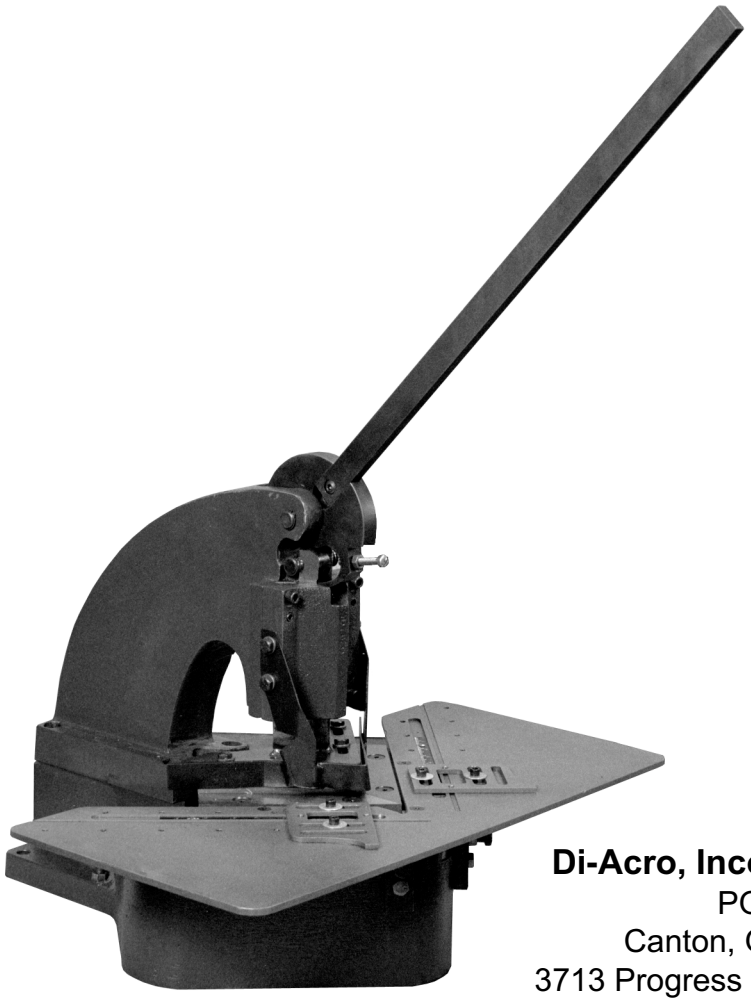
OPERATOR'S MANUAL & INSTRUCTIONS

NUMBER 2 Di-Acro Hand Tab Notcher



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CAUTION

TO PREVENT SERIOUS BODILY INJURY AND DAMAGE TO THE MACHINE

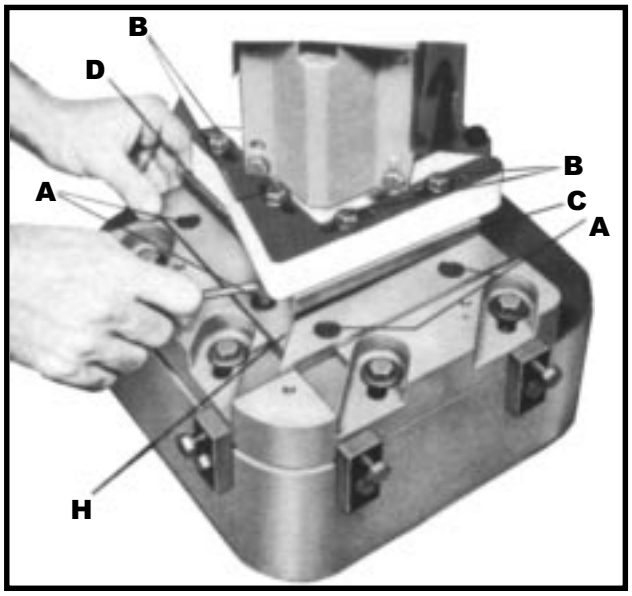
BOLT THE MACHINE TO THE STAND AND THE STAND TO THE FLOOR

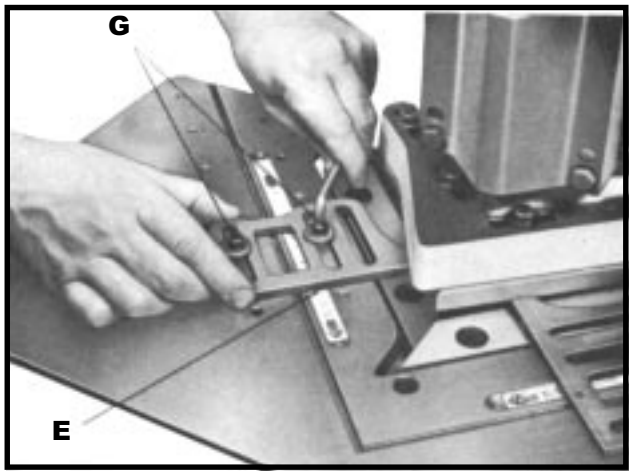
SETUP

A. Changing size of tab

1. Loosen bolts (A) holding lower blade to blade carrier (DO NOT REMOVE)
2. Slide blades forward or back, holding them against shoulder machined in blade carrier to obtain desired tab
3. Tighten bolts (A)
4. Loosen bolts (B)
5. Lower ram until upper blades pass by lower blades (it may be necessary to slide one upper blade back)
6. Slide blade (C) forward into notch in lower blade. Tighten bolts.
7. Slide blade (D) forward until it contacts blade (C). Tighten bolts.

(Note: A slight opening at (H) is normal to insure contact at cutting edge)





B. Setting size of notch

1. Loosen screws (G) and set to required notch depth, reading scale along edge (E).

Note: Scale is set to read from the edge of the notch so tab size must be subtracted to obtain a corner notch of equal depth.

2. To notch along the side of a sheet remove gauges and turn them upside down. Screws will fit in outside slot when gauges are set parallel to each other.

