



# Magnum Beveller Bypass Retrofit Installation Instructions

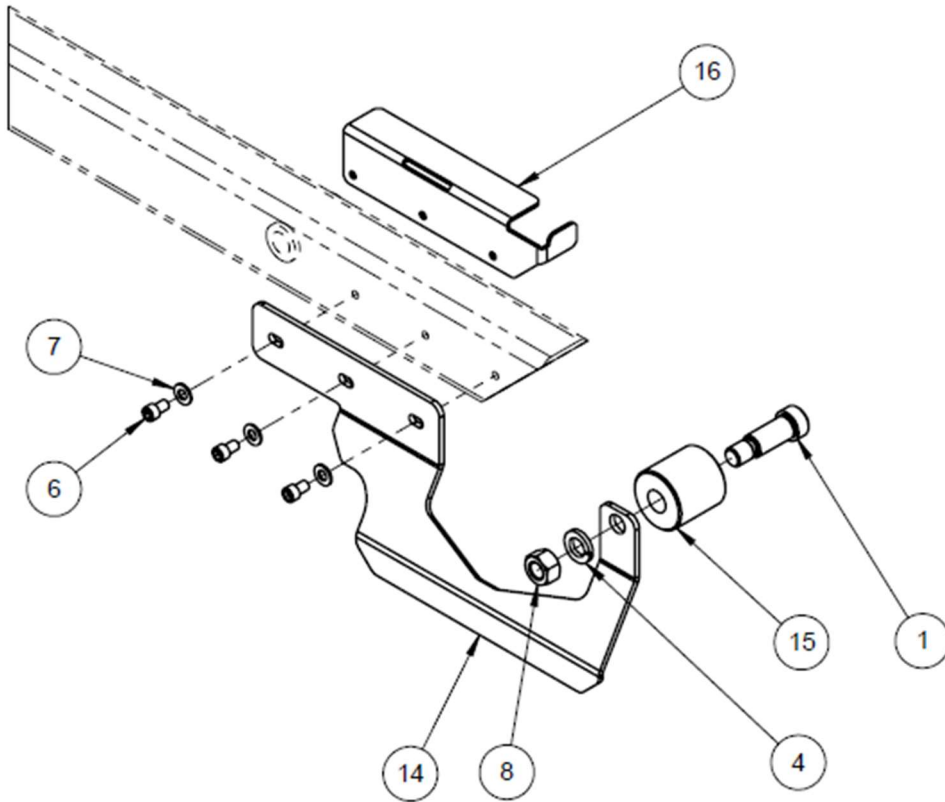
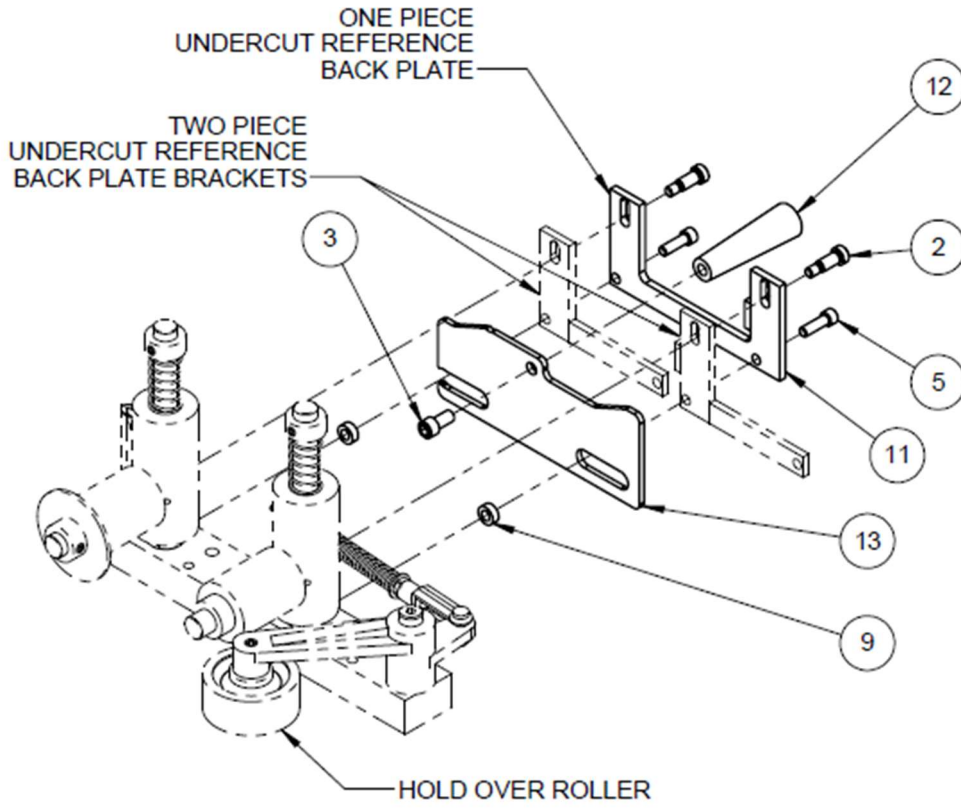
**Purpose:**

