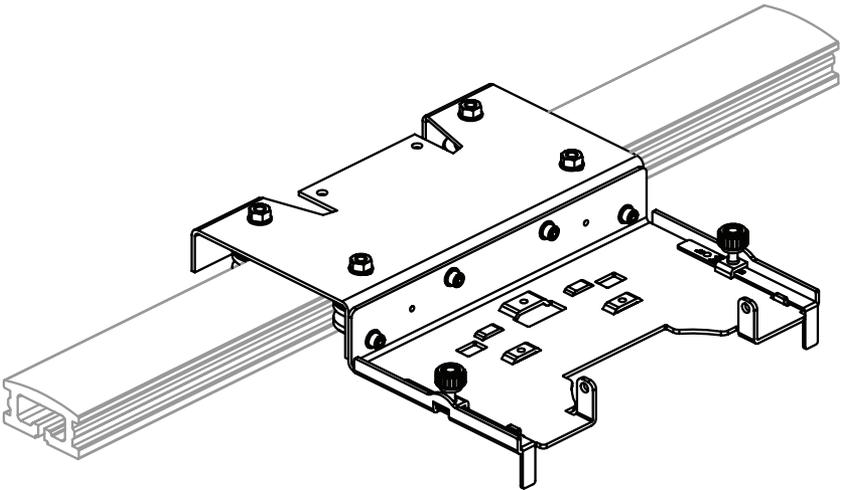


Alpha[®] BAB-CASM Carriage Assembly for the BAB1590 Instruction Manual



Part No: BAB-CASM
Version 1

 **Alpha Professional Tools**[®]

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INTRODUCTION

Thank you for purchasing the Alpha® BAB-CASM for use with the Alpha® Beveling Auxiliary Base. Please read this instruction manual thoroughly to ensure safe and correct usage of the BAB-CASM. Keep this manual in a place where operators can access it easily whenever necessary.

ATTACHING THE BAB1590 TO THE CARRIAGE ASSEMBLY FOR ORIGINAL BAB1590 MODELS (SOLD BEFORE JULY 1, 2018)

