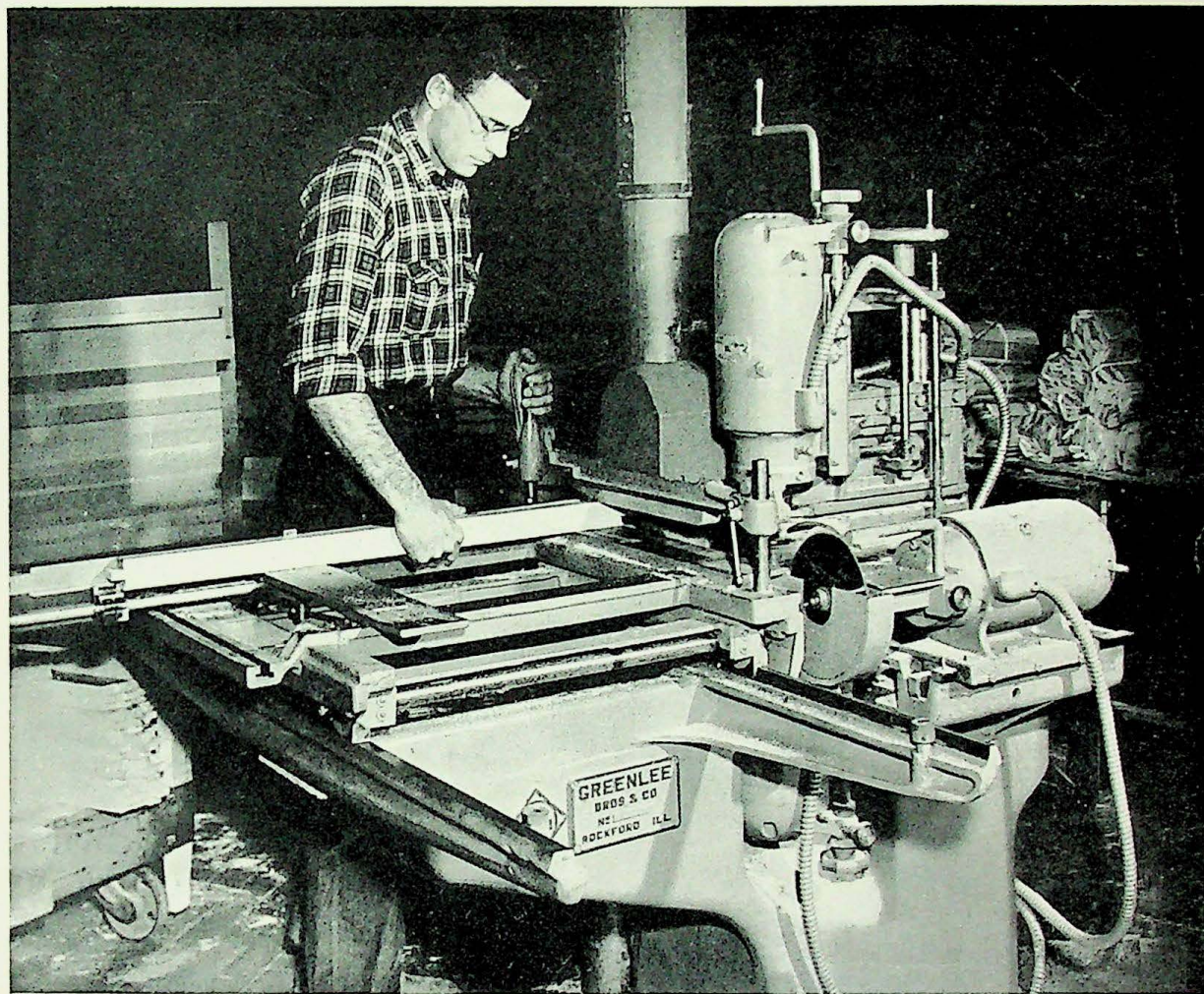


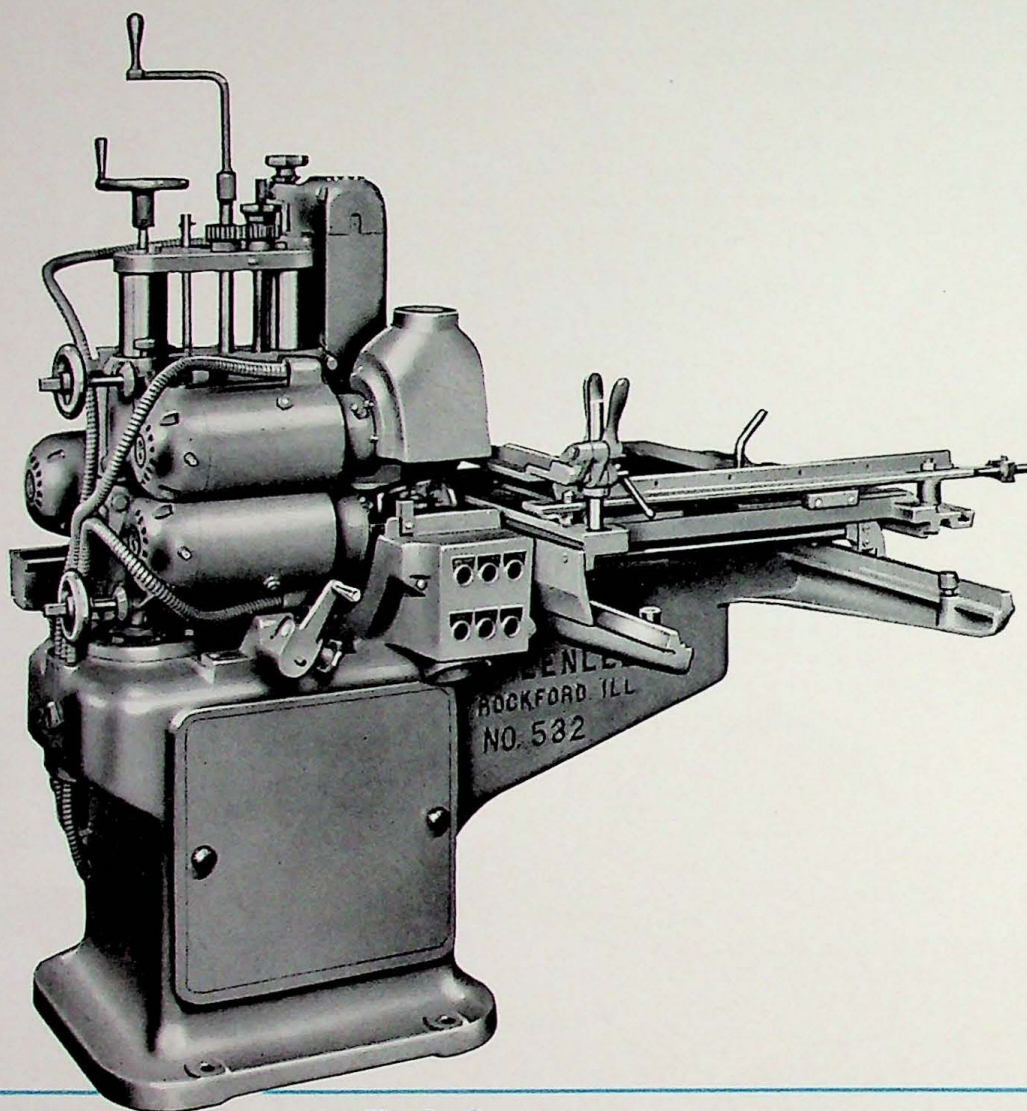


NO. 532 ★

**SINGLE-END
TENONER**



GREENLEE BROS. & CO., ROCKFORD, ILLINOIS, U. S. A.



GREENLEE NO. 532 SINGLE-END TENONER

The extremely rugged construction of this Tenoner (total weight is 2300 pounds) makes it a smooth-operating woodworking unit capable of high-speed production and years of accurate, trouble-free service. Its compact design, incorporating an ingenious table-travel arrangement, requires relatively little floor space for efficient operation. Maximum production output is insured through the careful grouping of the controls and adjustment mechanisms . . . they are readily accessible from the normal operating position, a feature which greatly reduces costly, non-productive set-up time.

FRAME CONSTRUCTION

The heavy, one-piece base of cast grey iron forms a solid support for the table roller tracks, cut-off attachment bracket, and the two heavy cylindrical columns on which the tenoning and cope units are mounted. The weight and rigidity inherent in this base minimizes vibration, preserving the precision alignment between the table and cutting units and thus insuring smooth, accurate operation.

BEARINGS and LUBRICATION

Motor spindles on the No. 532 Tenoner run on ball bearings which are enclosed in dust-proof cases. This construction insures years of trouble-free service with a minimum amount of power consumption. Grease-gun lubrication simplifies maintenance.