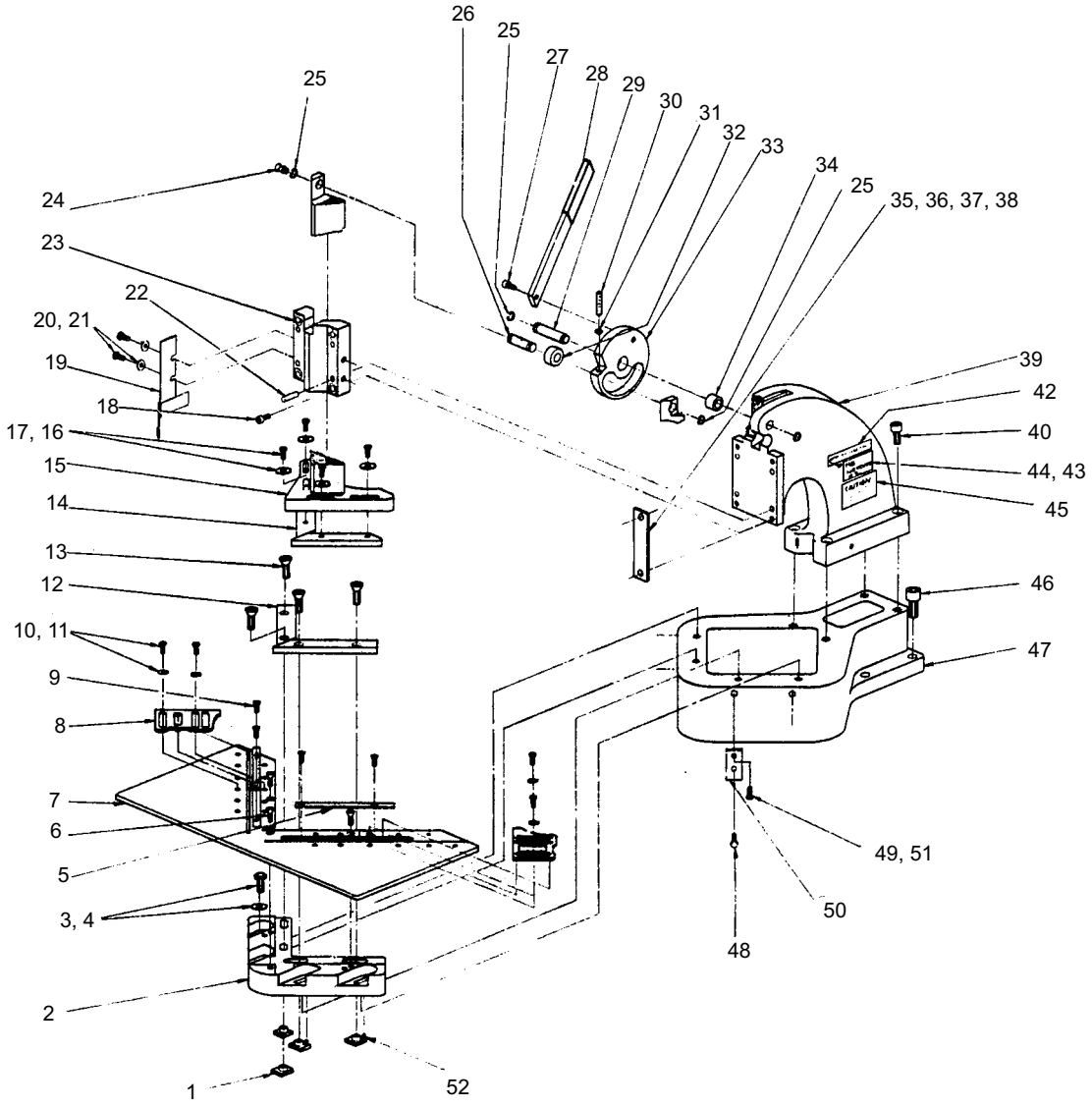
C. Shearing long strips full width

1. Remove lower left blade and adjust right blade to maximum tab size.

D. Setting depth of stroke

1. Adjust screw on cam until upper blade passes slightly by lower blade at bottom of stroke.

#2 NOTCHER PARTS



SPECIFICATIONS

	No. 2	
Model	**in.**	**mm**
Max. 90° notch	6 x 6*	152 x 152
Max. Tab	1	25.4
Max. Material Cap., mild steel	16 ga.	1.5
Tonnage	4	3.6
Stroke of Ram	5/8	16.9
Shipping Weight	265 lbs.	120 kg.
Stand, Shipping Weight	70 lbs.	32 kg.

