

Armstrong

NO. 6900 SHAPERS

FOR BAND, CIRCULAR AND
SASH GANG SAWS

ACCURACY AND EASE OF USE:

**The Two Most Important Considerations
When Buying a Shaper**

ACCURATE

Armstrong's No. 6900 Shaper is the most accurate shaper available and perhaps the easiest to adjust and operate. Precision shaping is essential to kerf control and smooth sawing. Use of the 6900 contributes to a smoother, more accurate cut which can reduce the allowance needed for planing. Armstrong incorporates two key features to ensure this level of accuracy.

1. The 6900 uses a "shovel point" tooth stop which locates just below the swaged point on the ground surface of the tooth. This location is always uniform, unlike the the swaged point which is often irregular.
2. Custom ground side dies clamp the saw plate with up to 4 tons of pressure. Side dies are individually ground according to customer specifications to provide the exact clearance required.

EASY TO ADJUST AND USE

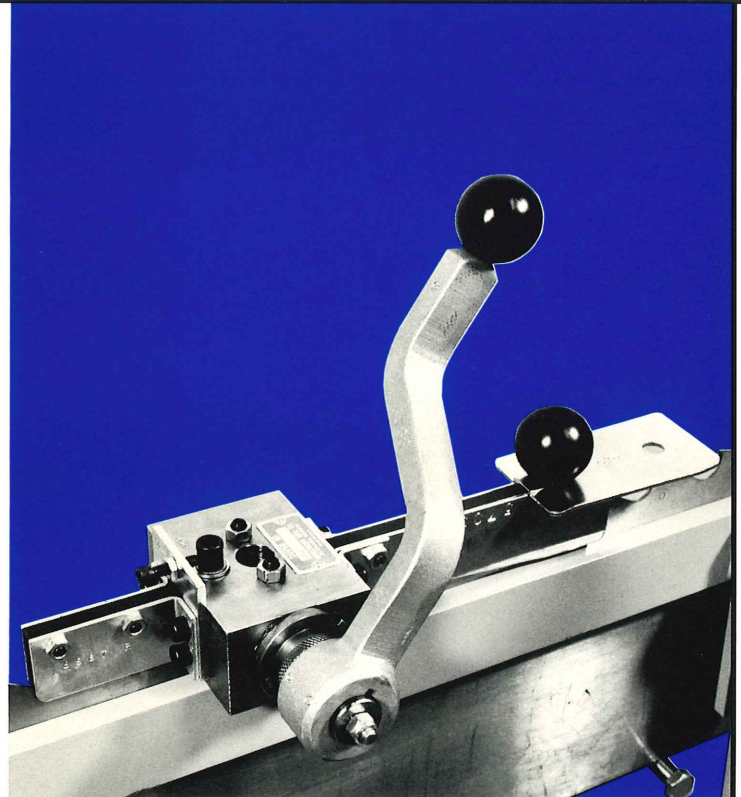
The No. 6900 Shaper requires very little set-up before it is ready for operation. Since clearance angles are ground directly into the side dies, these adjustments are "pre-set" at the factory. Adjusting for kerf and centering on the saw are accomplished in a few quick steps. In minutes, the No. 6900 Shaper is precisely adjusted for your specific needs.

AIR DRIVEN SHAPER (OPTIONAL)

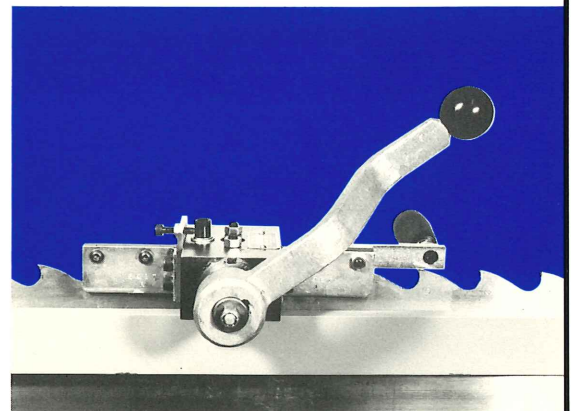
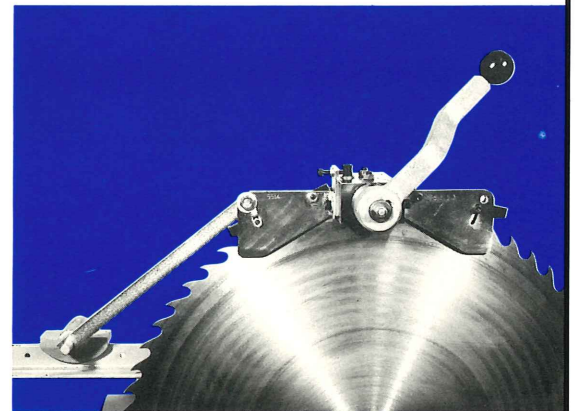
Armstrong offers an air driven version of the 6900-B band saw shaper. The 6900-BA was designed for those preferring an air shaper.

