

# MiTek<sup>®</sup>

## Manual Jigging

Includes Jigging by **TEKSET<sup>®</sup>**

U.S. and other patents pending.



Manual applies to U.S. equipment.


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## Introduction to the Equipment

	 <b>WARNING</b>
	<p><b>CRUSH AND CUT HAZARD.</b></p> <p>Do not enter the restricted zone to adjust jigging while the gantry is in operation.</p> <p>Improper use may damage fixtures and cause personal injury.</p>

	<b>NOTICE</b>
	<p>Do not strike any jigging component with a hammer or heavy object. Do not use damaged or broken jigging.</p> <p>Do not substitute other parts or mix parts in the Standard Stop Set and the Laser Jigging Fixture Set.</p> <p>Ensure the jigging will safely clear the gantry roller before operating.</p>

The MiTek Jigging is meant to be used in slotted-top tables to set up roof trusses. The jigging can be set up in almost any configuration to create roof truss designs.

To set up each truss configuration, jigging must be used. The jigging instructions are found here for manual jigging. For instructions on using automated jigging, refer to that manual.

Your jigging has a Standard Stop Set containing the basic components for an assembly line workstation for approximately four to six tables (30-45 ft of assembly line length). In addition to the Standard Stop Set, you will also need a fixture set. Use the Slotted Fixture Set with slotted-top tables that do not use a laser projection system, and a Laser Jigging Fixture Set with systems that use a laser projection system.

Additional pieces are offered to allow plate embedment at the table slots and aisles.

You can add to your jigging collection at any time by referencing the online Parts Guide and ordering the parts through MiTek Machinery Customer Service.

## Assembling the Jigging

Figure 1-1: Pucks for Standard Stop Set, Assembled

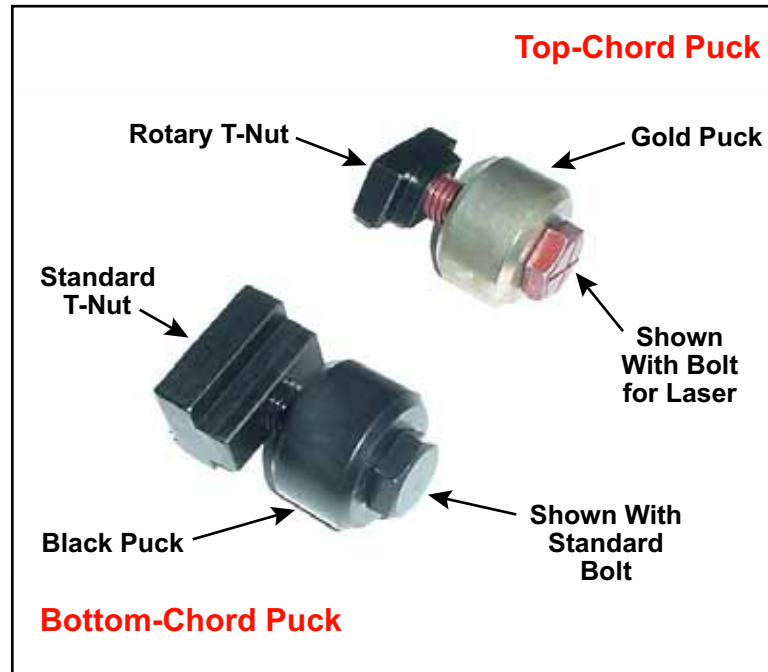
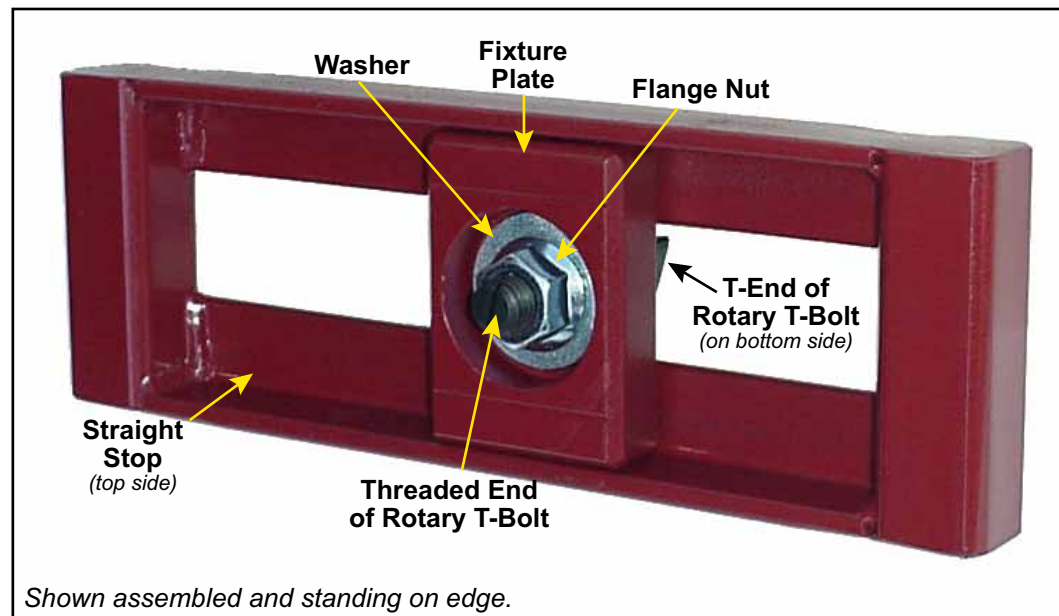


Figure 1-2: Straight Stop for Slotted Fixture Set



## Operation and Overview

### Standard Stop Set

(PN 010100)

The Standard Stop Set is used on most MiTek slotted-top tables. To use the Standard Stop Set, a bolt kit must also be used. There are standard bolts for systems not using laser projection and a separate set of bolts with cross-hairs for tables using laser projection.

