

# Logan Shaper Per-Setup Review List

## 1. Ram

- 1a. Does the Ram clear the Body?
- 1b. Will the Ram clear the Body for the entire cut (important if downfeed used)
- 1c. Is the stroke length correct?
- 1d. Is the Ram position correct?
- 1e. Are the Crank Pin Stud and Ram Clamp Screw tight?

**Cycle Ram by hand to check**, and remove Crank Handle from Jack Shaft.

## 2. Clapper Box, Downfeed, and Tool

- 2a. Are the Clapper Box and Tool angles safe and correct?
- 2b. Will the Clapper Box and Ram clear the Workpiece for the entire cut?
- 2c. Is the Downfeed overhang minimal?
- 2d. Does the Downfeed Dial position matter in this setup?  
If so, is it zeroed or set as you desire?
- 2e. Is the Clapper Hold Down either not set or set, as you intend?
- 2f. Is the Toolbit tight?
- 2g. Is the Toolbit wrench removed?

## 3. Ratchet

- 3a. Is the Ratchet Feed Link the correct length for the Saddle position?
- 3b. Is the Feed Crank Nut on the correct side so as to cause the Feed to occur during the backstroke?
- 3c. Does the Feed Dial position matter in this setup?  
If so, is it zeroed or set as you desire?
- 3d. Is the Feed either engaged or disengaged at startup, as you intend?
- 3e. Is the Feed amount appropriate for the work?

## 4. Saddle, Table, Vise, and Workpiece

- 4a. Are the top and bottom Saddle Gib Setscrews tightened?  
(Did you loosen them first, as the manual specifies, when you last moved the Saddle?)
- 4b. Is the Table Support in place and snug?
- 4c. Is the Vise, if used, secure and tightened down to the Table?
- 4d. Is the Workpiece secure?

## 5. Speed

- 5a. Do you know what speed the machine will start at when you turn it on?
- 5b. Is this speed comfortable for you as an operator?
- 5c. Is this speed appropriate for the job?
- 5d. But change speed only when the machine is running.

## 6. State of the Machine

- 6a. Is the Shaper in fact in working order and has it received its daily maintenance?
- 6b. Have all loose tools and parts been removed from the machine?
- 6c. Do you understand what will happen when you turn the machine on?

## **7. After all adjustments have been made, always cycle the machine by hand, and remove the Crank Handle from the Jack Shaft.**

## 8. Final Check

- 8a. Is the Crank Handle in fact removed from the Jack Shaft
- 8b. Is the toolbit in fact securely tightened?
- 8d. Are you wearing your Safety Glasses?
- 8e. Are you clear of the machine?