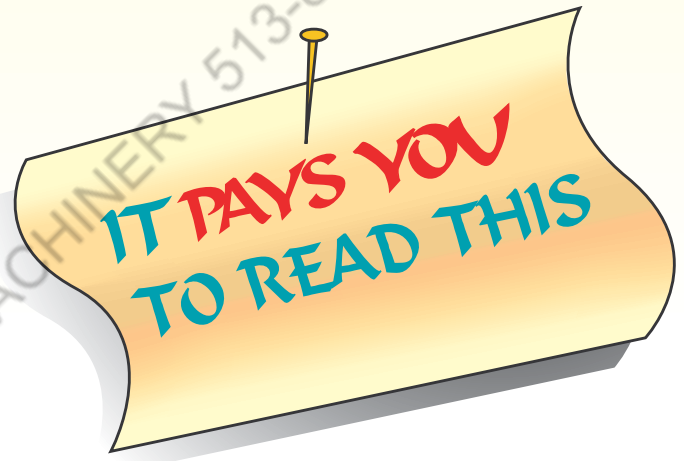
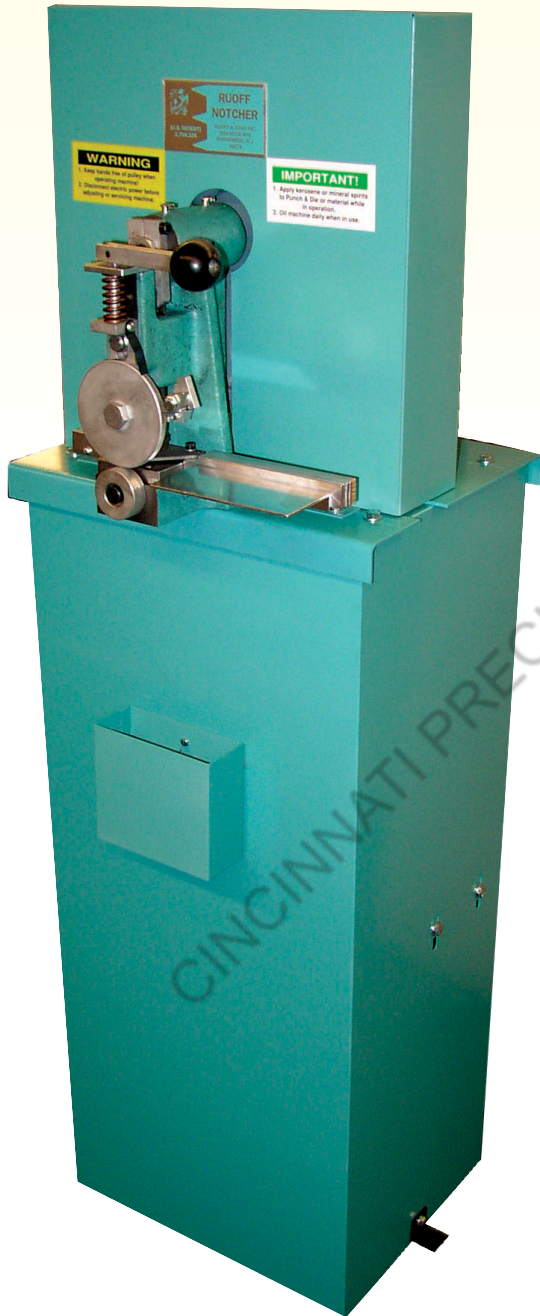


OPERATING INSTRUCTIONS AND PARTS LIST FOR **RUOFF NOTCHER**



When ordering parts mention
the part number and name. All
parts F.O.B. Factory.

PHONE 856-931-2064
FAX 856-931-0539

1030 ROSE AVENUE
RUNNEMEDE, NJ 08078

RUOFF & SONS, INC.

**WARNING: Keep hands free of pulley when operating machine.
Disconnect electric power before adjusting or
servicing Notcher.**

OPERATING INSTRUCTIONS

FLAT MATERIAL

To feed flat material into the Notcher, hold the material against the guide bar (54) and then move the material into position under the stripper plate (57) and between the feed wheel (34) and support wheel (42). The Notcher will feed automatically when the lever (22) is in the down position without any pushing

until the edge of the material is completely notched or until you remove the material from the Notcher after raising the lever (22).

IMPORTANT: Apply kerosene or mineral spirits to punch & die or material while in operation.

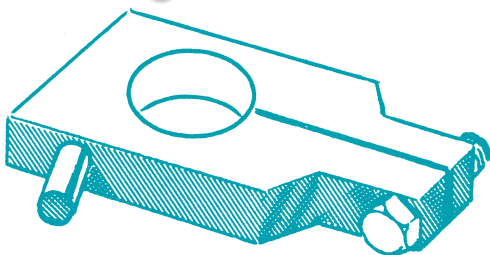
HOW TO SET SPACING OF NOTCH

To adjust the Notcher for different width of tabs or spacing turn the pulley by hand until the rocker arm (35) is in horizontal position, then loosen the collar screw (38) and turn the collar (39) in

either direction. Turning the collar (39) clockwise will shorten the tabs and counter clockwise will widen the tabs.

