

[®]
Di-Acro

OPERATOR'S MANUAL & INSTRUCTIONS

NUMBER 2

Di-Acro

Hand-Operated

Rod Parter



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MANUAL PARTER

Standard Equipment

Short handle for “parting-off” light material and long handle for “parting-off” heavier material
Ejectomatic Gauge
Set of cutting heads for “parting-off” round cold rolled bar stock

Rod Parter Accessories

Cutting head for “parting-off” square, rectangular, hexagon and other special shaped bar stock. Available on special quotation.

Construction Features

On the No. 2, there are nine holes in the cutting heads from 1/8” to 1/2” diameter graduated in steps of 1/16” (all holes are approximately .005 inch oversize). Cutting heads of heavy alloy tool steel, properly hardened and precision ground, assure a high degree of accuracy and are reversible to offer double service. They are easily removed for re-sharpening and can be quickly reinstalled. Three heavy duty bronze bearings in the multiple leverage system provide extreme ease of operation and long, trouble-free performance.

OPERATING INSTRUCTIONS

SET UP PROCEDURE

Hand Operated Rod Parter

The hand operated Di-Acro Rod Parter is shipped with the Handle and Material Gauge removed. To setup for operation:

1. Bolt Rod Parter to stand or bench and attach handle to handle holder.
2. Install gauge rod to base and attach Ejectomatic Gauge as follows:
 - A. Set Gauge Arm so bolt lines up with Pivot Bolt of Rod Parter, then adjust gauge for desired hole and length of piece. Only the lower portion of the rod should contact gauge.

Lubrication

To insure smooth, effortless operation, lubricate the hand Rod Parter periodically in the following places:

Hand Model

Grease fitting on Center Stud Bolt, N.G.L.I. No. 2 grease

Removing and Sharpening Cutting Heads

The Cutting Heads on the Rod Parter are designed so that their positions can be reversed to give extra cutting service before sharpening. To do this, turn Cutting Heads around so that the outside sections are back to back.

To Remove Cutting Heads

1. Remove Center Pivot Bolt, Link Bolt and disengage Upper Casting.
2. Remove socket head screws in both the Upper and Base Casting, and tap out Cutting Heads.

To Sharpen Cutting Heads

Grind them approximately .002” to .005” on a surface grinder or return them to factory for this service.

