

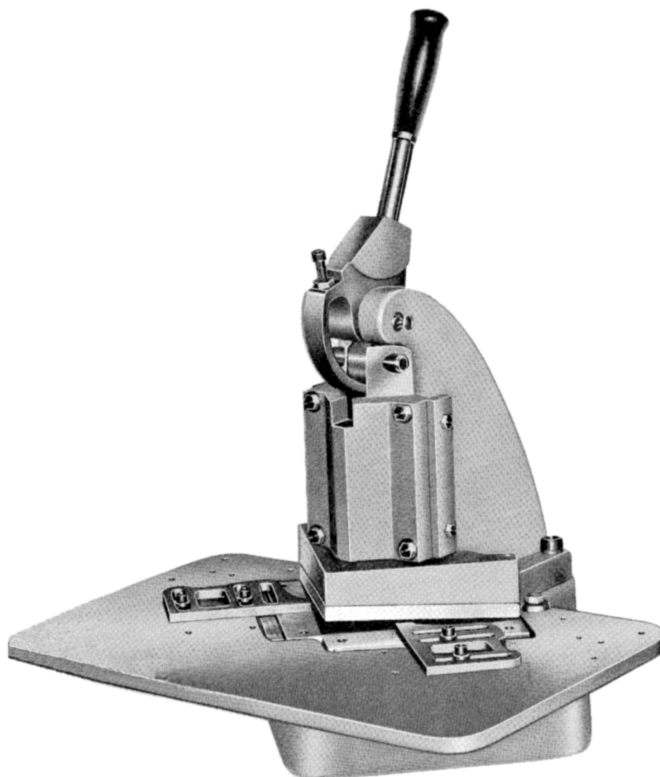
**Di-Acro®**

OPERATOR'S MANUAL & INSTRUCTIONS

# **NUMBER 1**

## **Di-Acro**

# **Hand Notcher**



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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 Gauges for the proper size notch.

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 each different notching operation and does away with time wasted in punch press setup--you simply adjust the Material Gauge and you're ready for production.

A roller cam mechanism is incorporated in the hand operated Di-Acro Notcher which develops a full 4 ton capacity. Sufficient power 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 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 burr.



Di-Acro #1 Hand Notcher on Stand

### Specifications and 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 form 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 resharpenered 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.

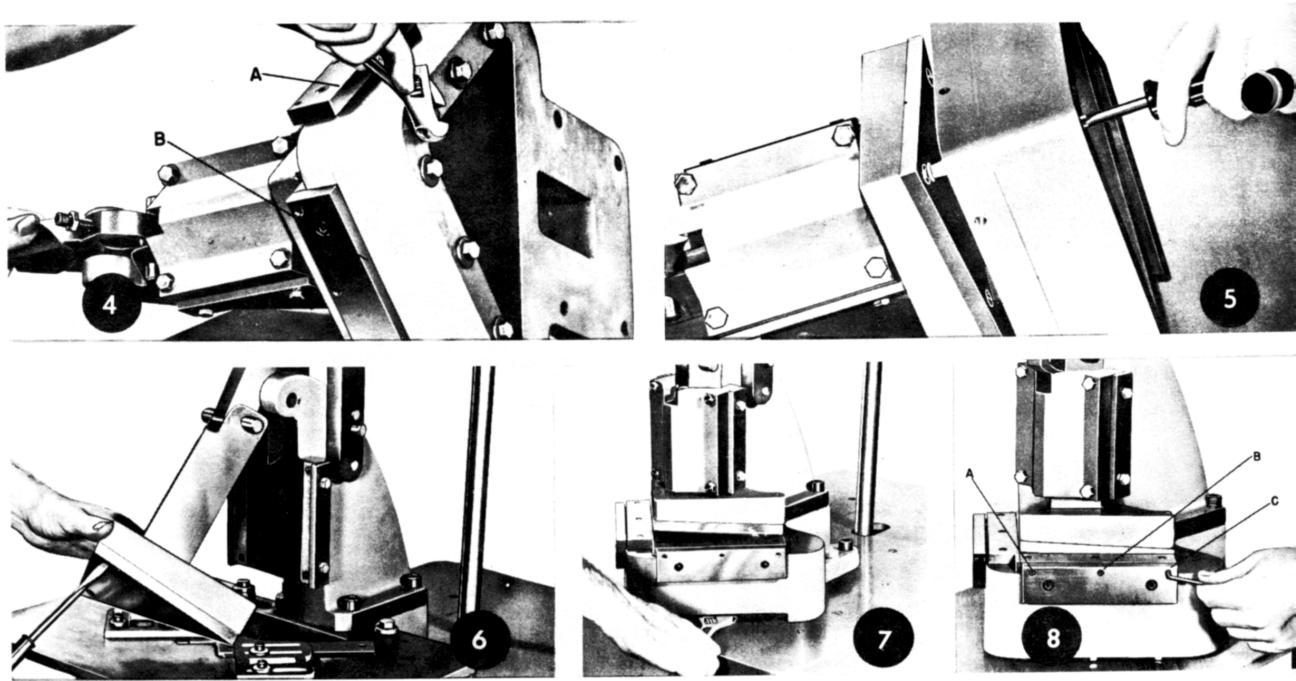
Hardened Steel Notcher Blades.

