# NUMBER 2 Di-Acro Hand Tab Notcher







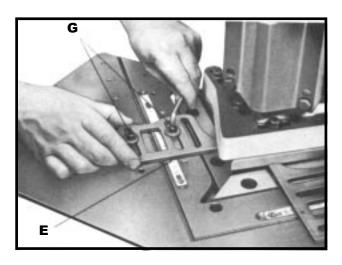
# **CAUTION**

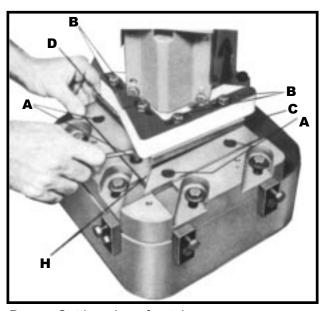
TO PREVENT SERIOUS BODILY INJURY AND DAMAGE TO THE MACHINE

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)





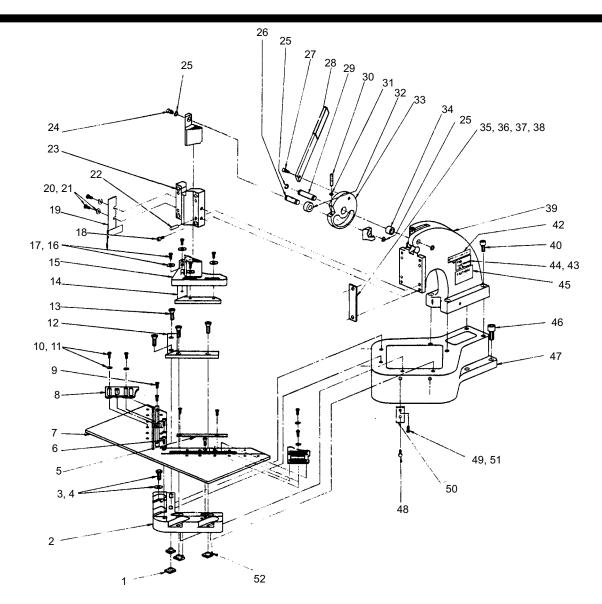
- B. Setting size of notch
  - 1. Loosen screws (G) and set to required notch depth, reading scale along edge (E).