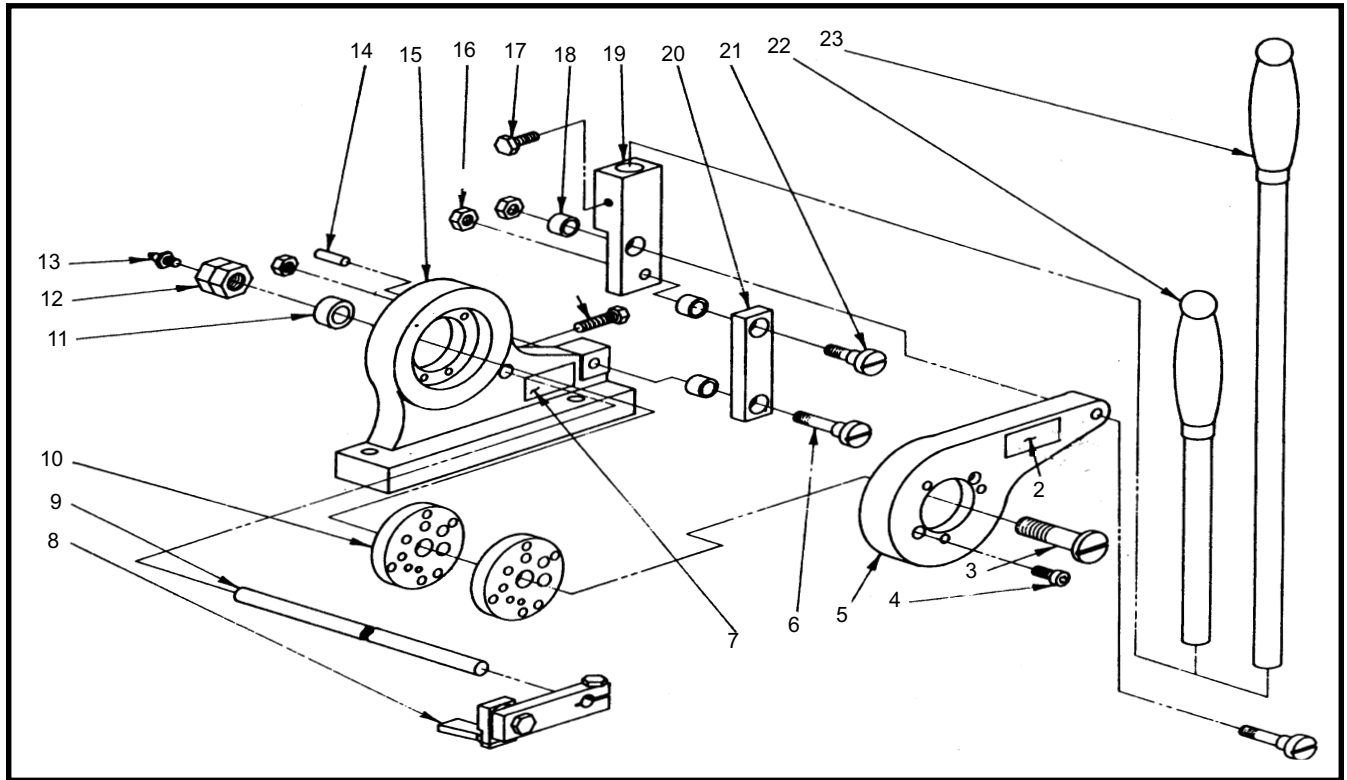
Safe operation of the Di-Acro Rod Parter must be considered as a matter of prime importance by the management as well as the operator.

