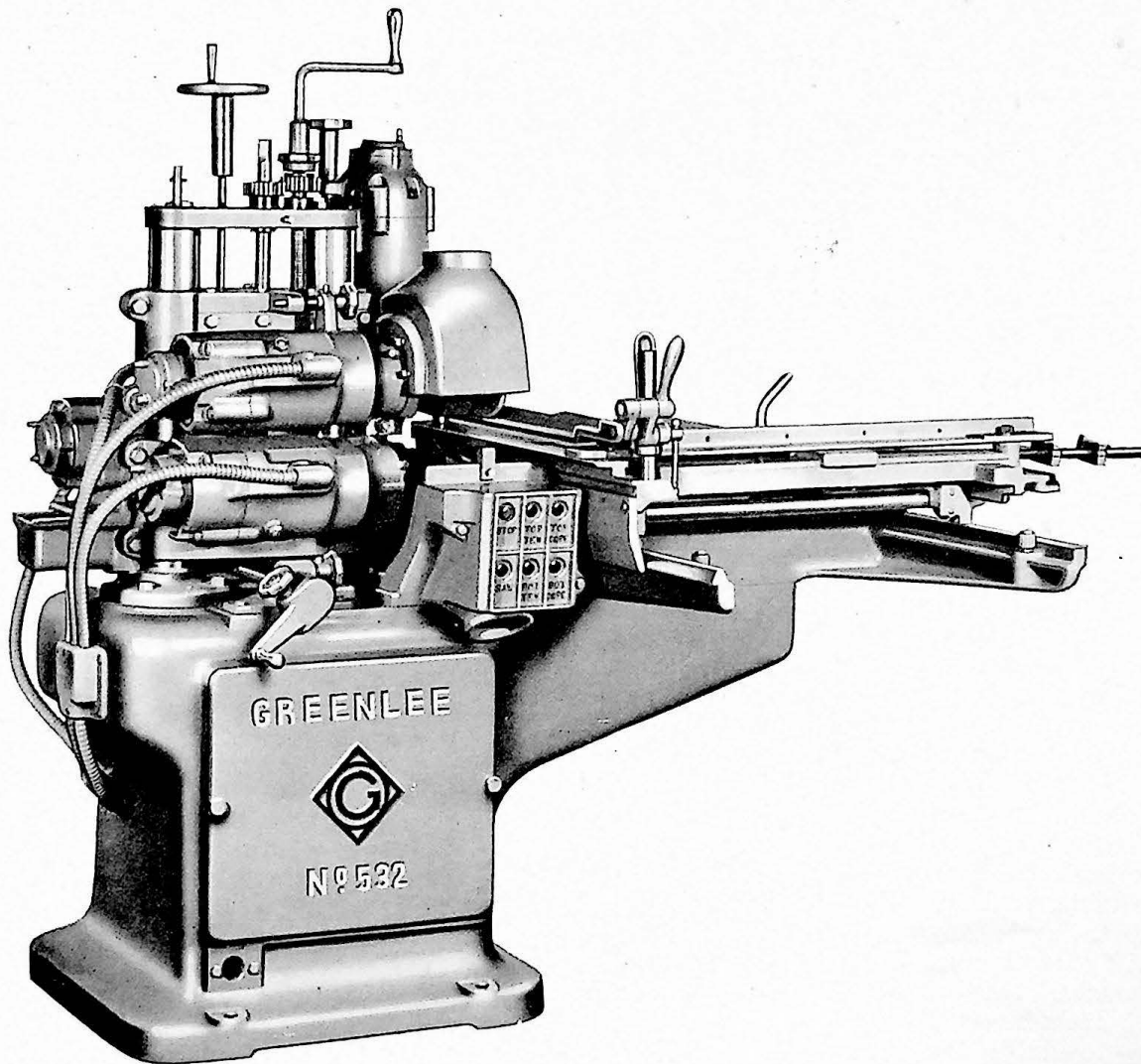


Greenlee

No. 532 ELECTRIC SINGLE-END TENONER



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

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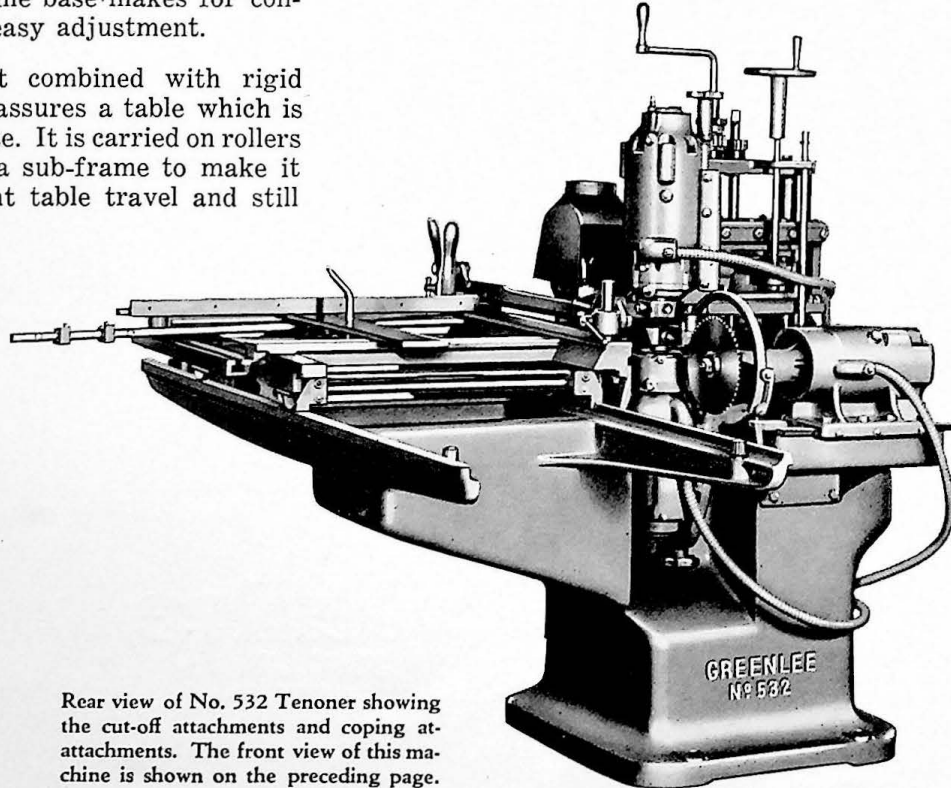
COMPACTNESS is one of the outstanding features of this tenoner. It is of great importance because it means a saving in floor space and avoids useless travel of the work table. The cylindrical columns which carry the tenoning head slides help secure the close-coupled, compact mounting and provide exceptional rigidity. These columns are turned and ground to fit perfectly the accurately bored and reamed holes in the slides, and this construction guarantees permanent alignment. Compactness is further provided for in this tenoner by making the drive completely electric, with all belts eliminated by means of built-in motors.

Frame Strength and rigidity are assured in this machine by giving it a substantial foundation, formed by the heavy one-piece base on which are mounted the two widely spaced cylindrical columns, the cut-off attachment bracket, and the table roller tracks. Ample foot room around the machine base makes for convenient operation and easy adjustment.

Table Light weight combined with rigid construction assures a table which is unusually easy to operate. It is carried on rollers which are mounted in a sub-frame to make it possible to get sufficient table travel and still keep the tracks relatively short. Front and rear stops are provided to limit the travel of the table, which is gibbed to avoid any possibility of tipping. The tracks, one of which is of the inverted V-type to guide the rollers, are carefully machined for accuracy and are cast integrally with the one-piece yoke to maintain perfect alignment. Dust shields and cleaners keep the tracks free from dust and dirt.

In addition to a work clamp, the table equipment consists of a fence for straight or angle tenons, an angle stop rest, and a false sliding table section to form the outer work support and carry the stop rod. The standard work clamp is adjustable for thickness of stock and clamps over the full width of the table. Its clamping movement is always parallel to the table surface, and it is operated by squeezing a pivoted handle, which forms a part of the post used in moving the table past the cutterheads. As soon as the handle is released, the clamp is raised to its top position by spring action.