1. Insert the carriage assembly to the guide rail. (See Figure 1)

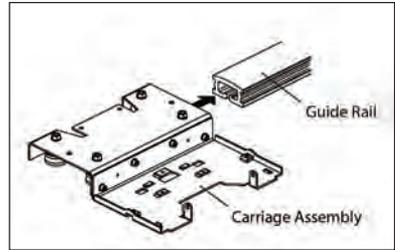


Figure 1

2. Place the BAB1590 on the carriage. (See Figure 2)

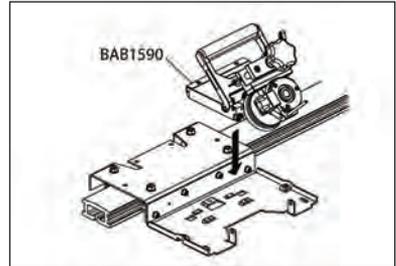


Figure 2

3. Touch the BAB1590 to the tabs to make parallel. (See Figure 3)

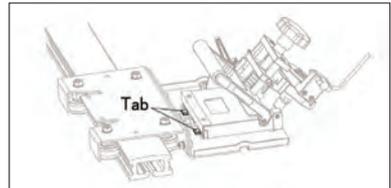


Figure 3

4. Tighten the BAB1590 with the screws that are included in the BAB1590 box. (See Figure 4)

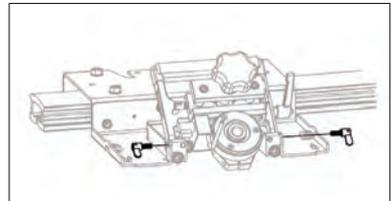


Figure 4

5. Tighten the BAB1590 using the clamping plate & knob bolt. (See Figure 5)

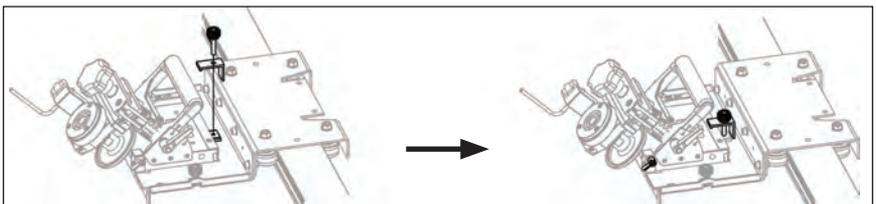


Figure 5

ATTACHING THE BAB1590 TO THE CARRIAGE ASSEMBLY FOR MODIFIED BAB1590 MODELS (SOLD AFTER JULY 1, 2018)

1. Insert the carriage assembly to the guide rail. (See Figure 6)

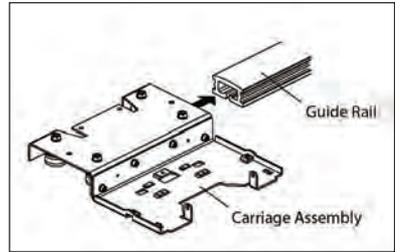


Figure 6

2. Place the BAB1590 on the carriage. (See Figure 7)

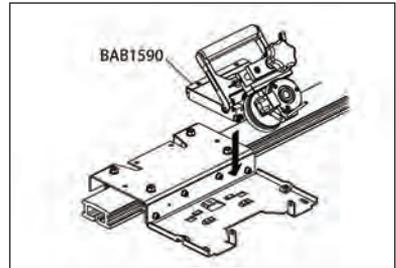


Figure 7

3. Touch the BAB1590 to the tabs to make parallel. (See Figure 8)

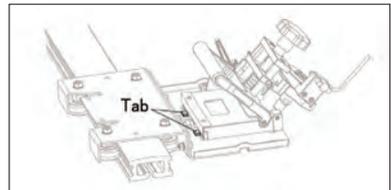


Figure 8

4. Tighten the BAB1590 with the screws that are included in the BAB1590 box. (See Figure 9)

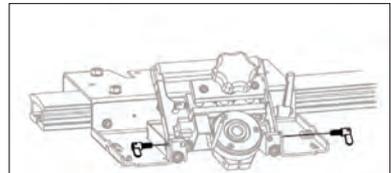


Figure 9

5. Tighten the BAB1590 using the two knob bolts. (See Figure 10)

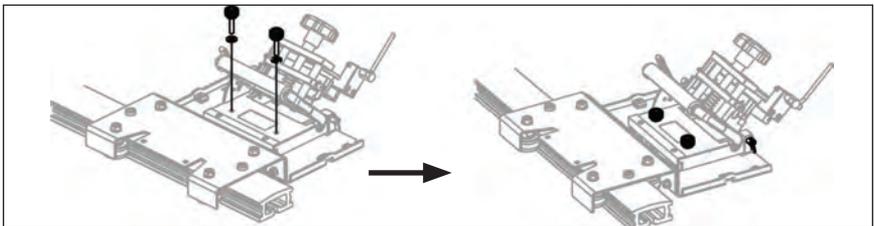
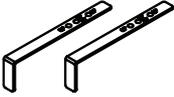


Figure 10

HOW TO USE THE SETTING GAUGE - 15°, 30° & 45° SETUP

Setting Gauge (2 pcs)



1. Insert the setting gauge into the slots on both sides of the carriage base and use the knob bolts to tighten down on the desired notch location of 15°, 30° or 45°

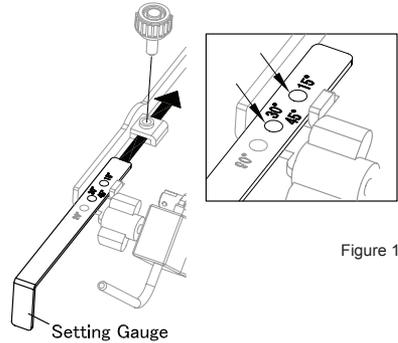


Figure 11

2. Touch both the setting gauges to the edge of the material

*Make sure the grinding or polishing wheel does not touch the material at this time.

