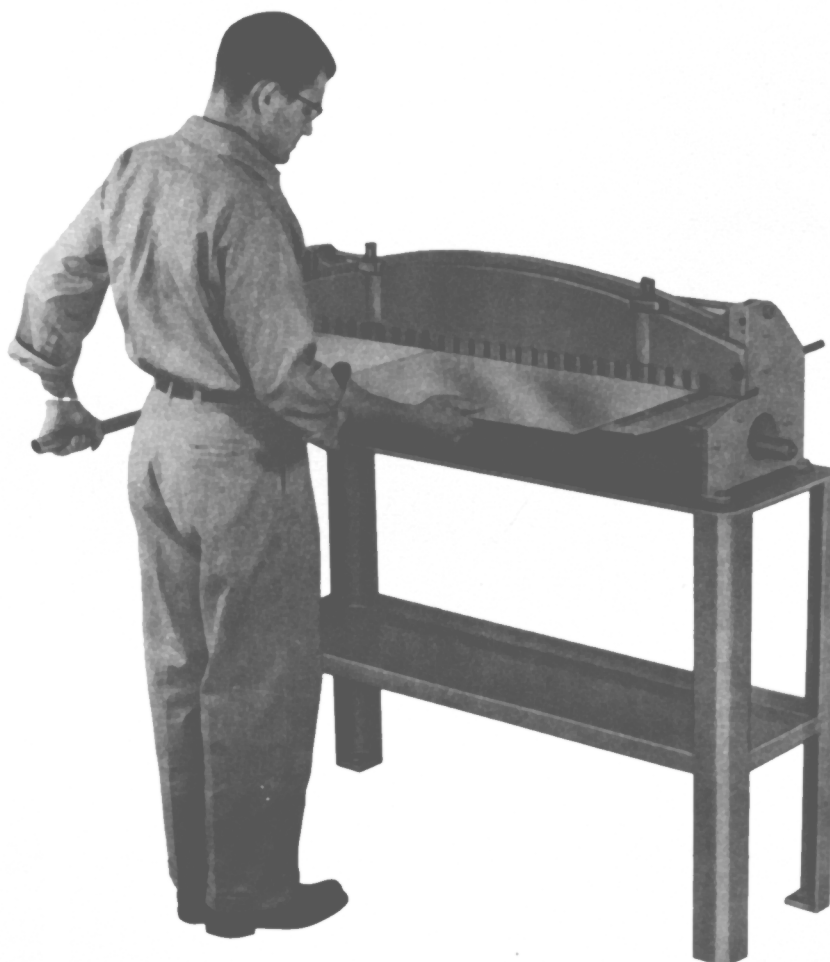


Di-Acro[®]

OPERATOR'S MANUAL & INSTRUCTIONS

MODEL 36 Di-Acro Hand Shear



Di-Acro, Incorporated

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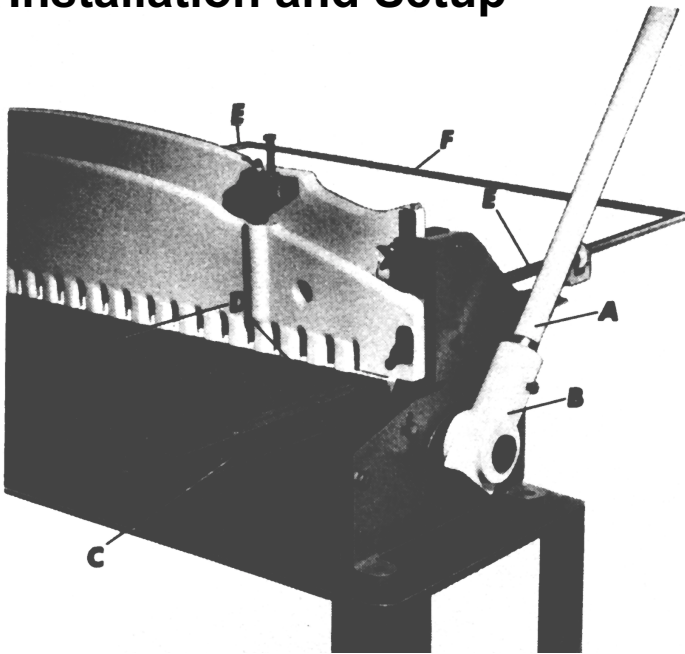
330-455-1942

