

**DiAcro**<sup>®</sup>

# NUMBER 1 DI-ACRO HAND NOTCHER



**DiAcro**<sup>®</sup>

METAL FABRICATION EQUIPMENT

579 SCHOMMER DR - STE C

HUDSON, WI 54016

(651) 342-1756 (P)

# **OBSOLETE MACHINE**

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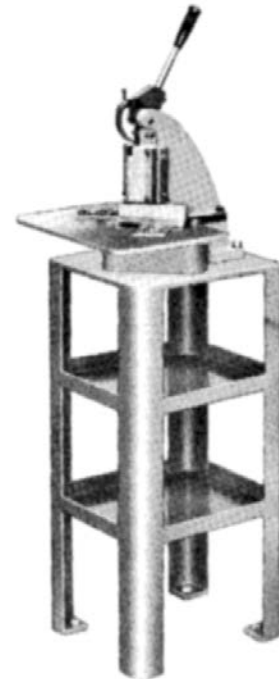
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The hand operated Di-Acro Notcher is shipped with the Material Table and Handle removed. To set up for operation, install handle and table and adjust the gauges for the proper size notch. (See instructions below.)

Smooth, even notches can be cut in all types of ductile material with the Di-Acro Notcher. It eliminates the high cost of special dies required for individual notching operations and reduces setup time. You simply adjust the Material Gauges and you're ready for production.

A cam roller mechanism is used on the hand-operated Di-Acro Notcher which develops a full 4 ton capacity. Sufficient leverage is available to cut a 90 degree notch as large as 6 x 6 inches in 16 gauge mild steel in one operation with minimum operator effort.

Adjustable gauges are used to locate a notch of any dimension at the corner of a sheet of material or at any position along the edge of the sheet. Notches greater or less than 90 degrees can be obtained in two operations and many straight shearing operations can also be performed. The hardened and ground triangular-shaped ram, used in the Di-Acro Notcher, will provide years of continuous, trouble-free performance and assure a clean cut free from rough edges or burrs.



**SPECIFICATONS & CAPACITIES**

Maximum Material Capacity- Sheet Steel	16 gauge
Maximum 90 degree notch (one operation)	6" x 6"
Rated Capacity	4 tons
Stroke of Ram	5/8"
Net Weight	125 lbs.
Stand Net Weight	90 lbs.

**CONSTRUCTION FEATURES**

**Triangular Top Blade** of the Di-Acro Notcher is made of tool steel and is bolted to an Alloy Casting which is mounted on the Ram. The two lower blades adjust to provide proper clearance for a clean cut in the thinnest of materials.

**Notching** blades are made from hardened and precision ground alloy tool steel. Upper blade is reversible and both lower blades have four cutting edges for extra duty. Blades can be easily resharpened on a surface grinder.

**Adjustable Gauges** accurately locate a notch either at a corner or at any position along the edge of material, they are mounted on a 12 x 18 inch work table which provides a large material support area and makes for easy work handling and positioning.

**Triangular Ram** hardened and precision ground, positively controls the position of the Cutting Head and provides perfect alignment at all times.

