

DiAcro[®]
METAL FABRICATION EQUIPMENT



#2 ROD PARTER 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
MAINTENANCE	PG. 3
TECHNICAL DATA	PG. 3
SET-UP PROCEDURE	PG. 4
REMOVING AND SHARPENING CUTTING HEADS	PG. 4
#2 ROD PARTER BREAKDOWN AND PARTS LIST	PG. 5-6
EJECT-O-MATIC GAUGE PARTS LIST	PG. 6-7
OPTIONAL STAND	PG. 8
WARRANTY	PG. 9

SAFETY INFORMATION



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.**

MAINTENANCE

Apply grease to fitting in Center Stud Bolt periodically.

TECHNICAL DATA

There are nine holes in the cutting dies of the #2 Rod Parter from 1/8" to 5/8" in diameter, in 1/16" increments. All holes are approximately .005" oversize to allow for material clearance. Cutting heads of 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.

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 Eject-o-matic Gauge as follows:

Set Gauge Arm so bolt lines up with Pivot Bolt of Rod Parter, then adjust gauge for desired hole size and length of piece. Only the lower portion of the rod should contact the gauge.

OPTIONAL ACCESSORIES

Cutting dies for “parting-off” square, rectangular, hexagon and other special shaped bar stock are available, call to request a special quotation

REMOVING AND SHARPENING CUTTING DIES

The cutting dies 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 Dies

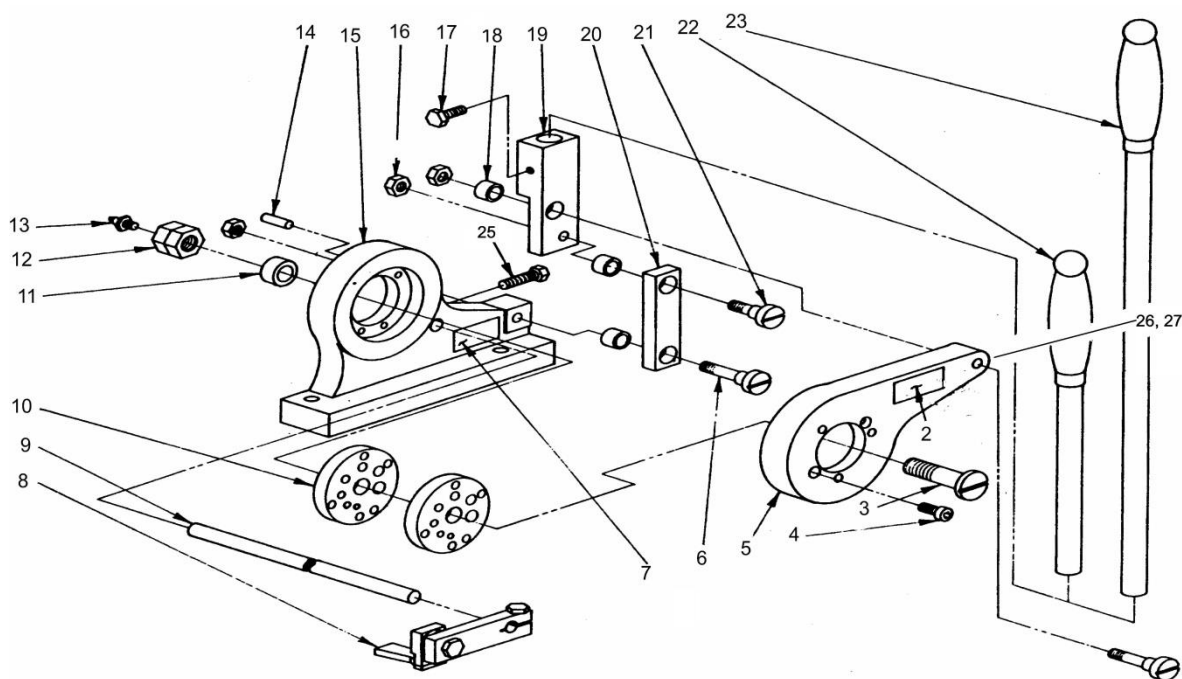
1. Remove Center Pivot Bolt, Link Bolt and disengage from Upper Casting.
2. Remove socket head screws in both the Upper and Base Casting, and tap out cutting dies.