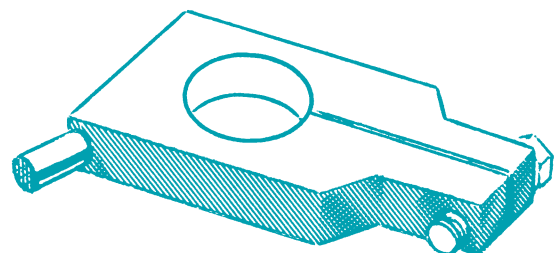
COLLAR POSITION FOR MAXIMUM AND MINIMUM SPACING OF NOTCH

Top View Max. Range



To obtain these different positions remove the punch (17) and die assembly and slip the collar (39) off the ram (16).

Top View Min. Range



Then tap the collar pin (37) to the other side of the collar (39) and replace the collar (39) upside down.

HOW TO SET DEPTH OF NOTCH

Four long spacers (52) and four short spacers (53) are provided with the Notcher. If the notch depth is too deep for your operations, loosen the two table screws (49) and insert the long spacers

(52) between the table (51) and guide bar (54). The short spacers (53) should be screwed to the left side of the guide bar (54). Each spacer reduces depth of notch by 1/8 ".

HOW TO SHARPEN THE PUNCH AND DIE

NOTE: Part #'s 17, 50, 54, 55, 57, & 58 can be returned to Ruoff & Sons for free estimate to sharpen and/or repair individual components.

The die assembly must be removed before the punch (17) can be removed. To remove the die assembly remove the two die screws (48) from the bottom of the casting (1). Then remove the guide bar screws (55) making sure the die locating portion of the guide bar (54) does not get burred. To properly sharpen the die (50) grind it evenly on the top surface and remove as little metal as possible to ensure a long die life.

To remove the punch (17), loosen set screw (17A) and raise the ram (16) to its highest position by turning the pulley (4) by hand and gently tap the punch (17) from its socket in the ram (16). The punch (17) must also be ground evenly

along its cutting surface and should have a slight shear angle as originally ground. In replacing the punch (17) and die (50) the same steps should be followed being sure to secure the punch (17) in the ram (16) before placing the die assembly onto the casting (1) and before inserting the two die screws (48).

1. Raise the ram (16) by turning the pulley (4) by hand.
2. Raise the die assembly and position the stripper plate (57) onto the punch (17).
3. Bring the ram (16) down to the bottom of the stroke, making sure the punch (17) enters the die (50).

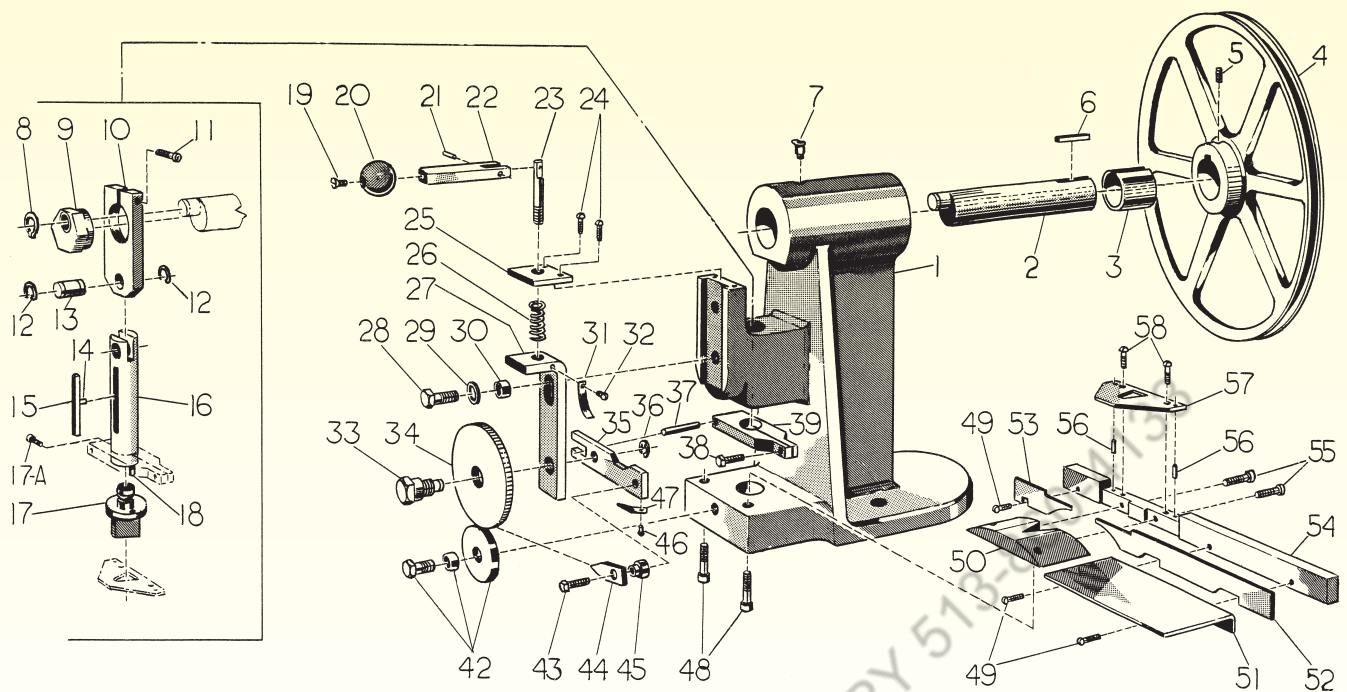
The ram (16) must be adjusted after sharpening the punch (17) and die (50) to make sure the punch (17) is entering the die (50) 1/32".