The black pucks are intended for use on the bottom-chord end of the table and must slide completely out of the table slot for removal. The gold pucks are intended for use at the top-chord end of the table to indicate that they have a rotary T-nut and do not need to slide out of the end of the table for removal.

#### Standard Stop Set Contents:

- Pucks: Place anywhere along the side of boards so boards are held in place by resting against the puck.
- T-nuts
- Wrench and equipment manual

### Bolt Sets

#### Bolts Set Choices:

- Standard bolt kit (PN 010160)
- OR
- Laser target bolt kit, for use with laser projection systems (PN 010150)

#### Instructions for Use

1. Assemble the black pucks with a bolt and a black standard T-nut. Place one assembly in each slot along the bottom chord.
2. Assemble the gold pucks with a bolt and rotary T-nut. Place one assembly in each slot along the top chord. Ensure that the nut is properly rotated and seated in the table slot.

Special open and double offset wrenches are supplied for quick setup. The stops are designed for 1/4- to 1/2-turn tightening with approximately 15 in-lbs of torque. Over-tightening them will reduce their life span and should be avoided.

## Slotted Fixture Set

(PN 010110)

The Slotted Fixture Set uses straight edges to keep truss members straight and aligned.

### Slotted Fixture Set Contents:

- Fixture plates with washers, rotary T-bolts, and flange nuts: Sits inside the fixtures to hold them to the tables
- Straight stops (12", 18", 24"): Use along straight edges of boards
- Heel stops (12", 18"): Angled corners for use at heels of truss
- T-stops (12", 18", 24"): Use along straight edges and near joints
- Equipment manual

### Instructions for Use

1. At first use, assemble the fixture as shown in Figure 1-2.
2. With washer and flange nut installed, but loose, insert the T on the rotary bolt into the table slot. Turn the bolt and/or the fixture so the fixture is in the location and angle it is needed while the T on the rotary bolt is inserted fully into the table slot.
3. Rotate the rotary bolt and tighten the flange nut to properly engage with the table slot.

## Laser Fixture Set

(PN 0010130)

The Laser Fixture set is identical to the Slotted Fixture Set, except it has painted lines on the top of the fixtures to align with a laser projection line.

### Laser Fixture Set Contents & Instructions for Use

This kit contains the same contents as the Slotted Fixture Set, but with laser lines on top. Assemble and use it in the same way as described for the Slotted Fixture Set. Ensure that the white laser lines on the fixture plate is oriented perpendicular to the fixture ends.

## Slider Pad

A slider pad covers parts of the ejector slot so that plates can be embedded into the lumber over the ejector slot if required.

1. Slide the pad into the ejector slot from either end of the table. The top surface of the slider pad should be even with the top of the table as shown in Figure 1-3.
2. Arrange the slider pad so it is located directly under the connector plate location.
3. To remove the slider pad, slide it completely out of the ejector slot.

**Figure 1-3: Using a Slider Pad in an Ejector Slot**



### NOTICE

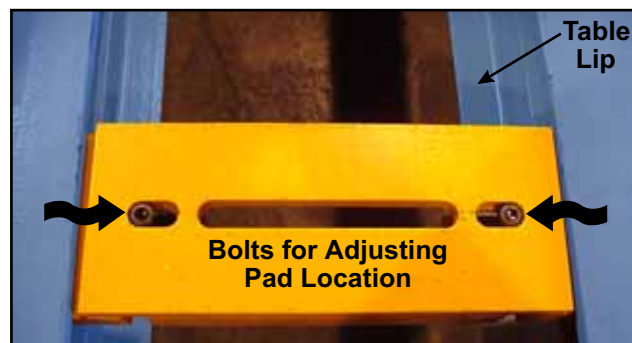
Remove the slider pads or turn off valves for ejectors that have slider pads over them before actuating ejectors!

## Aisle Pads

An aisle pad enables plates to be embedded into the lumber as the lumber crosses the walk-through aisle between the tables.

1. Slide the aisle pad between two tables from either end of the table. Rest the aisle pad's flanges on the lip of each table as shown in Figure 1-4.
2. Arrange the aisle pad so it is located directly under the connector plate location.
3. Tighten the bolts.
4. To remove the aisle pad, loosen the bolts, and slide the pad out from between the tables.

**Figure 1-4: Using an Aisle Pad in an Aisle**



## Jigging Maintenance

The jigging is designed for durability and accuracy with minimal maintenance. It is important, however, to promptly remove from service any damaged fixtures or components. Damage may occur if the jigging is hit with a heavy object, dropped on the floor, or from daily wear over a long period of time. If damaged components are not replaced immediately, they may cause damage to other threaded parts as well as inaccuracies in the trusses built with those components.

### Inspecting

All jigging should be inspected daily for damage. Damaged jigging must not be used and must be replaced immediately.

### Repainting the Target Lines

Target lines (on jigging designed for laser-projection systems) should be repainted at regular intervals using a fine-point white paint pen available at most office supply stores.

### Stocking Replacement Jigging

It is a good idea to stock extra jigging to ensure the jigging in operation is in optimum condition. As part of your annual preventive maintenance, we recommend taking inventory of all jigging you are currently using or have in stock. Replace any damaged jigging at this time.



Refer to the online Parts Guide to order individual items or entire kits.