Armstrong Air Shapers Offer:

- Easy adjustment of cylinder speed with two needle valves.
- A well-balanced tool, with the weight of the cylinder evenly distributed.
- Lubricator supplied with each air shaper.



Armstrong's No. 6900 Shapers are the most accurate and easily adjusted shapers available today. The No. 6900 Series offers models for band, circular, and sash gang saws.



Armstrong NO. 6900 PRECISION SHAPERS

PRECISION SHAPING THROUGH INNOVATIVE DESIGN

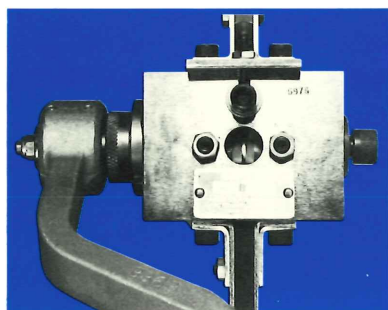
Increased precision, offered by the No. 6900 Shaper, comes through new ideas in design:

1. Clearances are pre-ground into the side dies, producing the *exact* same width and shape of tooth point time after time.
2. If desired, the 6900 is quickly adjusted for a wider point. The tooth stop can be moved to increase the width of the point .020" with standard 8 X 3 degrees back and side clearance.
3. The position of the clamping lever on the shaper is easily changed for operator comfort. A positive locking arrangement holds the lever firmly in place.
4. A new, heavy-duty pressure screw design applies approximately four tons of pressure to the tooth point.
5. The shaper operates on the "impact" principle. The saw itself acts as the stop for the side dies. When they contact the saw, no further pressure is needed. There is little or no tendency to make an incomplete stroke of the die lever.
6. The rugged "shovel point" tooth stop is designed to contact the saw just below the swaged point where the surface is consistent and uniform.

SIDE CLEARANCE

Since side dies are pre-ground to the exact clearance required by the customer, the following information must be provided:

1. the width of the finished point
2. the thickness of the saw plate
3. depth of gullet



Shown below is an example of how side clearance is calculated:

Finished point (saw kerf)125"
Subtract saw plate (16 gauge saw)	(-).065"
Total clearance060"
Divide .060 by 2030"
(Half the clearance on each side of the saw)	
Clearance per side is	.030"

INFORMATION FOR ORDERING

ONE SIZE ONLY: The No. 6900 Shaper is made in one size only and performs equally well on both thin and heavy gauge saws.

ESTIMATED SHIPPING WEIGHTS	Pounds
6900-B Hand Operated	15
6900-BA Air Operated	35
6900-C Hand Operated	22
6900-G Hand Operated	15

EASY MAINTENANCE

The No. 6900 Shaper is easy to maintain since there is a minimum of moving parts. All critical parts are made of hardened steel for long wear and are ruggedly designed to withstand the pressures applied.

A slight bulge on the side of the finished tooth point indicates it is time to replace the side dies. Side dies may be sent to Armstrong for prompt regrinding at a reasonable cost. Side dies may also be ground to different clearances if a change is made in the saw specifications.

Carbide for Longer Wear

Armstrong recommends the use of carbide parts whenever possible. Carbide side dies last longer, work better and cost less in the long run.

SIDE DIE AND TOOTH STOP SELECTOR:

Deep Tooth Range

$\frac{3}{4}$ " deep and deeper:

6980 side dies

6981 tooth stop

(If an order is received without the gullet depth noted, we will assume when the saw is 15 gauge or heavier that there is a minimum of $\frac{3}{4}$ " gullet.)

Shallow Tooth Range

$\frac{11}{16}$ " deep and shallower:

6982 side dies

6983 tooth stop

(Under normal conditions, the No. 6900 cannot be used on saws with less than a $\frac{1}{2}$ " tooth space or $\frac{1}{2}$ " gullet depth.)

CLEARANCE ANGLES

An eight degree back (tangential) angle and three degree side (radial) angle are standard on the No. 6900 Shaper. These are the same clearance angles used by other Armstrong shapers that have proven to be optimal in the majority of cases. This tooth point geometry provides good wear on the tooth point and allows maximum adjustment of the overall side clearance.

If desired, more or less back and side clearance angles can be ground into the side dies at no additional cost.

THE FOLLOWING SPECIFICATIONS ARE NEEDED TO ADAPT THE SHAPER TO YOUR EXACT REQUIREMENTS:

1. Thickness of the saw
2. Width of finished point
3. Standard 8 degree back X 3 degree side clearances will be furnished unless otherwise specified.

Armstrong Manufacturing Company

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