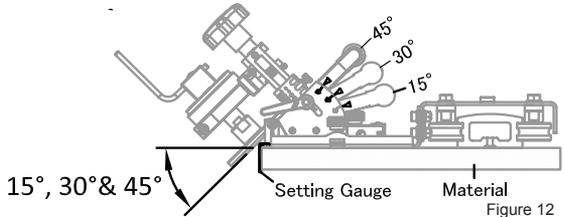


Figure 12

3. Insert the clamps into the grooves on both sides of the guide rail and fully tighten them to the material.

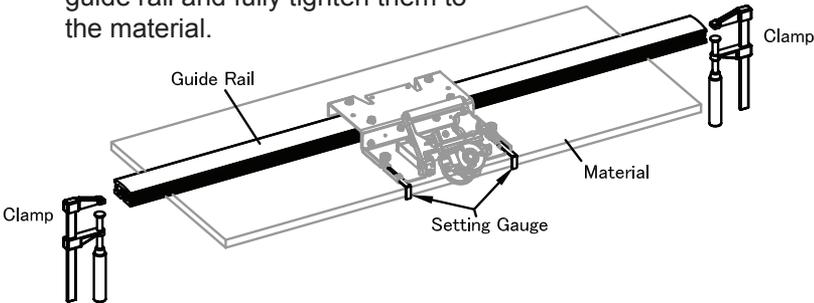


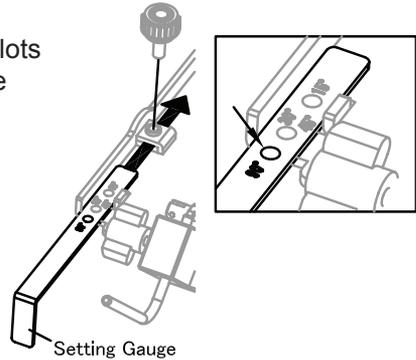
Figure 13

NOTE:

- When using the setting gauges for alignment of the Carriage Assembly, it is recommended to setup in the middle of the material.
- Remove the setting gauges after securing the guide rail and carriage assembly to the material.
- No matter how you use the Alpha® Guide Rail System, there is always a risk of scratching hard surfaces regardless of the materials you are working on. We suggest using the Alpha® Surface Protection Tape (BAB0650) to protect the surface from potential scratches caused by these applications.

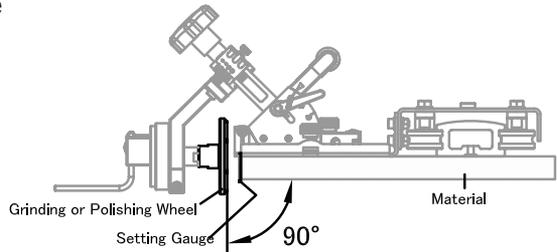
HOW TO USE THE SETTING GAUGE - 90° SETUP

1. Insert the setting gauge into the slots on both sides of the carriage base and use the knob bolts to tighten down on the notch of 90°.

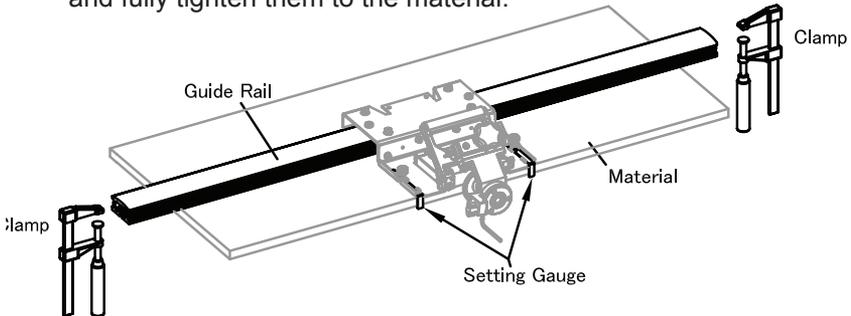


2. Touch both of the setting gauges to the edge of the material.

* Make sure the grinding or polishing wheel does not touch the material at this time.



