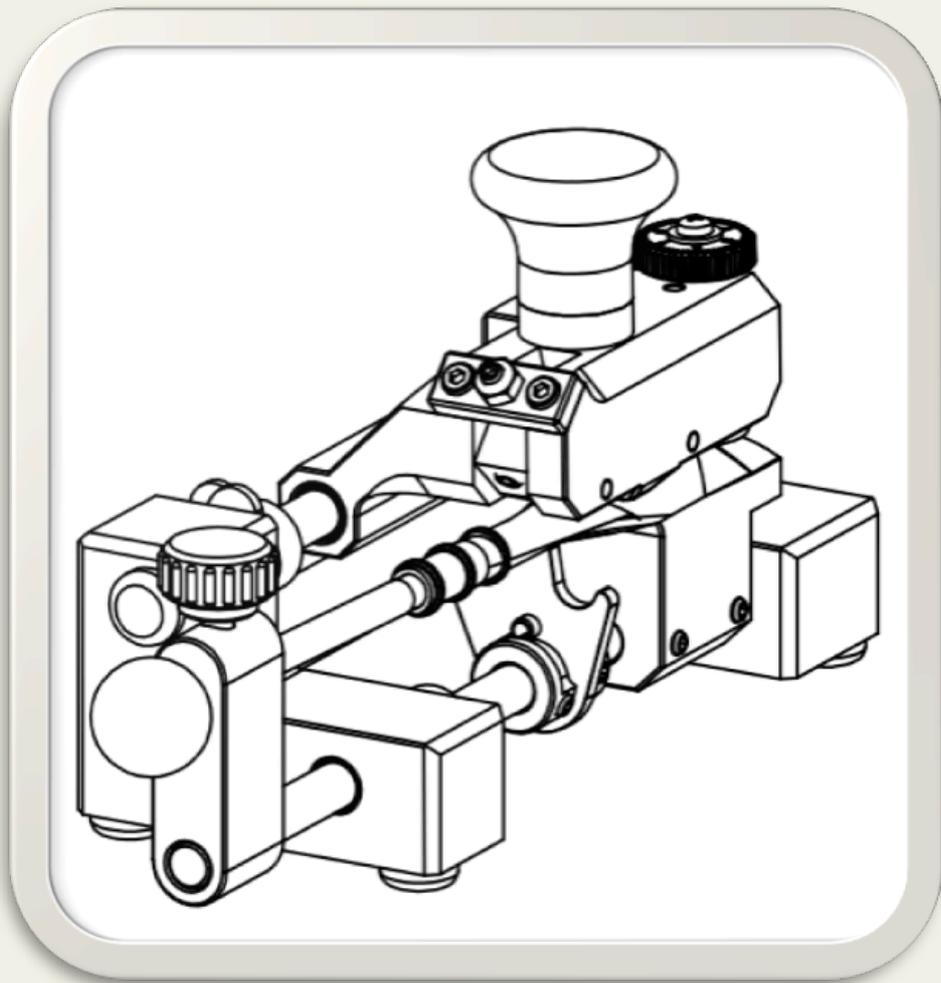


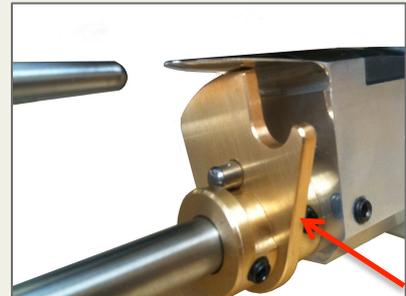
TIP PROFILING MACHINE FOR BASSOON REEDS



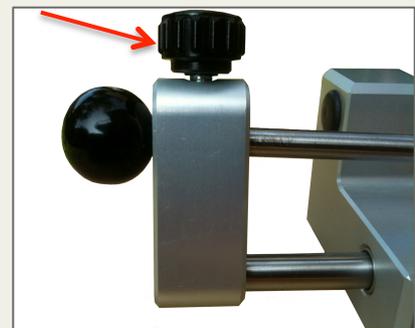
Andante e Rondò

User's manual for the “Andante e Rondò” tip profiling machine

- Wet the reed and be sure that it is not too open or too closed.
- Place the reed on the plaque, about half way to the line indicated. Then insert the mandrel into the tube of the reed and position the reed up to the line. Be sure that the reed is centered on the plaque.
- Put on the reed lock (*fig.1*) softly, without pushing on the cane, and then tighten the screw of the mandrel lock (*fig.2*).
- Begin the scraping of the reed from the middle and then work towards the sides.
- Do not grip the handle, but instead hold the carriage directly between the fingers to avoid applying excess pressure to the carriage during the scraping (*fig.3*).
- Do not remove all the material at once, but begin the scraping by first grazing the reed with the blade. Then **gradually** lower the blade by turning the regulation screw counterclockwise (*fig.4*) until arriving at “0” or at the final finishing point (predetermined final measurement).
- After finishing the scraping, remove the reed lock. Remove the reed from the plaque and then from the mandrel.



Reed lock
Fig. 1



Mandrel lock
Fig.2

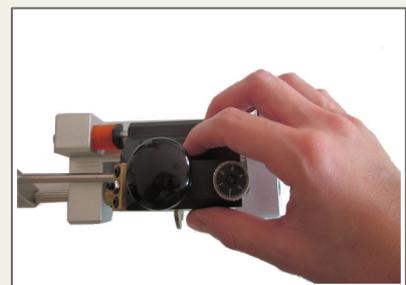
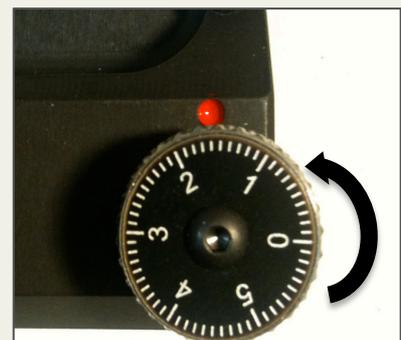


Fig.3



Regulation screw
Fig. 4

Regulation of the scraping and calibration of the graduated scale to the “0”

Loosen the two small stopping screws of the “0” (*fig.5*). Take a “test” reed and begin the scraping.