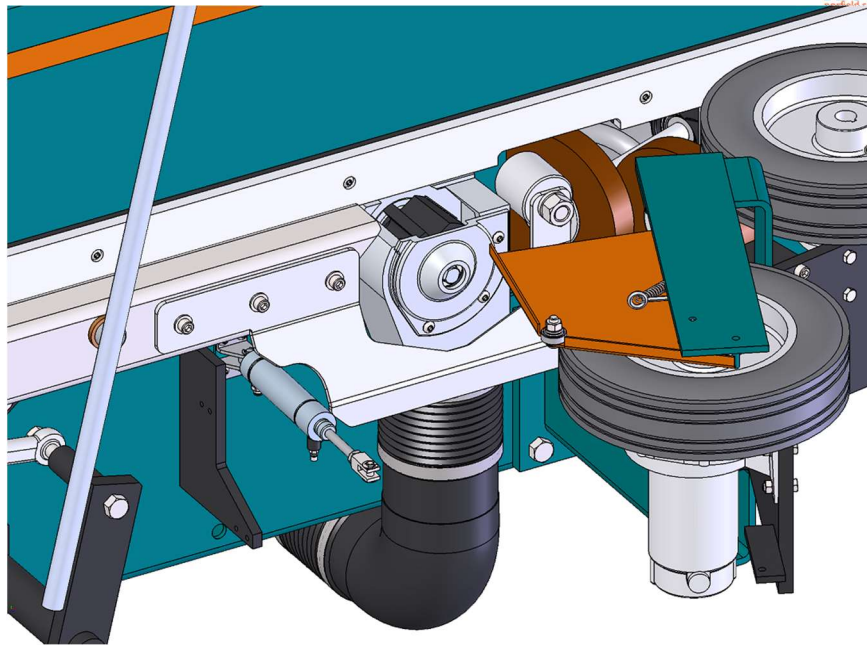
This is intended to guide in the installation of the parts to facilitate moving a door through a Magnum without machining the edge of the door with the beveling head.

**Before carrying out any maintenance work, be sure that the main power supply has been disconnected and that there are no live circuits in the machine main panel.**

