

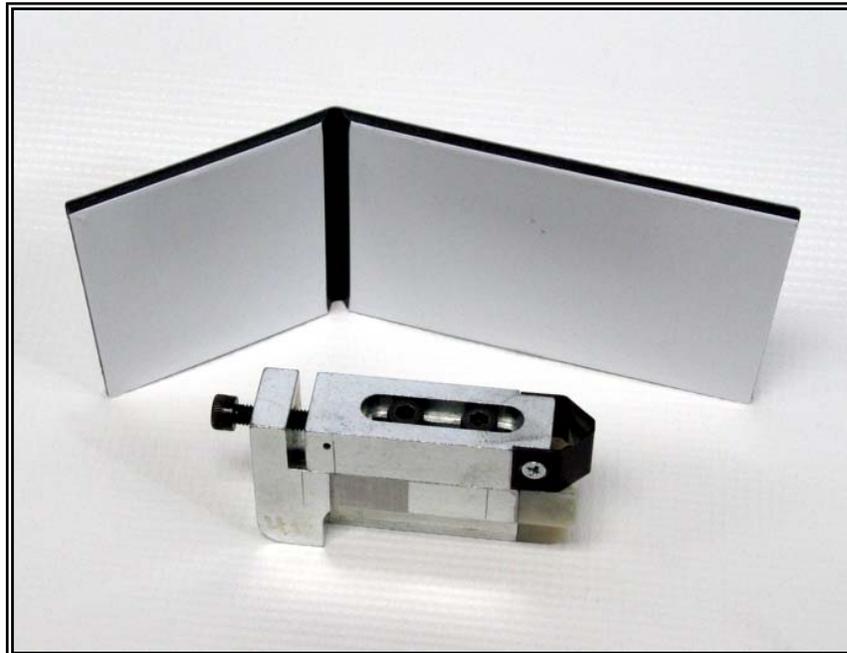


The Fletcher-Terry Company

*Quality. Service. Dependability. Value.
Since 1868*

INSTRUCTIONS

Fletcher FSC V-Groove Tool Holder



The Fletcher-Terry Company

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FORM #102210

Product Warranty

The Fletcher-Terry Company warrants the product purchased to be free from defects in parts and workmanship for (1) one year from the date of purchase. The Fletcher-Terry Company warrants that it will repair or replace any such defective parts, providing the product has been under normal use and service and the defective part is returned to The Fletcher-Terry Company at the purchaser's expense. The Fletcher-Terry Company must authorize the return in writing. Proof of purchase must be submitted to validate warranty coverage. The warranty is in lieu of all other agreements and warranties expressed or implied. THE FLETCHER-TERRY COMPANY DOES HEREBY EXPRESSLY DISCLAIM ANY WARRANTIES OF MERCHANT ABILITY OR FITNESS FOR A PARTICULAR PURPOSE. The Fletcher-Terry Company does not authorize any company employee or representative to assume for it any other liability than that set forth in this Product Warranty. The Fletcher-Terry Company shall not be liable for any damages or losses, whether incidental or consequential or direct or indirect, arising out of the use or abuse of this product. This Warranty is valid only when product is used with Fletcher consumables and/or replacement parts. In any event, THE PURCHASER'S SOLE AND EXCLUSIVE REMEDY UNDER THIS OR ANY OTHER WARRANTY IS LIMITED TO RETURN OF THE PURCHASE PRICE PAID FOR THIS PRODUCT.



SAFETY WARNINGS



- **Keep hands away from the cutting blade during operation**
- **Always use *both* hands to pull downward on the cutting head handles when using this tool**
- **Wear appropriate eye protection during operation**

Contact Fletcher-Terry customer support
for assistance at 800.843.3826 or by email
at customerservice@fletcher-terry.com.

Instructions for Use – FSC V-Groove Tool Holder

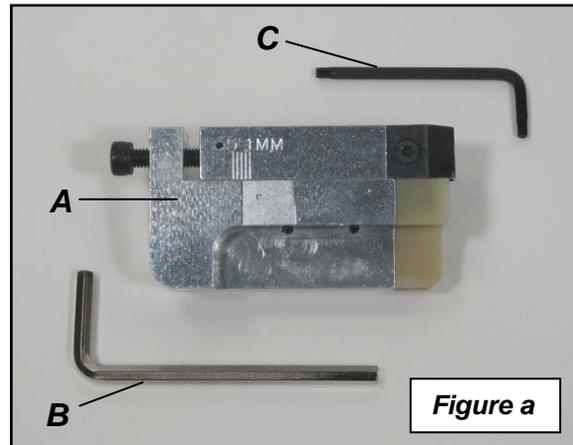
The FSC V-Groove Tool holder is specially designed to cut a strip of material from the surface of aluminum-composite sheets, up to 5mm thick – enabling folding and bending of the substrate for a wide variety of applications.

Please follow these instructions carefully for optimum safety, cut quality, and performance.