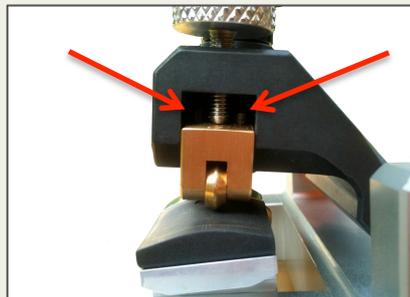
Check the thickness of the reed throughout the process. When you reach the desired thickness (it is advised to not go lower than 0.05mm on the edges of the corners of the reeds), tighten the two stopping screws of the “0” until feeling that they touch the metal (*fig.6*). Don’t tighten the screws more because this would change the desired thickness.

Loosen the screw shown in the *fig.7*. Turn the numbered wheel bringing the “0” to the red dot.

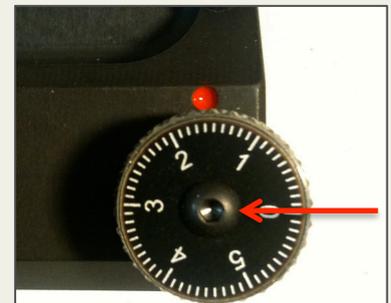
Retighten the screw of the numbered wheel, being careful that the wheel doesn’t turn together with the screw.



Stopping screws of the “0”
Fig.5



Stopping screws of the “0”
that touch the metal
Fig.6



Screw of the numbered
wheel
Fig.7

Changing of the templates and consequent regulation of the “0”

When you change the templates it may be necessary to repeat the process of the preceding paragraph: **Regulation of the scraping and calibration of the graduated scale to the “0.”**

Alternatively, you may take note of the different finishing points of each templates on the numbered wheel.

The machine is delivered with the “0” calibrated for the template no.7 (standard template).

Regulating, sharpening, and changing the blade

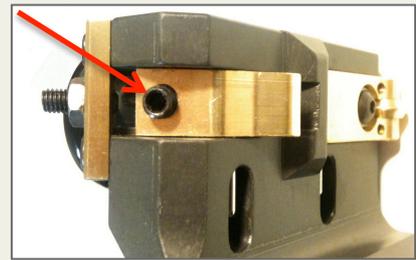
To regulate the height of the blade, loosen the Allen screw (*fig.8*). Calibrate the regulating Allen screw (*fig.9*) to achieve the desired height of the blade, and retighten the Allen screw of *fig.8*. (The steel nut is present only for security. It must be loosened until the point that the Allen screw of *fig.8* can be moved for adjustment, and then retightened.

Indicatively, the distance between the carriage and the edge of the blade should be 0.80 mm (*fig.10*).

The blade must project 0.05 mm from the surface of the carriage.

Once the blade is set at this position, it is advised not to make other adjustments, not even after sharpening or changing the blade. It is not necessary.

To sharpen the blade manually, drag it along the surface of a piece of sandpaper, grade 1000 as in figures 11 and 12.



Allen screw
Fig. 8



Regulating Allen screw
Fig. 9



Fig. 10



Fig. 11

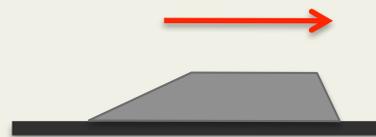


Fig. 12

Maintenance of the machine and use of the screws

Do not overtighten the screws.

Do not oil any moving parts of the machine.

Do not leave the machine in humid environments because the blade and the screws may become rusty.

Do not touch the spring screw (*fig.13*).



Spring screw
Fig. 13

CAUTIONS

- If with some templates, you see an evident gradation between the scraped and unscraped parts of the reed, this is because the cane is very thick. It is advisable to balance the difference with a file.

- It is possible to shorten the scrape of the reed by applying one or both of the spacers (*fig.14*) to the shaft along which the carriage moves .



Fig.14

Problems	Causes/solutions
The cane is torn along the edges of the blade of the reed	<ul style="list-style-type: none"> • The blade projects too much from the carriage • The carriage comes down too low • The process of lowering the carriage with the regulation screw is not done gradually enough (<i>Fig.4</i>) • Too much pressure is applied to the carriage
Marks of abrasion on the plaque of the machine	<ul style="list-style-type: none"> • The blade projects too much from the carriage • The carriage comes down too low
The blade does not scrape the cane sufficiently	<ul style="list-style-type: none"> • Check the sharpness of the blade • The blade does not project far enough from the carriage
The roller under the carriage does not turn	<ul style="list-style-type: none"> • The roller has become oval as a result of striking the template • The roller is stuck as a result of being dirty; clean it with rubbing alcohol on a piece of paper
The reed cracks after being placed on the plaque of the machine	<ul style="list-style-type: none"> • The reed was not wet enough • The reed lock was pressing too much on the reed
The resulting scraped reed is too weak	<ul style="list-style-type: none"> • The type of cane used has fibers which are too soft • The thickness of the cane after the scraping is too thin • Shorten the scrape of the reed using one or both spacers • Verify the tightness of the first wire
The resulting scraped reed does not vibrate	<ul style="list-style-type: none"> • The type of cane used has fibers that are too compact • The cane is too thick after scraping