

# **Lockformer / 5 foot and 10 foot Speednotch**

## **INSTALLATION PROCEDURE**

**IMPORTANT:** Because of shipping requirements and possible spillage of hydraulic fluid, the unit is tested at Lockformer's plant and the hydraulic fluid is drained. Therefore, it will be necessary to fill the unit before start up.

Before attempting to run unit, fill reservoir with 3 1/2 gallons of a commercial hydraulic oil having a viscosity of 150 SSU @ 100° F. An acceptable substitute for the above hydraulic oil is type A Automatic Transmission Fluid, available at auto service stations. A ruler inserted to the bottom of the reservoir will indicate 7 1/2" when the proper oil level is reached.

**CAUTION:** Severe damage to pump will result if run without oil in the reservoir.

**PRELIMINARY:** After uncrating, locate unit, with or without base skid to area of operation. Unbind foot switch cord, power cord and cylinder hoses and remove gauge pin bag.

**ELECTRICALS:** Normal electrics 110 Volt, 60 Cycle, Single Phase Motor furnished I H.P. X 3600 R.P.M. Full load amps 11.8. Check local code restrictions for electrical service required.

## **OPERATING INSTRUCTIONS**

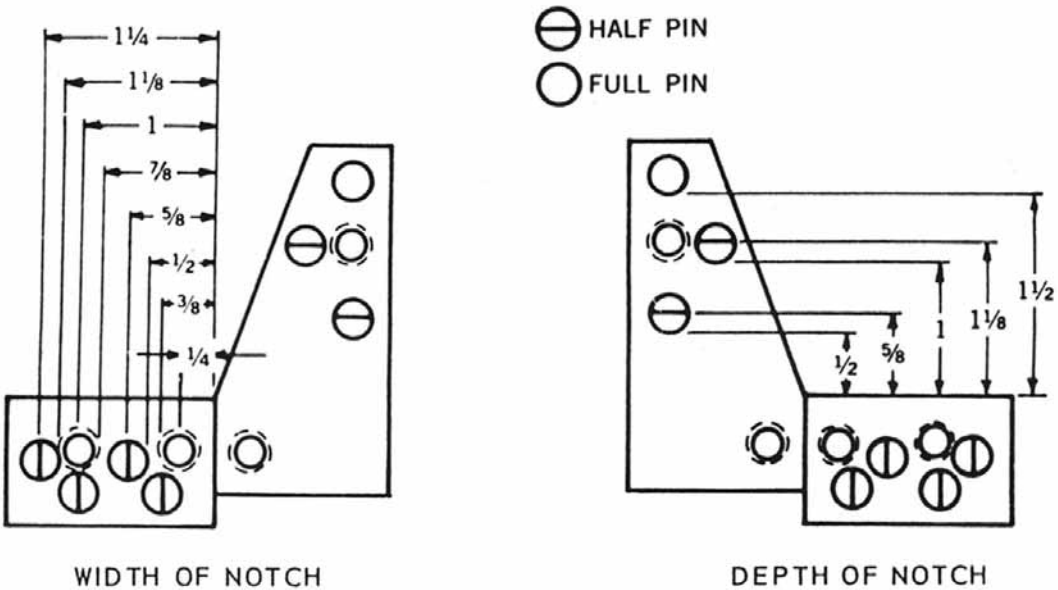
**CAPACITY:** 20 Gauge or lighter galvanized or cold rolled steel.

**OPERATION:** Loosen left hand notching head and slide to zero mark on back scale, clamp into position. Move Vee Notching Heads to required spacing by locating left side of heads to required measurement from zero on scale.

**PROCEDURE FOR TYPICAL 4" x 12" DUCT IN 22 GAUGE  
MATERIAL - ONE PIECE CONSTRUCTION**

1. Left forming head set at zero. **NOTE!** Width of notch required for 5/16" Pittsburgh Lock is 1" therefore, a half-pin is required in hole indicated as 1" on width of notch sketch, Using Standard "S" Cleats and Drive Cleats would require a minimum depth of notch to be 1", therefore, a full pin is required in hole indicated as 1" on depth of notch sketch. (See Sketch No. 1)

Notching heads will notch the equivalent of 20 Gauge. (.040") material, therefore, more than one thickness of lighter gauge materials can be notched in one operation, provided combined thickness does not exceed .040".