**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.

<sup>\*</sup>one operation



## **#2 NOTCHER PARTS**

1	ITEM	DESCRIPTION	PART NUMBER	QTY
BLADE CARRIER   B031110-101   1   1   3   SCREW   21A0398C1102   4   4   WASHER   B031180-101   2   4   61X0398C1332   4   61X0398C1304   6   61X0398C1304   6   61X0398C1304   6   61X0398C1304   6   6   6   6   6   6   6   6   6	1	T-NUT	8905350-000	4
3   SCREW				1 1
4				4
5         RULE         8031160-101         2           6         SCREW         2C01044F0102         3           7         TABLE         8000110-501         1           8         PROTRACTOR GAUGE         8001110-571         2           9         SCREW         22FXX060108         4           10         SCREW         20A0104F0508         4           11         WASHER         4         20A0104F0508         4           12         LOWER BLADE         8031120-901         2         2           13         SCREW         20C0516C2000         4         4           14         UPPER BLADE         8031120-900         2         2           15         RAM ASSEMBLY         8031120-900         2         2           16         SCREW         21A0516C1102         4         4           17         WASHER         61X0516         4         5         4           18         SCREW         20A0516C1102         4         4         4         4         4         4         4         4         4         4         4         4         4         4         4         4         4         4 <td< td=""><td></td><td></td><td></td><td>4</td></td<>				4
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         4           12         LOWER BLADE         8031120-901         2           13         SCREW         20C0516C2000         4           14         UPPER BLADE         8031120-901         2           15         RAM ASSEMBLY         8031121-300         1           16         SCREW         21A0516C1102         4           17         WASHER         61X0516         4           18         SCREW         20A0516C1102         4           20         SCREW         21A0516C0102         4           21         WASHER         61X0308-0104         4           22         PIN         18A0516X1102         4           23         CAP         8040110-800         1           24         DRIVE FITTING         8699100-200         1           25				
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         8031120-900         2           16         SCREW         21A0516C1102         4           17         WASHER         61X0516         4           18         SCREW         20A0516C1102         4           19         GUARD ASSEMBLY         8031110-609         1           20         SCREW         21A0516C0102         4           19         GUARD ASSEMBLY         8031110-609         1           20         SCREW         21A0516C0102         4           21         WASHER         61X0308-0104         4           22         PIN         18A0516K1102         4           24         DR		SCREW	20C0104F0102	
8         PROTRACTOR GAUGE         8031140-571         2           9         SCREW         22FXX060108         4           10         SCREW         20A0104F9508         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         <		TABLE		
9		PROTRACTOR GAUGE	8031140-571	2
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           21         WASHER         61X0308-0104         4           21         WASHER         61X0308-0104         4           22         PIN         18A0516X1102         4           23         CAP         8040110-800         1           24         DRIVE FITTING         8690100-200         1           25         RETAINER RING         8690100-200         1           26         CA		SCREW		
11				
12		WASHER		
13			8031120-901	
14		SCREW	20C0516C2000	
15		UPPER BLADE		
16         SCREW         21AD516C1102         4           17         WASHER         61X0516         4           18         SCREW         20A0516C1102         4           19         GUARD ASSEMBLY         8031110-609         1           20         SCREW         21A0516C0102         4           21         WASHER         61X0308-0104         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 <t< td=""><td></td><td></td><td></td><td></td></t<>				
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         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       8030120-300       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       810410-100       1         35       SHIM		SCREW	21A0516C1102	
99 GUARD ASSEMBLY 8031110-609 1 200 SCREW 21A0516C0102 4 21 WASHER 61X0308-0104 4 22 PIN 18A0516X1102 4 23 CAP 8040110-800 1 24 DRIVE FITTING 86901-200 1 25 RETAINER RING 8470510-100 4 26 CAM ROLLER PIN 8060120-300 1 27 SCREW 2010-800 1 28 LONG HANDLE ARM 8030120-800 1 29 CAM PIN 8030120-800 1 30 SCREW 23C0516C2000 1 31 NUT 31X0516C 1 32 ROLLER 8156111-300 1 33 CAM 803102-200 1 34 BEARING 8310410-100 1 35 SHIM 8030570-101 2 36 SHIM 8030570-101 2 37 SHIM 8030570-101 2 38 SHIM 8030570-101 1 38 SHIM 8030570-101 1 39 UPPER CASTING 8040570-102 1 39 UPPER CASTING 8040110-200 1 40 SCREW 20A0516C100 1 41 SCREW 20A0516C100 1 42 INSTRUCTION PLATE 8030650-300 1 45 CAUTION PLATE 8030650-300 1 46 SCREW 21A0308C1000 4 47 BASE 8031110-100 1 48 SCREW 21A0308C1000 4 49 JAM NUT 31X0102C 4 40 JAM NUT 31X0102C 4 41 SCREW 21A0308C1104 4		WASHER		4
19   GUARD ASSEMBLY   8031110-609   1   20   SCREW   21A0516C0102   4   4   4   4   4   4   22   PIN   18A0516X1102   4   4   22   PIN   18A0516X1102   4   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   8030120-800   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   8940570-101   2   37   SHIM   8940570-101   2   37   SHIM   8940570-102   1   38   SHIM   8030570-102   1   38   SHIM   8030570-102   1   39   UPPER CASTING   8040110-200   1   40   SCREW   20A0516C1102   1   41   SCREW   20A0516C1102   1   42   INSTRUCTION PLATE   8030650-300   1   45   CAUTION PLATE   8030650-300   1   46   SCREW   21A0102C1304   4   47   BASE   8031110-100   4   4   48   SCREW   21A0102C1304   4   47   BASE   8031110-100   4   4   49   JAM NUT   31X0102C   4   49   JAM NUT   31X0102C   4   40   5CREW   21A0308C1000   4   49   JAM NUT   31X0102C   4   50   BACKUP PLATE   21A0308C1104   4   50   CREW   21A				4