### Di-Acro Notcher Accessories

High Carbon High Chrome Blades are recommended for use with the notcher when stainless steel, monel and other high silicon-high alloy sheets are to be cut.

### Di-Acro Notcher Stand

Designed to increase operating efficiency, this stand is made of heavy plate steel and especially formed sections welded into a sturdy unit. Height is 36".



### 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 Notching Blades, carefully read instructions below on aligning lower Notching Blades.

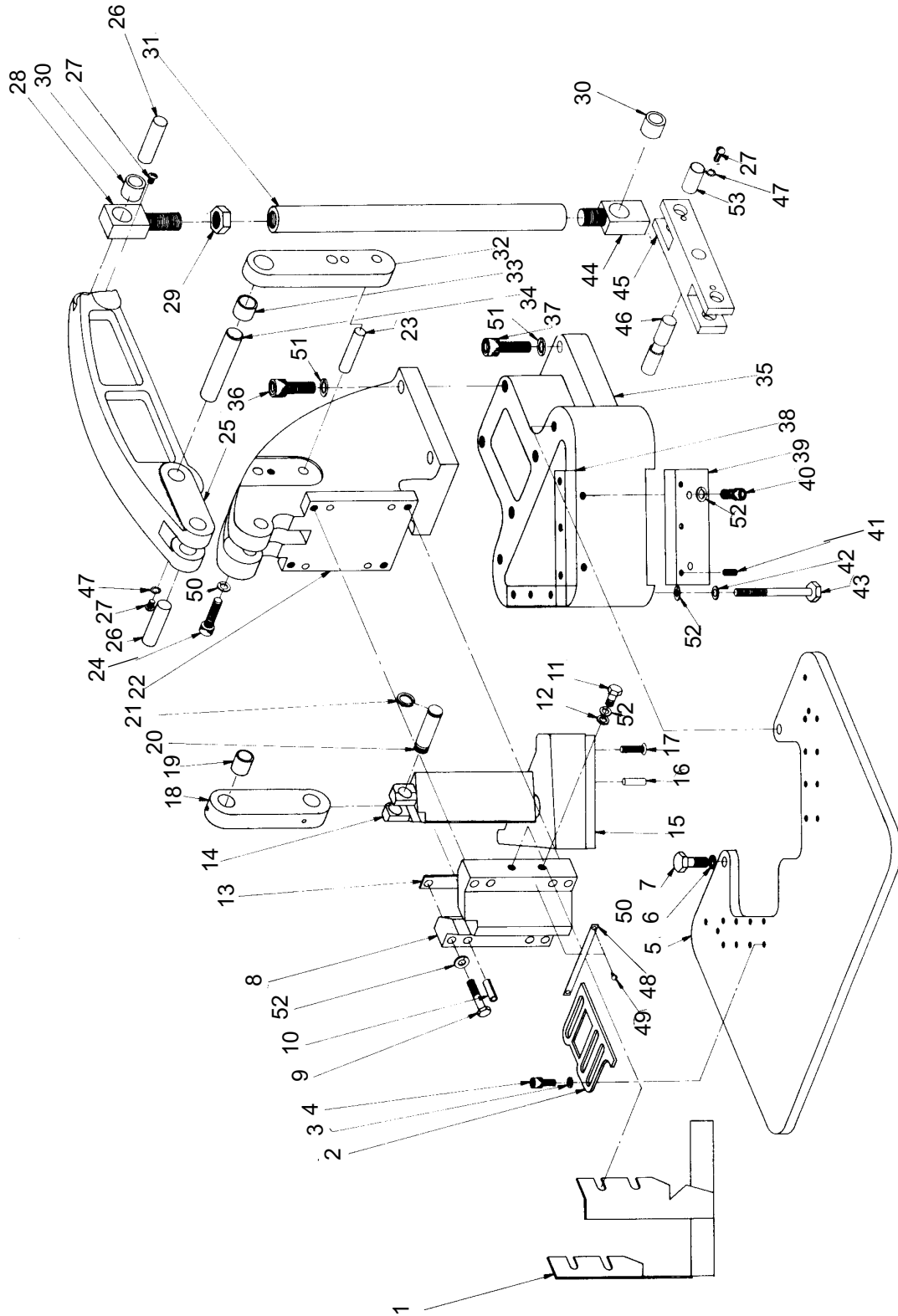
\*CAUTION: If Ram Cap is removed, make sure Shims between Ram and Ram Cap are replaced and Ram remains grit and dust free or it will be impossible to obtain proper alignment of the Notcher Blades.

