

PS-66 OPERATING INSTRUCTIONS

1. Mount and level Notcher with drop-out overhanging edge of bench and bolt or lag in place. Lubricate all points with SAE 30 machine oil before operating.
2. Upper Standard Blades - 17 and 18 are set at factory for "pierce" cutting, starting at apex, or corner of inside cut. To change to "splay" cutting, interchange blades 17 and 18 end for end so that cut starts at outside edge of sheet. Align blades at point (elongated holes are provided in blades for this purpose) before tightening blade bolts (16) securely.
3. Lower Standard Blades - 28 and 29 are each symmetrical and can be mounted to use all 4 cutting edges. Blades are positioned by blade bolts (32) from underneath table.
4. Blade Adjustment:
 - A. Take off table (21) by removing two table screws (27)
 - B. Position the slide at bottom of stroke.
 - C. Loosen lower blade bolts (32) slightly.
 - D. Turn blade adjusting screws (26) mounted in adjusting plate (25) to bring blade to .002 normal clearance between upper and lower blade. (Clearance should be greater for heavy stock - less for thin stock).
 - E. Tighten blade bolts (32) securely.
 - F. Remount table.
5. Tab Notching - To install tab blades:
 - a. Remove table (21) as in 4a and disassemble four standard blades.
 - b. Install top right hand (18T) and left hand (17T) tab blades using the 3/8" socket head cap screws furnished with tab blade kit. (Use one 3/4 long screw (16TS) in front hole of each blade.) Tighten screws finger tight until blades are properly positioned.
 - c. Top right hand blade should protrude past the edge of the left hand blade the desired depth of notch. Tighten all screws securely.
 - d. Mount lower blades (28T & 29T), using blade plates (30T & 31T) furnished with kit, leaving screws finger tight until proper setting is attained.
 - e. Position slide at bottom of stroke, taking care that lower blades are back, clear of the upper blades.
 - f. Set lower right hand blade so that front cutting corner is in line with front corner of the upper right hand blade with the normal clearance of .002" between them. Tighten right hand blade screws securely.
 - g. Set lower left hand blade so that the notched front edge of the lower left hand blade just touches the front corner of the lower right hand blade. Set for normal clearance of .002" between upper and lower blades and at the beveled surface of the notch. Tighten lower left hand blade screws securely.
 - h. Check clearances at all points before operating.
6. Depth of Cut can be limited by adjusting stop screw (20) and check nut.
7. Safety Brake is adjusted through screw (9) and check nut, to prevent dead-weight fall of handle and slide.

