

**DI-ACRO**  
**#2 ROD PARTER**  
**INSTRUCTION MANUAL**



Manufacturers of **K-Prene®**... the unequalled **Urethane**

**www.acrotech inc.com**    **www.diacro.com**    **800-345-0583**

**Metal Fabrication Equipment**

... a Division of **ACROTECH**

980 West Lakewood Ave P.O. Box 466 Lake City, MN 55041 Fax: 651-345-3759 Email: di-acro@di-acro.com Email: acrotech@acrotech.com

## **TABLE OF CONTENTS**

<b>A.</b>	<b>SAFETY INFORMATION</b>	<b>PG. 3</b>
<b>B.</b>	<b>SET UP PROCEDURE</b>	<b>PG. 3</b>
<b>C.</b>	<b>MAINTENANCE</b>	<b>PG. 3</b>
<b>D.</b>	<b>TECHNICAL DATA</b>	<b>PG. 4</b>
<b>E.</b>	<b>OPERATING INSTRUCTIONS</b>	<b>PG. 4</b>
<b>F.</b>	<b>PARTS LIST FOR ROD PARTER</b>	<b>PG. 5-6</b>
<b>G.</b>	<b>EJECTOMATIC GAUGE</b>	<b>PG. 6</b>
<b>H.</b>	<b>PARTS LIST FOR EJECTOMATIC</b>	<b>PG. 6-7</b>
<b>I.</b>	<b>STAND</b>	<b>PG. 7</b>
<b>J.</b>	<b>WARRANTY</b>	<b>PG. 8</b>

## A. Safety Instructions



**Before Rod Parter is set up for operation, mount on work bench or stand\*.**

**\*IF ROD PARTER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR**

## B. Set-up Procedure

After Rod Parter is bolted to work bench or stand attach Handle to Handle Holder. Install gauge Rod to Base and attach Ejectomatic Gauge as follows:

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.

## C. Maintenance

Grease fitting on Center Stud Bolt periodically.

## **D. Technical Data**

There are nine holes in the cutting head of the #2 Rod Parter from 1/8" to 1/2" in diameter graduated in steps of 1/16" (all holes are approximately .005" 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.

### **Standard Equipment**

Short handle for "parting-off" light material is standard equipment.

### **Optional Equipment**

Long handle for "parting-off" heavier material is optional equipment.

### **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.

## **E. 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.

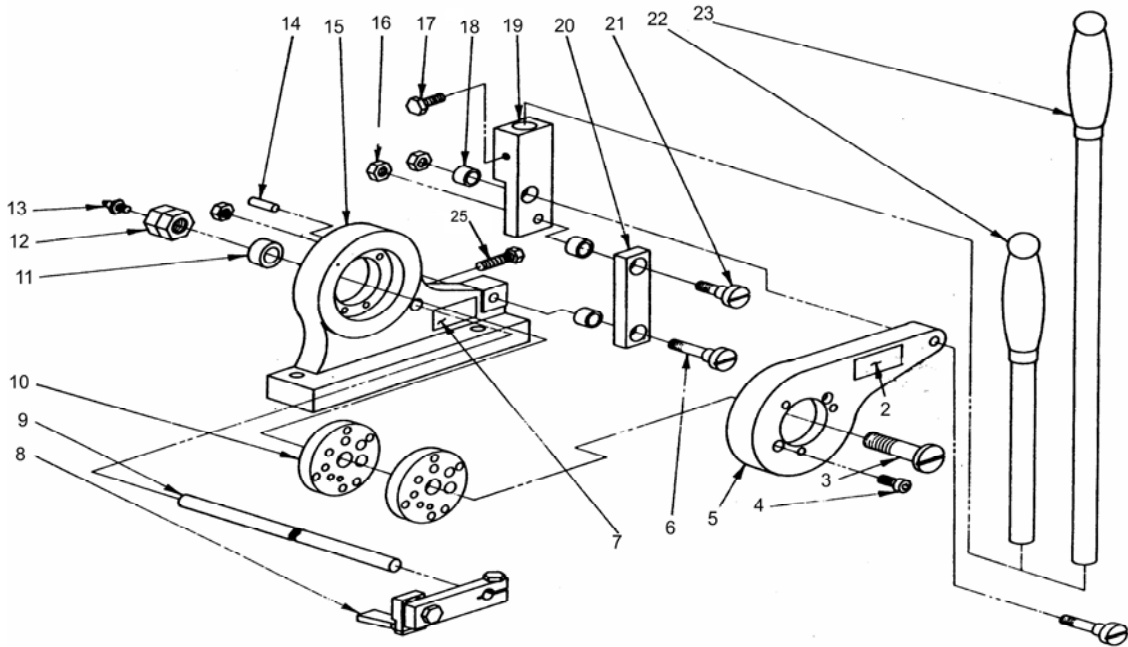
### **To Remove Cutting Heads**

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 the factory for this service.