DRIVE and CONTROLS

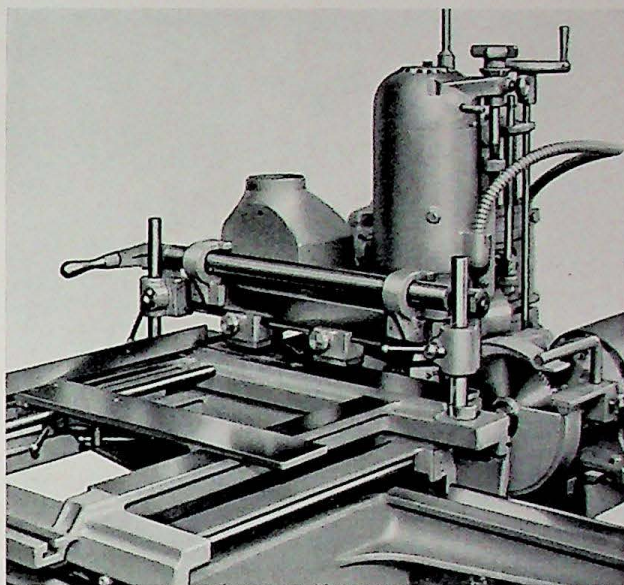
The cutting heads are mounted directly on the arbors of the 3600 R.P.M. motors, eliminating all belts and gearing. A control panel containing individual push buttons is conveniently placed at the operating position. A master switch stops all motors simultaneously. If all units are not required, the individual push buttons allow operation of only those spindles necessary for the job.

TABLE and WORK CLAMPS

The light-weight, rigidly-constructed table moves easily, with an accelerated action provided by two-step rollers. The table travels on the large diameters of the rollers, while the smaller diameters travel on a sub-frame. This arrangement permits the use of relatively short tracks, yet provides ample table travel. Front and rear stops limit the table travel, and gibbed ways prevent any possibility of tipping. The table tracks are carefully machined to obtain maximum accuracy, and are cast integrally with the one-piece yoke for precise alignment. The inner track is V-shaped to guide the rollers. Dust shields and cleaners keep the tracks free of dust and dirt.

The table is 29" wide, 34" long, 36" high, and has 48" maximum travel. Layout stops permit making tenons as short as $\frac{1}{4}$ ". The end stop adjusts for lengths to 5'-8".

The standard work clamp operates by squeezing a pivoted handle which forms a part of the post used in moving the table past the cutterheads. Its clamping action is always parallel to the table. It is quickly adjustable for various thicknesses of stock. A special eccentric-type clamp is also available. This clamp, designed for holding wider stock more securely, or for making heavier cuts, has two adjustable, rubber-faced shoes that effectively grip the work.

