

NOTCHER 50/60/65/75/100dx/120 Ton Ironworkers



CAUTION

Your Ironworker includes a notcher as a standard feature. When maintained within tolerance, the notcher will provide a distortion and burr free shear cut to mild steel bar, plate or angle iron. Notcher tooling is equipped with one, three-sided top notcher blade and three, four-sided bottom blades. The top blade is mounted to the moving “center” of the Ironworker, while the bottom three blades are secured into a base housing. Notcher blades are wearing parts and need to be maintained or replaced over time. Observe the following procedure when maintaining the Ironworker notcher station.

Turn off power to machine by depressing the red stop / off button and lockout upstream power at the main electrical panel.

Remove and replace moving blade:

1. Remove or swing the notcher guard assembly up and away from the notcher table.
2. Remove the two 1/2” socket head cap screws that secure the existing top notcher blade to the moving center.
3. Clean the keyway in the moving center of any dirt or debris.
4. Install the top notcher blade with the keyway up. Secure the top blade using the two 1/2” socket head cap screws. Tighten bolts.

Remove and replace stationary blades:

1. The notcher table includes three blades secured within the table housing. Remove the four 1/2” bolts and washers that secure notcher table to the base table.
2. Remove the six, 3/8” socket head cap screws that secure the blades into the base table housing.

3. Clean the blade pockets of any dirt or debris.
4. The bottom shear blades have multiple cutting surfaces. Either rotate/flip the existing blade set to the new cutting surfaces or install new cutting blades into the blade pockets. Re-install the six 3/8” socket head cap screws and tighten. The blades should be planar to each other at the top surface of the working table.
5. Re-install the notcher table with the open “U” facing the center of the machine. The guide foot of the top notcher blade should be centered within the base table blades.
4. Loosely secure the notcher table from the underside of the base with four 1/2” bolts and washers (provided).
5. Check for top and bottom blade alignment by powering up the machine and slowly inching down the top blade to meet the bottom blades with the foot pedal. Power the machine off.
6. Using a feeler gauge, adjust the clearance between the perimeter of the top and bottom blades to allow for .010 clearance on all three sides.
7. In the event that the top and bottom blades are not aligned, simply loosen the bolts under the table allowing the table to be moved to center the top blade within the bottom blades. When aligned, tighten the table bolts to secure the table.
8. Adjust the cap screws at the end of the notcher table to engage the base notcher table to the base table. Lock the two 3/8” nuts in place to secure the cap screws in place.
9. Swing the notcher guard back in place.