



PIPE NOTCHER ACCESSORY For 45 Ton Iron Worker

NOTICE

The Coper Notcher and Pipe Notcher accessories can not be installed or used when the Brake accessory is installed.

NOTICE

Before installing Pipe Notcher Accessory, raise the punch all the way up. Do this by pressing the Cylinder Retract Foot Pedal to lift the punch. This will give you enough clearance to remove existing hardware and install the Pipe Notcher Accessory.

Removing Existing Punch, Die, and Punch/Die Table Assembly

Refer to Figures 1 - 3:

1. Run the ironworker to fully retract the cylinder thereby lifting the punch fully open/up position.
2. Stop the motor and disconnect the ironworker from the power supply.
3. Using a 1/2" wrench, loosen the hex head screws (A) that secure the strippers to the Punch Ram Guide Block (see Figure 1).



Figure 1

(Punch table removed for clarity. Do not operate the punch with the table removed.)

4. Using the punch nut wrench, loosen the punch retaining nut (B, Figure 2). Continue to unscrew the nut from the threaded punch ram and remove.

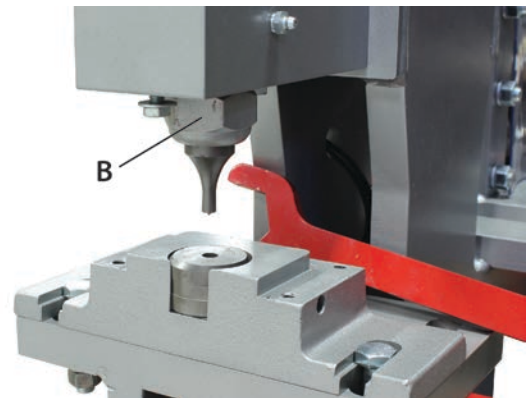


Figure 2

5. Loosen and remove bolts (C) and remove the punch table/die table assembly (D) from ironworker frame table pedestal (see Figure 3).

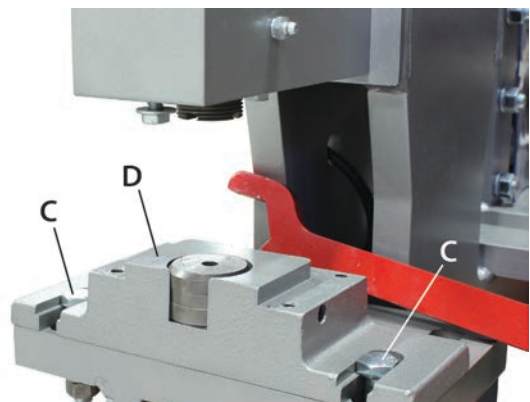


Figure 3

(Punch table removed for clarity. Do not operate the punch with the table removed.)

Installing Pipe Notcher

NOTE: This pipe Notcher accessory does not come with a notching die.

Refer to Figures 4 - 7:

1. Screw Push Nut onto the punch ram threads (see Figure 4). Tighten using the punch nut wrench or adjustable wrench.

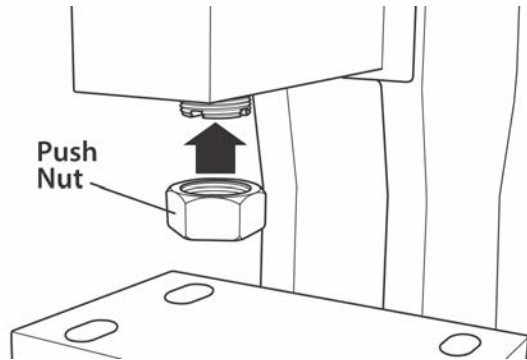


Figure 4

2. Place Pipe Notcher Table on Ironworker frame (see Figure 5). Align threaded mounting holes on bottom of Pipe Notcher Table with mounting slots on ironworker frame pedestal.

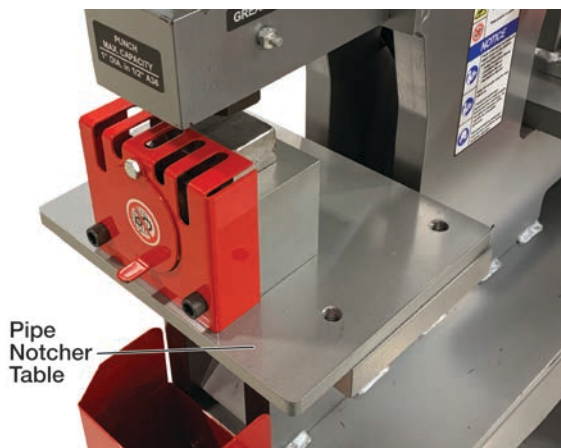


Figure 5

3. Using four table mounting bolts, lock washers, thick flat washers, and thin flat washers, insert bolts up through table pedestal mounting slots and into the threaded holes in the bottom of the Pipe Notcher Table (see Figure 6). Make sure table is straight and aligned properly. Make sure you provide proper clearance between the Push Nut and the red Pipe Notcher Guard (see Figure 7). Tighten bolts firmly.

