

NOTCHER INSTRUCTIONS

1. DO NOT attempt to operate this Notcher until you have bolted it down to a strong bench. To clamp the Notcher in a vise and give it a try is not a fair test of the machine. BOLT IT DOWN SOLID. Bolt through the two slots on the bottom of the machine to the side of your welding table, or bolt the Notcher to a piece of angle iron, and then to the top of your table. Thanks.
2. For the Notcher you will need to make a pull handle 4 feet long using 1 ½" I.D. schedule 40 pipe or .120 wall tubing. Do not make it any shorter than 42 inches.
3. The Notcher works best with .050 to .060 blade clearance. It may be necessary to reset the blade clearance after the first few cuts.
4. The blade clearance is set for .095 wall tubing. For thinner wall tubing it may be necessary to close the blade clearance slightly. For schedule 40 pipe a little more clearance will help. To adjust the clearance between the male and female cutter, slightly loosen the 2 bolts and nuts holding the female cutter and tap the cutter forward or back. You MUST wear safety glasses to do this.
5. PLEASE OIL all moving parts including main ram.
6. When you pull the handle to notch the tubing it will cause the tubing to pull up. It is NOT necessary to hold the tube down.
7. When you put the tubing in the machine JAM IT IN HARD so the cutter gets a bite on the tube. This will not hurt the cutter.
8. The male cutter can be turned down on a lathe with a carbide cutter to the exact size of the tubing you are working with. This will give you the deepest possible notch for that size of tubing. Example: If you have the 1 ¼" to 1 7/8" machine and notch mainly 1 ½" tubing you can turn down the 1 5/8" O.D. male cutter to 1 ½" which will give you a deeper notch. Additional male cutters are available to retain your original size range. When you turn down the cutter it will no longer be cam shaped. This is okay, it will still work.
9. To re-sharpen the male cutter simply hold it on a flat belt sander until it puts a sharp edge back on the cutting edge. You can re-sharpen both the top and bottom surface .060 deep before you go through the case hardening.
10. The hole in the male cutter is not perfectly in the center. This is done so that you can turn the male cutter to line it up with the female cutter when changing cutters.
11. If the tubing tries to twist out of your hand when notching, this can be fixed by turning the male cutter 1/8 of a turn either way, keep turning until you find the proper setting for your machine.
12. #1 Notcher, 1" to 1 ¼", has 2 male cutters. Use the large cutter for 1 1/8" to 1 ¼" and the small one for 1" to 1 1/16". There is no jam nut with the #1 cutters. Turn the cutter clockwise to remove it. Vise grips will not hurt the cutter.
13. #2 Notcher, 1 ¼" to 1 7/8", has 3 male cutters. The 1 7/8" cutter is for 1 7/8" down to 1 5/8", the 1 5/8" is for 1 5/8" down to 1 3/8" and the 1 3/8" cutter is for 1 3/8" down to 1 ¼".
14. #3 Notcher, has 2 male cutters. They will work with 2" to 2 1/2" O.D. pipe or tube.
15. #4 Notcher, has 3 male cutters. 1 7/8" for 1 7/8", 1 5/8" for 1 5/8", and 1 3/8" for 1 3/8".
16. Check the male cutter jam nut every once in awhile. If it gets loose, it will chew up the ram threads. Replacement rams are available.
17. To remove the male cutter, turn the jam nut counter clockwise and the cutter clockwise.