

MODEL NO. 50 ANGLE IRON NOTCHER
OPERATION, PARTS & MAINTENANCE MANUAL

Model:	Purchased From:
Serial #:	Date Received:



MADE IN THE USA

An American Tradition Since 1910

FOREWORD

This manual has been prepared for the owner and operators of Roper Whitney No. 50 Angle Iron Notcher. Its purpose, aside from operations instructions, is to promote safety through the use of accepted operating procedures. Read all instructions thoroughly before operating the notcher.

Also contained in this manual is the parts list for your notcher. It is recommended that only Roper Whitney or factory authorized parts be used as replacements.

Warranty Statement:

3 YEAR LIMITED WARRANTY

Roper Whitney ("Manufacturer") warrants, commencing with the date of shipment to first end-user ("Customer") and for a period of thirty-six (36) months thereafter, all machinery and parts manufactured by Manufacturer to be free of defects in workmanship and material. **This warranty remains in force for the above time period only if all of Manufacturer's operational procedures are followed and recommended maintenance is performed.** If, within such warranty period, any machinery or parts manufactured by Manufacturer shall be proved to Manufacturer's satisfaction to be defective, such machinery or parts shall be repaired or replaced, at Manufacturer's option. All warranty claims are made F.O.B Manufacturer's plant, providing such machinery or parts are returned freight prepaid to Manufacturer's plant or designated service center for Manufacturer's inspection. All failed parts or components must be returned to Manufacturer prepaid for inspection before credit will be issued for new parts or components. Manufacturer's obligation hereunder shall be confined to such repair or replacement and does not include any charges, direct or indirect, for removing or replacing defective machinery or parts. No warranty shall apply to machinery, or parts or accessories, which have been furnished, repaired, or altered by others so as, in Manufacturer's judgment, to affect the same adversely or which shall have been subject to negligence, accident or improper care, installation, maintenance, storage, or other than normal use or service, during or after shipment. No warranty shall apply to the cost of repairs made or attempted outside of Manufacturer's plant or designated service center without Manufacturer's authorization. No warranty shall apply with respect to machinery or part not manufactured by Manufacturer, including but not limited to motors, accessories, electrical and hydraulic components, if such machinery or part is subject to warranty by the manufacturer of such machinery or part. No warranty claims by Customer will be honored with respect to any machinery or part from which the name and date plate has been removed or is otherwise no longer located or exhibited on such machinery or part. **THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY AND IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. MANUFACTURER SHALL NOT BE SUBJECT TO ANY OTHER OBLIGATIONS OR LIABILITIES WHATSOEVER WITH RESPECT TO MACHINERY, PARTS, ACCESSORIES, OR SERVICES MANUFACTURED OR FURNISHED BY IT OR ANY UNDERTAKINGS, ACTS, OR OMISSIONS RELATING THERETO. UNDER NO CIRCUMSTANCES SHALL MANUFACTURER BE LIABLE FOR ANY CONSEQUENTIAL OR OTHER DAMAGES, EXPENSES, LOSSES, OR DELAYS HOW SO EVER CAUSED.**

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.

Note: Consumable tooling is not covered under the 3 year manufacturer's warranty.

RETURN OF THE PRODUCT REGISTRATION CARD FURNISHED WITH THE PRODUCT IS NECESSARY TO OBTAIN WARRANTY COVERAGE THEREON. CARD MUST BE FULLY COMPLETED, SIGNED BY THE PURCHASER, AND IF APPLICABLE, SIGNED BY THE DISTRIBUTOR. RETURN REGISTRATION CARD TO:



Roper Whitney / 2833 Huffman Blvd. / Rockford, IL 61103 / 815-962-3011 / Fax 815-962-2227
www.roperswhitney.com

SAFETY INSTRUCTIONS

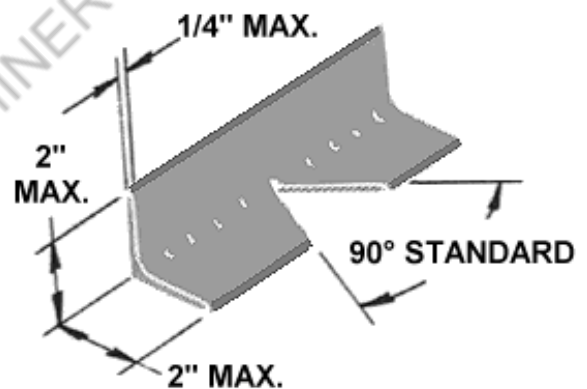
FOR MAXIMUM OPERATOR SAFETY DO:

1. Read and understand this manual.
2. Be sure you notch within capacity of tool.
3. Wear safety glasses.

CAUTION: After angle has been notched, front clamp screw (13) must be backed out to free clamp bracket (14). This must be done prior to reversing spindle direction. Failure to do so will result in damage to tool.

SPECIFICATIONS		
	IN	MM
Capacity	2" x 2" x 1/4"	
Height	12	304.8
Width	9 1/2	241.3
Length	13	330.2
Weight	55 Lbs*	

* Includes 32" operating bar handle.