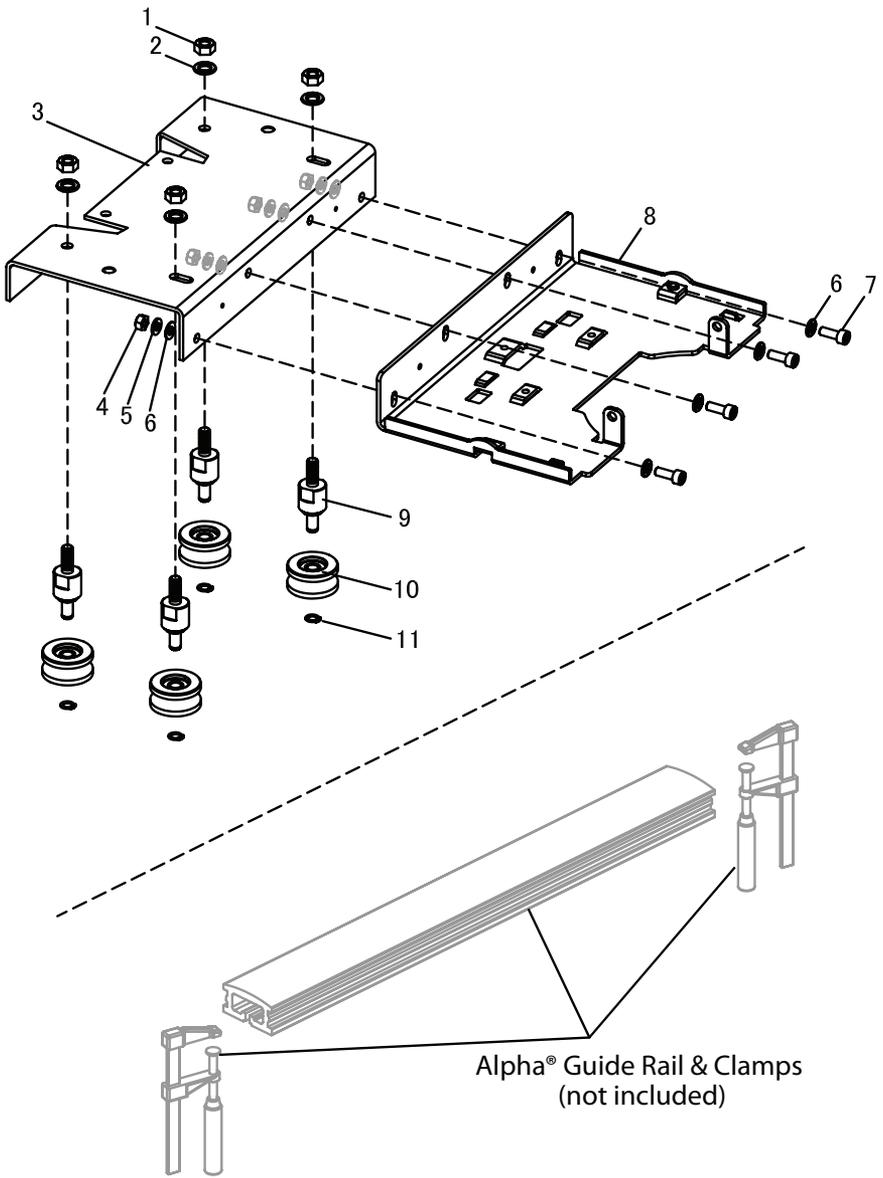
3. Insert the clamps into the grooves on both sides of the guide rail and fully tighten them to the material.



