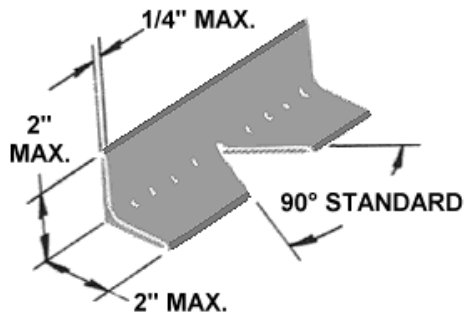
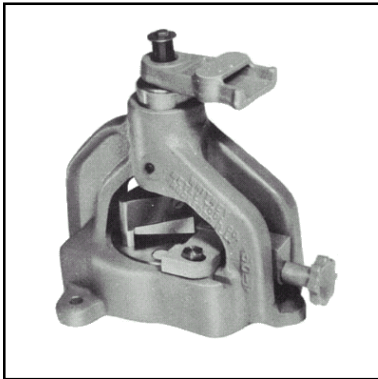


# NO. 50 ANGLE IRON NOTCHER

## INSTRUCTIONS AND PARTS LIST



**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.

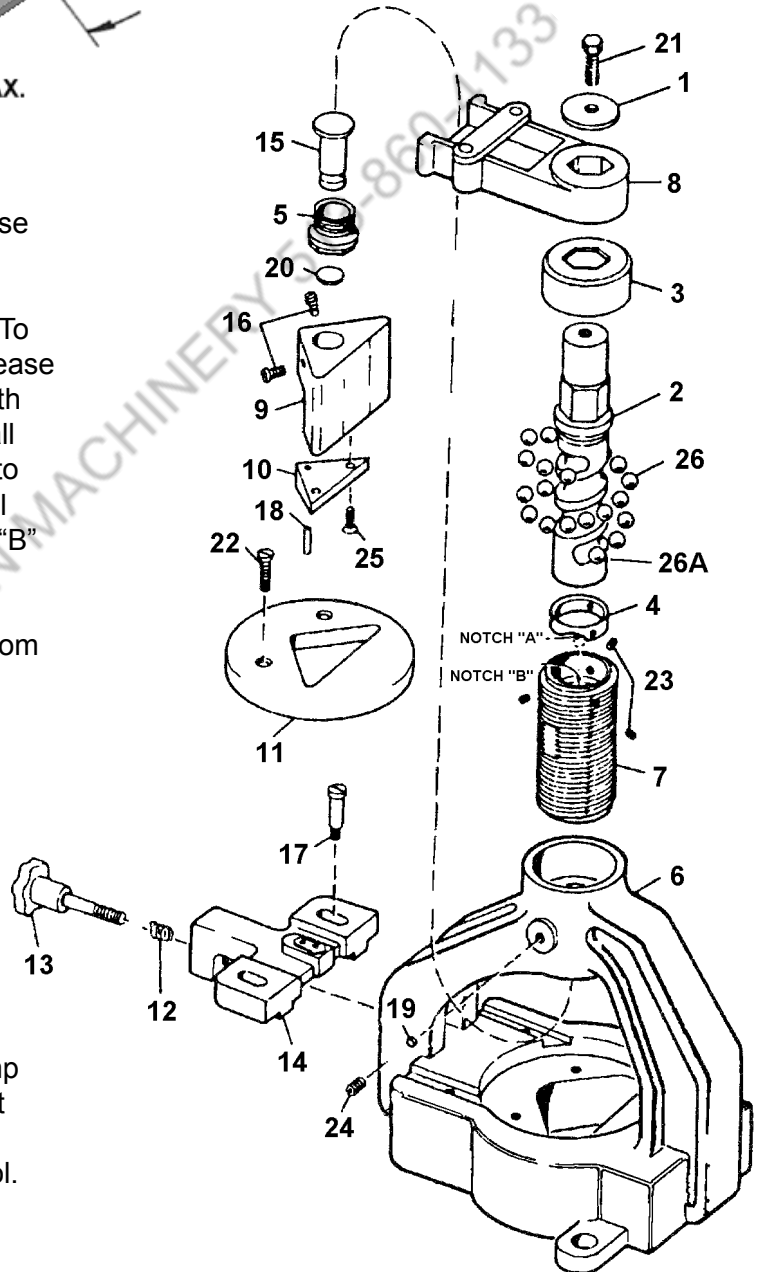
**FOR MAXIMUM OPERATOR SAFETY DO:**

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

**FOR MAXIMUM OPERATOR SAFETY DO NOT:**

1. Notch over capacity of the tool.

**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.



**ROPER WHITNEY OF ROCKFORD, INC.**

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## NO. 50 ANGLE IRON NOTCHER 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	350700212	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

**When ordering, list Item No., and Part Name**