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DRO FlipStop Instructions

Congratulations on the purchase of your new DRO FlipStop. This document will help you install it properly and guide you on the usage of your new Cross Cut Fence stop. Please read the instructions fully before starting to install the unit. If you have any questions, please feel free to call us at 602-349-8292, or email us through the website.

Unboxing

Your FlipStop will be shipped in a cardboard box with foam blocking and peanuts to protect it from damage. Remove the top pieces of foam, then lift out the stop assembly and discard/ recycle the peanuts, careful to keep the two plastic installation shims and Fiama instruction booklet. Under the lower two layers of rigid foam you will find a shallow box containing the magnetic banding and cover strip.

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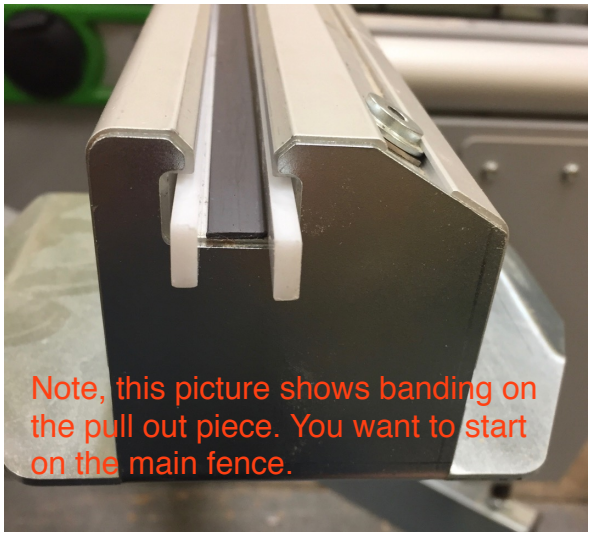
Installing the Magnetic Banding

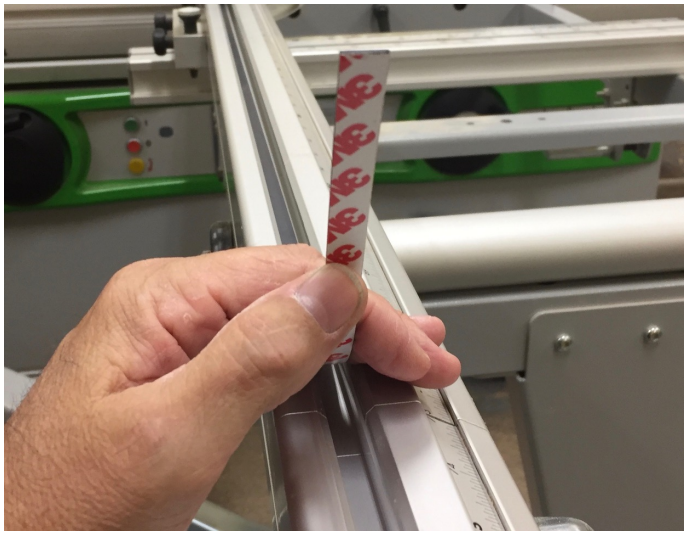
The magnetic banding and cover strip have adhesive strips on the back to attach the banding into the T-slot on top of your slider extrusion. Carefully unroll the banding and separate it from the cover strip, using caution to not kink or damage the cover strip. The DRO FlipStop will work on the main portion of your Crosscut fence, you will use the extension portion as you did before with the stock Felder flip stop, the Digital Readout will only be on the portion up to the length of the main Fence section.

Measure the length of your Fence extrusion, not including the extension portion of the fence. Cut your magnetic band about 1” short using tin snips. Clean the t-slot thoroughly removing all saw dust and wipe with some alcohol on a paper towel for best adhesion. Lay the two white plastic strips into the “T” portion of the T-slot on the fence extrusion. Alternately you can cut wood shims 3/16” thick by 3/8” tall as long as you want, to fill the slot also. Also examine and clean the top surface of the magnetic banding, we have seen some loose particles from manufacturing get stuck magnetically to the top surface, remove those with you finger or very carefully with a knife point or razor blade.

