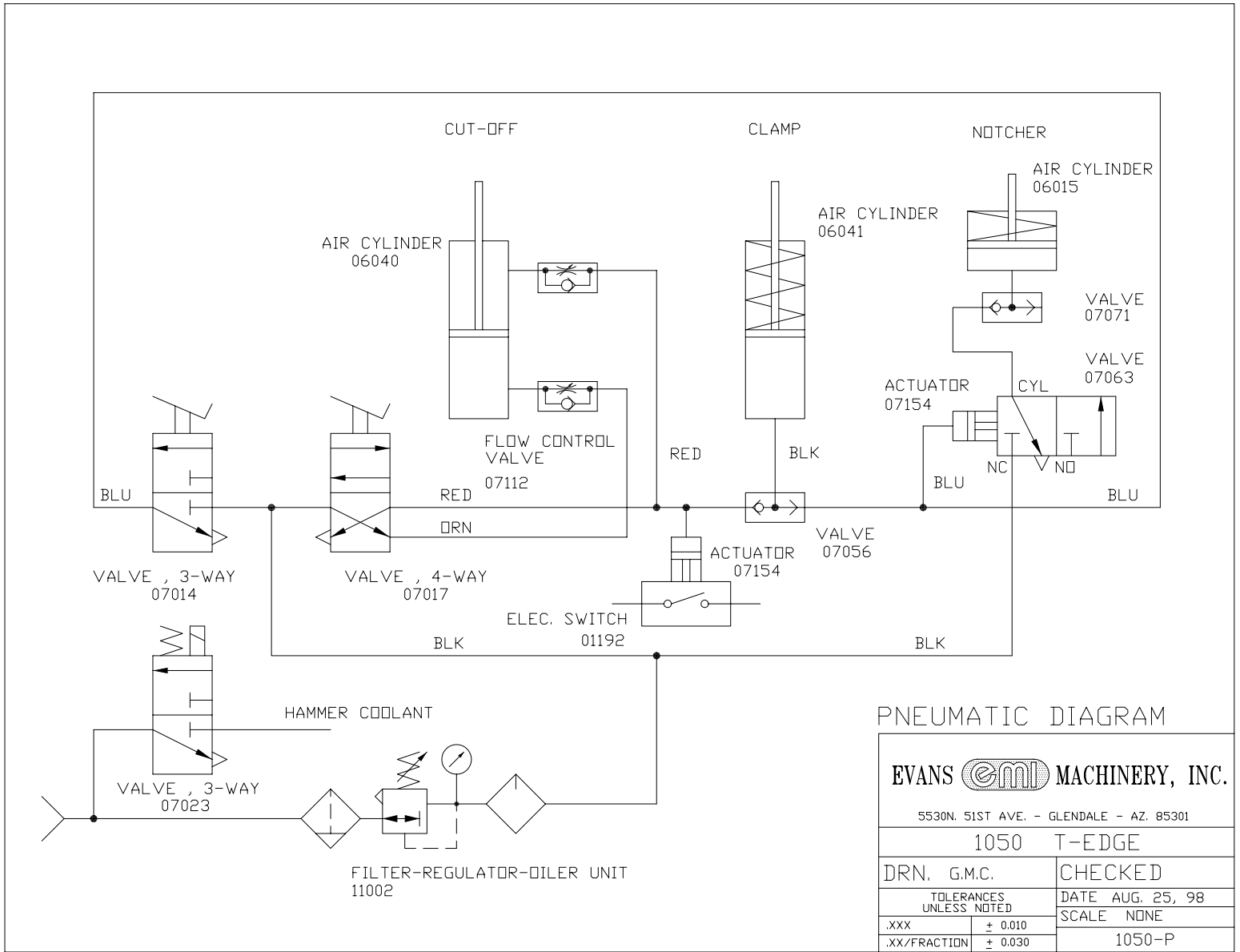
**EVANS MACHINERY, INC.**

SCALE : 1 : 4      APPROVED BY:      DRAWN BY G.M.C.