*one operation

#2 NOTCHER PARTS

ITEM	DESCRIPTION	PART NUMBER	QTY
1	T-NUT	8905350-000	4
2	BLADE CARRIER	8031110-101	1
3	SCREW	21A0308C1102	4
4	WASHER	61X0308C1332	4
5	RULE	8031160-101	2
6	SCREW	20C0104F0102	3
7	TABLE	8000110-501	1
8	PROTRACTOR GAUGE	8031140-571	2
9	SCREW	22FXX060108	4
10	SCREW	20A0104F0508	4
11	WASHER		4
12	LOWER BLADE	8031120-901	2
13	SCREW	20C0516C2000	4
14	UPPER BLADE	8031120-900	2
15	RAM ASSEMBLY	8031121-300	1
16	SCREW	21A0516C1102	4
17	WASHER	61X0516	4
18	SCREW	20A0516C1102	4
19	GUARD ASSEMBLY	8031110-609	1
20	SCREW	21A0516C0102	4
21	WASHER	61X0308-0104	4
22	PIN	18A0516X1102	4
23	CAP	8040110-800	1
24	DRIVE FITTING	8690100-200	1
25	RETAINER RING	8470510-100	4
26	CAM ROLLER PIN	8060120-300	1
27	SCREW	20B0516C0508	1
28	LONG HANDLE ARM	8030120-800	1
29	CAM PIN	8030120-302	1
30	SCREW	23C0516C2000	1
31	NUT	31X0516C	1
32	ROLLER	8156111-300	1
33	CAM	8030120-200	1
34	BEARING	8310410-100	1
35	SHIM	8030570-101	2
36	SHIM	8930570-101	2
37	SHIM	8940570-101	1
38	SHIM	8030570-102	1
39	UPPER CASTING	8040110-200	1
40	SCREW	20A0102C1304	4
41	SCREW	20A0516C1102	1
42	INSTRUCTION PLATE	8030650-310	1
44	NAME PLATE	031-6501110	1
45	CAUTION PLATE	8030650-300	1
46	SCREW	21A0102C1304	4
47	BASE	8031110-100	1
48	SCREW	21A0308C1000	4
49	JAM NUT	31X0102C	4
50	BACKUP PLATE	031-1105011	4
51	SCREW	21A0308C1104	4
52	PIN	8120313-600	4

LUBRICATION

A. Lubricate cam roller and ram occasionally with a few drops of heavy machine oil.

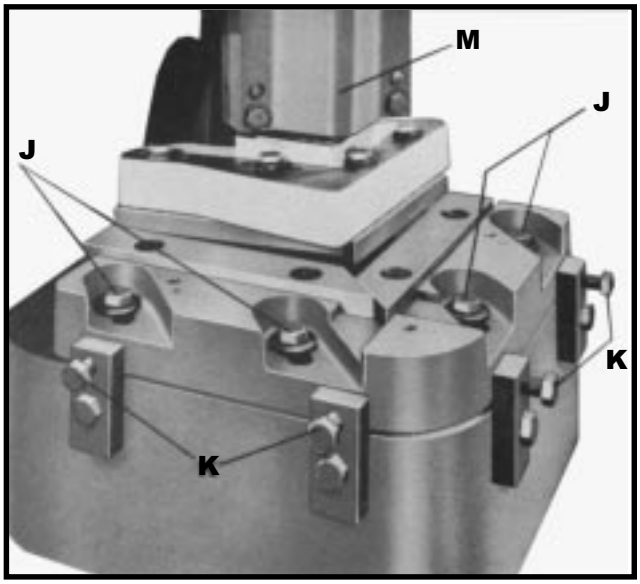
MAINTENANCE

A. Sharpening blades

1. Blades have two cutting edges. A new cutting edge is obtained by changing right blade to left side and visa versa.
2. If only a slight amount of sharpening is required, grind wide edge only, as this will eliminate necessity of resetting clearance.
3. When grinding ends be sure to maintain angle presently on blade.
4. Reset scale to zero, lining up zero on scale with straight edge along blade cutting edge.

B. Adjusting blade clearance

1. Remove table
2. Loosen blade mounting bolts A and B
3. Loosen blade carrier bolts (J)
4. Adjust lower blades to required tab (per instructions, A "changing size of tab", 1,2,3)
5. Set upper blades for no tab or a tab smaller than set in lower blades



6. Back off screws (K) and pull blade carrier away from top blade
7. Move ram to bottom of stroke
8. Turn in screws (K) by hand pushing blade in until it contacts upper blade. Placing a shim or piece of paper between blades will provide clearance to prevent rubbing of blades. Too much clearance will cause a burr on workpiece. Excessive rubbing of blade will reduce blade life.
9. Tighten bolts (J)
10. Set upper blade to tab notch in lower blade and tighten

C. Adjusting ram clearance

1. Remove ram cap (M) and remove a shim from both sides. Color of shim indicates the thickness: Purple .0015; Red .002; Green .003; Blue .005.
2. Replace cap