**Alloy Cast Base and Body** assure extreme rigidity and durability.

**Standard Equipment Includes**

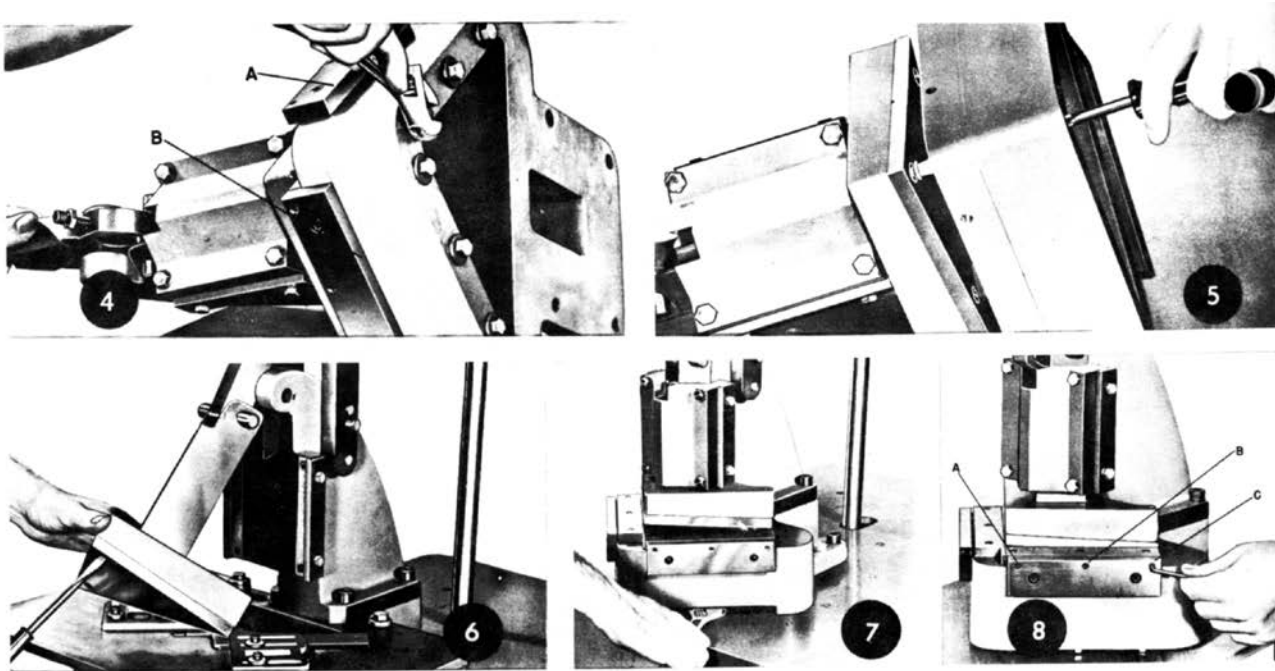
Short Handle - for production speed when working with light materials.

Long Handle - for notching heavier materials

12 x 18 inch work table - cast and precision ground

Adjustable Material Gauges

HCHC Notcher Blades



### To Remove Blades

Remove work table and turn Notcher on its side. Remove the six bolts holding the lower notching blades and the two bolts holding supports A and B (photo 4). Then remove the three bolts holding the upper Notching Blade (photo 5). Before replacing lower blades, carefully read instructions below on aligning lower blades.

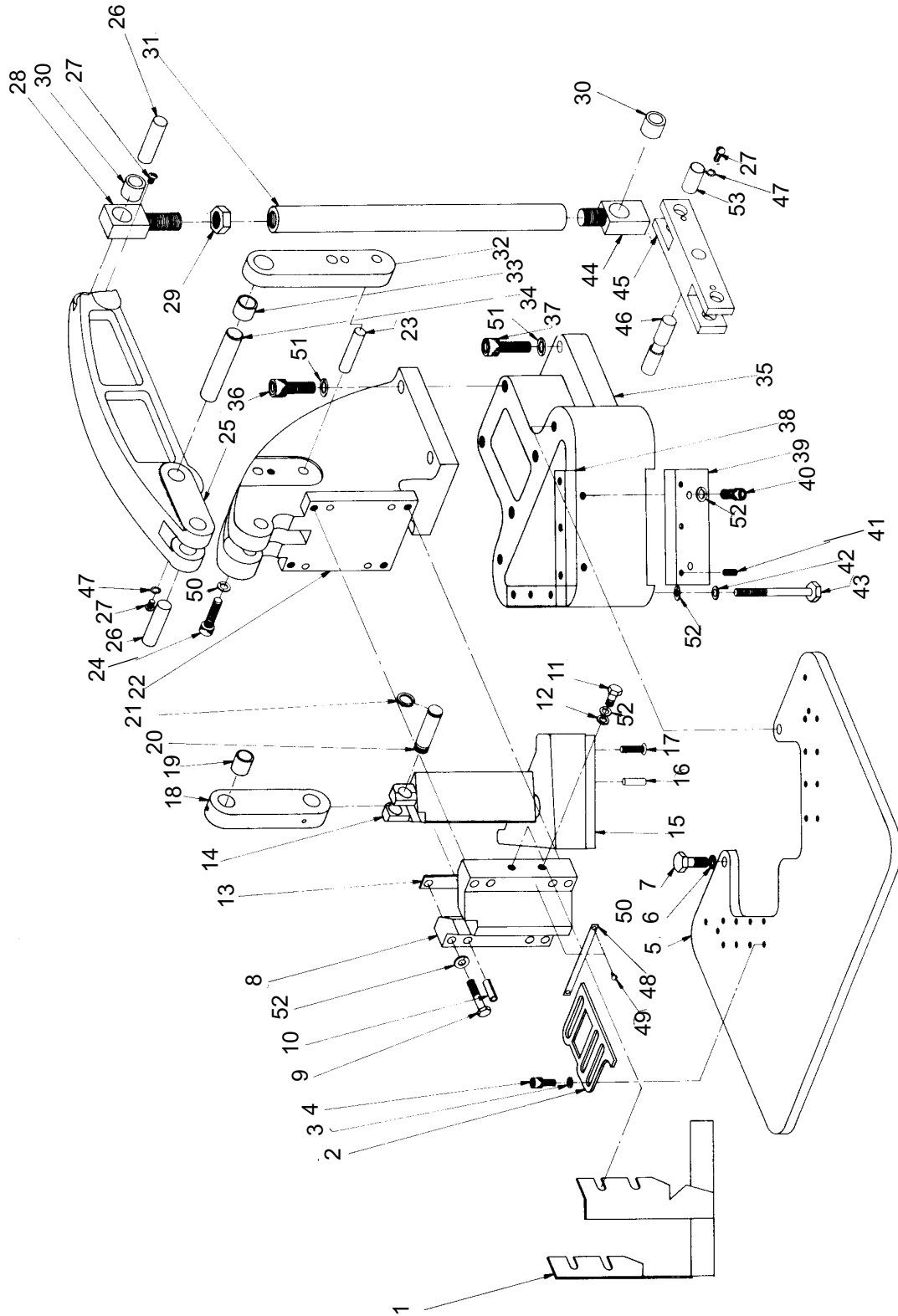
**\*CAUTION:** If ram cap is removed, make sure shims between ram and ram cap are replaced and kept free of grit and dust, to obtain proper alignment of the Notcher blades.