330-455-0220 (fax)

Revised 01/02

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Installation and Setup



1. Bolt the shear to a flat surface such as a workbench or stand. If the surface is not level, it may be necessary to place shims under one of the mounting flanges on the shear base. Be certain that the mounting bench or stand is securely bolted to the floor to prevent tipping.

2. Insert the shear handle (A) into the holder (B) and secure with screw. Handle holder may be moved to the opposite end of machine for left hand operation.

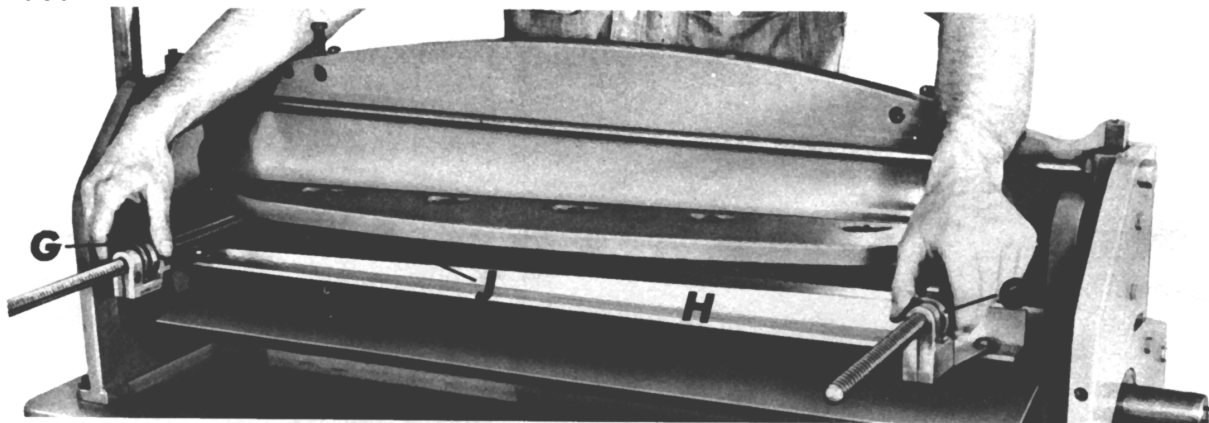
3. Mount the shear table (C) onto the base using the flat head screws (D) provided.

4. Assemble the micrometer back

gauge and screw the threaded gauge rods (E) into the holes in the rear of the machine base as far as possible.

5. Lock the threaded gauge rods into place by tightening the lock nuts against the ram.

6. Install the tie bar (F) between the threaded gauge rods and secure with the cap screws provided.



Synchronizing Micrometer Gauges

1. Set both micrometer dials on zero, depress and slide entire assembly forward until the material stop bar (H) contacts lower Shear blade (I).