## **PARTS BREAKDOWN** **# 2 ROD PARTER**



### **#2 ROD PARTER PARTS LIST**

ITEM	PART NUMBER	DESCRIPTION	QTY
2	8150650-110	NAMEPLATE	1
3	8400470-100	CENTER STUD BOLT	1
4	20A0516C1104	SCREW-SOCKET 5/16-18X1-1/4	4
5	8080110-200	UPPER CASTING	1
6	8080470-100	LONG STUD BOLT	2
7	030-6503001	CAUTION PLATE	1
8	8080141-070	EJECTOMATIC TRIGGER ASSY (SEE PG 6 & 7 FOR PARTS BREAKDOWN)	1
9	8080141-001	STOP ROD	1
10	8100120-901	DIE ROD PARTER	2
11	8080110-800	SPACER	1
12	8470410-200	MALE/FEMALE LOCKNUT	1
13	8690100-200	DRIVE FITTING	1
14	19A0308X1102	PIN-DOWEL 3/8 X 1-1/2	8
15	8080110-100	BASE	1

**#2 ROD PARTER  
PARTS LIST  
CONTINUED**

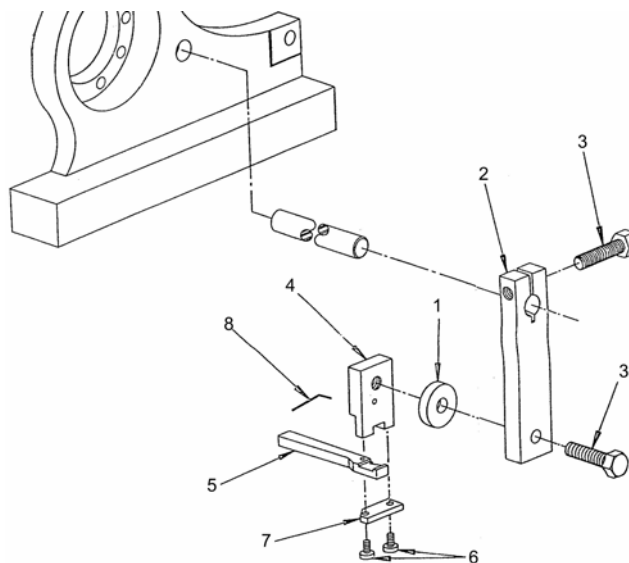
ITEM	PART NUMBER	DESCRIPTION	QTY
16	30X0102C	NUT-FULL 1/ 2X13	3
17	23A0516C0508	SCREW-SOC 5/16-18X5/8	1
18	8310410-100	BEARING	3
19	8993120-800	HANDLE HOLDER	1
20	8080120-101	LINK	1
21	8300470-100	SHORT STUD BOLT	1
22	8080120-800	HANDLE ARM (SHORT)	1
	100-0142-M	HANDLE GRIP	1
23	8000120-871	HANDLE ARM ASSY(LONG) (OPTIONAL)	1
24	62X0102	WASHER-LOCK 1/2 (NOT SHOWN) GOES BEHIND ITEM 16	3
25	23A0516C1000	SCREW-SOC 5/16-18X1	1

**F. 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 the hand operated rod parter.

**EJECTOMATIC TRIGGER ASSEMBLY**



**EJECTOMATIC  
PARTS LIST**

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8200141-001	EJECTOMATIC SPACER	1
2	8300141-001	EJECTOMATIC ARM	1
3	21A0516C1000	SCREW-HEX 5/16-18 X 1	2
4	8400141-001	EJECTOMATIC HOLDER	1
5	8500141-001	EJECTOMATIC TRIGGER	1
6	22FXX06F0308	SCREW-BINDER #6-32 X 1/4	2
7	8600141-001	EJECTOMATIC PLATE	1
8	8080510-402	SPRING	1

**G. OPTIONAL STAND PART NUMBER 8230110-900  
STAND DIMENSIONS ARE:  
20" WIDE, 15" DEEP, 33-1/4" HIGH**

**CALL ACROTECH FOR PRICE AND AVAILABILITY**



Fasteners needed to attach Rod Parter to the stand are the following:  
Fasteners to attach stand to floor are not included.

PART NUMBER	DESCRIPTION	QTY
21A0102C3000	Screw-HHCS 1/2-20X3	4
61X0102	Washer-Flat 1/2	4
31X0102	Nut-Hex Jam 1/2-20	4

# Warranty & Limitation of Liability

Defective parts of a product manufactured by ACROTECH/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 ACROTECH/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 warranty claims are made FOB our plant, providing such item(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components or systems not manufactured by ACROTECH/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 ACROTECH/DI-ACRO before returning parts or equipment to the factory. ACROTECH/DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt and inspection of the product.

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

**THIS IS ACROTECH/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 ACROTECH IS NOT RESPONSIBLE FOR DAMAGE OR INJURY CAUSED TO OTHER PRODUCTS, MACHINERY, PROPERTY OR PERSONS BY REASON OF THE USE OF ITS PRODUCTS.**