Items Included

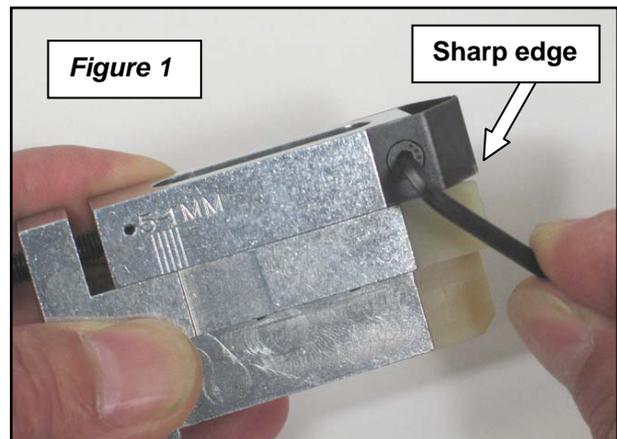
The optional V-Groove Tool Holder includes:

- A. V-Groove Tool Holder, with Blade
- B. 4mm Hex key
- C. T10 Torx key (see Figure a)



Mounting the V-Groove Blade

1. To mount a blade to the holder for the first time, or to replace a worn blade, first remove the two (2) Torx head blade mounting screws (one on each side) from the holder block.
2. Orient the new blade on the holder with the sharp edge pointing downward, as shown (Figure 1). Re-insert the torx screws and tighten both of them securely with the supplied T10 tool.



Always use caution when handling blades.

Setting the Blade Depth

1. Place a sheet of the aluminum composite material on the FSC machine's horizontal material bar, and clamp it in place. Determine the thickness of the sheet material, usually between 2 and 5mm.
2. Loosen the two depth locking screws on the top surface of the V-Groove tool with a 4mm hex key (supplied). Turn the tool so that the scribed depth markings are facing you, and then rotate the depth adjustment screw so that the indicator is aligned with the thickness of material you intend to cut from. Rotate the adjustment screw Clockwise to increase blade depth, and Counterclockwise to reduce it. Retighten the two locking screws (Figures 2a and 2b).

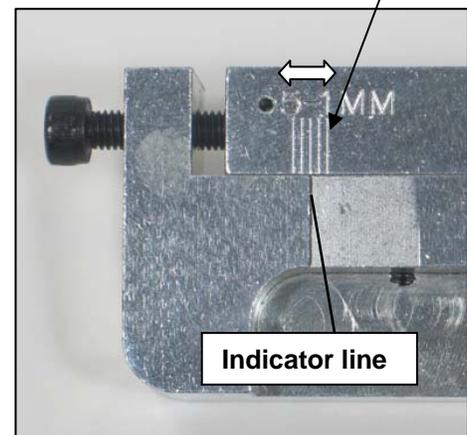
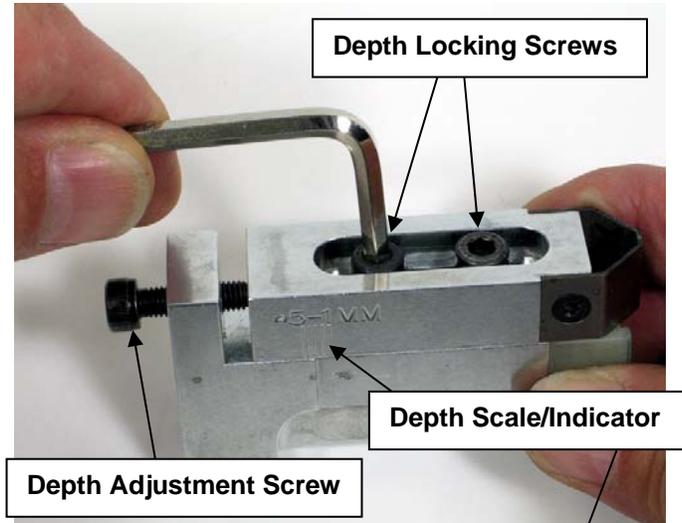
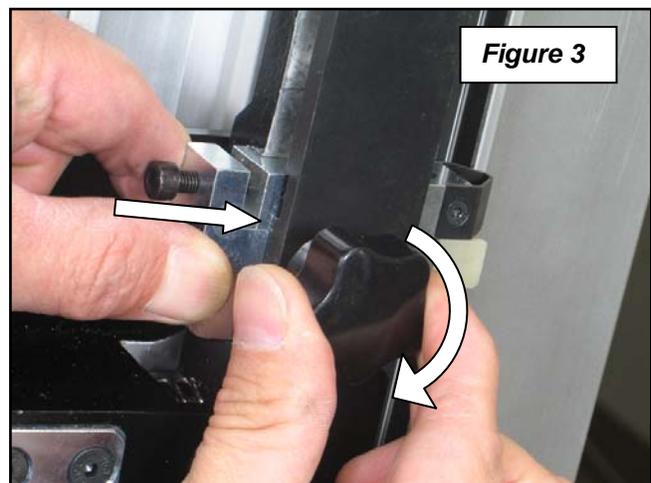