**Contents:**

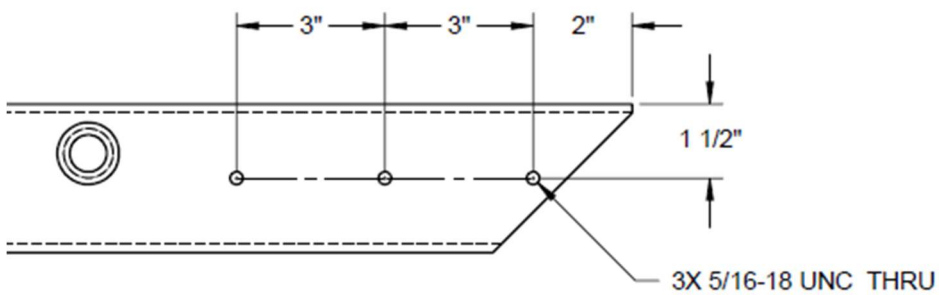
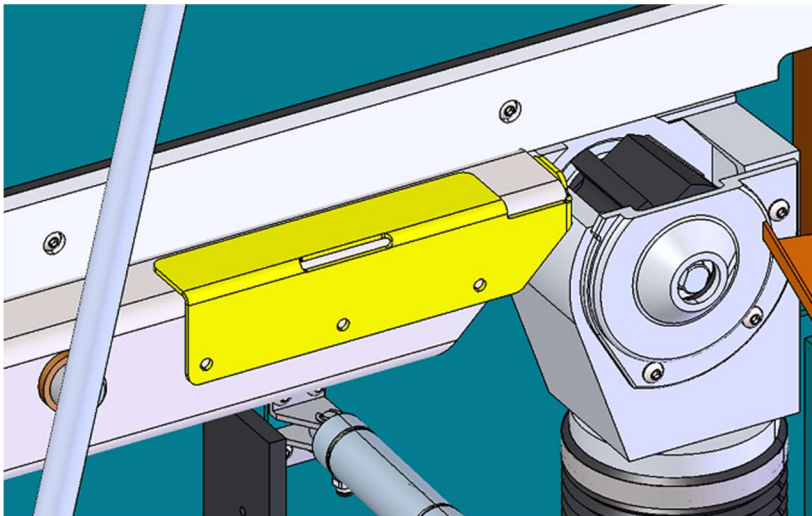
ITEM	PART NUMBER	DESCRIPTION	QTY.
1	*****	3/4 x 1-1/2" Shoulder Bolt	1
2	*****	3/8 x 3/4" Shoulder Bolt	2
3	*****	3/8-24 x 3/4" SHCS	1
4	*****	5/8" Lock Washer	1
5	*****	5/16-18 x 1" SHCS	2
6	*****	5/16-18 x 1/2 SHCS	3
7	*****	5/16" Flat Washer	3
8	*****	5/8-11 Hex Nut	1
9	12-1186	Spacer, 5/8OD x 11/32ID x 1/4LG	2
10	17-638	Beveller Bypass Retrofit Instr	1
11	0072-103	Restricting Plate Weldment	1
12	0085-002	Handle	1
13	6803-044	Roller Lift Cam Plate	1
14	6803-045	Support Roller Bracket	1
15	6803-046	Support Roller	1
16	6803-047	Infeed Bar Drill Template	1



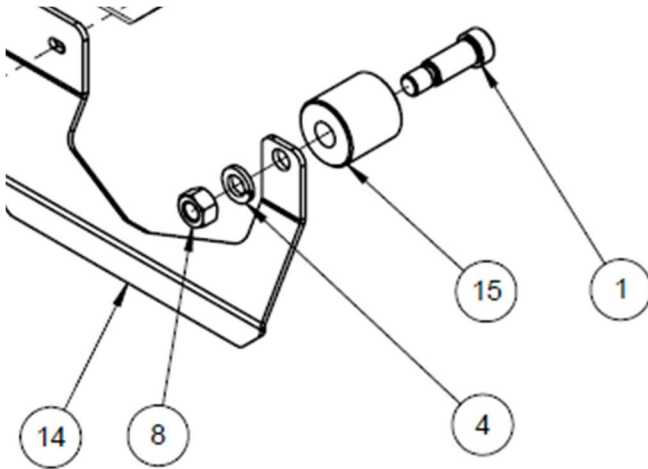


**Step 1: Modify the infeed bed and mount the support roller bracket.**

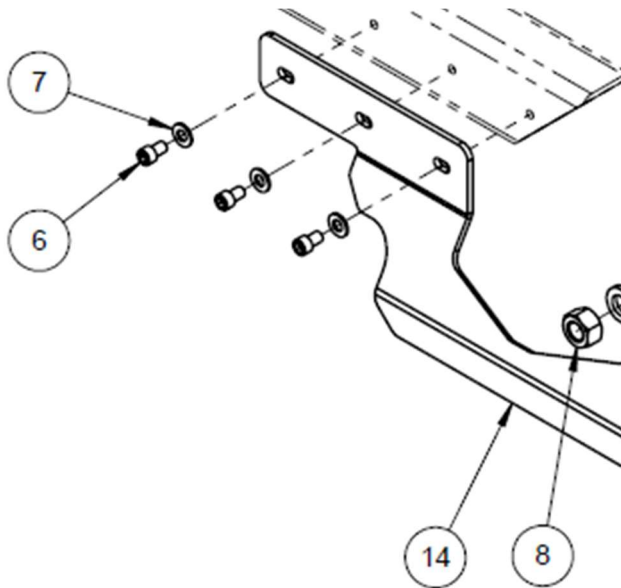
- A. Use drill template, 6803-047, to locate the tapped holes. Recommend using 1/4" transfer punch. Drill and tap 5/16-18 UNC holes. The power feed roller will have to be disconnected from the air cylinder to gain access to the infeed bed bar.  
Discard drill template after use.