2. Turn both micrometer dials slightly to be sure they engage threaded gauge rods.

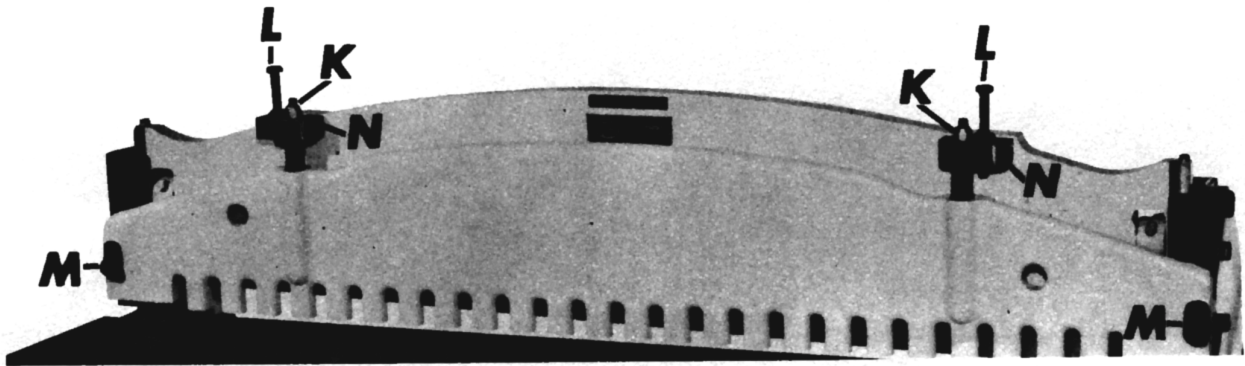
3. Loosen lock nuts and turn threaded gauge rods counter-clockwise while turning micrometer dial clockwise. When material stop bar is in contact with lower blade, and both micrometer dials read zero, gauge is synchronized.

4. Tighten lock nuts on threaded gauge rods.

With the gauge synchronized, the micrometer stops can be moved to any measurement, set approximately parallel and adjusted to exact parallel by turning the micrometer dials (G) to identical settings.

Adjusting Gauges

1. The side squaring gauge furnished is calibrated in 1/16" increments, reading from zero at the cutting edge of the lower blade.
2. The protractor gauge furnished is adjustable for cutting angles and beveling corners. To adjust, loosen the two cap screws slightly, turn the gauge to the desired position, and re-tighten the screws.
3. To adjust the micrometer back gauge, turn both micrometer dials (G) to zero. Push both dials down to release them from the threaded gauge rod and slide them to the approximate position required. Turn the micrometer dials to set the gauge to the exact position.



Adjusting The Holddown Bar

To increase or decrease opening between holddown bar and bed, adjust nuts (K) until opening is obtained.

Slitting Adjustment

Slitting may be performed by adjusting screws (L) to stop ram travel.

Upper Blade Removal

1. Remove screws (M) and screws holding brackets (N) to ram. Remove holddown from machine.
2. Remove bolts fastening blade to ram.

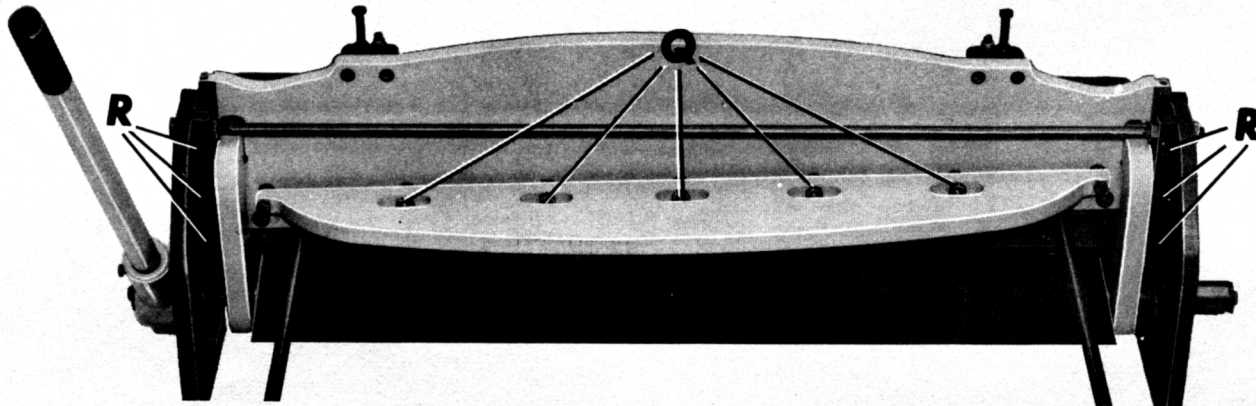
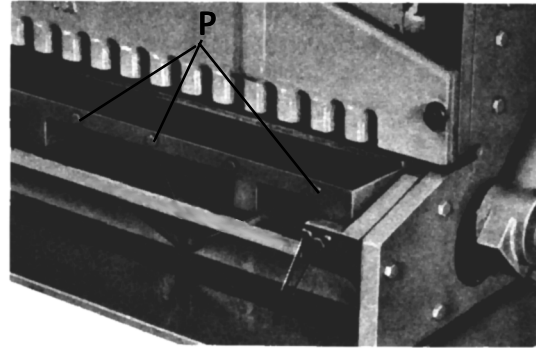
Lower Blade Removal