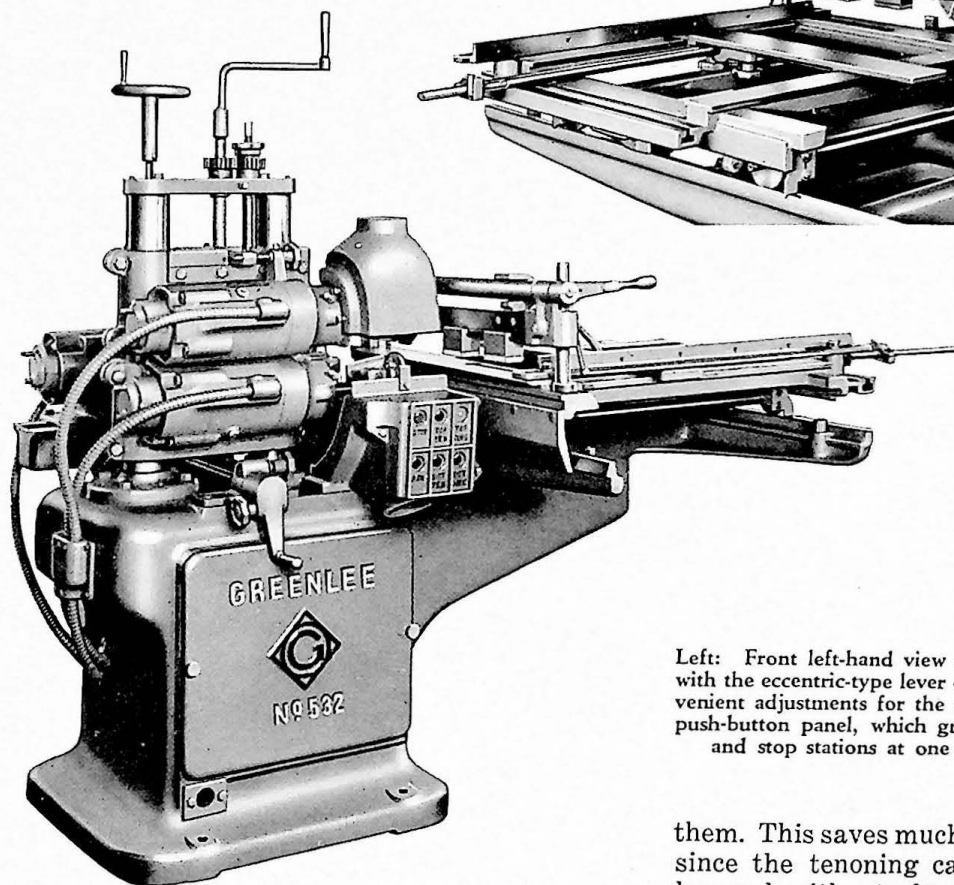
Special clamps for unusual requirements can be furnished. On the following page is shown a No. 532 Tenoner fitted with a specially designed eccentric-type lever clamp, which clamps the work firmly until released by the operating handle. This clamp has two rubber-faced shoes which have adjustment for width of stock.



Rear view of No. 532 Tenoner showing the cut-off attachments and coping attachments. The front view of this machine is shown on the preceding page.

Tenoning Units

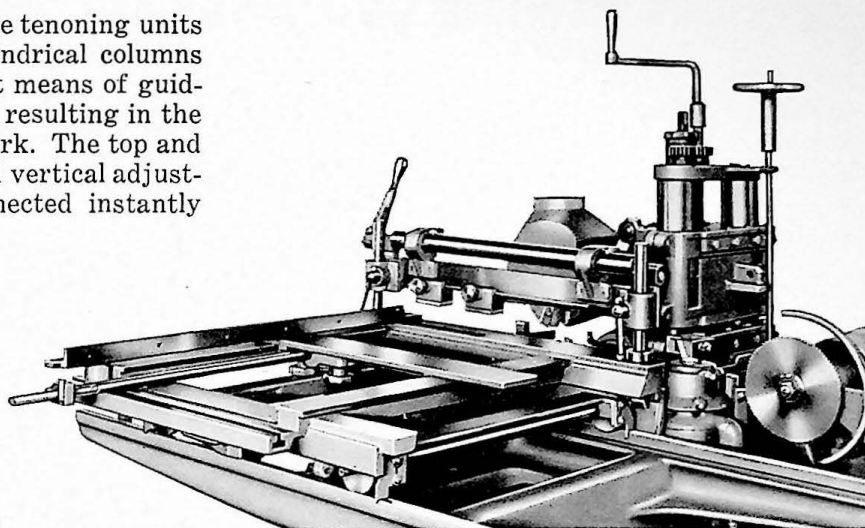
The mounting of the tenoning units on the vertical cylindrical columns affords an excellent means of guiding and clamping the carriages, resulting in the greatest possible accuracy of work. The top and bottom carriages have connected vertical adjustment, but this can be disconnected instantly



for independent adjustment of each spindle carriage. This has the advantage that the tenon can be raised or lowered, relative to the table, without changing its thickness, or the thickness can be changed quickly as desired. Fine screw endwise adjustment is provided for the top spindle carriage to permit lining up the top and bottom tenoning heads.

Coping Units

The slides for the top and bottom coping carriages are attached to the top and bottom tenoning carriages respectively, so that when the tenoning spindles are raised or lowered, the coping spindles move with



Above: View of tenoning table fitted with a specially designed eccentric-type lever clamp having rubber-faced shoes, adjustable for width of stock. This photograph also shows the close grouping of cutting units, which decreases the table travel.

Left: Front left-hand view of complete machine with the eccentric-type lever clamp. Note the convenient adjustments for the cutting units and the push-button panel, which groups the motor start and stop stations at one convenient point.

them. This saves much time in changing set-ups, since the tenoning carriages can be raised or lowered without changing the position of the tenoning and coping heads with reference to each other. Independent horizontal and vertical adjustment for the coping attachments is also provided.