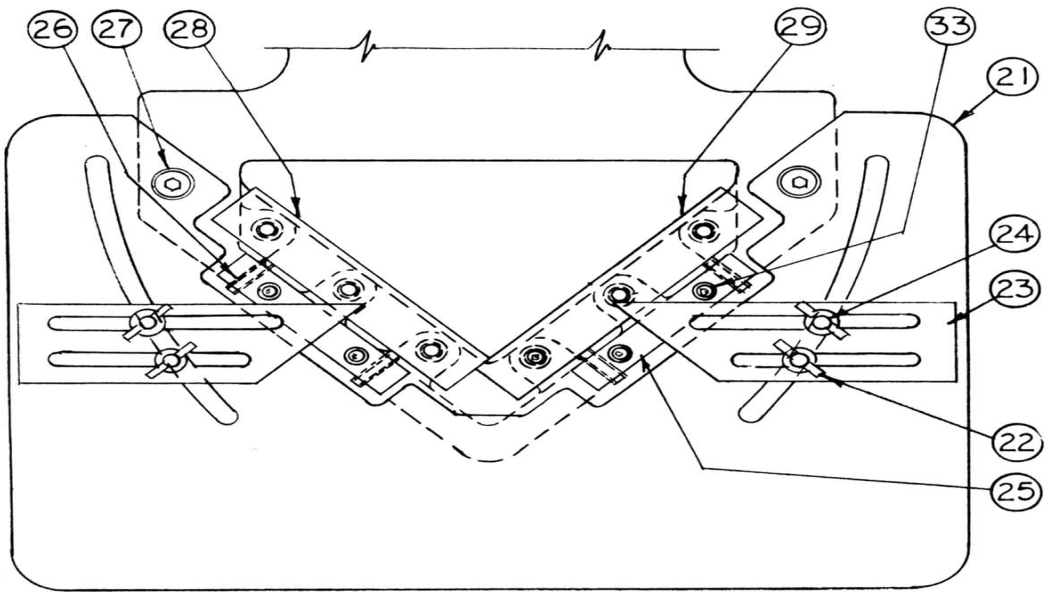
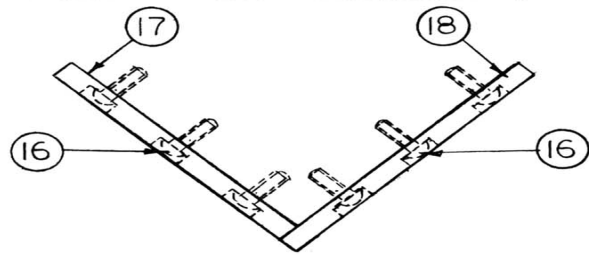
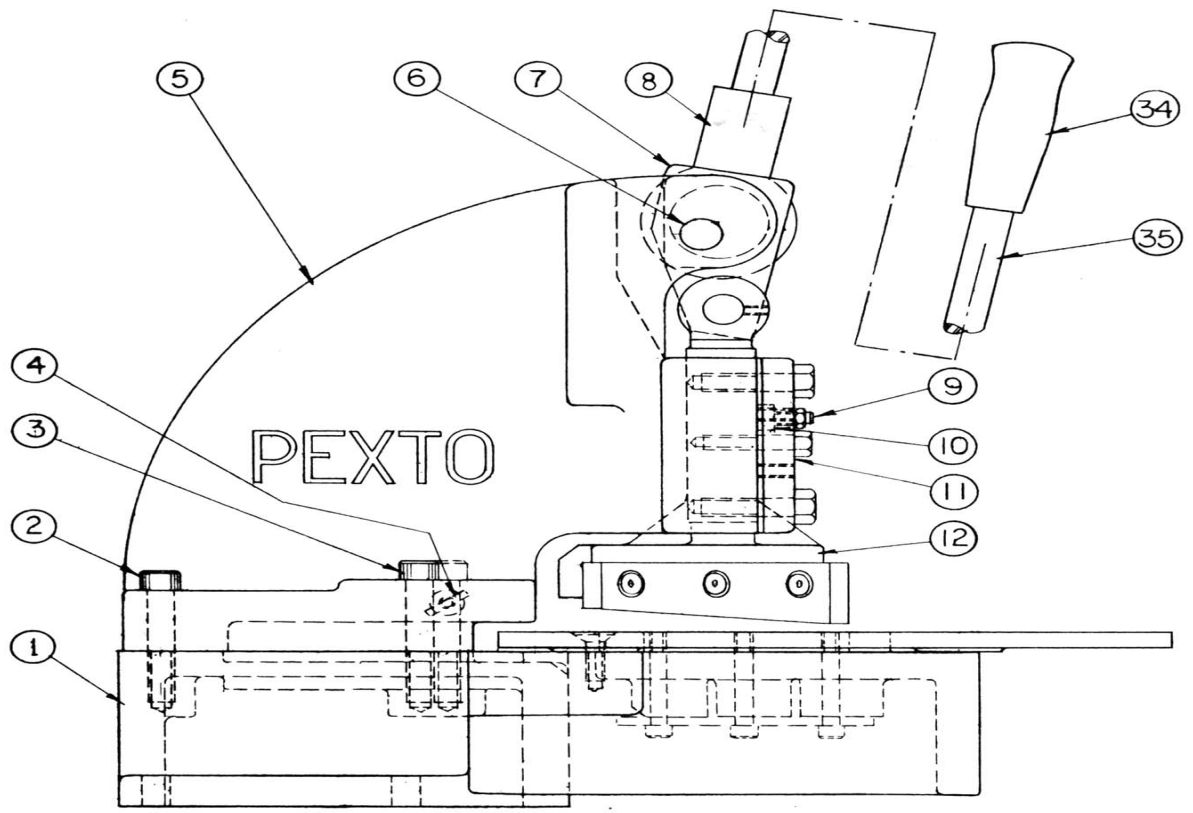
CAUTION: Check this adjustment frequently for safe operation.

8. Squaring or cut-off shearing stock of any length to 6 inches in width can be done by opening throat.
9. Throat - To open throat, back off frame bolt (3) and hold in "up" position with thumbscrew (4) (to prevent its being lost).

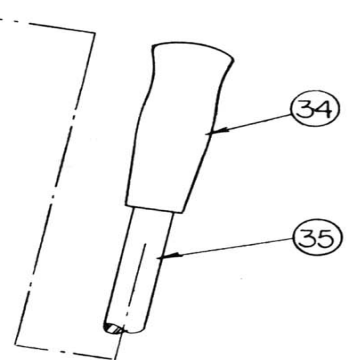
CAUTION: Open throat position used only for slitting, squaring and cut-off shearing.