**SKETCH 1**

2. Move First Vee notch head to either 4" or 12" on tape and secure.
3. Move second Vee Notch head to 16" and secure. NOTE! 4" @ 12" = 16")
4. Move third Vee Notch head to 20" or 28" dependent on setting of first Vee Notching head. (NOTE! 4 + 12 + 4= 20 or 12 + 4 + 12 = 28)
5. Move right hand notching head to required notch width of 1/4" for right angle flange.

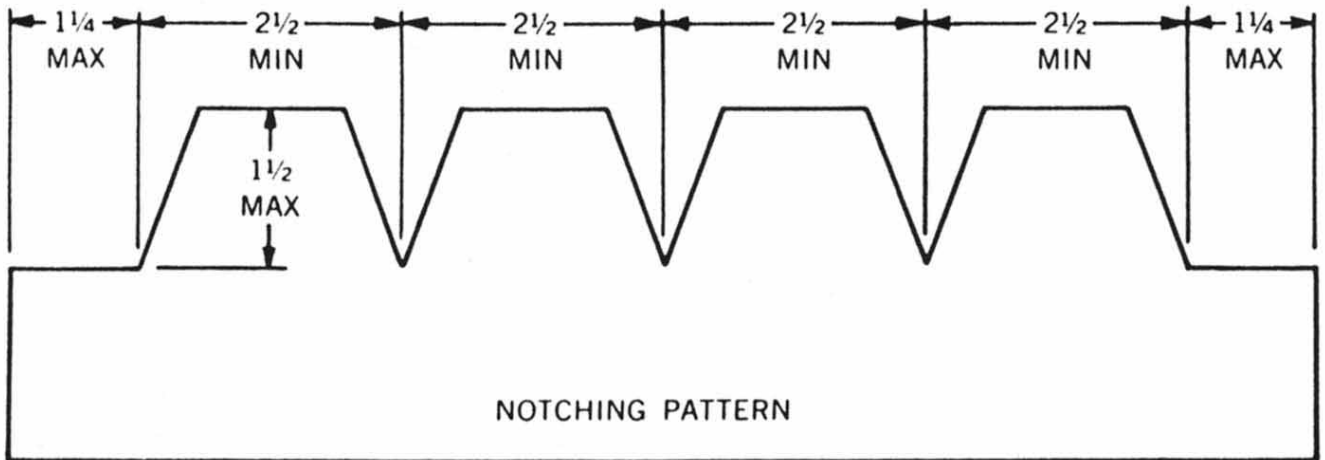
NOTE: Place gauge pin into hole for gauging set up piece. Pin may be removed for easier gauging on similar size sheets. Place back gauge pin into proper hole I" for depth of notch.

Place proper width of material 33 1/4" (for 22 Gauge 4" x 12" one piece duct using 5/16" Pittsburgh Lock and 1/4" 90° Flange) onto gauge support table and square duct to gauge pins. Activate notching heads by depressing foot switch until notching is completed. Release foot switch and remove completely notched duct sheet.

CAUTION: Release foot switch immediately after cutting is completed. If foot switch is kept depressed oil pressure will be at maximum setting of relief valve and will cause unnecessary heating of oil and possible damage to pump.

NOTE: When two piece duct construction is manufactured, the notching heads that are not required can be quickly deactivated by closing the valve located on each cylinder. This makes heads not required inoperative.