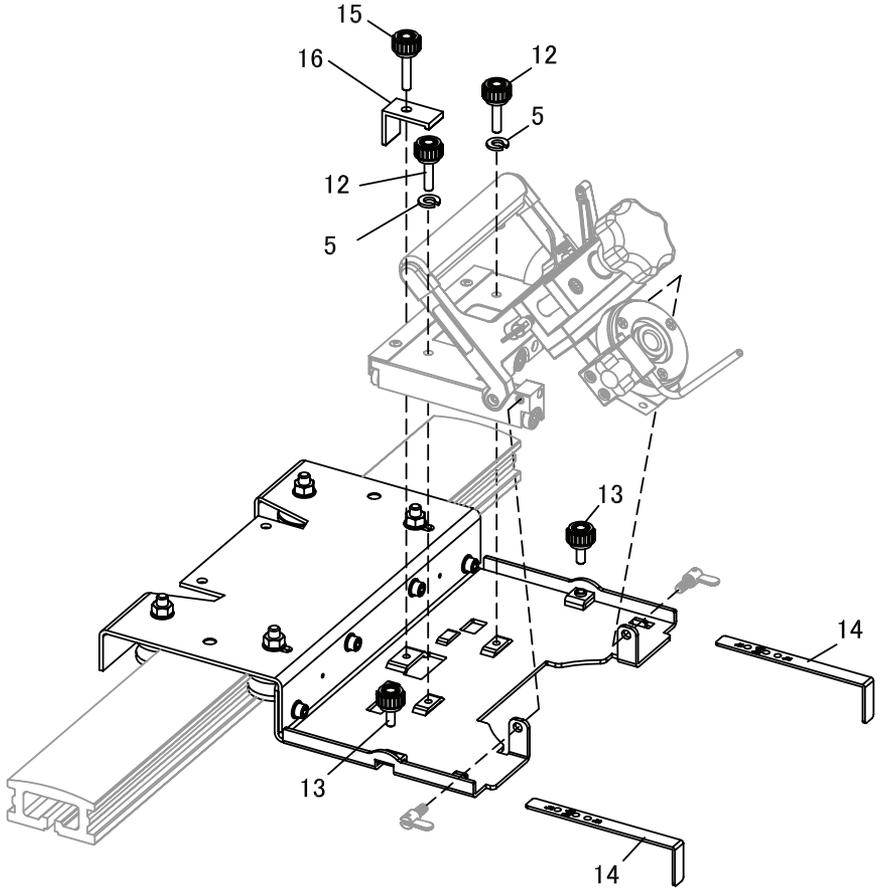
NOTE:

- *When using the setting gauges for alignment of the Carriage Assembly it is recommended to setup in the middle of the material.*
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- *No matter how you use the Alpha® Guide Rail System, there is always a risk of scratching hard surfaces regardless of the materials you are working on. We suggest using the Alpha® Surface Protection Tape (BAB0650) to protect the surface from potential scratches caused by these applications.*

ALPHA® BAB-CASM CARRIAGE BASE SCHEMATIC



ALPHA® BAB-CASM CARRIAGE ASSEMBLY SCHEMATIC



ALPHA® BAB-CASM PARTS LIST

DRAWING NO.	PART NO.	DESCRIPTION	QUANTITY
1	133285	Nut (M8)	4
2	133252	Washer (M8)	4
3	500089	Guide Rail Carriage	1
4	803138	Nut (M6)	4
5	133072	Spring Lock Washer (M6)	6
6	133071	Washer (M6)	8
7	133251	Cap Screw (M6*16)	4
8	500090	Carriage Base for BAB1590	1
9	133434	Rail Wheel Axle	4
10	133239	Rail Wheel Assembly	4
11	133051	Retaining Ring-C (8)	4
12	500094	Knob Bolt (M6x25)	2
13	500095	Knob Bolt (M6x15)	2
14	500096	Setting Gauge	2
15	500092	Knob Bolt (M6x30)	1
16	500093	Clamping Plate	1



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