DATE : NOV. 03, 95      REVISED OCT. 15, 98

**1050 T-EDGE**

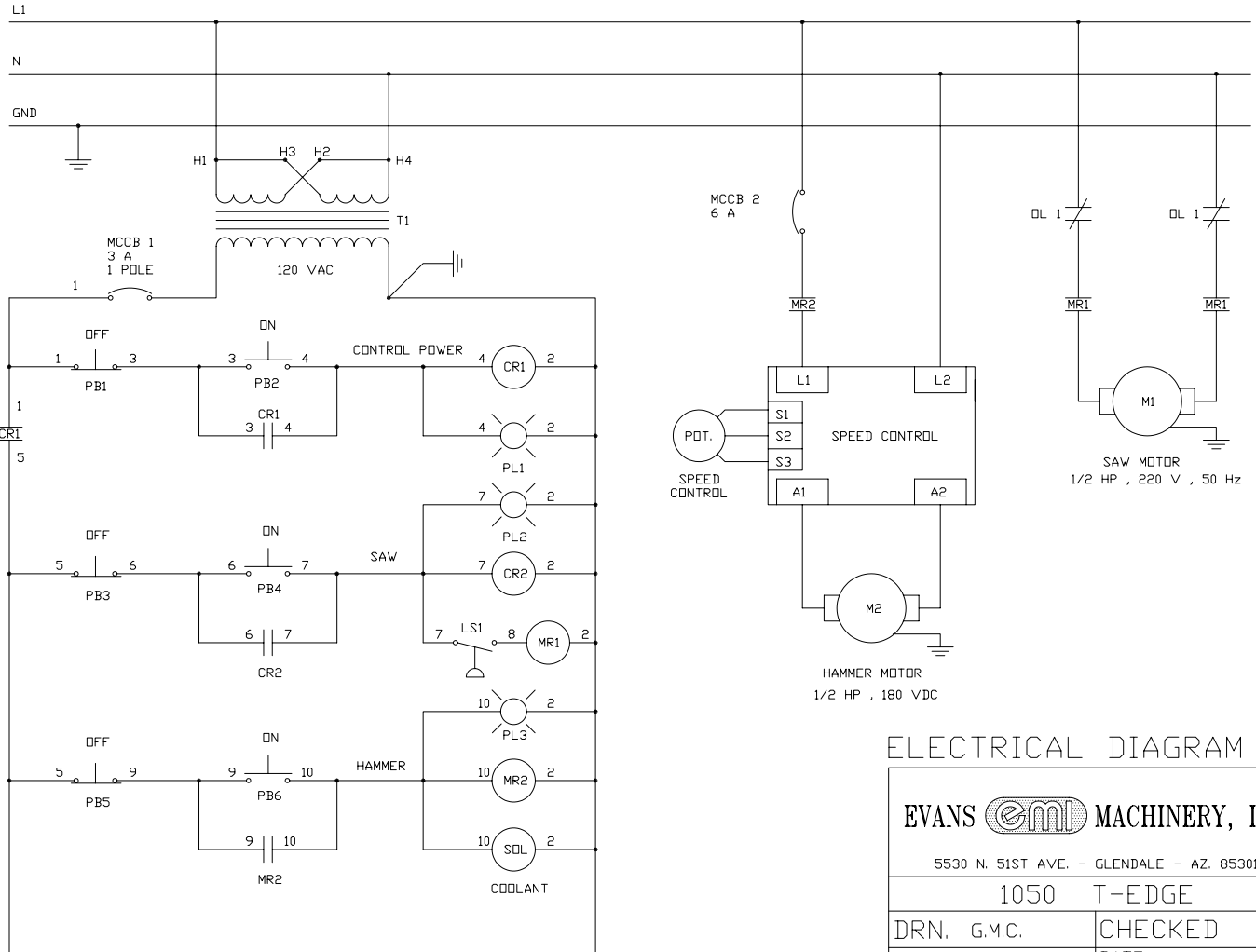
EXPLODED VIEW      DRAWING NUMBER 1050-EXP 3



