Veneer Cylinder Replacement Instructions

The veneer gauge is a hydraulically operated set of fingers located on the outbound side of the machine. It is used to cut stone to a desired length after being manually set to the correct setting. On older machines, The hydraulic cylinders may need to be replaced after time due to normal wear. Since these cylinders are now longer available, a new cylinder must be retrofitted to the machine.

You will need to have an experienced welder with either a oxyacetylene torch **or** a MIG welder with a Air-Arc cutter, a hand held grinder , a bandsaw and a tape measure.

Procedure

1) Remove the old cylinder and set it off to the side.
2) Torch Cut **or** Air-arc any old mounting brackets which are on the machine that were connected to the old cylinder and grind the surface flat.
3) Find the center of the finger gauge bar, grind away any paint and weld the upper cylinder mount into place. Use a 3/8" fillet weld all the way around it.
4) Adjust the gauge bar so that it is located in the first hole.
5) **Extend the hydraulic cylinder to its maximum stroke** and attach it to the upper cylinder mount. (Remove the plugs so the air can escape.)
6) Locate the centerline of the machine on the bottom beam.
7) The bottom cylinder mount will need to be cut to size. Use a bottle jack and a 2x4 to raise to the gauge finger bar to it's fully extended position. **The cylinder should sit vertical when it is installed** in the first hole of the bottom cylinder mount. Measure the bottom cylinder mount, cut it to length.
8) Grind any paint off of the machine, mark the location of the bottom mount and weld it into place.
9) Reinstall the new cylinder and transfer the hoses from the old cylinder to the new one.

Remember.
Measure Twice,
Cut and Weld only once.