HOW TO ADJUST THE RAM

The ram (16) is properly adjusted when the punch (17) enters the die (50) approximately 1/32" on the bottom of the stroke and also clears the bottom of the stripper plate (57) on the upstroke before the feed wheel (34) turns. These conditions can easily be met as follows:

1. Lower the ram (16) to the bottom of the stroke.
2. Loosen the connecting link screw (11).

3. Turn the eccentric hex bushing (9) until the punch (17) enters the die (50) approximately 1/32".
4. Tighten the connecting link screw (11).
5. Check if the punch (17) clears the bottom of the stripper plate (57) on the upstroke before the feed wheel (34) turns. If not, the punch (17) is in the die (50) more than 1/32" and must be raised by adjusting the eccentric hex bushing (9).



*To ensure a correct fit, the components (part #s 17,50,54,55,56,57 and 58) of the Punch & Die Assembly are made and assembled as a unit and are not interchangeable. Punch & Die Assemblies can be returned to Ruoff & Sons for free estimate to replace and/or repair individual components. Component parts of Punch & Die Assembly may not be ordered separately.

PARTS LIST

- | | | |
|--|--|--|
| 1. Casting | 22. Lever | 48. Die Screws |
| 2. Crankshaft | 23. Stud | 49. Table Screws and Spacer Screws |
| 3. Pulley Sleeve | 24. Top Plate Screws | 50. Die |
| 4. Pulley
Standard -Single Groove
Heavy Duty-Double Groove | 25. Top Plate | 51. Table |
| 5. Pulley Set Screw | 26. Coil Spring | 52. Long Spacer |
| 6. Pulley Key | 27. Sliding Bracket | 53. Short Spacer |
| 7. Oil Cup | 28. Sliding Bracket Screw | 54. Guide Bar |
| 8. Crankshaft Retaining Ring
Waldes Truarc #5105-50 | 29. Sliding Bracket Washer | 55. Guide Bar Screws |
| 9. Eccentric Hex Bushing | 30. Sliding Bracket Bushing | 56. Stripper Plate Dowel Pins |
| 10. Connecting Link | 31. Feed Wheel Spring | 57. Stripper Plate |
| 11. Connecting Link Screw | 32. Feed Wheel Spring Screw | 58. Stripper Plate Screws |
| 12. Connecting Link Pin
Retaining Rings-Waldes
Truarc #5103-50 | 33. Feed Wheel Shoulder Bolt | The following parts are not
shown on the illustration: |
| 13. Connecting Link Pin | 34. Feed Wheel | 59. Stand |
| 14. Ram Key Self Lock Pin | 35. Rocker Arm | 60. Pulley Guard with Bracket |
| 15. Ram Key | 36. Feed Wheel Shoulder Screw
Retaining Ring-Waldes
Truarc # 5133-25 | 61. Scrap Bucket |
| 16. Ram | 37. Collar Dowel Pin | 62. Motor
Standard-1/4 H.P.
Heavy Duty-3/4 H.P. |
| 17. Punch | 38. Collar Screw | 63. Motor Pulley
Standard-Single Groove
Heavy Duty-Double Groove |
| 17A Punch Set Screw | 39. Collar | 64. V-Belt |
| 18. Punch Locating Self Lock Pin | 42. Support Wheel Assy.
(incl #40 & #41) | 65. On-Off Switch |
| 19. Lever Knob Screw | 43. Pawl Screw | 66. Rubber Cord with Plug |
| 20. Lever Knob | 44. Pawl | |
| 21. Lever Self Lock Pin | 45. Pawl Bushing | |
| | 46. Pawl Spring Screw | |
| | 47. Pawl Spring | |