Remove bolts (O, next page) accessible at front of base casting under table.

Adjusting Blade Clearance

Blade clearance may be varied but for longer blade life, a few thousandths clearance should be maintained. Blades should not be in actual contact with each other. Best results may generally be obtained with .002" clearance on the ends and .001" clearance at the center.

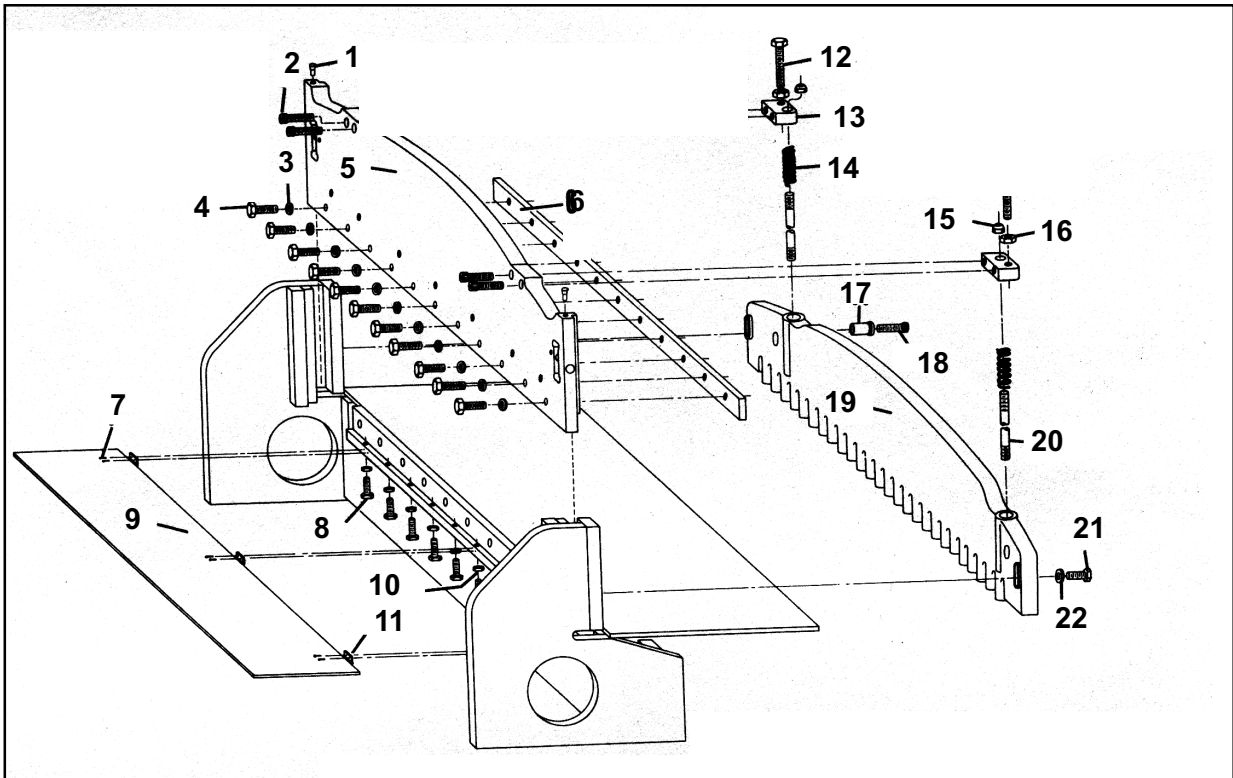
1. Move the handle down until ram is at the bottom of its stroke
2. Check clearance between the blades, adjust to obtain equal clearance on both ends of ram. Opposing screws (P) on both ends of base castings will move bed in and out when bed clamp bolts are loose.