Ejectomatic Gauge

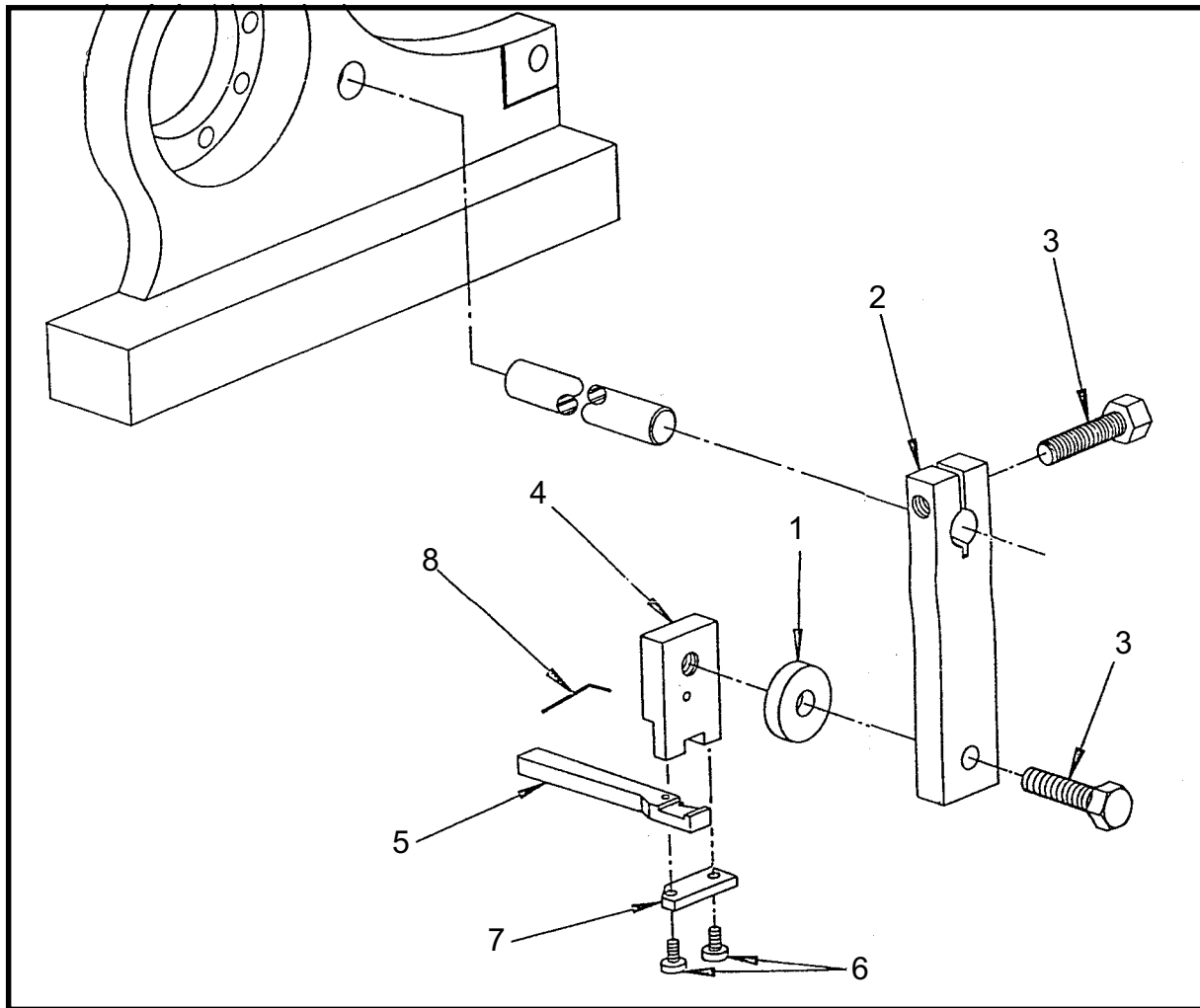
Greatly increases production output as it allows the three separate operations of gauging, parting and ejecting to be obtained in a single working cycle.

The Ejectomatic Gauge is especially valuable when cutting lengths under six inches but is equally as useful “parting” stock of longer lengths. It is supplied as standard equipment on all hand operated Di-Acro Rod Parter.





ITEM	DESCRIPTION	PART NUMBER	QTY
2	NAME PLATE	8080650-110	1
3	CENTER STUD BOLT	8400470-100	1
4	SCREW	20A0516C1104	4
5	UPPER CASTING	8080110-200	1
6	LONG STUD BOLT	8080470-100	2
7	CAUTION PLATE	030-6504001	1
8	EJECTOMATIC TRIGGER ASS'Y	8080141-070	1
9	STOP ROD	8080141-001	1
10	DIE ROD PARTER	8100120-901	2
11	SPACER	8080110-800	1
12	M-F LOCKNUT	8470410-200	1
13	DRIVE FITTING	8690100-200	1
14	PIN	19A0308X1102	8
15	BASE	8080110-100	1
16	NUT	0011539-000	3
17	SCREW	21A0516C1000	2
18	BEARING	8310410-100	3
19	HANDLE HOLDER	8993120-800	1
20	LINK	8080120-101	1
21	SHORT STUD BOLT	8300470-100	1
22	HANDLE ARM ASS'Y (SHORT)	8080120-800	1
23	HANDLE ARM ASS'Y (LONG) (OPTIONAL)	8000120-871	1



ITEM	DESCRIPTION	PART NUMBER	QTY
1	EJECTOMATIC SPACER	8200141-001	1
2	EJECTOMATIC ARM	8300141-001	1
3	SCREW	21A0516C1000	2
4	EJECTOMATIC HOLDER	8400141-001	1
5	EJECTOMATIC TRIGGER	8500141-001	1
6	SCREW	20AXXX6F0308	2
7	EJECTOMATIC PLATE	8600141-001	1
8	SPRING	8080510-402	1