PNEUMATIC DIAGRAM


<b>EVANS  MACHINERY, INC.</b>	
5530N. 51ST AVE. - GLENDALE - AZ. 85301	
1050 T-EDGE	
DRN. G.M.C.	CHECKED
TOLERANCES UNLESS NOTED	DATE AUG. 25, 98
.XXX ± 0.010	SCALE NONE
.XX/FRACTION ± 0.030	1050-P

220 VAC  
1∅  
50 Hz

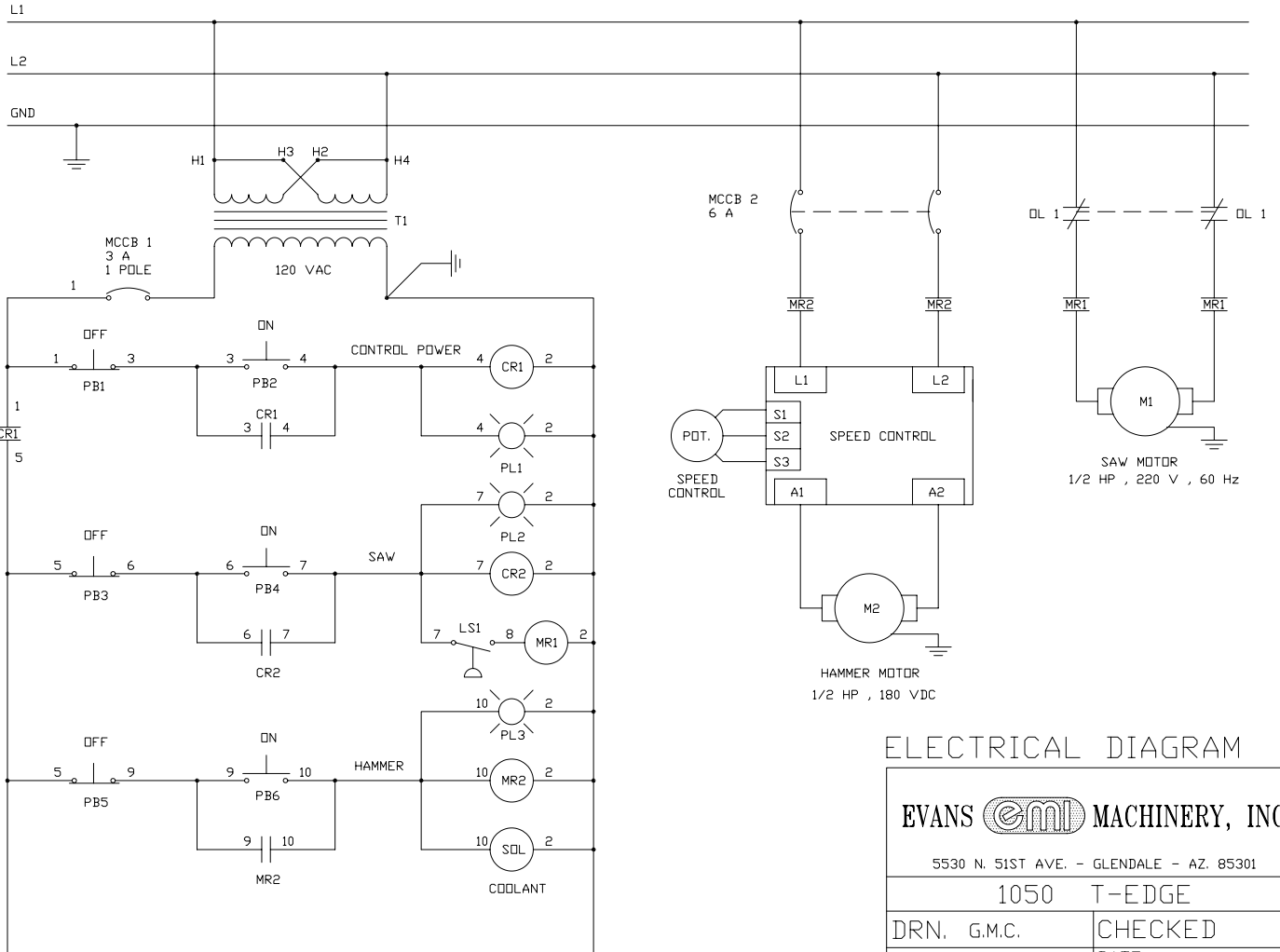


220 VAC , 1∅ , 50 HZ

ELECTRICAL DIAGRAM

<b>EVANS  MACHINERY, INC.</b>	
5530 N. 51ST AVE. - GLENDALE - AZ. 85301	
1050 T-EDGE	
DRN. G.M.C.	CHECKED
TOLERANCES UNLESS NOTED	DATE AUG. 25, 98
.XXX ± 0.010	SCALE NONE
.XX/FRACTION ± 0.030	1050-E-220150

220 VAC  
1∅  
60 Hz



220 VAC , 1∅ , 60 HZ

### ELECTRICAL DIAGRAM

EVANS  MACHINERY, INC.

5530 N. 51ST AVE. - GLENDALE - AZ. 85301

1050 T-EDGE

DRN. G.M.C.