3. If clearance of blade is other than recommended above, adjust nuts (Q) to obtain proper clearance. This will align top blade with lower blade. (Loosening inner nut and tightening outer nut will pull blade and ram forward or decrease blade clearance.)
 4. When final adjustment is complete, nuts should be locked against blade straightener.
- NOTE: Check clearance while this is being done – 1/16 of a turn can vary blade straightness approximately .007".

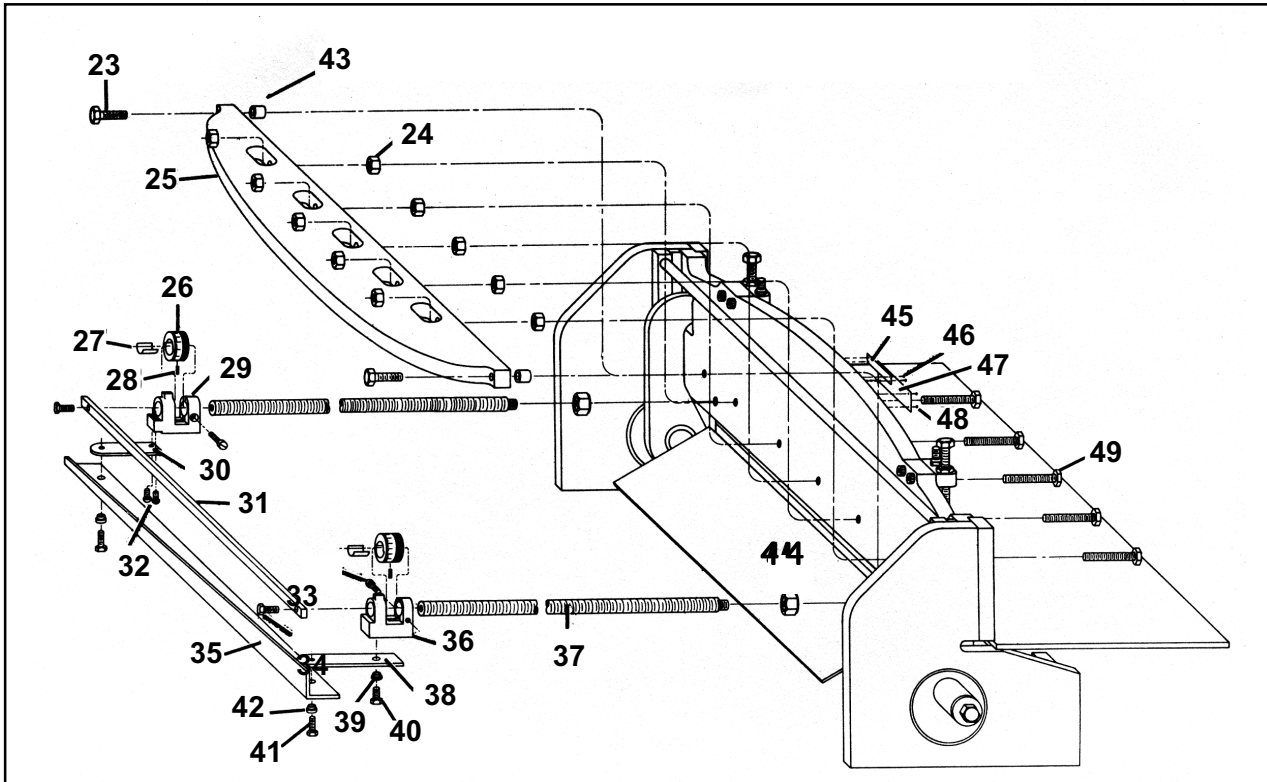
Adjusting Clearance Of Ram Slides

Clearance on ram slides should be kept to a minimum but care should be exercised to prevent binding. Adjust screws (R) evenly on both sides of ram to obtain proper clearance.

