

DiAcro[®]
METAL FABRICATION EQUIPMENT



#2 TAB NOTCHER OPERATION AND PARTS MANUAL

DiAcro[®]

12430 55th St N · Oak Park Heights, MN 55082

Phone: 651.342.1756 · Fax: 651.342.1293

Email: info@diacro.com

TABLE OF CONTENTS

SAFETY INFORMATION	PG. 3
TECHNICAL DATA	PG. 3
SET-UP PROCEDURE	PG. 4-6
MAINTENANCE & BLADE SHARPENING	PG. 7
#2 TAB NOTCHER BREAKDOWN AND PARTS LIST	PG. 8-10
OPTIONAL STAND	PG. 11
WARRANTY	PG. 12

SAFETY INFORMATION



Before Notcher is set up for operation, mount on work bench or stand.

***IF NOTCHER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR.**

TECHNICAL DATA

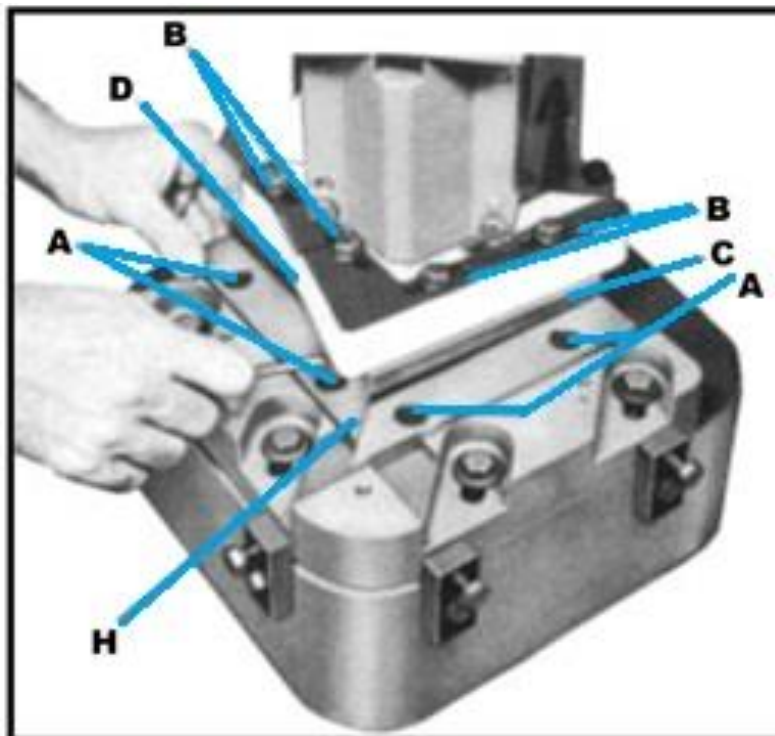
SPECIFICATIONS

Model #2 Tab Notcher	in.	mm
Max. 90° Notch	6 x 6	152 x 152
Max. Tab	1	25.4
Max Material Cap. m.s.	16 ga.	1.5
Tonnage	4	3.6
Stroke of Ram	5/8	16.9
Shipping Weight	265 lbs.	120 kg.

SET-UP PROCEDURE

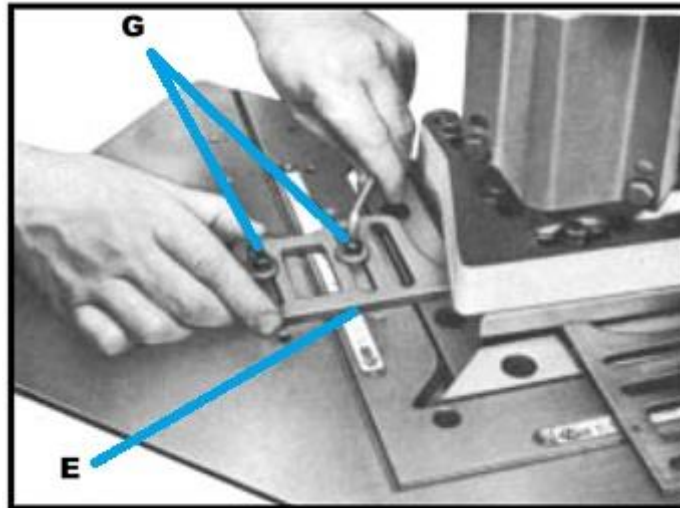
CHANGING SIZE OF TAB:

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.