CHECKED

TOLERANCES  
UNLESS NOTED

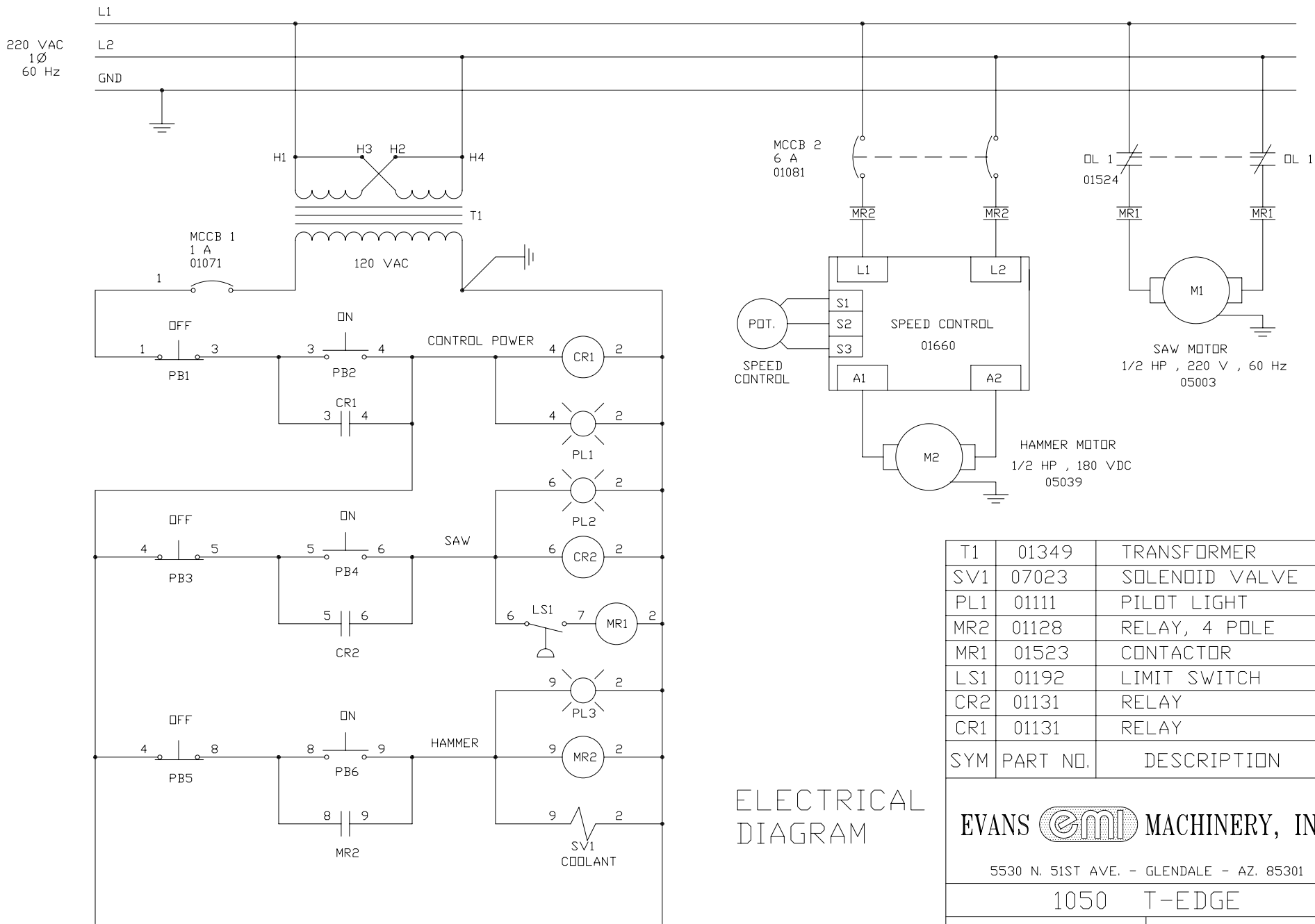
DATE AUG. 25, 98

.XXX ± 0.010

SCALE NONE

.XX/FRACTION ± 0.030


1050-E-220160



### ELECTRICAL DIAGRAM

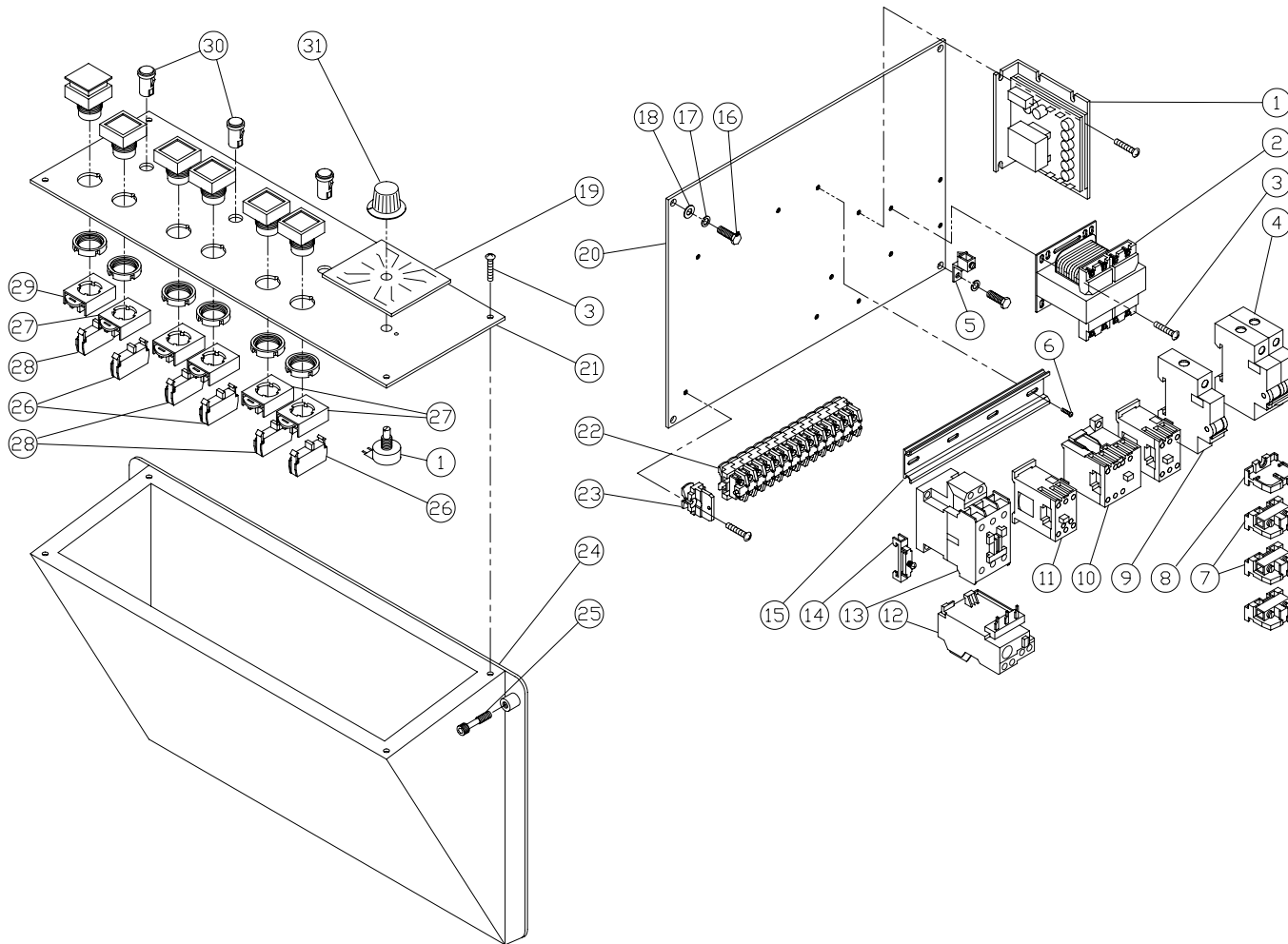
220 VAC , 1Ø , 60 HZ

SYM	PART NO.	DESCRIPTION
T1	01349	TRANSFORMER
SV1	07023	SOLENOID VALVE
PL1	01111	PILOT LIGHT
MR2	01128	RELAY, 4 POLE
MR1	01523	CONTACTOR
LS1	01192	LIMIT SWITCH
CR2	01131	RELAY
CR1	01131	RELAY

**EVANS  MACHINERY, INC.**  
 5530 N. 51ST AVE. - GLENDALE - AZ. 85301

1050 T-EDGE

DRN. G.M.C.	CHECKED
TOLERANCES UNLESS NOTED	DATE OCT 13, 10
.XXX ± 0.010	SCALE NONE