## NOTCHING DIAGRAM FOR TYPICAL SQUARE DUCT



### NOTCHING HEADS:

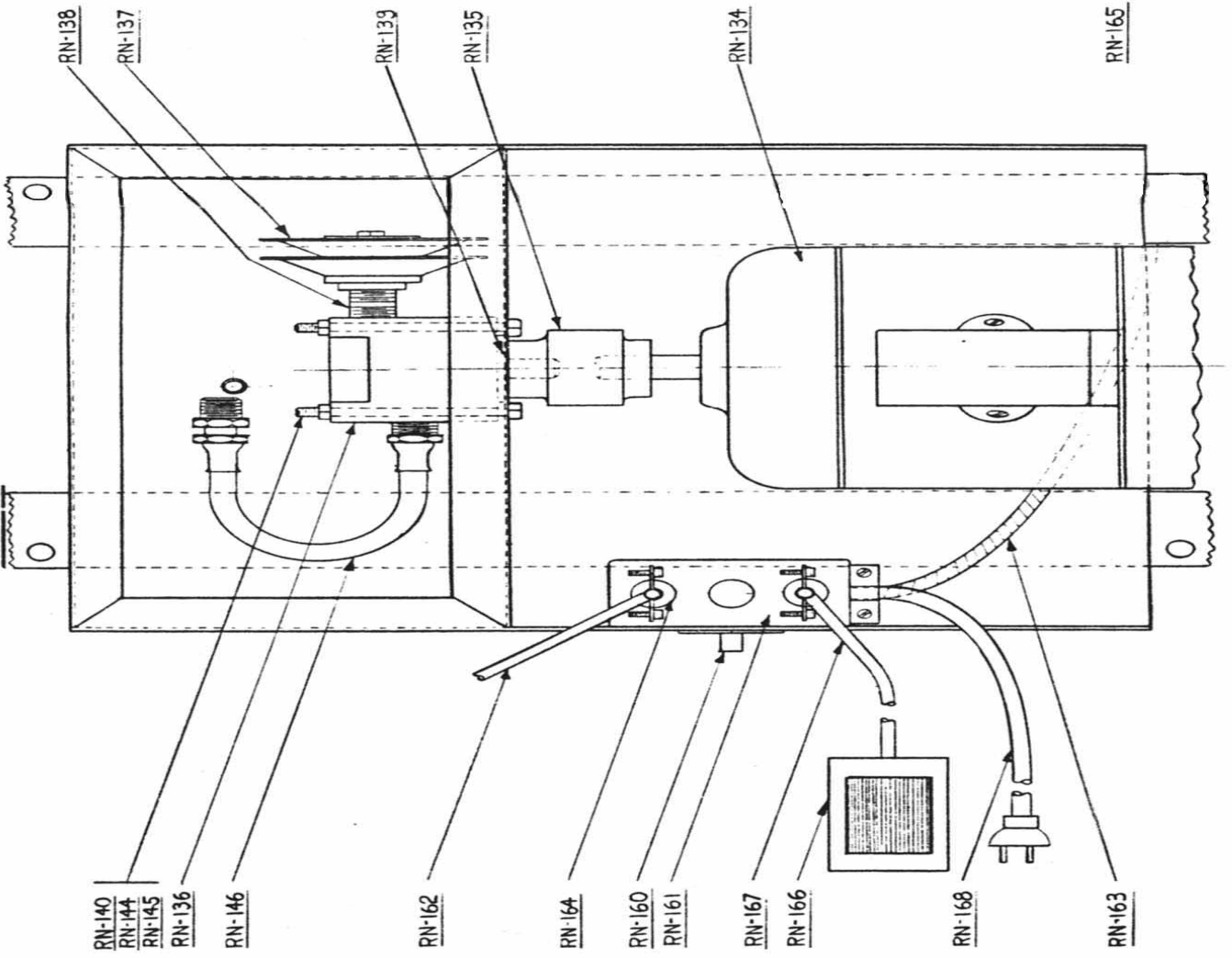