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.



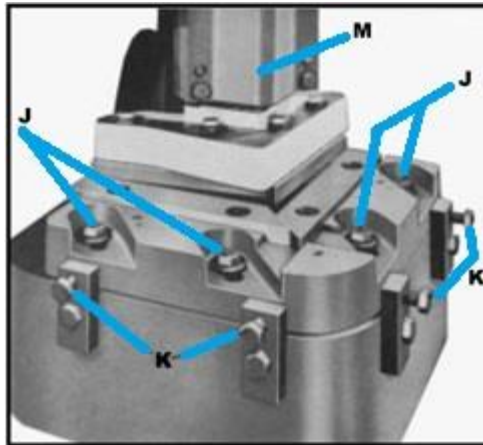
SHEARING LONG STRIPS FULL WIDTH:

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

SETTING DEPTH OF STROKE:

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

ADJUSTING BLADE CLEARANCE:



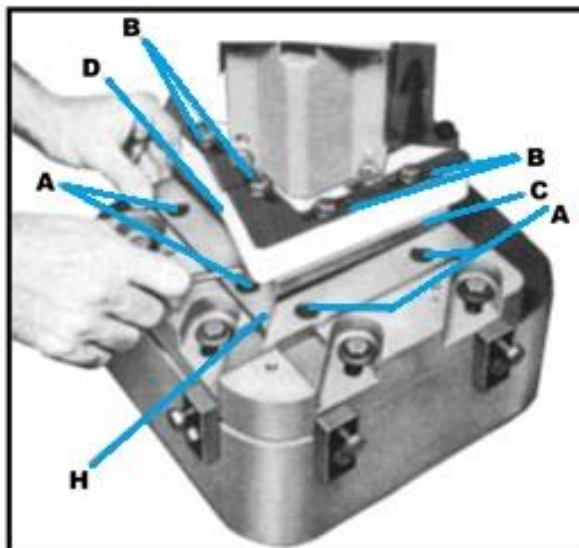
1. Remove table.
2. Loosen blade mounting bolts (A) and (B).
3. Loosen blade carrier bolts (J).
4. Adjust lower blades to required tab (per instructions, B "changing size of tab" 1, 2 and 3).
5. Set upper blades for no tab smaller than set in lower blades.
6. Back off screws (K) and pull blade carrier 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 work piece. Excessive rubbing of blade will reduce blade life.
9. Tighten bolts (J).
10. Set upper blade to tab notch in lower blade and tighten.

ADJUST 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 (M).