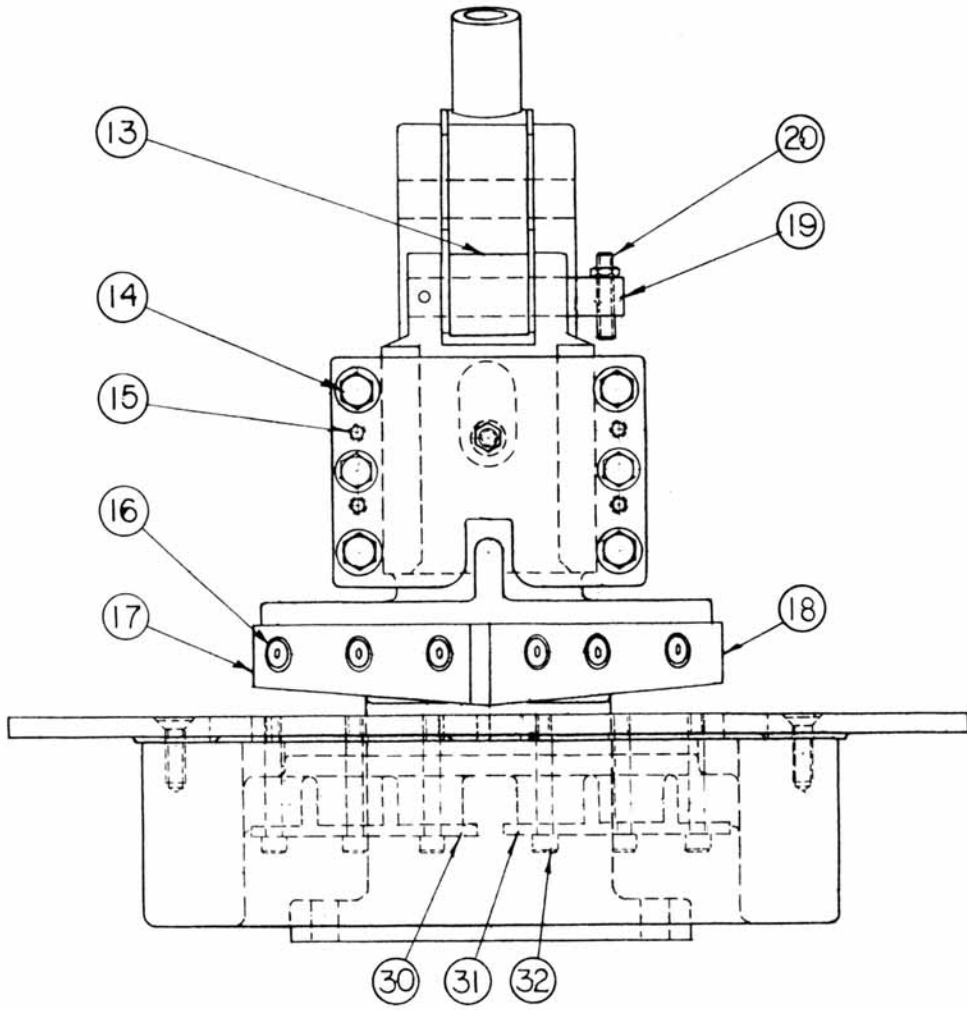
10. Slitting - Up to 6 inches wide strips can be slit from any width sheet. With upper blades mounted for "splay" cutting, remove left hand upper blade (17) and open throat.
11. Frequent lubrication of slide ways and cam pivots will insure continued smooth operation.
12. Adjustment of Slide - may become necessary to compensate for wear. Back off four slide adjusting screws (15) and adjust slide cap screws (14) to "tight" fit. Then reset slide adjusting screw (15) to obtain sliding fit. Oil ways.
13. Gage Setting - can be accomplished by using combination square. Table edges machined at 45° to cutting edges.
14. Check clearances between upper and lower blades occasionally to see that normal .002 clearance is maintained!