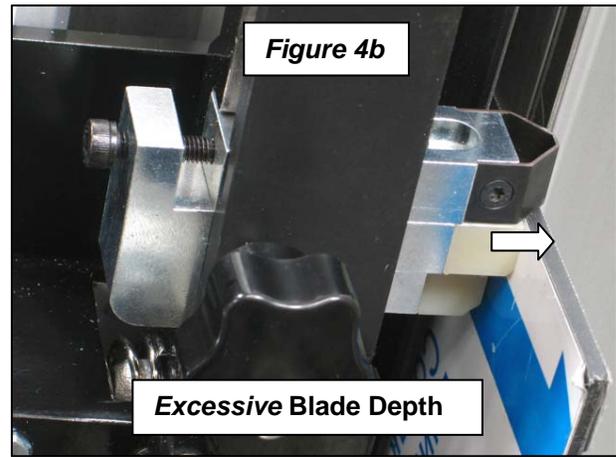
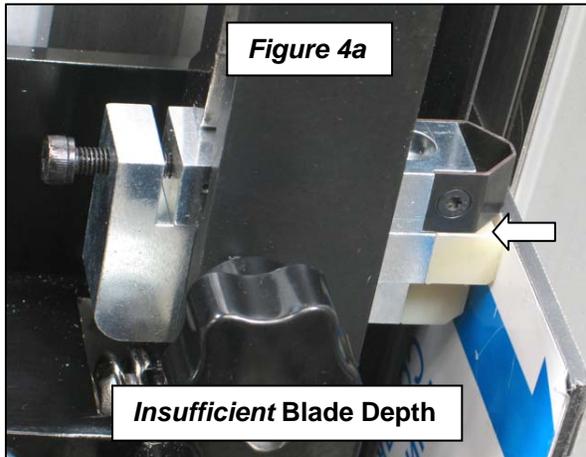
Figure 2b:
*Depth Scale
close up*

3. Raise the FSC cutting head above the top edge of the sample sheet of material, and tighten the head locking knob to keep it in place. Insert the V-groove tool into the FSC cutting head, as shown, and tighten the tool locking knob (Figure 3).

Note: It may be necessary to push down on the cutting head thumb lever in order to fully insert the tool holder.



- Loosen the head locking knob, and slowly lower the head so that the V-groove blade is resting on the top edge of the sheet of material. Visually check the front edge of the blade, and see how far into the material's thickness it extends (Figures 4a and 4b below). Depending on the amount of material you wish to remove, it may be necessary to adjust the blade depth again. Make a test cut in the composite to verify (see next section below).

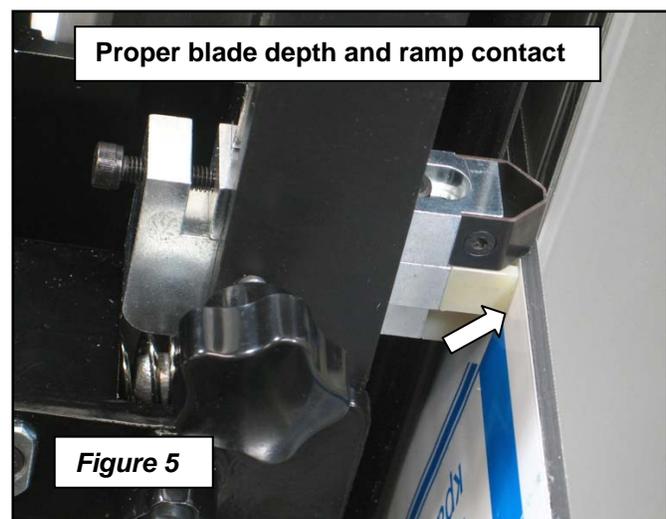


Tip: As a general rule, allow a minimum of 0.5mm (1/64"+) of the material's plastic core, plus the aluminum skin, to remain after the groove has been cut. Cutting too deeply may compromise the strength of the material when bending afterwards.

- To readjust the blade depth setting, remove the blade holder from the FSC head. Loosen the blade depth locking screws; adjust the depth setting screw as needed, and retighten the locking screws once again.

Making a V-Groove Cut

- After setting the blade to the desired depth and reinserting the holder into the head, depress the thumb lever and raise the cutting head above the top edge of the material. Gently lower the head/blade holder and release the thumb trigger when the plastic ramp is in contact with the front surface of the sheet, and the blade is resting on its top edge (Figure 5).



Note: The plastic ramp must be in firm contact with the material surface in order to ensure uniform groove depth and width throughout the full cutting stroke.

2. Grasp both handles on the cutting head and pull downward in a slow, steady manner to make the cut (Figure 6). Complete the cut by pulling the head down to its bottom, resting position.

Important! Make sure that the substrate is clamped securely before cutting by pivoting the clamp lever downward all the way.



3. Unclamp the material, remove it from the FSC machine, and bend the aluminum composite sheet as desired. You may make additional V-groove cuts in the same sheet in any location or direction.

➤ **V-Groove Replacement Blades (2 pack), Fletcher item #05-233**

To order replacement blades, or for technical assistance, contact Fletcher-Terry customer support at 800.843.3826, or by email at customerservice@fletcher-terry.com.

