

The **nail exit** is the corner nail distribution center. A cartridge system to hold the nails is one option; a strip of nails that is glued at the top is another. Cartridges can be changed quickly when you are going from one size to another. Non-cartridge systems are cheaper, but you must change the distributor block every time you change the size of the wedge. Some machines offer wedges for special functions.

The **90°Assembly Angle** adjusts to correct gaps in cutting angles. Backfences adapt their inclination to the form of the profiles by being to correct gaps on top or at the bottom.

**Handles** adjust the machine to the thicknesses of the mouldings.

**Compressed air regulation and lubrication unit** conditions the compressed air supplied to the machine from a compressor.

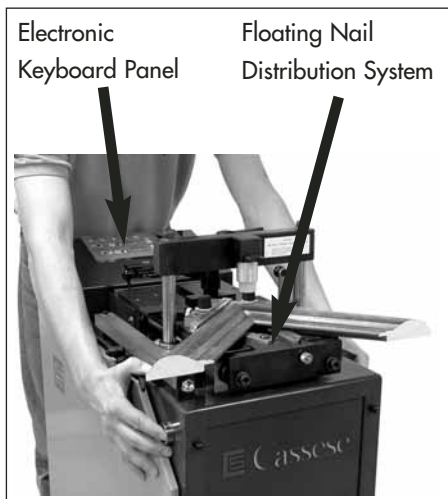
More advanced machines may have an **electronic keyboard panel** to program the assembly parameters (the number of nails and where to insert them) so that the machine does everything automatically.

The **floating wedge distribution system** assembles double rabbet mouldings for shadowboxes and more complicated designs.

## Maintenance

Your underpinner should be maintained on a regular basis. It is important to clean the machine from the glue and debris after every use. Using a mat cutter lubricant, buff it to the surface table of the machine. Make sure that glue does not ooze out onto the machine by leaving a small amount of the frame edge, about 1/8" uncoated so when the glue squeezes down as the sides are being joined, extra glue has a place to go. Cables should be adjusted for foot pedals. Air compressors should be checked once a week for proper humidity. A light weight silicone-based oil should be applied to the machine's air line to displace any water that may enter the valves. Tighten knobs and shafts.

Overall, a good framer must decide what their personal needs are for the underpinner, pick an appropriate model, and fire away! ■



*Cassese has manufactured upgraded models with improvements since its inception including the 276A, 276B, 276C, 276D, and 276E (shown here).*