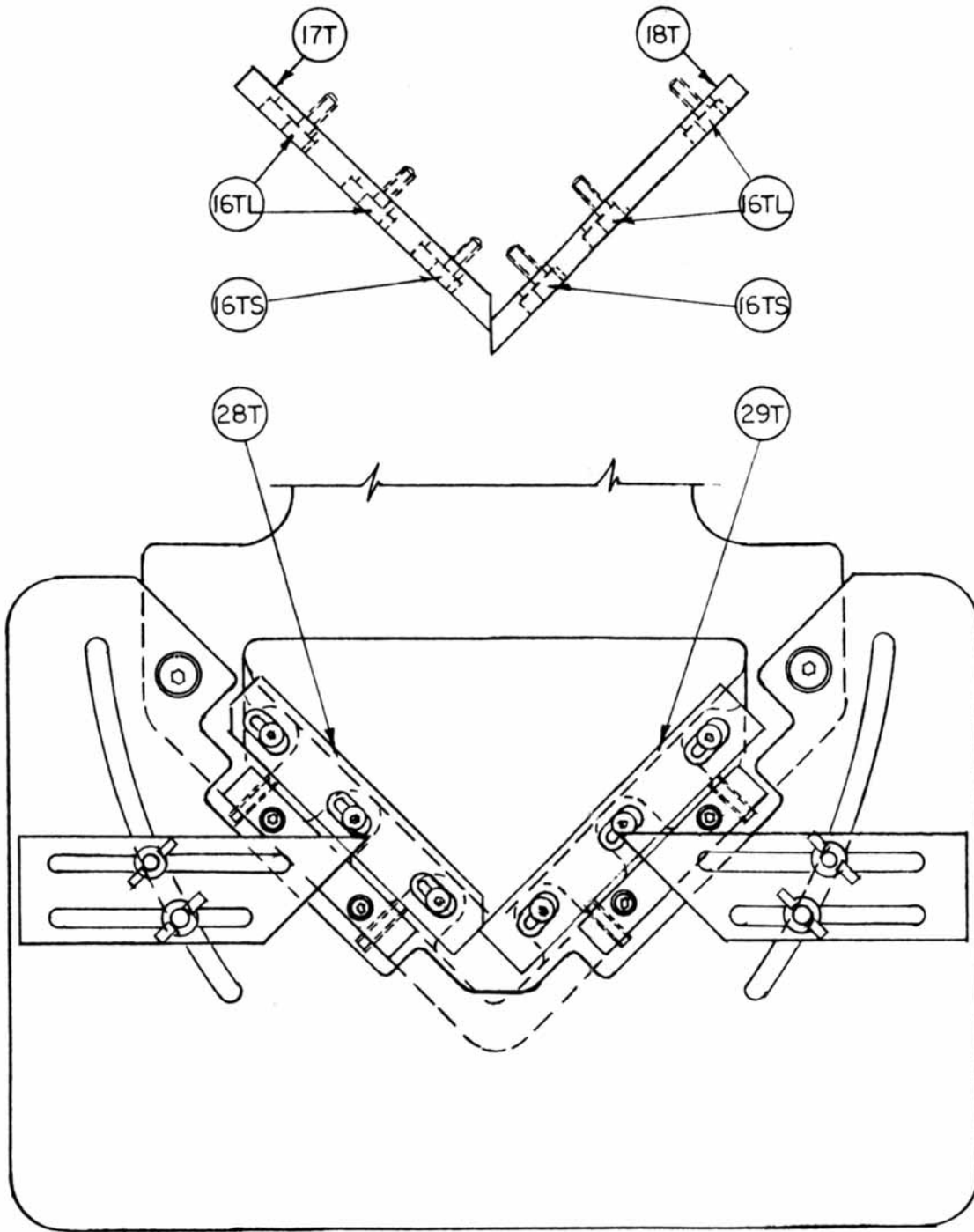
INDEX	NAME	PART NO.
1	BASE	D6021
2	SHORT FRAME BOLT	
3	LONG FRAME BOLT	
4	THUMB SCREW	
5	FRAME D	6020
6	CAM PIVOT	A61219
7	LINK	A60223
8	CAM	A60218
9	FRICION SHOE ADJ. SCREW	
10	FRICION SHOE	A52149
11	SLIDE CAP	B60141
12	SLIDE	C6122
13	CAM ROLLER	A60221
14	SLIDE CAP BOLTS	
15	SLIDE ADJ. SCREW	
16	UPPER BLADE BOLTS	
17	TOP L H BLADE	A6226
18	TOP RH BLADE	A6225
19	SLIDE PIVOT	A60222
20	SLIDE STOP SCREW	
21	TABLE	D6022
22	THUMB NUT	
23	GAUGE	A62155
24	TEE BOLT	12438
25	ADJ.PLATE	A60228
26	BLADE ADJ. SCREW	
27	TABLE SCREW	
28	LOWER L.H. BLADE	A60227
29	LOWER R.H. BLADE	A60226
30	L.H. BLADE PLATE	A6217
31	R.H. BLADE PLATE	A6219
32	LOWER BLADE SCR.	
33	ADJ. PLATE SCREW	
34	HANDLE GRIP	
35	HANDLE	A60220
	TAB BLADF- KIT	
16T	TOP R.H. BLADE	A62294
17T	TOP L.H. BLADE	A62295
29T	LOWER R.H. BLADE	A62296
26T	LOWER L.H. BLADE	A62297
31T	R. H. BLADE PLATE	A62298
30T	L. H. BLADE PLATE	A62299
16TS	3/8 x 3/4 SOC. HD. CAP SCR.	
16TL	3/8 x 1 SOC.HD.CAP SCR.	
	5/16 KEY WRENCH	



STANDARD BLADES







TAB BLADES
(OPTIONAL)