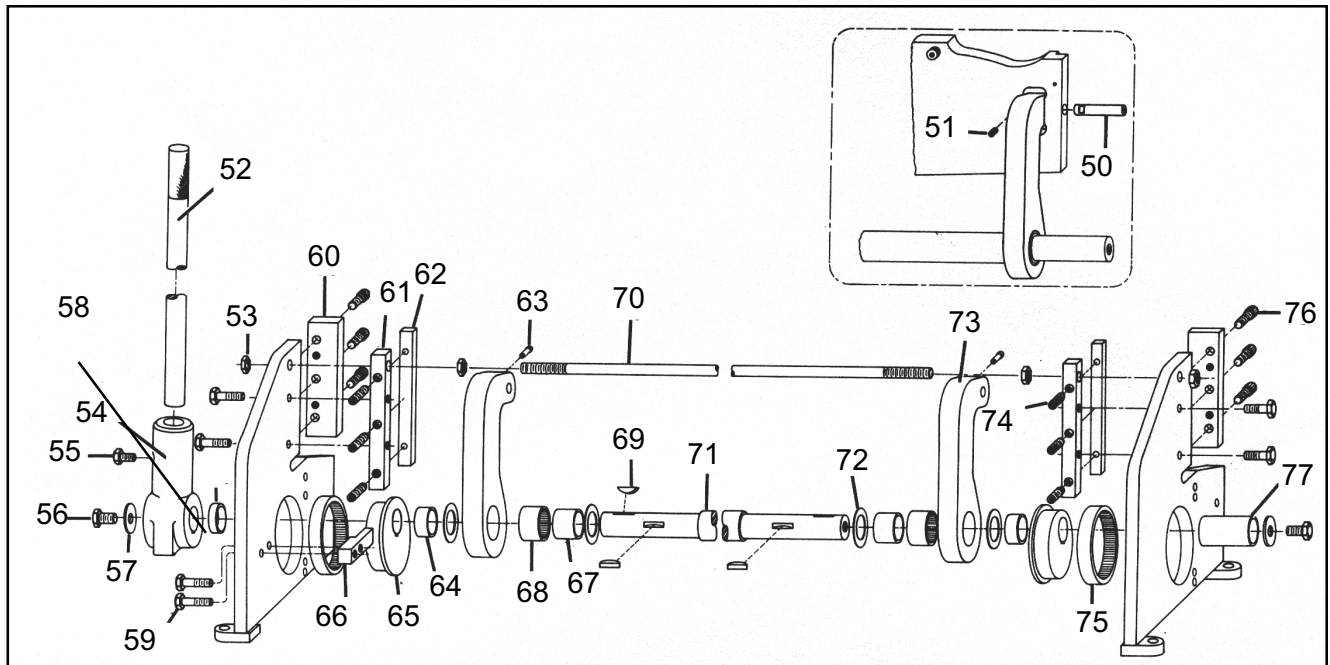


Item No.	Description	Part No.
1	Hinge Type Oil Cup	6901001
2	Soc. Head. Cap Screw	20A0308C1000
3	Washer	8490110-800
4	Hex Head Cap Screw	4701112
5	Ram	236-1213019
6	Blade High Carbon-High Chrome	236-1209038
	Blade Alloy Tool Steel	8236120-900
7	Hex Head Cap Screw	21AXX06C0104
8	Hex Nut	30X0516C
9	Chute	236-1109042
10	Hex Nut	30X0516C
11	Butt Hinge	4501002
12	Hex Head Cap Screw	4701122