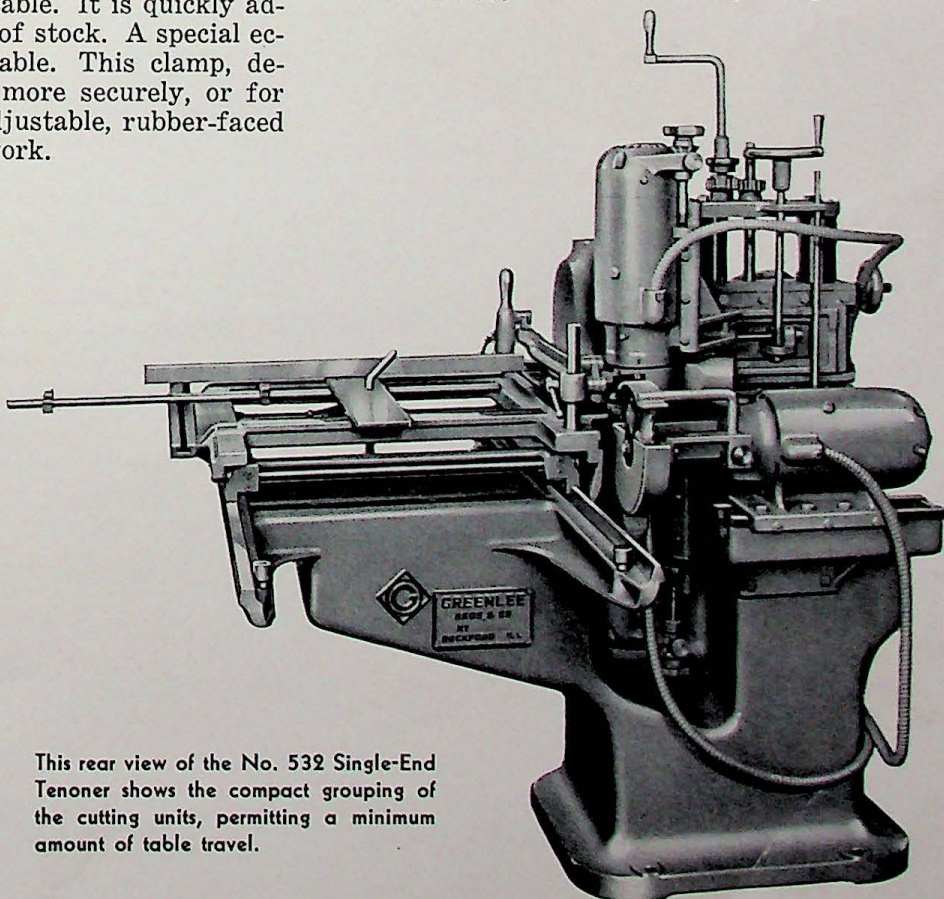


The special eccentric-type lever clamp shown above is available for more secure clamping of wide stock, or when heavier cuts are required.

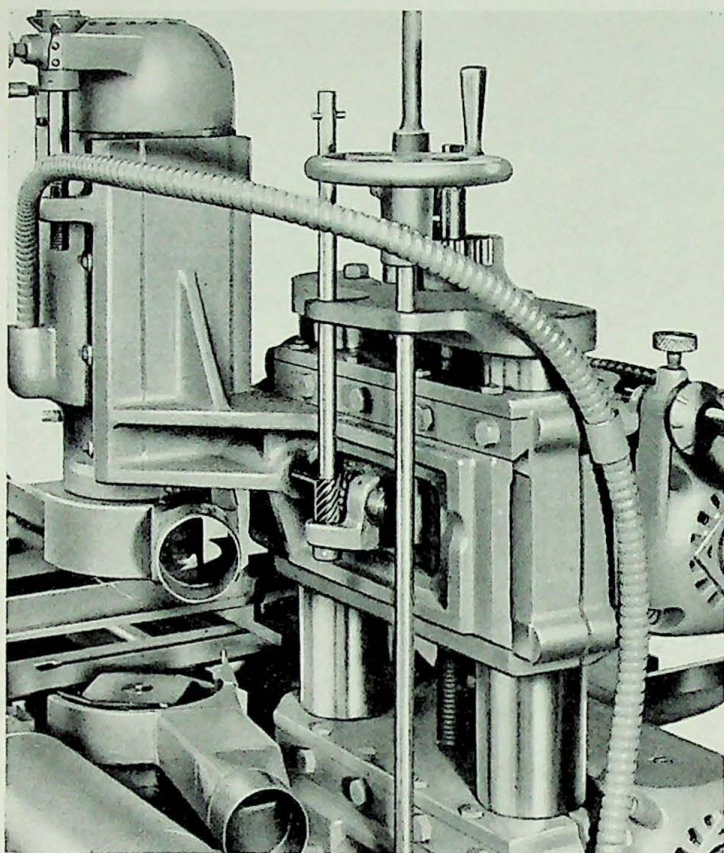
With single heads, tenons up to $3\frac{3}{4}$ " can be made, or up to $7\frac{1}{2}$ " with two passes. Double heads cut 6" tenons with one pass, and up to $7\frac{1}{2}$ " with two passes. The tenon heads open wide enough for 5" thick tenons, and stock up to 24" wide can be worked. Tenoning head spindles are $1\frac{5}{16}$ " in diameter, $6\frac{1}{4}$ " long.

TENONING UNITS

The upper and lower tenoning heads are mounted on two heavy cylindrical columns for maximum rigidity. Individual vertical and horizontal adjustments are provided for each head, with the vertical adjustment mechanism also arranged to permit both heads to be moved simultaneously while maintaining a specified tenon thickness. The top head cuts from zero to $5\frac{1}{2}$ " above the table, and adjusts horizontally $2\frac{3}{4}$ " so that it can be located to $1\frac{1}{4}$ " from the table edge or $1\frac{1}{2}$ " over the table. The lower head cuts from zero to $5\frac{3}{8}$ ", and adjusts horizontally to $1\frac{1}{2}$ " from the table edge.