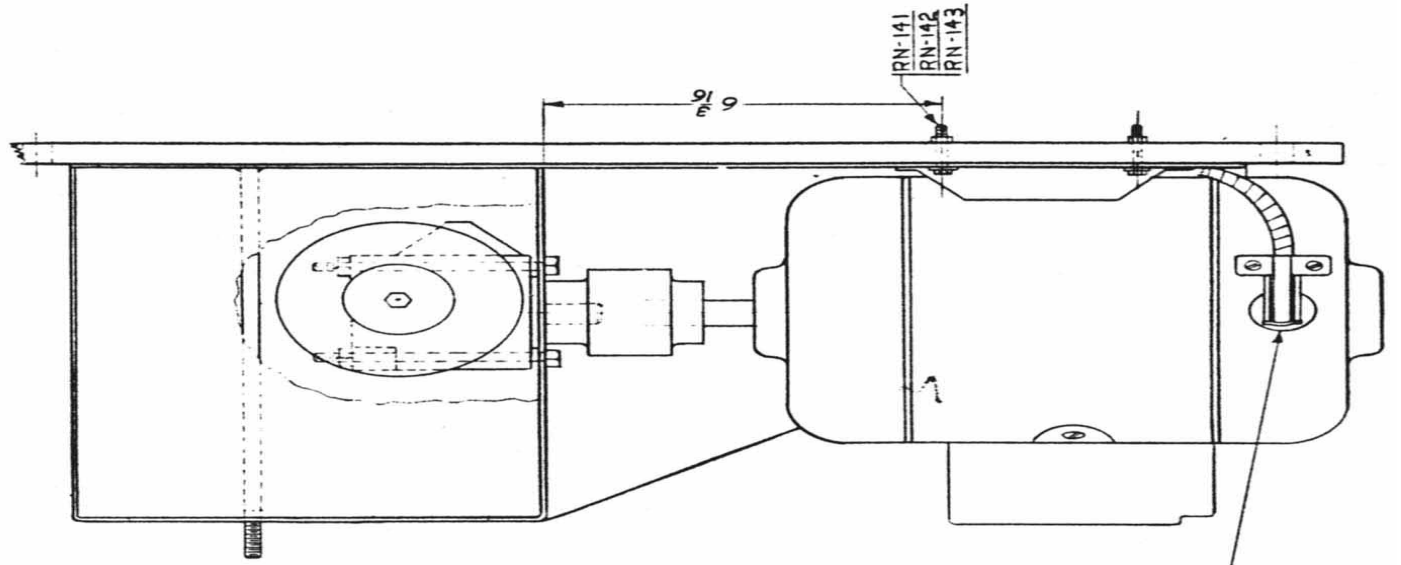
- 1 – Left Hand 110° Corner Notch
- 3 – 40° Vee Notch
- 1 – Right Hand 110° Corner Notch