13	Ram Stop	237-1213022
14	Spring	5102107
15	Elastic Stop Nut	4704014
16	Jam Nut	31X0308C
17	Holddown Guide	236-1108035
18	Socket Head Cap Screw	20A0516C1102
19	Holddown Bar	236-1213031
20	Holddown Stud	236-4701033
21	Hex Head Cap Screw	21A0308C1000
22	Holddown Bar Washer	236-4901032

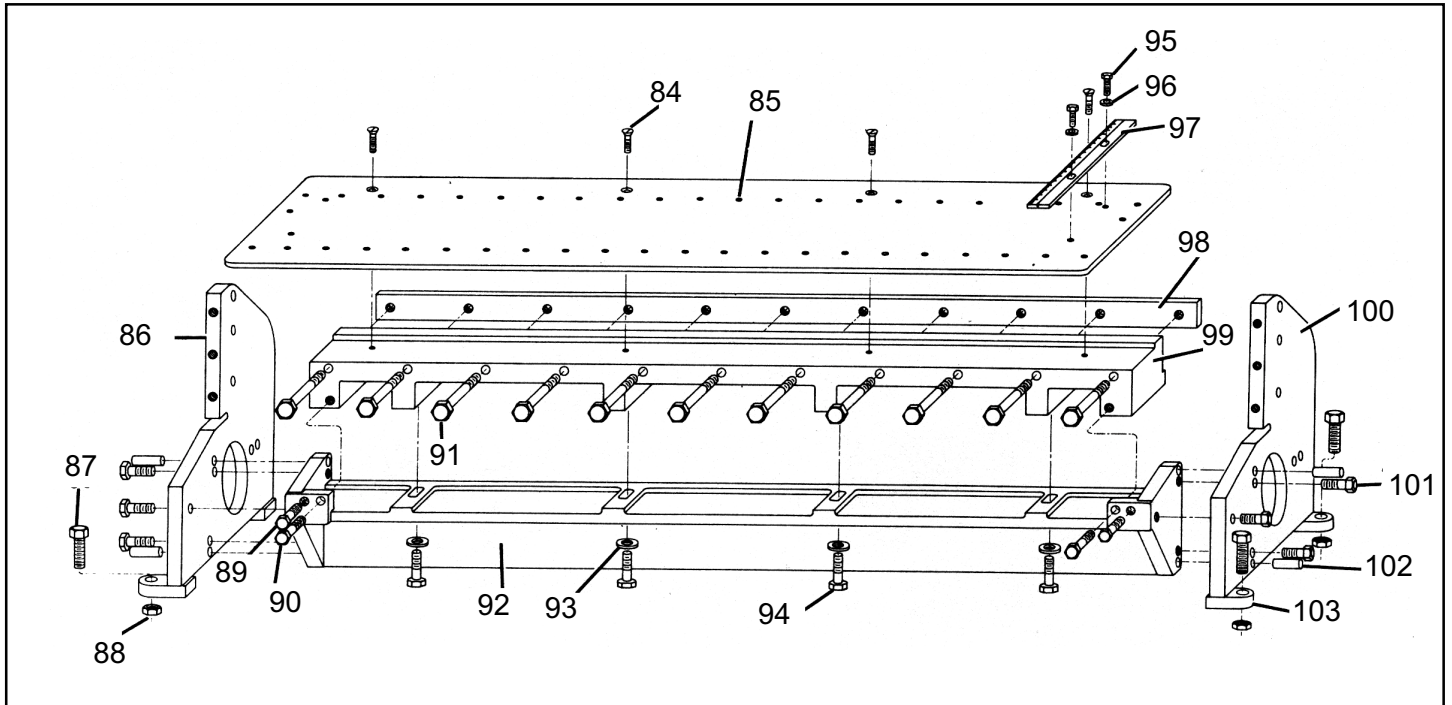
DI-ACRO MODEL 36 HAND SHEAR PARTS LIST – When ordering, specify part number and part name for positive identification.