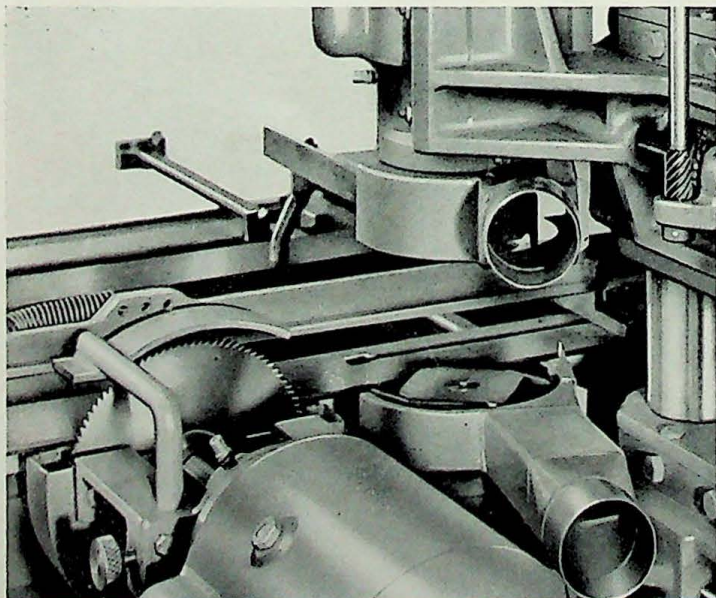


This rear view of the No. 532 Single-End Tenoner shows the compact grouping of the cutting units, permitting a minimum amount of table travel.



This close-up of the cope units shows in detail the slide and mounting arrangement. Note the exhaust hoods for efficient chip disposal.

Details of the cut-off unit are shown below. The adjustable guard allows the use of a 9-inch cut-off saw blade.



COPE UNITS

To facilitate making set-ups, the top and bottom cope units are mounted on the top and bottom tenoning carriages respectively. This permits changing the position of these heads without altering their relationship to each other. Independent horizontal and vertical adjustments are also provided. The upper cope head will cut from zero to $1\frac{1}{2}$ " above the cutting line of the top tenoning head, and the lower cope head from zero to $\frac{1}{2}$ " below the cutting line of the bottom tenoning head. Both cope units adjust horizontally from zero to $3\frac{1}{2}$ " from the table edge, and will swing a 9" slotting saw, cutting to a depth of $3\frac{1}{2}$ ". The top cope spindle is $1\frac{3}{16}$ " in diameter, $2\frac{3}{8}$ " long; bottom cope spindle $1\frac{3}{16}$ " in diameter, $1\frac{7}{16}$ " long.

CUT-OFF UNIT

The cut-off unit is mounted at the rear of the machine frame. It can be adjusted to cut from $\frac{1}{4}$ " to $6\frac{1}{2}$ " from the table edge. With the standard 8" blade provided, cuts up to $2\frac{5}{8}$ " can be made. If necessary, a 9" diameter blade can be used. A hand-crank, conveniently located near the operating position, provides a quick means of approximate adjustment, and a hand-knob on the crank permits final settings of micrometer accuracy.

SPECIFICATIONS

Standard equipment for the No. 532 Single-End Tenoner includes single top and bottom tenoning heads, cope heads, 8" cut-off saw, hand-grip parallel-motion clamp, angle fence, stop rod with stops, and wrenches.

The electrical equipment includes 2-H.P., 3600 R.P.M., 220, 440, or 550-volt, 2 or 3-phase, 60-cycle, fan-cooled motors, enclosed magnetic switches with push-button controls, thermal overload relays, and under-voltage protection.

Floor space requirements for maximum table travel are $5\frac{1}{3}$ x $6\frac{2}{3}$ feet. The base measures 29" x 26".

CODES and SHIPPING WEIGHTS

CODE	DESCRIPTION	WEIGHT
GORYZ	No. 532 with Tenons, Copes, and Cut-Off Saw.....	2600 lbs.
GUJYL	No. 532A with one Cope omitted.....	2450 lbs.
GUKYM	No. 532B with both Copes omitted.....	2300 lbs.
GULYN	Cut-Off Attachment omitted.....Deduct	150 lbs.

GREENLEE BROS. & CO., ROCKFORD, ILLINOIS, U.S.A.

Machinery for Planing, Shaping, Tenoning, Mortising, Boring and Sawing

Tools for Mortising, Boring and Routing