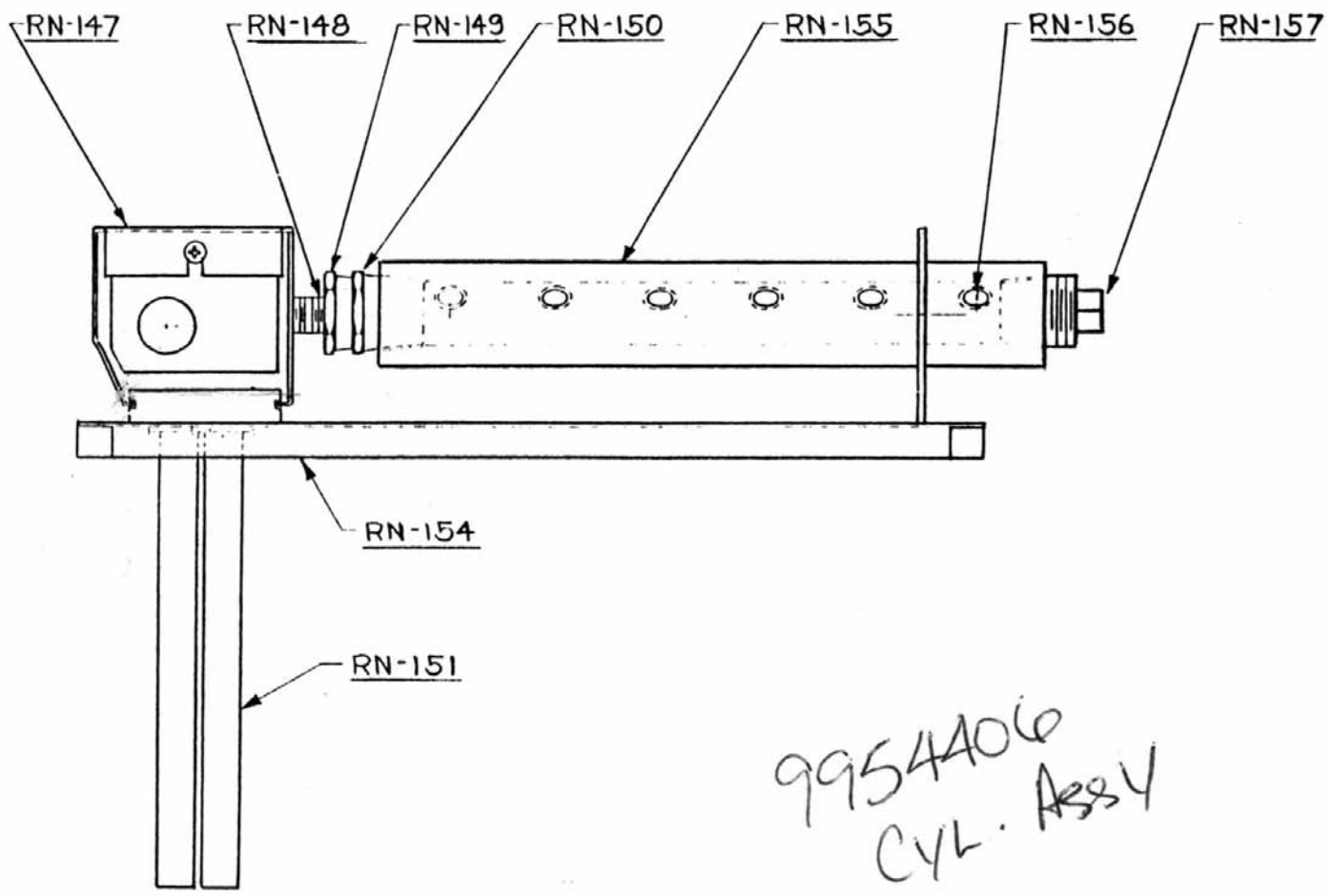
**HYDRAULIC UNIT MAINTENANCE:** For proper maintenance of the hydraulic system, the oil should be kept clean and free of dirt or other foreign matter. The suction strainer located in the reservoir should be removed and cleaned periodically. The system should be changed after approximately one year's operation and refilled with clean filtered oil (See paragraph 1 for recommended oil)