To Sharpen Cutting Dies

Grind them approximately .002” to .005” on a surface grinder.

#2 ROD PARTER PARTS BREAKDOWN

8080810-080



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	PARTING DIE – 1" WIDE	2
11	8080110-800	SPACER	1
12	8470410-200	MALE/FEMALE LOCKNUT	1
13	8690100-200	DRIVE FITTING	1
14	19A0308X1102	PIN-DOWEL 3/8X1-1/2	8
15	8080110-100	BASE	1

PARTS LIST - CONTINUED

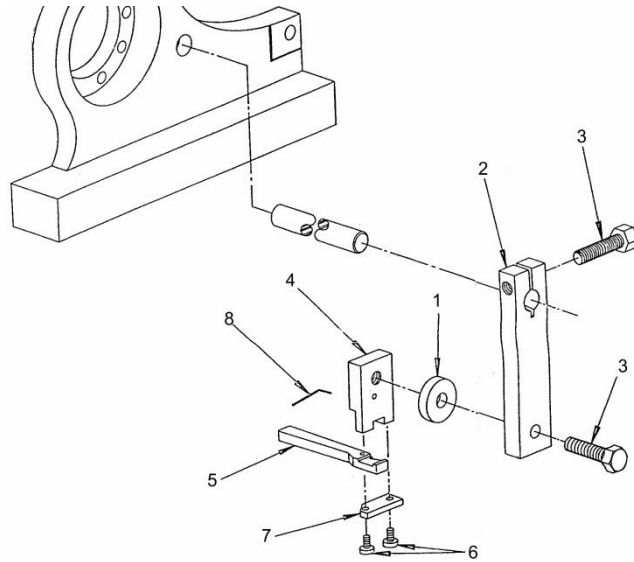
ITEM	PART NUMBER	DESCRIPTION	QTY
16	30X0102C	NUT-FULL 1/2X13	3
17	23A0516C0508	SCREW-SSS 5/16-18X5/8	1
18	8310410-100	BEARING	3
19	8993120-800	HANDLE HOLDER	1
20	8080120-101	LINK	1
21	8300470-100	SHORT STUD BOLT	1
22	8080120-800	HANDLE ARM (SHORT)	1
22A	100-0142-M	HANDLE GRIP	1
23	8000120-871	HANDLE ARM ASSY(LONG) (OPTIONAL)	1
24	62X0102	WASHER-LOCK 1/2(NOT SHOWN - BEHIND ITEM 16)	3
25	23A0516C1000	SCREW-SSS 5/16-18X1	1
26	21A0104C1104	SCREW-HHCS 1/4-20X1-1/4 (NOT SHOWN)	1
27	31X0104C	NUT-JAM (NOT SHOWN)	1
OPTIONAL	8000120-901	PARTING DIES - .015 OVERSIZED FOR HR MAT'L	2

EJECT-O-MATIC 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 Eject-O-Matic 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.

EJECT-O-MATIC GAUGE BREAKDOWN #0808141-070



ITEM	PART NUMBER	DESCRIPTION	QTY
1	8200141-001	EJECTOMATIC SPACER	1
2	8300141-001	EJECTOMATIC ARM	1
3	21A0516C1000	SCREW-HEX 5/16-18X1	2
4	8400141-001	EJECTOMATIC HOLDER	1
5	8500141-001	EJECTOMATIC TRIGGER	1
6	20B0X06C0104	SCREW-BHSCS #6-32X1/4	2
7	8600141-001	EJECTOMATIC PLATE	1
8	8080510-402	SPRING	1

OPTIONAL STAND

Part Number: 8230110-900

Stand Dimensions: 20" WIDE, 15" DEEP, 33-1/4" HIGH

CALL DI-ACRO 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
21A0102C2102	SCREW-HHCS 1/2-13X2-1/2	2
61X0102	WASHER-FLAT 1/2	2
30X0102C	NUT-FULL 1/2-13	2

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