



Established 1930

Distributors of new & used workshop Equipment

S247 FN-M616

6" X 16GA X 90DEG

HAND OPERATED NOTCHER

OPERATION & PARTS MANUAL

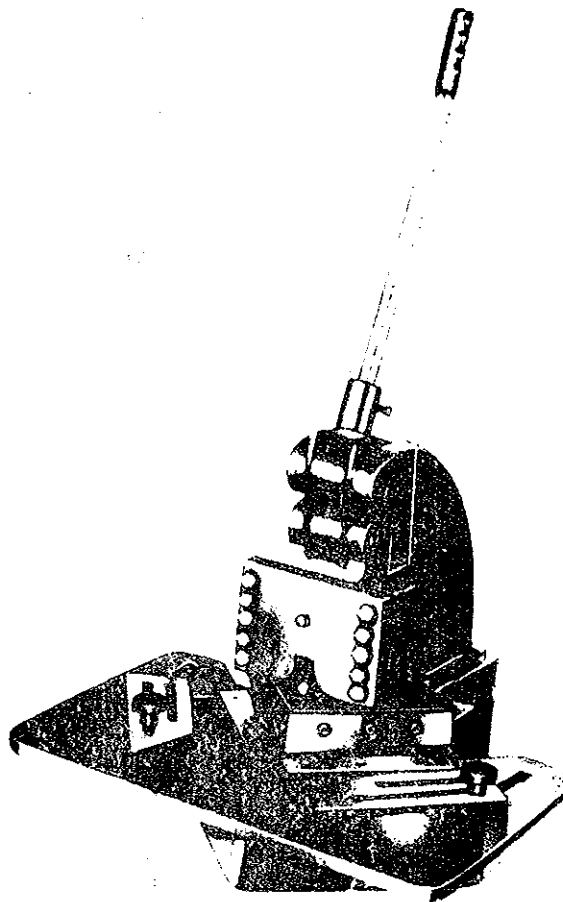
20-10-1997

20/10/95

5247

HAND OPERATED NOTCHER OPERATORS MANUAL & PARTS LIST

C425



MODEL:FN-M616 6"×16GA×90°

SPECIFICATIONS:

Capacity	4 Ton
Material Capacity	16 GA (1.6mm)
Notcher	6"x6"x90° (152mmx152mmx90°)
Stroke	3/4" (19mm)
Table Dimension	18"x12" (457x305mm)
Net Weight	95 kg
Shipping Weight	125 kg

The notching blades are made from hardened and precision ground alloy tool steel. Upper blade is bolted to an alloy casting mounted on the ram. It is reversible. Each of the two lower blades has four cutting edges for extra duty, and can be easily adjusted to get a clean even cut on thinner material. Blades can be resharpened on a surface grinder.

Adjustable gauges are mounted on a 12"x18" work table, which provides a large material support area for easy work handling and positioning. Users can accurately locate a notch either at a corner or at any position along the edge of material.

The hardened and precision ground triangular ram accurately controls the position of the cutting head and provides perfect alignment at all times.

Alloy cast base and body assures extreme rigidity and durability.

HOW TO REMOVE BLADES

Remove work table and turn notcher on its side. Then remove the six bolts holding the lower notching blade and the two bolts holding the two supports. Lastly, remove the three bolts holding the upper blade. (as figure 1 and 2)

HOW TO ALIGN LOWER NOTCHING BLADE

It can be made by removing work table and adjusting the 3 screws in the lower notching blade. Then, insert a piece of paper and notch it to check if it make a clean even cut at all points. If not, adjust lower blade accordingly to achieve a exact alignment. (as figure 3)

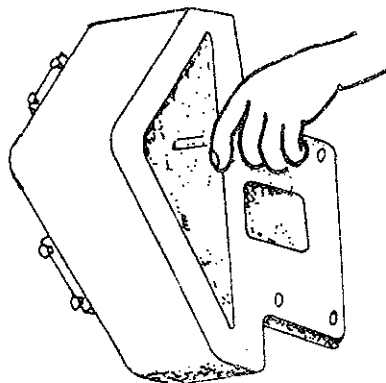


Figure 1

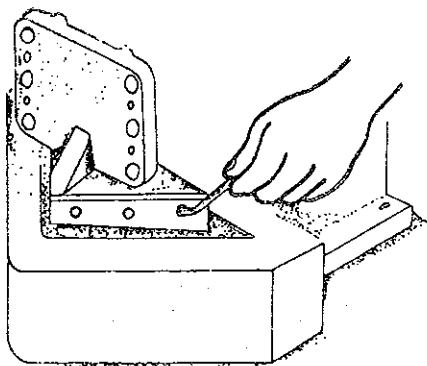


Figure 2.

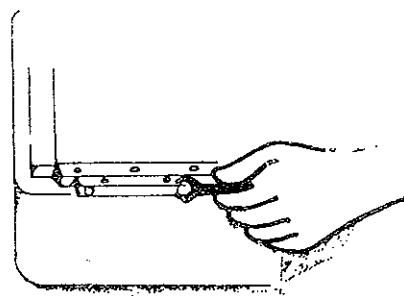


Figure 3.

PART LIST OF FN-M616 METAL NOTCHER

ITEM NO:	DESCRIPTION
1.	CAN FIXED SHAFT.
2.	FIXED PLATE.
3.	CAM.
4.	5/16" x 1/2" SOC SET SCR.
5.	5/16" x 1/2" SOC SET SCR.
6.	UPPER BLADE.
7.	1/4" x 3/8" SOC SET SCR.
8.	1/2" x 2 1/2" HEX HD CAP SCR.
9.	3/8" x 60mm PIN.
10.	CAM ROLLER PIN.
11.	CAM ROLLER.
12.	WEARING PLATE - INSIDE.
13.	5/16" x 1/2" SOC SET SCR.
14.	RAM.
15.	CAP.
16.	5/16" x 1 1/2" HEX HD CAP SCR.
17.	3/8" x 1 1/2" HEX HD CAP SCR.
18.	5/16" x 1 1/2" SOC SET SCR.
19.	TABLE PLATE.
20.	3/8" x 3/4" SLOTTED SCREW.
21.	ANGLE GAUGE.
22.	3/8" NUT.
23.	3/8" SCREW.
24.	LOWER BLADE.
25.	BLADE FIXED PLATE.
26.	1/4" x 1" HEX HD CAP SCR.
27.	BOTTOM BASE.
28.	5/16" x 1 1/2" HOLLOW HEAD SCR.
29.	HANDLE LEVER.
30.	5/16" x 1" HOLLOW HEAD SCR.
31.	STROKE ADJUSTMENT SCREW
32.	RULE.
33.	FINGER GUARD.