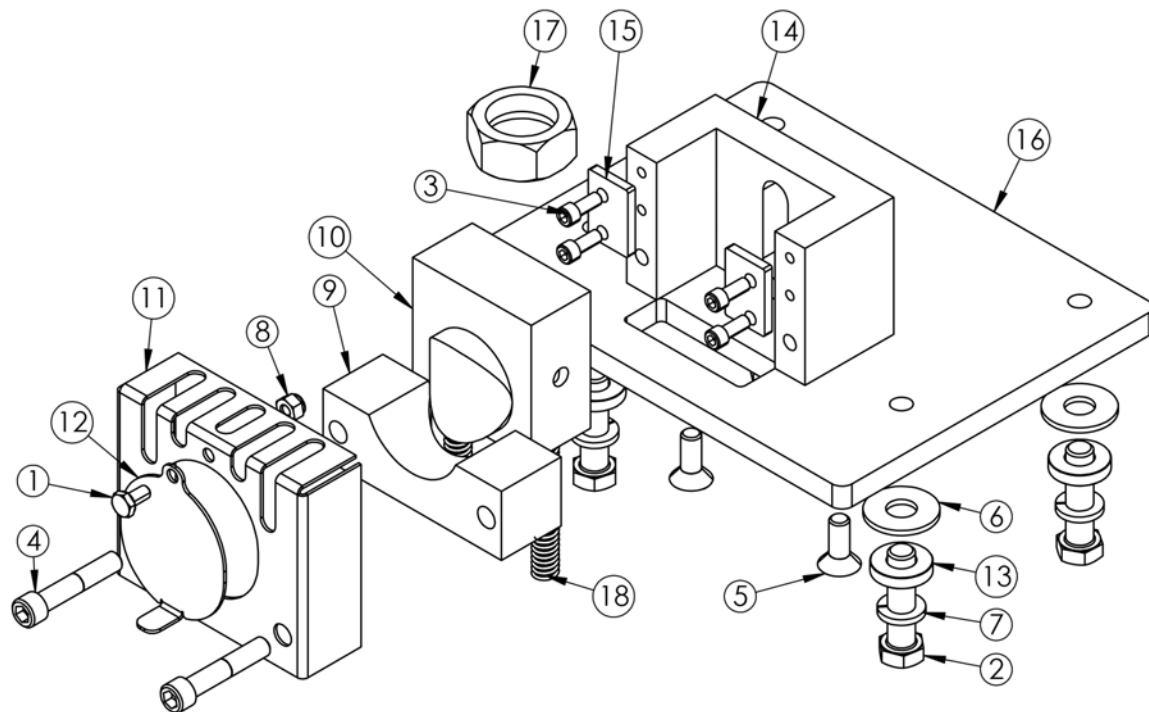


Figure 6



Figure 7

Parts List and Exploded View – Pipe Notcher Accessory



Index No	Part No	Description	Size	Qty
1	13001	Hex Bolt	1/4-20 x 1/2	1
2	13211	HCS, Z5	1/2-13 x 2.00	4
3	23202	SHCS	1/4-20 x 5/8	4
4	23311	SHCS	3/8-16 x 2.00	2
5	24286	Hex Drive FSCS	3/8-16 x 1	2
6	33012	Flat Washer, USS Z	1/2"	4
7	33626	Split Lock Washer	1/2"	4
8	37018	Steel Nylon Insert Lock Nut	1/4-20	1
9	Blade Set	Call for part # and sizes		1
10	Blade Set	Call for part # and sizes		1
11	GRD738	Guard Pipe Notcher		1
12	GRD745	Guard Pipe Notcher Door		1
13	HD2434	Flat HD Washer	1/2"	4
14	HM693	Pipe Die Block		1
15	HM925-02	Pipe Notcher Side Plate		2
16	JT1-258	Jet Pipe Notcher Plate		1
17	JT1-259	Push Nut – JIW – Pipe Notcher		1
18	Return Spring	Comes with blade kit		2



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