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         8030120-800         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         8930570-101         2           36         SHIM         8930570-101         2           37         SHIM         8940570-101         1           39				1 1
21       WASHER       61X0308-0104       4         22       PIN       18A0516X1102       4         23       CAP       8040110-8000       1         24       DRIVE FITTING       8690100-200       1         25       RETAINER RING       8470510-100       4         26       CAM ROLLER PIN       8060120-300       1         27       SCREW       2080516C0508       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       8930570-101       2         36       SHIM       8930570-101       2         37       SHIM       8930570-101       1         39       UPPER CASTING       8040110-200       1         40       SCREW       20A0102C1304       4         41       SCREW       <				
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         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         8940570-102         1           40				
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         8030570-101         2           37         SHIM         8930570-101         1           38         SHIM         8030570-102         1           39         UPPER CASTING         8040110-200         1           40         SCREW         20A0102C1304         4           41 <td></td> <td></td> <td></td> <td></td>				
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				
25 RETAINER RING 26 CAM ROLLER PIN 27 SCREW 20B0516C0508 1 28 LONG HANDLE ARM 29 CAM PIN 30 SCREW 23C0516C2000 1 31 NUT 31 XN0516C 1 32 ROLLER 33 CAM 34 BEARING 35 SHIM 35 SHIM 36 SHIM 37 SHIM 38 SHIM 38 SHIM 38 SHIM 38 SHIM 39 UPPER CASTING 40 SCREW 41 SCREW 42 A040516C1102 44 NAME PLATE 45 CAUTION PLATE 48 SCREW 49 JAM NUT 40 SCREW 40 SCREW 41 SCREW 41 SCREW 42 LA0308C1100 44 SCREW 45 BACKUP PLATE 50 BACKUP PLATE 50 BACKUP PLATE 50 BACKUP PLATE 51 SCREW 41 SCREW 42 LA0308C1104 44 SCREW 45 SCREW 46 SCREW 47 BASE 46 SCREW 49 JAM NUT 51 SCREW 41 SCREW 42 LA0308C1104 44 SCREW 45 DATE 140308C1104 45 SCREW 46 SCREW 47 BASE 48 SCREW 49 JAM NUT 50 BACKUP PLATE 50 BACKUP PLATE 51 SCREW 41 SCREW 42 LA0308C1104				
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         39       UPPER CASTING       8040110-200       1         40       SCREW       20A0102C1304       4         41       SCREW       20A012C1304       4         41       SCREW       20A0516C1102       1         44       NAME PLATE       8030650-310       1         45       CAUTION PLATE       8030650-300       1         46       SCREW       21A0102C1304       4         47       BASE <td< td=""><td></td><td></td><td></td><td></td></td<>				
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       8130410-100       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       20A0102C1304       4         41       SCREW       20A0516C1102       1         44       NAME PLATE       8030650-300       1         45       CAUTION PLATE       8030650-300       1         46       SCREW       21A0102C1304       4         47       BASE       8031110-				
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         8930570-102         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         21A0308C1000         4           49				
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       20A0102C1304       4         41       NAME 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 <td></td> <td></td> <td></td> <td></td>				
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				I
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       21A0				
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				
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				
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				
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				
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				
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				
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				
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				· ·
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				
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				
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				
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				· ·
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				· ·
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				
47       BASE       8031110-100       1         48       SCREW       21A0308C1000       4         49       JAM NUT       31X0102C       4         50       BACKUP PLATE       031-1105011       4         51       SCREW       21A0308C1104       4				
48       SCREW       21A0308C1000       4         49       JAM NUT       31X0102C       4         50       BACKUP PLATE       031-1105011       4         51       SCREW       21A0308C1104       4				
49       JAM NUT       31X0102C       4         50       BACKUP PLATE       031-1105011       4         51       SCREW       21A0308C1104       4				· ·
50 BACKUP PLATE 031-1105011 4 51 SCREW 21A0308C1104 4				
51 SCREW 21A0308C1104 4				•
			3.2370 000	· .

### **#2 NOTCHER**



### LUBRICATION

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

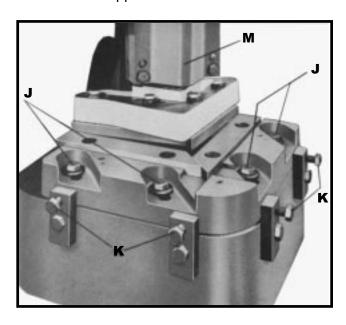
### **MAINTENANCE**

### 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",
- 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)
- 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