

# Tyler® Drawer Front Dovetailer

*For high volume production of French dovetail drawer fronts.*



Now you can produce French dovetail drawer fronts all in one operation—quickly, accurately and efficiently.

The Tyler® Drawer Front Dovetailer combines the power of 3 high speed heads (2 run at 20,000 RPM for routing dovetail slots, the other at 15,000 RPM machining the bottom drawer groove). All heads are equipped with T.E.F.C. squirrel cage induction motors. Produces 10-12 pieces per minute, including optional boring operations and is rated for continuous operation.

Built for long lasting operations, the spindle shaft has a rugged integral collet chuck and precision bearings for high speed applications. It also offers a precisely machined flanged spindle housing for dependable service.

Common changes (IE: distance between drawer slides, dovetail cut length) are made easily and accurately via built-in digital read-outs. For a quick set-up, simply loosen the lock-down screws, reposition them, move the right-hand head to the desired distance from the left-hand head, re-tighten the screws and you're ready for your next run, often in a minute or less.

One to four drill units are available to mount on overhead beams, each with an adjustable center distance of 1.0" to 6.6". Each unit also has a ½ HP T.E.F.C. motor, pneumatic feed for a maximum stroke of 2.0" and a separate on/off switch. Center guide router or drill is air operated and sequenced into the machine cycle.

The machine controls are in a fixed machine position and can be manually

controlled for set-up and automatically controlled during operation cycles

Electrical controls are sealed in a dust-tight cabinet (NEMA 12 rated). Simplified hydraulic controls are interchangeable and mounted on an aluminum manifold subplate, standard pneumatic controls are similarly arranged. The hydraulic feed pump is mounted on the machine and the oil reservoir is built into the base.

## Other Options:

- Automatic repeat cycle with adjustable dwell
- Center stock support which can double as an inside face chip breaker

## At a glance:

- Three high speed heads for precision routing
- Quick set-up to maximize throughput
- Drawer front hardware drills (optional) occurs during dovetail/groove cycle (no additional production time required)
- Center guide router or drill (optional) air operated, sequenced into machine cycle
- Many other optional features available

## What it is:

Drawer fronts dovetailers and other operations performed in one single machine setup

## What it does:

- Used for pre-assembly wood drawer front machining
- French dovetails drawer front sides
- Grooves drawer front for receiving drawer bottom
- Drills mounting holes for hardware (optional)
- Drills or routes drawer center guide (optional)



**Tyler®**

**Warsaw Machinery, Inc.**  
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# General Specifications

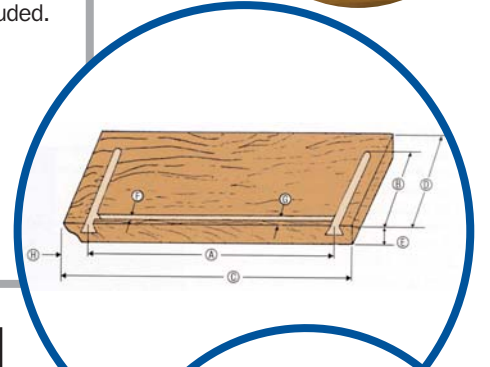
**Electrical motors:** 2 HP on dovetail heads, 2 HP on groover head, 3 HP on hydraulic pump. All motors are T.E.F.C. squirrel cage induction type, 115 V control circuit, fused disconnect, built-in dust-proof control panel cabinet. Arranged for 230 or 460 Volt/3 Phase/60 Hertz power supply (to be specified when ordered). For other electronic requirements—consult factory.

**Hydraulic:** Integral System: reservoir built into base, sight oil-level gauge, built-in cabinet contains directional valves and controls.

**Pneumatic:** Used for: clamping, groover lift, accessories.

**Dust Collection:** Three 2-inch diameter outlets for connection to plant system. Total dust collection load is approximately 300 CFM based on 4500 ft./min. velocity.

**General:** Machine has fully automatic cycle. Simple set-up controls for fast change-overs. Service manuals and wrenches furnished. Cutting tools and hydraulic oil are not included.



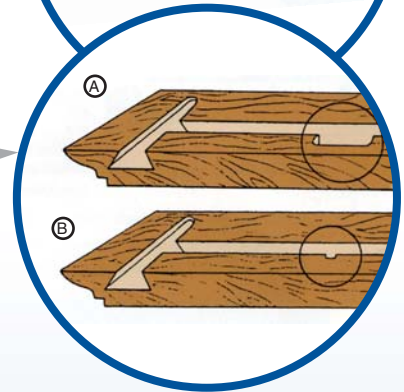
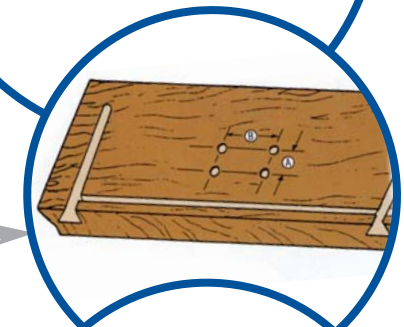
Standard Capacities								
Capacities	A	B	C	D	E	F	G	H
<b>Minimum</b>	5-3/4	3-1/2	6	4	3/8	0	0	0
	36	11-1/4	40	unlimited	1-3/4	3/8	1-1/2	2
<b>Maximum</b>	42	11-1/4	46	unlimited	1-3/4	3/8	1-1/2	2
	48	11-1/4	52	unlimited	1-3/4	3/8	1-1/2	2

Hardware Drills (optional)			
Capacities	A	B	Hole Dia.
<b>Minimum</b>	Variable	1"	1/16"
<b>Maximum</b>	Variable	6.6"	3/8"

Generally, the hardware hole pattern may be located to within 1" of the drawer top edge, dovetail cuts, or drawer bottom groove.

Center Guide (optional)	
<b>A</b>	Slotting type, Up to .38" wide x .5" deep x 2.25" long
<b>B</b>	Single hole, up to .5" diameter x .5" deep

Generally, the center guide locating hole will be located between the bottom of the drawer front and the lower edge of the drawer bottom groove, and centered left-to-right on the drawer front.



## Tyler®

- Dovetailer-French
- Router
- Drill Head
- Double End Tenoner
- Undercut Dado Machine
- Multi-Spindle Panel Router
- Panel Feeder
- Hopper Feeder

## MBD®

- CNC Automatic Bandsawing System
- Vertical Industrial 36" Bandsaw
- Resaw Attachment
- Band Resaw
- Block Cutting Bandsaw

## Handy®

- Econo Frame
- Revolving Frame Clamps
- Louvered Door Assembly
- Frame Clamping
- Case Clamping Machines

*Since the manufacturer continuously strives to improve its products, it reserves the right to make changes and modifications without notice. For illustrative purposes only, some machinery may appear without guards or safety devices.*

**Tyler®**



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