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, adjust lower Blades accordingly.



Item No.	Part No.	Description	Qty Used
1	030-1106099	Guard Assy	1
2	030-1405013	Protractor Gauge	2
3	61X0104	Flat Washer	4
4	20A0104C0508	Socket Head Cap Screw	4
5	030-1105012	Table	1
6	61X0308C1332	Flat Washer	2
7	21A0308C1000	Hex Head Cap Screw	2
8	040-1108006	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	030-5701017	Shim	2
	030-5701018	Shim	2
	030-5701019	Shim	2
	030-5701020	Shim	2
14	030-1213003	Ram Wldmt	1
15	030-1209009	Upper Blade	1
16	1203101	Dowel Pin	1
17	22C0104C1000	Flat Head Mach Screw	3
18	035-1201078	Ram Link	1
19	3104102	Brg.	2
20	060-1203003	Cam Roller Pin	1
21	4705101	Ret Ring	2
22	035-1102002	Upper Casting	1
23	1203177	Dowel Pin	4
24	20A0308C1102	Socket Head Cap Screw	2
25	035-1215075	Power Arm	1
26	035-1203074	Power Arm Pin	2
27	22D0104C0308	Truss Head Mach Screw	10
28	035-1201051	Rod End	1
29	31X0304F	Jam Nut	1
30	3104101	Brg.	2
31	035-1201050	Connecting Rod	1
32	035-1110076	Power Arm Support	2
33	3104103	Brg.	2
34	035-1203077	Pin	1
35	035-1101001	Base	1
36	20A0102C1304	Socket Head Cap Screw	4
37	20A0102C1102	Socket Head Cap Screw	4
38	030-1209010	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	21A0516C3102	Hex Head Cap Screw	6
44	035-1201053	Rod End	1
45	035-1215071	Rocket Arm	1
46	035-1203070	Rocket Arm Pin	1
47	62X0104	Lock Washer	12
48	030-6503105	Instruction Plate	1
49	29AXXX0X0108C	Drive Screw	2
50	62X0508	Lock Washer	4
52	62X0516M	Lock Washer	18
53	346-1203028	Clamp Pin	2
	030-1202004	Cam (Hand Notcher Only)	1 (Not Shown)
	030-1208007	Long Handle Arm (Hand Notcher Only)	1 (Not Shown)
	156-1113005	Roller (Hand Notcher Only)	1 (Not Shown)
	030-1203020	Cam Pin (Han Notcher Only)	1 (Not Shown)