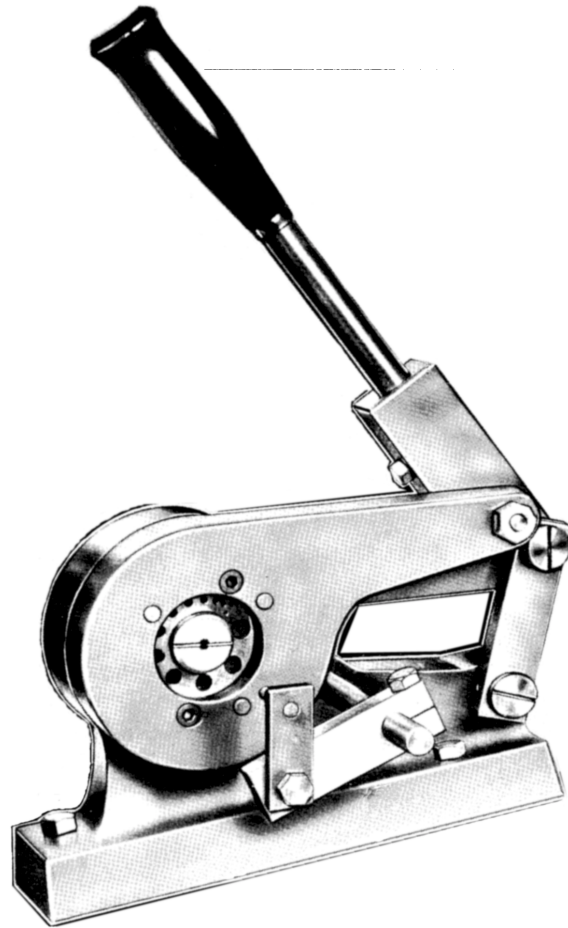


**Di-Acro®**

OPERATOR'S MANUAL & INSTRUCTIONS

# **DI-ACRO #1 HAND OPERATED ROD PARTER**



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Revised 03/02

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### MANUAL PARTER

#### Standard Equipment

Short handle for “parting-off” light material and long handle for “parting-off” heavier material  
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.

### SET UP PROCEDURE

#### Hand Operated Rod Parter

The hand operated Di-Acro Rod Parter is shipped with the Handle and Material Gauge removed. To setup for operation:

1. Bolt Rod Parter to stand or bench and attach handle to handle holder.
2. Install gauge rod to base and attach Ejectomatic Gauge as follows:
  - A. 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.

#### Lubrication

To insure smooth, effortless operation, lubricate the hand Rod Parter periodically in the following places:

#### Hand Model

Grease fitting on Center Stud Bolt, N.G.L.I. No. 2 grease

#### Construction Features

The Di-Acro Rod Parter No.1 is equipped with cutting heads that provide eleven holes graduated in size from 1/16” to 3/8” diameter in steps of 1/32”. 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.

#### 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

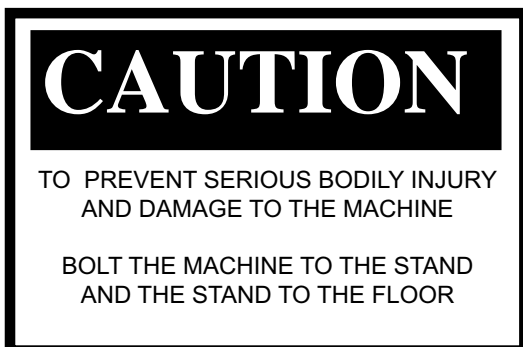
Grind them approximately .002” to .005” on a surface grinder or return them to factory for this service.