**DIE CARE AND MAINTENANCE:** Punch and dies are manufactured of high carbon high chronic tool steel for maximum cutting service. When die cutting surfaces become worn the punches and dies are removed and inverted to present a new cutting edge. **NOTE:** When installing punches and dies a clearance of .003" must be set between the punch and die by placing a .003" shim on both sides of the cutting edge of the die with tile punch engaged it] the die and then tightening the capscrews retaining the die.

A light oil should be applied occasionally to cutting surface of punch and die to prolong die life.

New Part No.	Old Part No.	Description	Pieces Per Unit	New Part No.	Old Part No.	Description	Pieces Per Unit
40470	RN-102	Main Body 88470	5	80525	RN-168	Cord Set 14-3 10	1
40480	RN-104	Pnch. Actr. 88480	5	65157	RN-169	Residential Notcher Name Plate	1
14503	RN-105	Pvt. Pin	5	85164	RN-1 70	Lockformer Logo	1
22060	RN-106	Clamp Bar	5	85307	RN-173	Caution Tag	1
22116	RN-107	Lower Clamp	5	62618	RN-174	1/4 x 5/8 Dwl. full	1
40510	RN-110	Vee Punch	3	42501	RN-174-AGa.	Step Pin 62618	3
40520	RN-111	Corner Punch	2	54401	RN-180	Tank Npl. Assembly	1
40530	RN-112	Die 88530	8	65177	RN-181	3/8 Blk. Elbw.	1
40540	RN-113	Cor. Die	2	30905	RN-182	Slug Ejector	1
62602	RN-115	3/16 x 1 Dwl.	5	60590	RN-183	1/4-20 x 7/8 FLHMS	1
60612	RN-117	1/4-20 x 1/2 SSS	5	15125	RN-184	Rod End	5
60304	RN-118	1/4-20 x 1 SHCS	20	15126	RN-185	Cap End	5
60407	RN-119	3/8-16 x 1- 1/2 SCHS	10	15105	RN-186	Piston	5
62707	RN-120	Roll Pin 1/4 x 1-1/25		15106	RN-187	Cylinder Body	5
65719	RN-122	Hose	5	71019	RN-1 88	Comp. Spring	5
65100	RN-123	3/8 x 1/4 Hex. Bushing	5	65635	RN-189	O Rg.	5
65575	RN-124	Gate Valve	5	65628	RN-190	O Rg.	5
58551	RN-1 25	Stand Assembly	1	20900	RN-192	Sub Plate	1
60094	RN-127	3/8-16 x 1-1/4 HHCS	4	65112	RN-194	1/2 x 3/8 Hex. Bushing	1
61120	RN-128	3/8-16 HN Hvy. SF	8	65275	RN-195	1/2 x 1/2 x 1/2 Tee	1
62363	RN-129	3/8 LockWasher Med.	4	65041	RN-196	1/2 Close Hvy. Npl.	1
80041	RN-1-34	1 HP 1 60 36 56	1	65176	RN-1 97	1/ 4 Street Elbw.	1
70801	RN-135	G100 Coupling	1	60312		1/4-20 x 7/8 SHCS	5
65402	RN-136	Pump C-4	1	60306	RN-198	1/ 4-20 x 1-1/2 SHCS	4
65675	RN-137	Suction Strainer	1	23502		Gasket	2
65026	RN-138	318 Close Npl. Hvy.	2	23503		Gasket	2
65600	RN-139	Gasket 030 Shurpak	1	52602		Locking Handle Assembly	5
65800	RN-140	5 /16 ID Washer	4	56533		Punch Ga, Bar Assembly	1
60047	RN-141	5/16-18 x3/4 HHCS	4	56534		Wk. Guide Assembly	1
61101	RN-142	5/16-16 HN Hvy. SF	8	60091		3/8-16 x 1 HHCS	1
62362	RN-143	5/16 Lock Washer	4	60575		10-24 x 3/8 RHMS	2
60053	RN-144	5116-18 x3-1/2 HHCS	4	60795		4 x 3/16 Dr. Screw TP-U	4
65704	RN-146	Hose	1	60951		3/8 x 2-1/2 Lag Screw	8
65534	RN-147	Slnd- Valve 110 V	1	60960		6-32 x 1/4 BHSMS	2
65113	RN-1 49	1/4 x 1/2 Bush	1	61040		10-24 Hn	2
65122	RN-150	3/4 x 1/2 Hex. Bushing	1	62010		5/16 x 1/16 Washer	4
65000	RN-152	1/4 Close Npl.	5	62029		3/8 x 1/16 Washer	4
54400	RN-1 53	Tank Body Assy.	2	62081		5/8 x 3/16 Washer	8
54405	RN-1 54	Tank Cover Assembly	1	62712		Roll Pin 1/4 x 1-1/45	
15164	RN-155	Manifold	1	62713		Roll Pin 5/32 x 1	5
65212	RN-156	1/4 Npt. Shpp.	1	80483		Bx Connector 3/8	2
65230	RN-157	3/4 Npt. Blk. Shpp.	2	80602		Rg. Tng. Terminal	7
80204	RN-160	Toggle Switch 8941	1	80607		Insulating Cap	2
80651	RN-161	Handy Box 230	1	80608		Wire Joint	2
80430	RN-163	BX Cable 14-2	2	62026		3/8 x .052 Washers	4
80481	RN-164	BX Connector 1/2	2	85140		Tape	1
80485	RN-165	BX Elbw. Connector	2	85143		Dble. Sided Tape	120
80209	RN-166	Foot Switch	1	60628		10-24 x 1/2 Screws	2
				33010		Guard Base	1
				33011		Ft. Pedal Guard	1
				35446		Coupling Cover	1
				65841		Relief Valve	1





9954406  
CYL. ASSY