.XX/FRACTION ± 0.030	1050-E-220160



31	1	10262	KNOB
30	3	01111	PILOT LIGHT
29	1	01161	SWITCH , EMERGENCY STOP
28	3	02669	CONTACT BLOCK , N.C.
27	5	01165	SWITCH , PUSHBUTTON
26	3	02668	CONTACT BLOCK , N.O.
25	2	3100-087	CONTROL PANEL KNOB
24	1	1050-03-00-00	CONTROL COVER ASSEMBLY
23	1	02160	END PIECE
22	14	02303	TERMINAL SECTION
21	1	1050-022	CONTROL PANEL
20	1	1050-023	ELECTRICAL PANEL
19	1	02423	SPEED DIAL
18	3	52003	1/4 FLAT WASHER
17	4	48005	1/4 LOCKWASHER
16	4	40002	1/4-20 x 1.00 H.H.C.S.
15	1	02070	DINRAIL , 10"
14	1	02068	END CLAMP
13	1	01523	CONTACTOR RELAY
12	1	01524	OVERLOAD RELAY , 2.5-4 A
11	1	01131	RELAY , 2 POLE , 10 A
10	2	01130	RELAY , 2 P , 10 A (FOR 50 Hz)
	2	01128	RELAY , 4 P , 10 A (FOR 60 Hz)
9	1	01072	CIRCUIT BREAKER , 1 POLE , 3 AMP
8	1	02158	END PIECE
7	3	02300	TERMINAL SECTION
6	2	44001	#6-32 x 3/8 P.H.M.S.
5	1	02073	GROUND LUG
4	2	01074	CIRCUIT BREAKER , 1 P , 6 A (FOR 50 Hz)
	2	01081	CIRCUIT BREAKER , 2 P , 6 A (FOR 60 Hz)
3	16	44002	#10-32 x 3/8 P.H.M.S.
2	1	01349	TRANSFORMER
1	1	01660	SPEED CONTROL W/ POTENTIOMETER
NO.	QTY.	PART NO.	DESCRIPTION

**EVANS  MACHINERY, INC.**

SCALE : 1 : 4      APPROVED BY:      DRAWN BY G.M.C.  
 DATE : NOV. 03, 95      REVISED OCT 13, 10

1050 T-EDGE

EXPLODED VIEW

DRAWING NUMBER  
1050-EXP 3