

TIN KNOCKER

TK 1016 TDC-P HYDRAULIC DUCT NOTCHER



INSTRUCTIONS & PARTS DIAGRAM

RED RIVER MACHINERY
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www.redrivermachinery.com

INSTALLATION & OPERATION

Tin Knocker 1016 Hydraulic Duct Notcher

INSTALLATION

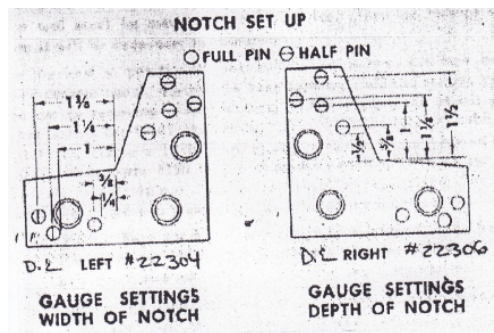
1. It is suggested that the machine should be uncrated at or near the location where it will be used. Free the foot switch cord and hydraulic hoses going the notching heads.
Remove the gauge pin bag.
2. Remove manual starter box cover and wire as indicated on the inside of the cover. Standard electric on this machine is 220v/1phs/60Hz, using a 3HP, 1800 RPM motor.
3. Ensure the motor and pump are turning in the proper direction, referring to the direction arrows on the motor and pump. JOG the unit confirm proper rotation. CAUTION: Severe pump damage will occur if the pump is run backwards.

OPERATION

Max Capacity: 16 gauge galvanized or cold rolled mild steel

Operation:

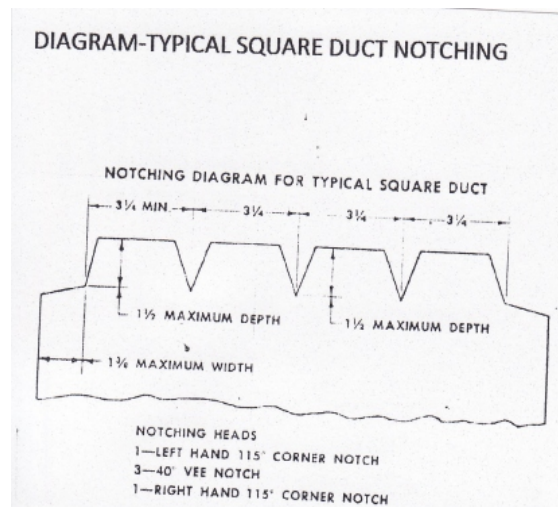
1. Loosen the left hand notching head and slide to zero on the embedded scale and clamp into place.
2. Move the "V" notching heads to the desired positions.
3. Place gauge pin in hole to determine depth of notch. See diagram.



4. Place the sheet blank on the gauge support table and square material to gauge pins.
5. To activate the notching heads, step on foot pedal and hold until the notching is complete. Release foot switch and remove the notched blank. CAUTION: Release foot switch immediately after notching is complete as continued depression of the foot switch can cause overheating and damage to the machine.

Note: If in the desired notching operation, some heads are not needed, the hoses can be detached from these to prevent their activation.

DIAGRAM-TYPICAL SQUARE DUCT NOTCHING

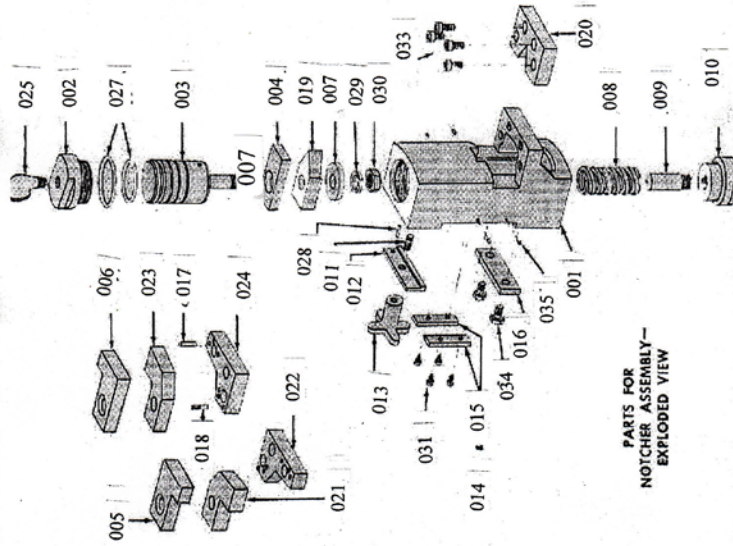


PARTS LIST AND DESCRIPTION OF HEAD AND DIE ASSEMBLY

PLEASE USE NEW NUMBER
WHEN ORDERING PARTS.

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Part No. / FN	Description	New Part No. / FN	Description	Pieces Per Unit	Pieces Per Unit
DN 001	Cylinder	DN 019	Punch	5	3
DN 002	Head	DN 020	Die Vee	5	3
DN 003	Piston	DN 021	Punch Left	5	1
DN 004	Backing Plate	DN 022	Die Left	3	1
DN 005	Backing Plate Left	DN 023	Punch Right	1	1
DN 006	Backing Plate Right	DN 024	Die Right	1	1
DN 007	Guide Washer	DN 025	1/2 Straight Elbow	5	5
DN 008	Compression Spring	DN 026	1/4 x 1 Nipple	5	5
DN 009	Spring Guide	DN 027	O Rings	5	10
DN 010	Bottom Cap	DN 028	3/16 x 1 Roll Pin	5	5
DN 011	Stud	DN 029	5/8 Lock Washer	5	5
DN 012	Cylinder Clamp	DN 030	3/4-11 Hex Nut Finished 3/16	5	5
DN 013	Handle	DN 031	3/4-28 x 3/4 SH Gap Screw	20	20
DN 014	Gib Left	DN 032	1/2 Swivel Adapter	5	5
DN 015	Gib Right	DN 033	3/4-16 x 3/4 SHGS	5	18
DN 016	Guide Plate	DN 034	1/4-28 x 1/2 HH Gap Screw	5	10
DN 017	1/4 x 3/4 Dowel Pin	DN 035	1/4-28 x 3/4 Socket Set Screw	2	20
DN 018	Gauge Step Pin	DN 036	Ball Valve	3	5



Oil: Commercial oil with viscosity of 150 SSU at 100 degrees.
Reservoir Capacity: 7 US gallons. Type A automatic transmission fluid, commonly found at automotive parts stores, is a suitable hydraulic fluid for this machine. The oil should be kept clean and be changed periodically (annually is suggested). Proper oil level can be determined by insertion of a ruler into the reservoir. A reading of 7" indicates "full".

Die Maintenance: Periodically, the notching dies will need to be re-sharpened. Contact us for an easy, step-by-step procedure for extracting the dies). Once sharpened and replaced, a small amount of oil should occasionally on the cutting surface to prolong die life.

Note: A clearance of not to exceed .003" should be set between the upper and lower "V" notch dies. This is achieved by using shim stock from .003" to .0025" on both sides of the cutting dies. For the corner notching units, a clearance of .005" is desired.

WARRANTY

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: 1. This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you.