MAINTENANCE

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

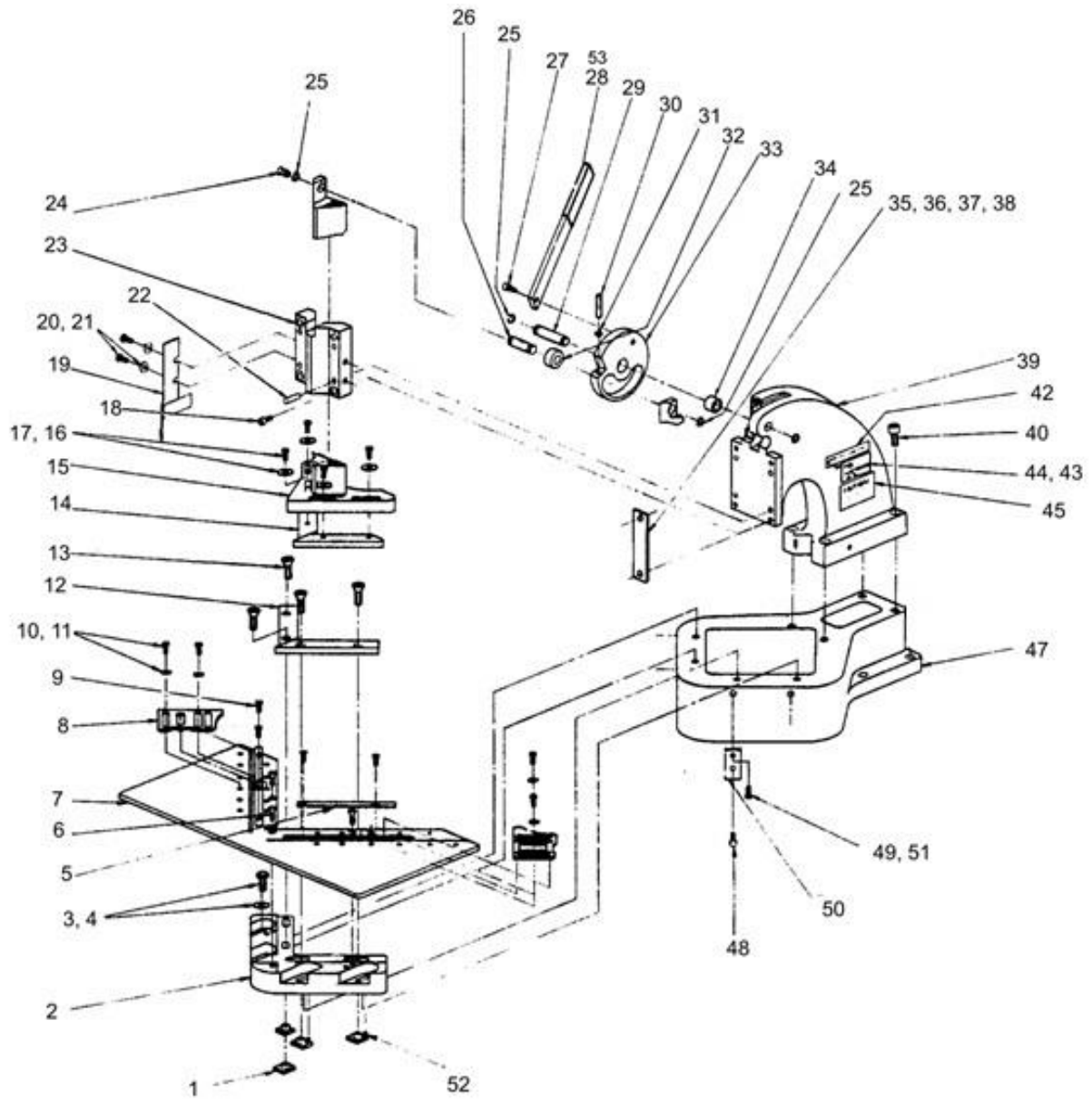


SHARPENING BLADES:

1. Blades have two cutting edges. A new cutting edge is obtained by changing right blade to the left side and vice 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.

#2 TAB NOTCHER PARTS BREAKDOWN

8030800-080



PARTS LIST
8030800-080

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8905350-000	T-NUT	4
2	8031110-101	BLADE CARRIER	1
3	21A0308C1102	SCREW-HHCS 3/8-16X1-1/2	4
4	61X0308	WASHER-3/8	4
4A	0102WILLIAMS WASHER	WASHER-1/2 WILLIAMS (NOT SHOWN GOES UNDER 3/8 WASHER)	4
5	8031160-101	RULE	2
6	20C0104C0508	SCREW-FHSCS 1/4-20X5/8	3
7	8000110-501	TABLE	1
8	8031140-571	PROTRACTOR GAUGE-LH	1
8	8031140-572	PROTRACTOR GAUGE-RH	1
9	20B0X06C0108	SCREW-BHSCS #6-32X1/8	4
10	21A0104C0308	SCREW-HHCS 1/4-20X3/8	4
11	61X0104	WASHER-FLAT 1/4	4
12	8031120-901	LOWER BLADE	2
13	20C0516C2000	SCREW-FHSCS 5/16-18X2	4
14	8031120-900	UPPER BLADE	2
15	8031121-300	RAM WELDMENT	1
16	21A0516C1308	SCREW-HHCS 5/16-18X1-3/8	4
17	61X0516	WASHER-FLAT 5/16	4
18	20A0516C1102	SCREW-SHCS 5/16-18X1-1/2	4
19	8031110-609	GUARD WLDMT	1
20	21A0516C0102	SCREW-HHCS 5/16-18X1/2	4
21	61X0516	WASHER-FLAT 5/16	4
22	18A0516X1102	PIN-DOWEL 5/16X1-1/2	4
23	8040110-800	CAP	1
24	8690100-200	DRIVE FITTING	1
25	8470510-100	RETAINING RING	4
26	8060120-300	CAM ROLLER PIN	1
27	20B0516C0508	SCREW-BHSCS 5/16-18X5/8	1
28	8030120-800	LONG HANDLE ARM	1
29	8030120-302	CAM PIN	1
30	23C0516C2000	SCREW-SQHSS 5/16-18X2	1
31	31X0516C	NUT-JAM 5/16-18	1
32	8156111-300	ROLLER	1
33	8030120-200	CAM	1
34	8310410-100	BEARING	1