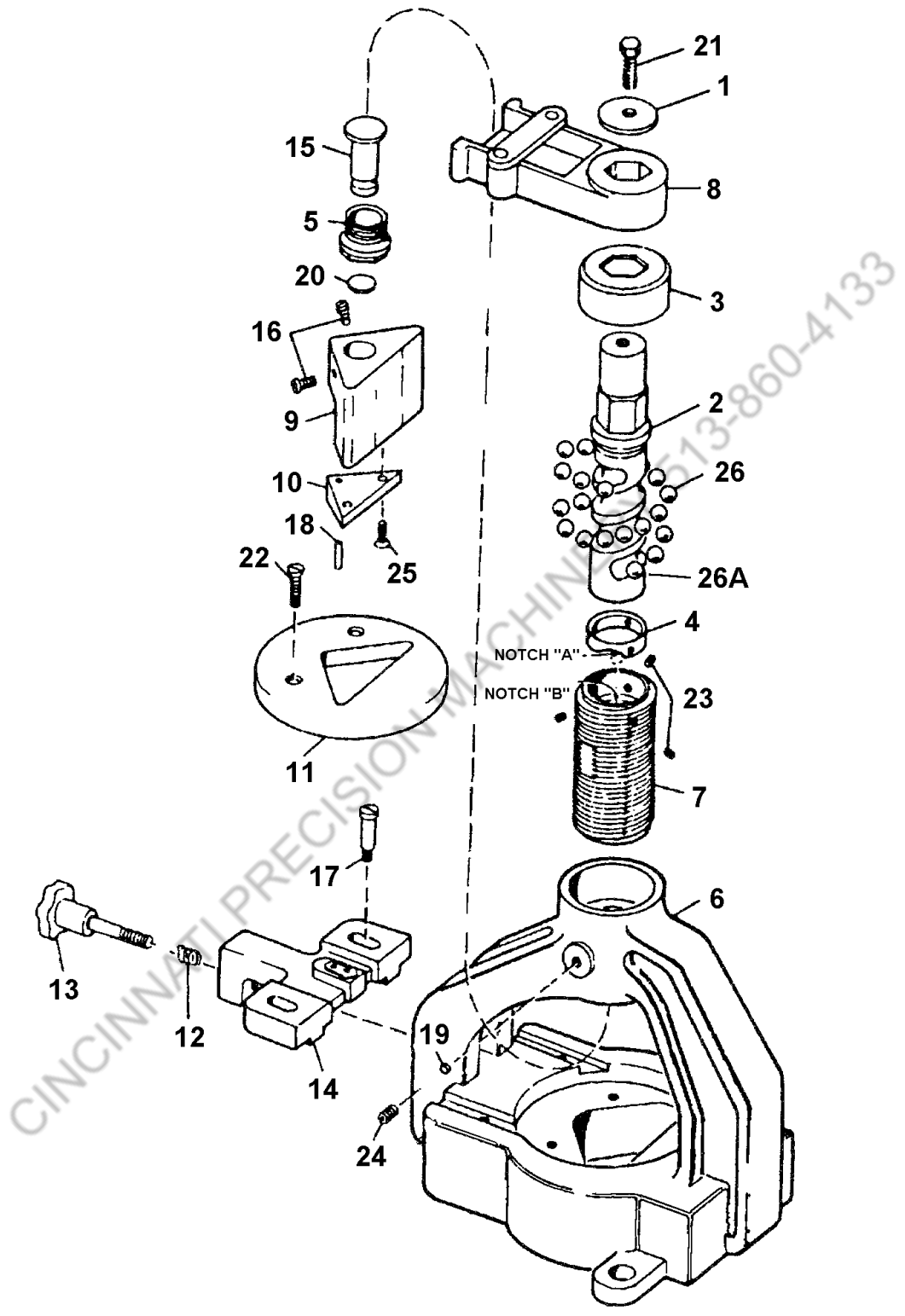


INSTRUCTIONS

CARE: Before attaching coupling pin to spindle grease coupling head.

OPERATION: Coupling nuts have left hand thread. To assemble spindle, place a small amount of heavy grease in ball race of spindle. Slide stop collar on spindle with notch "A" in stop collar in down position. Place 30 ball bearings (11/32") in ball race of spindle and thread into ball race sleeve as far as possible; turn back until ball race can be seen. Align notch "A" in stop collar with "B" start of ball race in frame and tighten the three-stop collar set screws. Screw ball race sleeve into punch body until bottom of ball race sleeve is even with bottom of punch body. Align flats and insert set screw plugs and screws.

NO. 50 PARTS LIST



Roper Whitney / 2833 Huffman Blvd. / Rockford, IL 61103 / 815-962-3011 / Fax 815-962-2227
www.ropwhitney.com

NO. 50 PARTS LIST

ITEM NO.	PART NO.	PART NAME	QTY.
1	678033116	Handle Washer	1
2	730770083	Spindle	1
3	740220072	Dust Cap	1
4	730260085	Stop Collar	1
5	331002011	Coupling Nut	1
6	740140067	Frame	1
7	730520084	Ball Race Sleeve	1
8	731460159	Operating Handle	1
9	740010068	Shear Blade Holder	1
10	745120053	Shear Blade	1
11	350700213	Shear Die	1
12	600184522	Clamp Spring	1
13	740650078	Front Clamp Screw	1
14	740670079	Clamp Bracket	1
15	740160077	Coupling Pin	1
16	740650069	Blade Holder Set Screws	2
17	740650070	Clamp Hold Down Screws	2
18	600053316	Shear Blade Dowel Pin	1
19		See #24	
20	740570071	Pressure Plug	1
21	601012128	Handle Washer Screw 5/16-18 x 1/2 Hex Head	1
22	613012177	Die Screws 3/8-16 x 1 1/4 Flat Head	2
23	623012082	Stop Collar Set Screws 1/4-20 x 1/4 Headless Cone Pt	3
24	600010474	Brass Tip Set Screw 7/16-14 x 5/8 Socket Set	2
25	613012088	Shear Blade Screws 1/4-20 x 5/8 Flat Head	2
26	600093702	11/32 Ball Bearings	31
26A	600093700	Ball Bearing	1
27	731460188	32" Bar Handle (not shown)	1
*	245940000	Ball Race Sleeve Assembly Consists of item numbers: 2, 4, 5, 7, 15, 23 and 26 fully assembled.	1