Item No.	Description	Part No.
23	Hex Head Cap Screw	21A0308C1304
24	Full Nut	30X0308C
25	Blade Straightener	236-1213011
26	Quik Set Dial Nut	210-1431042
27	Quik Set Dial Shoe	210-1431043
28	Spring	210-5102048
29	Quik Set Bracket L	220-1431038
30	Quik Set Arm Short	236-1431041
31	Quik Set Tie Bar	236-1431050
32	Button Head Cap Screw	20BX10C0102
33	Fillister Head Machine Screw	22B0104C0708
34	Hex Head Cap Screw	21A0516C0304
35	Quik Set Stop	238-1431040
36	Quik Set Bracket R	210-1431038
37	Qik Set Rod	236-1431039
38	Quik Set Arm Long	236-1431040
39	Quik Set Pivot Sleeve	210-1431046
40	Hex Head Cap Screw	21A0104C0102
41	Hex Head Cap Screw	21A0104C0308
42	Quik Set Spacer Sleeve	240-1431047
43	Blade Straightener Spacer	236-1213012
44	Quik Set Lock Nut	690-4704045
45	Capacity Tag	6503105
46	1/8 - O Drive Screw	
47	Name Plate	6501120
48	1/8 - O Drive Screw	
49	Hex Head Cap Screw	4701122



Item No.	Description	Part No.
50	Pitman Pin	236-1203023
51	Socket Head Set Screw	23A0104C0308
52	Handle	236-1208001
53	Jam Nut	31X0102C
54	Handle Holder	236-1208002
55	Hex Head Cap Screw	21A0516C0508
56	Hex Head Cap Screw	21A0308C0304
57	Washer	4901112
58	Handle Spacer	236-1108004
59	Hex Head Cap Screw	21a0308c0102
60	Stationary Gib	236-1108026
61	Gib Screw Mount	236-1103024
62	Adjustable Gib	236-1108025
63	Hinge Type Oil Cup	6901001
64	Shaft Spacer	236-1108006
65	Eccentric	236-1202018
66	Shaft Stop	236-1110015
67	Needle Bearing Race	3103013
68	B-2416 Type DC Needle Bearing	3103008
69	Woodruff Key	5501131
70	Truss Rod	236-1110021
71	Shaft	236-1211001
72	Washer	4901116
73	Pitman	236-1212022
74	Nylon Socket Set Screw	23A0308C1104
75	B-5612 Type DC Needle Bearing	3103010
76	Socket Head Cap Screw	20A0308C1000
77	Shaft Collar	236-1108007



Item No.	Description	Part No.
78	Fillister Head Machine Screw	22B0104C0508
79	Protractor Gauge (not shown)	230-1435026
84	Fillister Head Screw	22B0104C0508
85	Table	236-1105001
86	Side Frame L	236-1103002
87	Hex Head Cap Screw	21A0102C1102
88	Full Nut	30X0102C
89	Hex Head Cap Screw	21A0308C1000
90	Hex Head Cap Screw	21A0308C1104
91	Hex Head Cap Screw	21A0516C4000
92	Bed	236-1104003
93	Washer	4901110
94	Hex Head Cap Screw	21A0308C1104
95	Hex Head Cap Screw	21A0104C0304
96	Washer	4901102
97	Squaring Gauge	236-1601029
98	Blade High Carbon-High Chrome	236-1209038
	Blade Alloy Tool Steel	236-1209009
99	Blade Mount	236-1213010
100	Side Frame R	236-1103001
101	Hex Head Cap Screw	21A0308C1104
102	Dowel Pin	
104	Stand	236-1109034