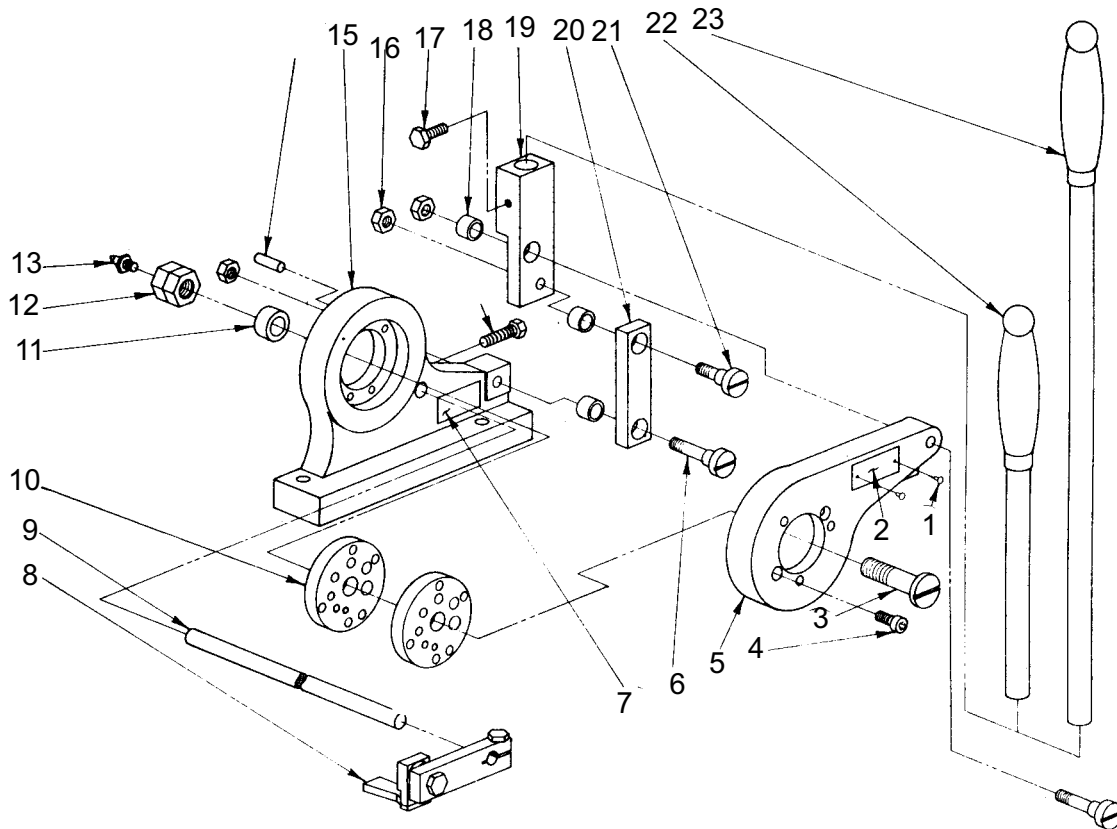
Safe operation of the Di-Acro Rod Parters must be considered as a matter of prime importance by the management as well as the operator.

#### 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 all hand operated Di-Acro Rod Parters.





Item No.	Part No.	Description	Qty Used
1	29AXXX0X0108C	Drive Screw	2
2	070-6501108	Nameplate	1
3	070-4701009	Center Stud Bolt	1
4	20A0516C0304	Socket Head Cap Screw	4
5	070-1102002	Upper Casting	1
6	070-4701007	Long Stud Bolt	2
7	030-6504001	Caution Plate	1
8	070-1410707	Ejectomatic Trigger Assy	1
9	070-1410011	Stop Rod	1
10	070-1209014	Dies	2
11	070-1108003	Spacer	1
12	4704101	M-F Lock Nut	1
13	1203144	Dowel Pin	6
14	070-1101001	Base Casting	1
15	30X0308C	Hex Nut	3
16	21A0516C1000	Hex Head Cap Screw	2
17	3104107	Bearing	3
18	070-1208006	Handle Holder	1
19	070-1201010	Link	1
20	070-4701008	Short Stud Bolt	1
21	030-1208713	Short Handle Arm Assy	1
22	030-1208714	Long Handle Arm Assy	1