Roughly lay out and position the banding into the slot and with it being centered by the shims, lift it up and peel back about 12” of the paper on the back, start at the outboard end of the fence, about 1/4” from the end of the main fence extrusion ***(do not put banding on pull out piece)*** and start sticking it down, say 6-8” worth. Slide the shims further down the extrusion, peel back another foot of the paper and stick that section down. Continue to work the length of the fence until all the banding is stuck down. Use a smooth piece of wood that will fit into the slot to push firmly down on the banding to make sure it is well adhered.

Now for the cover strip, cut it slightly longer than the banding, about 1/4”-5/16”, then using a pair of pliers, bend down the last slightly less than 1/8” on each end to about 30º, this leaves a nice finished edge at each end. Repeat the process of sticking down the cover strip just as you did with the banding using the shims as you proceed. This completes the install of the banding.





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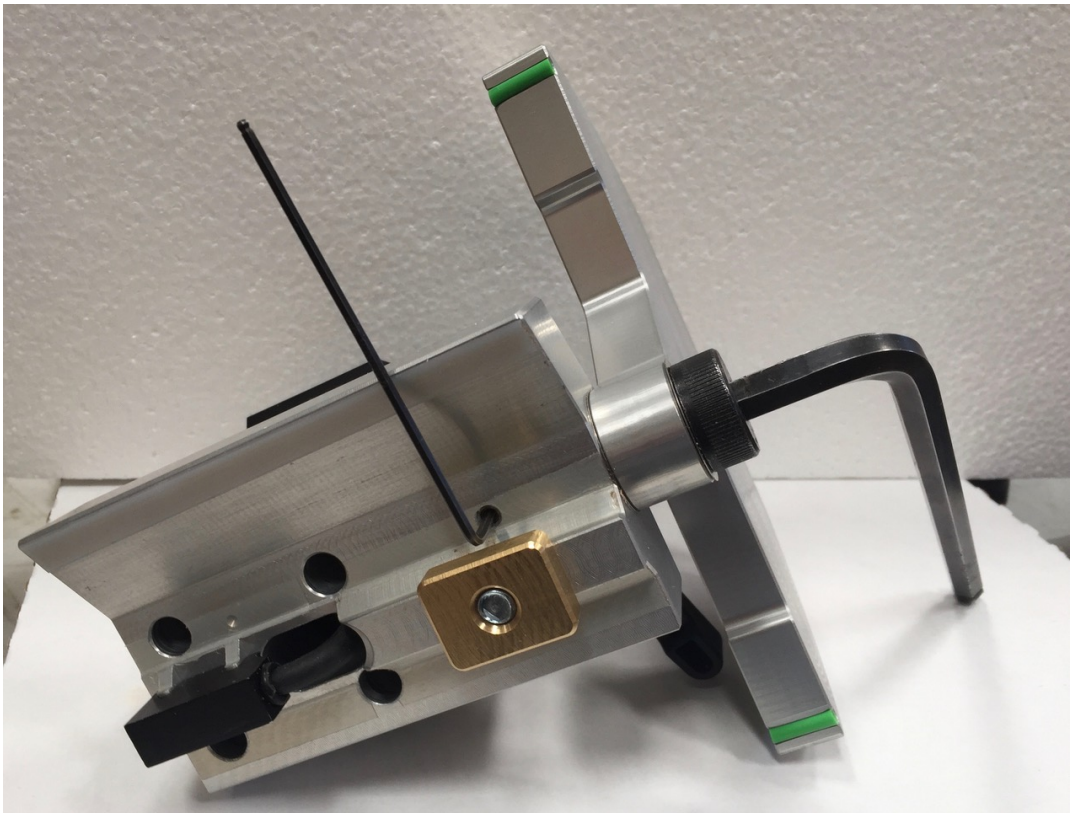
Install the FlipStop

Loosen the Kip lever a turn or two so the brass nut on the bottom will swivel. Slide the nut into the t-slot, allow the FlipStop to slide into the slot on top of the fence extrusion. You will need to adjust the angle of the Kipp lever so that it faces either front or back when tight, so it clears the actual stop blade. A tip for getting the angle of the Kipp lever, align the brass nut in the direction it will go into the slot, tighten the kip lever and set it at the 3 o'clock position. Loosen the lever 120º CCW and slide the nut into the t-slot. The lever should lock the FlipStop into the t-slot at about the 12 o'clock position now, adjust if necessary.