PARTS LIST - CONTINUED
8030800-080

ITEM	PART NUMBER	DESCRIPTION	QTY
35	8030570-101	SHIM .0015" - PURPLE	VARIES
36	8930570-101	SHIM .0020" - RED	VARIES
37	8940570-101	SHIM .0030" - GREEN	VARIES
38	8030570-102	SHIM .0050" - BLUE	VARIES
39	8040110-200	UPPER CASTING	1
40	20A0102C1304	SCREW-SHCS 1/2-13X1-3/4	4
42	8150650-110	NAMEPLATE	1
45	030-6503001	CAUTION TAG	1
47	8031110-100	BASE	1
48	21A0308C1000	SCREW-HHCS 3/8-16X1	4
49	31X0308C	NUT-JAM 3/8-16	4
50	031-1105011	BACKUP PLATE	4
51	21A0308C1104	SCREW-HHCS 3/8-16X1-1/4	4
52	19A0108X0102	PIN-DOWEL 1/8X1/2	4
53	8030120-801	HANDLE GRIP	1
	8030650-301	LABEL – PINCH POINT (NOT SHOWN)	1

OPTIONAL STAND

Part Number: 8031110-900

Stand Dimensions: 28" WIDE, 15" DEEP, 33-1/4" HIGH

CALL DI-ACRO FOR PRICE AND AVAILABILITY



Fasteners needed to attach Punch to the stand are the following:

(Fasteners to attach stand to floor are not included.)

PART NUMBER	DESCRIPTION	QTY
21A0102C2102	SCREW-HHCS 1/2-13X2-1/2	4
61X0102	WASHER-FLAT 1/2	4
30X0102C	NUT-FULL 1/2-13	4

Warranty & Limitation of Liability

Defective parts, of a product manufactured by DI-ACRO, will be replaced or repaired at no charge for twelve (12) months following delivery to the original purchaser. Labor is included for the first 90 days. This warranty becomes void when products have not been used according to instructions furnished by DI-ACRO, nor does it cover any altered parts or unauthorized repairs. We cannot be responsible for the cost of repairs made or attempted outside of our factory. All other warranty claims are made FOB our plant, providing such items(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components or systems not manufactured by DI-ACRO. These products are covered instead by the existing warranties, if any, of their manufacturers. Normal service items with a reasonable life expectancy of less than one year are warranted only to the extent of the reasonable life under normal use and service.

Authorization must be obtained from DI-ACRO before returning parts or equipment to the factory. DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt, inspection and defect identification.

DI-ACRO's liability under this warranty shall not exceed the amount paid for the product.

THIS IS DI-ACRO'S SOLE WARRANTY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY, FITNESS OR ANY LOSS, DAMAGE OR EXPENSES DIRECTLY OR INDIRECTLY RELATED TO THE USE OF ITS PRODUCT OR FROM ANY OTHER CAUSE OR FOR CONSEQUENTIAL DAMAGES INCLUDING, WITHOUT LIMITATION, LOSS OF TIME AND LOSS OF PRODUCTION.

IT IS EXPRESSLY UNDERSTOOD THAT DI-ACRO IS NOT RESPONSIBLE FOR DAMAGE OR INJURY CAUSED TO OTHER PRODUCTS, MACHINERY, PROPERTY OR PERSONS BY REASON OF THE USE OF ITS PRODUCTS.



12430 55th St N · Oak Park Heights, MN 55082

Phone: 651.342.1756 · Fax: 651.342.1293

Email: info@diacro.com