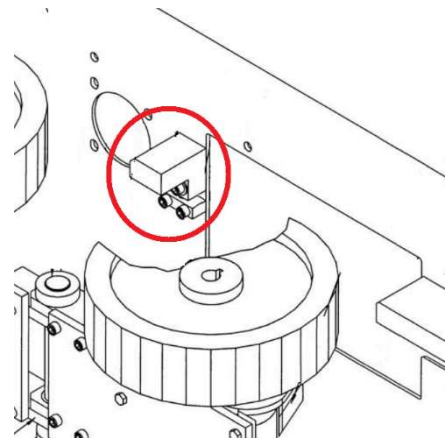
- B. Using  $\frac{3}{4}$ " shoulder bolt, nut, and lock washer, attach support roller, 6803-046, to bracket, 6803-045. Make sure that roller is free to rotate when bolt and nut are fully tight.



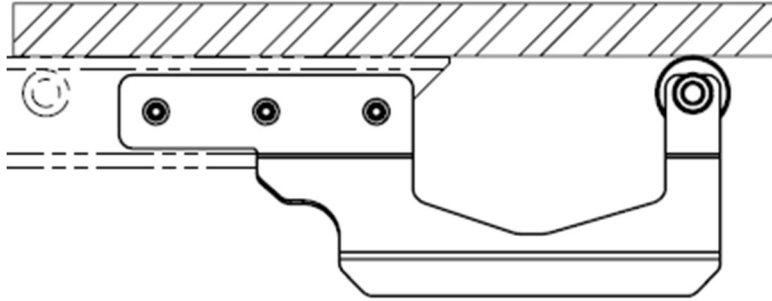
- C. Using the  $\frac{5}{16}$ " bolts and washers, mount the bracket, 6803-045, to the infeed bed.

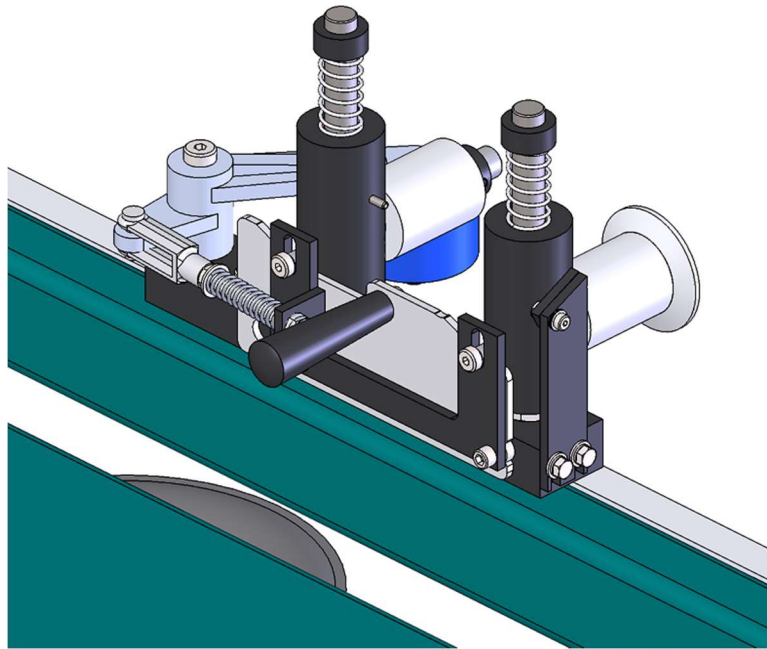


On older Signature Series Magnums the support block next to the beveller head will have to be removed. (This block is not on newer Magnums.)