The FlipStop rides on layers of UHMW film adhered to the bottom side and angled surfaces, so it should slide very smoothly back and forth on the fence. We have noticed if clamped in place for extended periods, you might have to "break it loose" by gently tipping it front to back at the top, then it will slide as it should.

The stop blade is adjusted to have some tension to prevent it from being sloppy and yet not so tight that you can't swivel it up and down. If this changes or you want a different tension, loosen the brass set screw on the bottom, and ever so slightly adjust the pivot bolt with a 5/16" hex wrench. Re-tighten the brass set screw and you are done.



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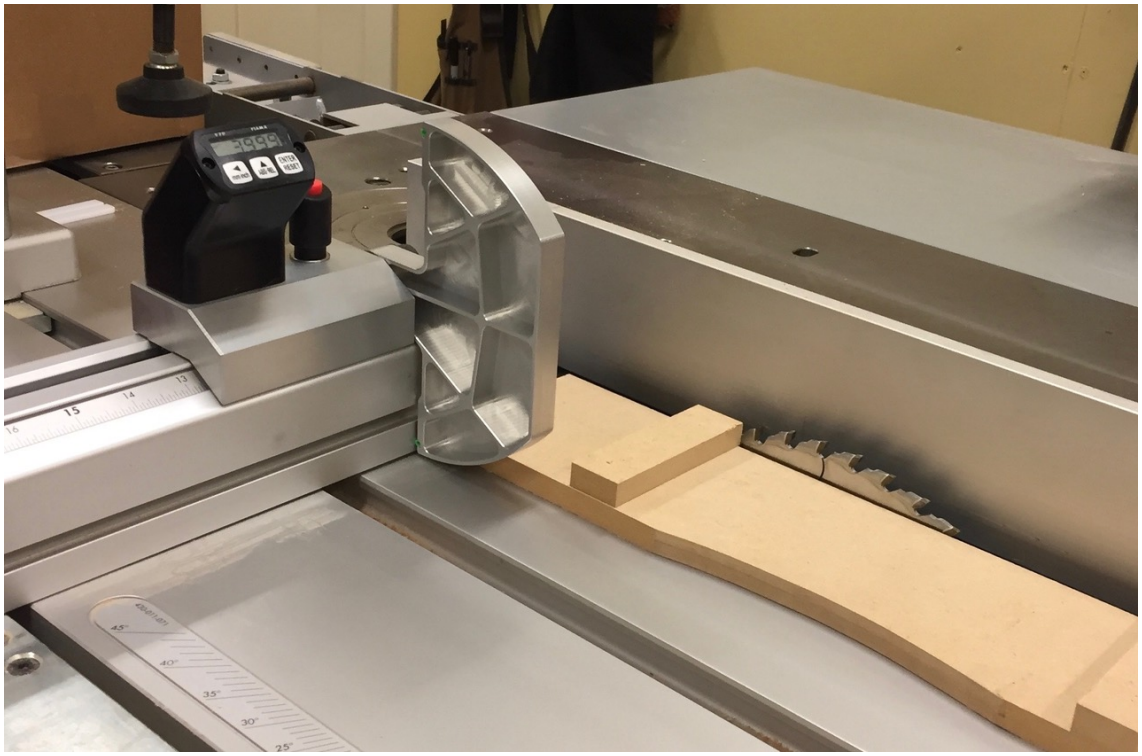
Calibrating the DRO

