OPERATING INSTRUCTIONS AND PARTS LIST FOR RUOFF NOTCHER

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

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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 $\frac{1}{8}$ ".

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).

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 burried. 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).
*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  
2. Crankshaft  
3. Pulley Sleeve  
4. Pulley  
   Standard -Single Groove  
   Heavy Duty-Double Groove  
5. Pulley Set Screw  
6. Pulley Key  
7. Oil Cup  
8. Crankshaft Retaining Ring  
   Waldes Truarc #5105-50  
9. Eccentric Hex Bushing  
10. Connecting Link  
11. Connecting Link Screw  
12. Connecting Link Pin  
   Retaining Rings-Waldes  
   Truarc #5103-50  
13. Connecting Link Pin  
14. Ram Key Self Lock Pin  
15. Ram Key  
16. Ram  
17. Punch  
17A Punch Set Screw  
18. Punch Locating Self Lock Pin  
19. Lever Knob Screw  
20. Lever Knob  
21. Lever Self Lock Pin  
22. Lever  
23. Stud  
24. Top Plate Screws  
25. Top Plate  
26. Coil Spring  
27. Sliding Bracket  
28. Sliding Bracket Screw  
29. Sliding Bracket Washer  
30. Sliding Bracket Bushing  
31. Feed Wheel Spring  
32. Feed Wheel Spring Screw  
33. Feed Wheel Shoulder Bolt  
34. Feed Wheel  
35. Rocker Arm  
36. Feed Wheel Shoulder Screw  
   Retaining Ring-Waldes  
   Truarc # 5133-25  
37. Collar Dowel Pin  
38. Collar Screw  
39. Collar  
40. Support Wheel Assy.  
   (incl #40 & #41)  
41. Pawl Screw  
42. Pawl  
43. Pawl Bushing  
44. Pawl Spring Screw  
45. Pawl Spring  
46. Pawl Spring Screw  
47. Pawl Spring  
48. Die Screws  
49. Table Screws and Spacer Screws  
50. Die  
51. Table  
52. Long Spacer  
53. Short Spacer  
54. Guide Bar  
55. Guide Bar Screws  
56. Stripper Plate Dowel Pins  
57. Stripper Plate  
58. Stripper Plate Screws  
59. Stand  
60. Pulley Guard with Bracket  
61. Scrap Bucket  
62. Motor  
   Standard-1/4 H.P.  
   Heavy Duty-3/4 H.P.  
63. Motor Pulley  
   Standard-Single Groove  
   Heavy Duty-Double Groove  
64. V-Belt  
65. On-Off Switch  
66. Rubber Cord with Plug