Cut-Off Attachment

When furnished, this attachment is mounted at the rear of the machine frame, but all adjustments are made from the front. Quick adjustment for approximate location is made by a convenient crank. The crank is then locked by turning a hand-knob, and another one provides micrometer adjustment for the final setting. The attachment is regularly equipped with an 8-inch saw blade.

Bearings

All spindles on this machine run in selected precision ball bearings enclosed in dust-proof cases and having grease-gun lubrication. This provides for continued accuracy and low power consumption.

Heads

Single or double tenoning heads, 6 inches in diameter, can be furnished as required. The double heads are used for making tenons longer than $3\frac{3}{4}$ inches at one pass of the table. Cope spindles will take slotting saws up to 9 inches in diameter.

Drive

This tenoner is a beltless machine, since the drive of each spindle is by a 3600-R.P.M. motor, the rotor of which is mounted directly on the spindle. Push-button control is provided, and the individual push buttons for starting each motor, as well as the master stop button, are all grouped in one panel at the front of the machine. The individual control permits running only the spindles that are to be used to perform the required operations.

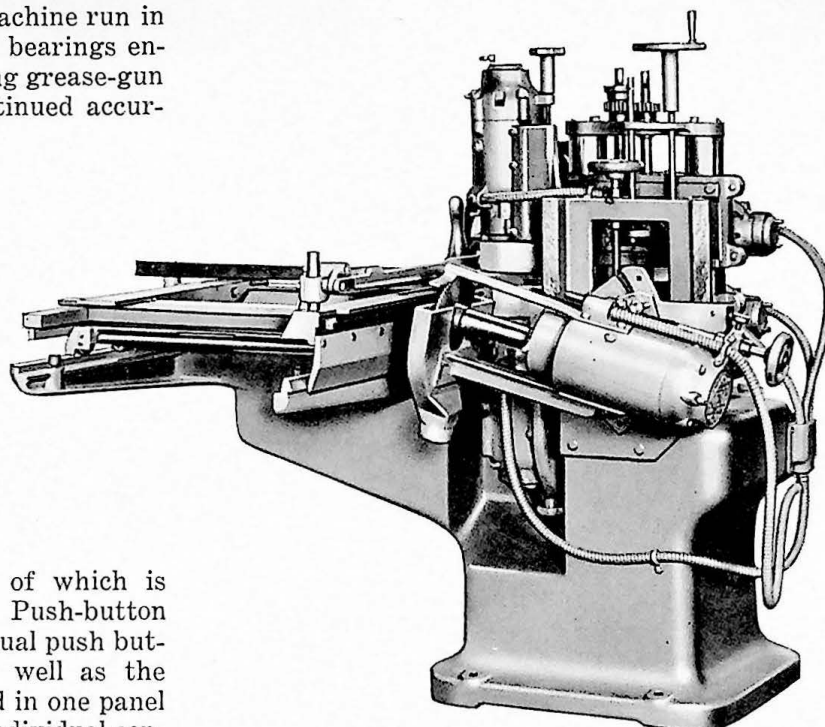
Specifications

Equipment

This machine is regularly equipped with single top and bottom tenoning heads, cope heads, the table outfit, and a set of wrenches. When furnished, the cut-off attachment has an 8-inch saw blade. The electrical equipment includes $1\frac{1}{2}$ or 2-H.P., 3600-R.P.M., 220 or 440-volt, 2 or 3-phase, 60-cycle motor for each spindle, enclosed magnetic switches, having push-button control, thermal overload relays, and under-voltage protection. While 1-H.P. motors are not recommended, they can be furnished for any or all spindles.

Range

When single heads are used, tenons up to $3\frac{3}{4}$ inches long can be cut with one pass of the table, or up to $7\frac{1}{2}$ inches with two passes. Double heads cut 6-inch tenons with one



No. 532 Single-End Tenoner fitted with a special cut-off attachment for trimming tenons and other parts on an angle. In addition to the horizontal setting, a locating pin provides angle settings of 15° above the horizontal and 45° below. Modifications can be made to suit most requirements.

pass, or $7\frac{1}{2}$ -inch with two. Heads open up for 5-inch thick tenons, and stock up to 24 inches wide can be worked.

Weight in pounds.....	2450
Weight boxed for export.....	3200
Box measure in cu. ft.....	110
Additional weight for cut-off attachment.....	150
Floor space for maximum table travel.....	5' 4" x 6' 8"

Codes:

No. 532 with top and bottom cope attachments....	GORYZ
No. 532-A with one cope attachment.....	GUJYL
No. 532-B without cope attachments.....	GUKYM
Cut-Off Attachment	GULYN
Set of inside tenoning heads to increase range for cutting 6" long tenons.....	GUMYP

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

*Machinery for Planing, Shaping, Mortising, Tenoning, Boring and Sawing
Tools for Mortising, Boring and Routing*