The Fiama DRO unit has numerous ways of being programmed. It will come set to a default of .01mm or .001" resolution, and when zeroing to the blade or cutter, a 4" offset will be applied. So the best process is to have a "Setting Piece" of wood that measures exactly 4" in width and long enough to span your largest blades, say 12" or so. Place the piece of wood gently against the raised blade in contact with multiple teeth, so as not to flex the blade, then bring your FlipStop into contact with the wood and then push the "Enter/Reset" button and hold down for approximately 3-4 seconds and it will zero out the display to read 4.000 (101.6mm). If you work in metric, the offset amount parameter can be changed to 100mm or whatever spacer width is convenient for you.

That's it! Ready to go! You can use imperial or metric at the push of a button, Absolute, means the distance from the blade/zero position, Incremental can be used if you make one cut and then want to move a specific amount, go into Incremental, push the Enter button once (and do not hold or you will reset the zero) and the display should read zero, move your increment, say 1" plus the blade kerf of .125" and you can make another cut yielding a 1" piece, re-zero and do again. Pushing the ABS-REL button again will return the display to absolute with no loss of position in relation to the blade.

Using a calibrated piece of wood between the stop and the cutting edge will allow you to set the FlipStop to either the blade, a shaper cutter or whatever else you might need. If you find yourself needing a longer set up piece, you can change the parameter in the unit accordingly, say 10" instead of 4" if you want to set to a cutting edge of a shaper cutter frequently.



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The Fiama manual is included and covers changing parameters to do just about anything you would like.There is also a youtube video showing how to set the unit, https://www.youtube.com/watch?v=8ZWIXSv_Zig . The batteries are available on Amazon, ***1/2AA 3.6V Lithium Battery, stock unit is a Tadiran SL-750 ZDBF***, and they last approximately 4 years, and the unit **does NOT power off**, so just use it until you get a battery warning and then order a battery, or keep one on hand when it gets close. The Fiama components are warranted for a period of one year.

Default Parameter Settings

The current parameter settings for the Fiama DRO are listed below with explanations of what they do. More details and options are available in the manual supplied.

1. Hold the up arrow (ABS-REL) button until the display reads PASS, then hit the Enter button twice, the display will read 000, with the right digit blinking. Push the up arrow three times to change the right digit to 3, push the left arrow one time to advance to the digit to the left and use the up arrow to change it to 7, again one digit to the left and up arrow to 2, when the display reads 273 hit Enter and you will now be in programming mode.

2. Skip the ulS parameter by hitting the up arrow once.

3. ndEC should be showing, hit Enter, change it using the up arrow to 2, then hit enter.

4. tASt should be showing, hit Enter, first digit on right should be flashing, up arrow until it reads 8, then left arrow to center digit, up arrow until it reads 1, left arrow to left digit and change it to 1, Screen should read 118, hit Enter.

5. PrSt should be showing, this is your offset amount, hit Enter, then starting on the right digit, enter your offset value in millimeters, i.e. 4” is your desired amount, enter 101.60 (value needs to be in mm) into the value using your up arrows and shifting to the left for the correct column. Once the display reads your offset amount, hit Enter.

6. dlr should be showing, hit enter, using the up arrow button set it to 0, then Enter.

7. You can now hit the left arrow key and it will exit the programming mode, or just let it sit for 20-30 seconds and it will automatically exit.

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That should complete the setting of the DRO. In explanation, the u15 parameter relates to the frequency of the poles on the magnetic band. The ndEC is the decimal places to the right, so with 2 selected, you get .00 for mm and .000 for imperial. The tASt dictates the actions of the buttons, the left arrow is mm/inch, up arrow is abs/rel and the Enter button is delayed preset (after 3 seconds). The PrSt is the preset amount that the DRO will read when the Enter button is held down for over 3 seconds. The dIr is the parameter to set which direction causes the display to ascend, moving left, or moving right.

If you have any further questions, read the Fiama Manual, or feel free to contact us, using the contact us portion of our website, www.lambtoolworks.com