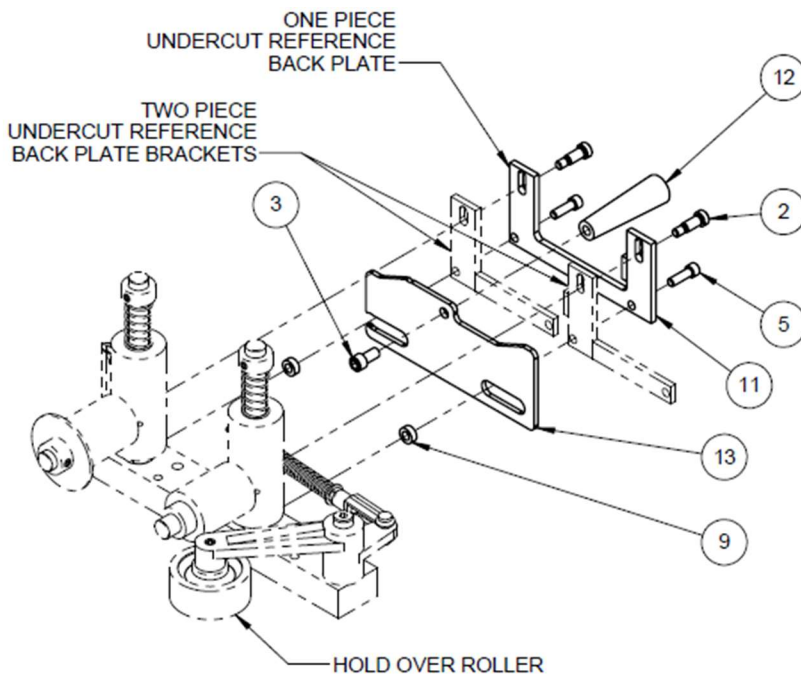
- D. Using a straight edge or door, locate the top of the roller to be level with the top of the infeed bed.





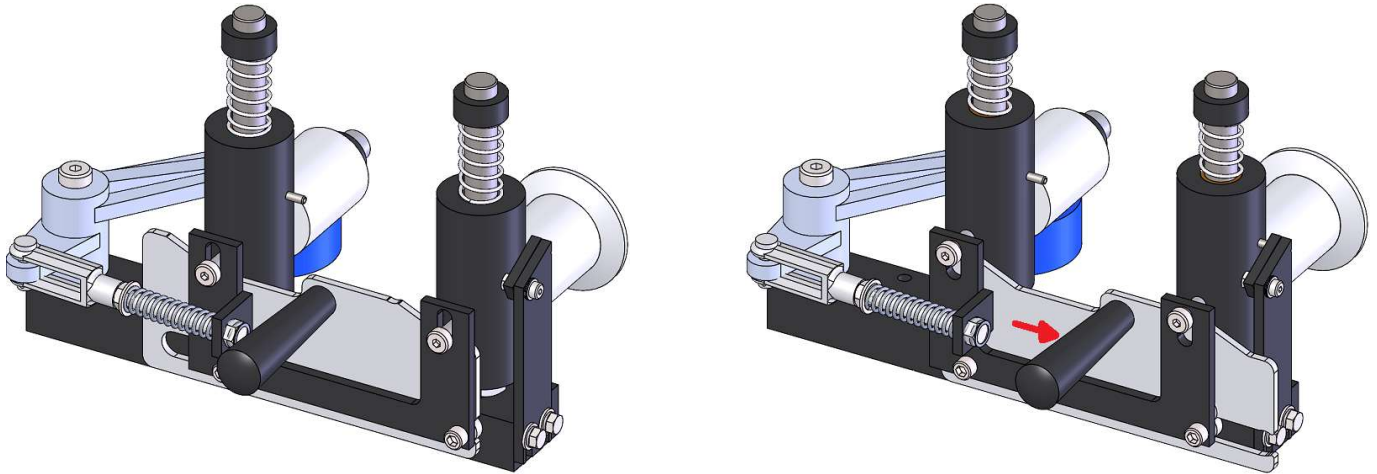
**Step 2: Modify the Undercut Reference Assembly**

- A. For Magnums with the one piece undercut reference back plate, remove the back plate without removing the bolt/spring for the hold over roller.  
For older Magnums with the two piece back plate, remove both brackets and install the bolt/spring for the hold over roller onto the new one piece undercut reference back plate.
- B. Remount the back plate with the lift cam plate, 6803-044, and standoffs, 12-1186, sandwiched between the back plate and the undercut reference mount block. Replace the existing shoulder bolts and bolts with the new longer shoulder bolts and bolts.
- C. Mount the handle, 0085-002, to the roller lift cam plate using the 3/8-24 bolt.



**Use:**

- First engage the undercut roller lift plate. Pull the lift plate handle to the right to raise the undercut reference rollers. When pulled all the way to the right the plate will lock in place.



- Second, adjust the infeed bed up so that the door will pass over the beveller cutter head. The support roller will prevent the door from dropping onto the cutter head when the door leaves the infeed bed.