To remove the two lower Notching Blades, remove the six bolts located below the Notcher Base (photo 7). Before replacing, carefully read instructions below on aligning lower Notching Blades.

### Aligning Lower Notching Blades

Alignment of lower Notching Blades on both the hand and power operated Di-Acro Notcher can be made by removing work table and adjusting set screws A, B, and C (photo 8).

To test for exact alignment, insert a piece of paper and notch by hand. If Notcher fails to make a clean even cut at all points, re-adjust lower blades accordingly.



**MODEL #1 HAND NOTCHER  
030-8000800 PARTS LIST**

**\*\*\*Please note: This manual has been modified from the Power Notcher version - Items not used on the manually operated Model 1 Notcher have been removed from this Parts List.\*\*\***

ITEM NO.	PART NO.	DESCRIPTION	QTY USED
(Not Shown)	8030120-200	Cam	1
(Not Shown)	8030120-302	Cam Pin	1
(Not Shown)	8156111-300	Roller	1
(Not Shown)	8310410-100	Bearing 5/8 x 13/16 x 3/4	1
(Not Shown)	8030120-800	Long Handle Arm	1
(Not Shown)	8690100-200	Drive Fitting 3/16	1
(Not Shown)	31X0516C	Jam Nut	1
1	030-1106099	Guard Assy	1
2	030-1405013	Protractor Gauge	2
3	61X0104	Flat Washer	4
4	20A0104C0304	Socket Head Cap Screw	4
5	030-1105012	Table	1
6	61X0308C1332	Flat Washer	2
7	21A0308C1000	Hex Head Cap Screw	2
8	8040110-800	Cap	1
9	21A0516C1508	Hex Head Cap Screw	4
10	1203102	Spring Pin	4
11	21A0516C0102	Hex Head Cap Screw	4
12	61X0308-0104	Flat Washer	4
13	8030570-101	Shim (purple - .0015")	2
	8930570-101	Shim (red - .002")	2
	8940570-101	Shim (green - .003")	2
	8030570-102	Shim (blue .005")	2
14	8030121-300	Ram Weldment	1
15	8030120-900	Upper Blade	1
16	1203101	Dowel Pin	1
17	22C0104C1000	Flat Head Mach Screw	3
20	8060120-300	Cam Roller Pin	1
21	4705101	Retaining Ring	2
22	030-1102002	Upper Casting	1
35	030-1101001	Base	1
36	20A0102C1304	Socket Head Cap Screw	4
37	20A0102C1102	Socket Head Cap Screw	4
38	8030120-901	Lower Blade	2
39	030-1110011	Lower Blade Support	2
40	20A0516C0508	Socket Head Cap Screw	4
41	23A0104C0102	Socket Set Screw	6
42	4901106	Flat Washer	6
43	21A0516C4000	Hex Head Cap Screw	6
48	030-6503105	Instruction Plate	1
49	29AXXX0X0108C	Drive Screw	2
50	62X0508	Lock Washer	4
52	62X0516M	Lock Washer	18