

PEXTO

PS-66

COMBINATION NOTCHER, COPER & SHEAR

OPERATING INSTRUCTIONS AND PARTS IDENTIFICATION



ROPER WHITNEY

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OPERATING INSTRUCTIONS FOR PS-66 PEXTO COMBINATION NOTCHER, COPER & SHEAR

WARNING: Before operating, machine **must** be bolted to work bench. If floor stand has been provided, machine must be bolted to floor stand with bolts provided. Stand **must** be securely lagged to floor.

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). Position the slide at bottom of stroke.
 - b. Loosen lower blade bolts (32) slightly.
 - c. 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).
 - d. Tighten blade bolts (32) securely.
 - e. 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 (16T) 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 deadweight fall of handle and slide.

CAUTION: Check this adjustment frequently for safe operation.

8. Squaring or cutoff 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 cutoff shearing.

10. Slitting - Up to 6 inch 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.

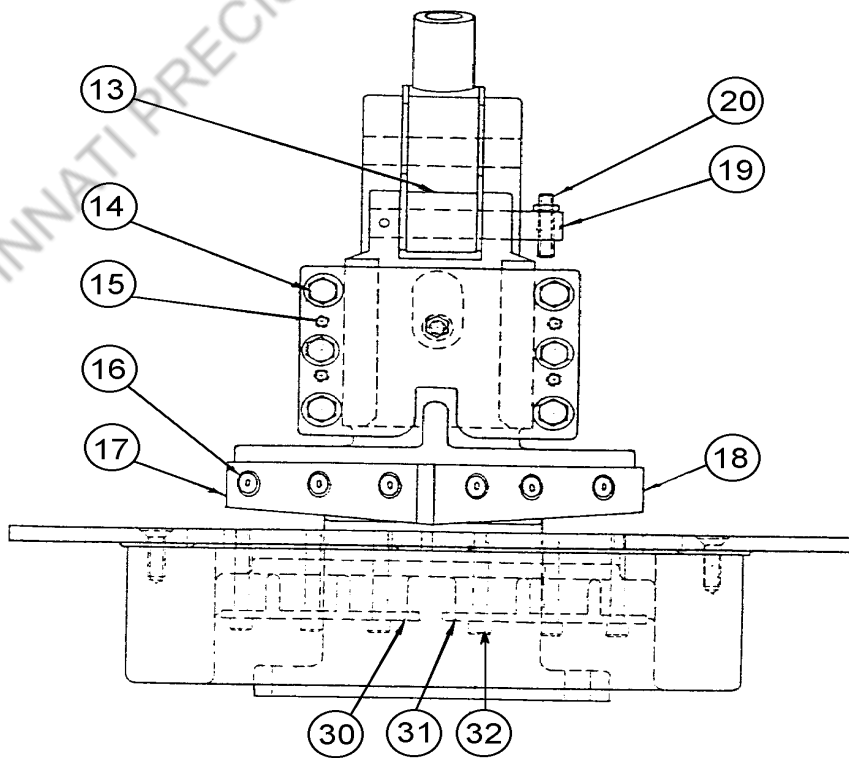
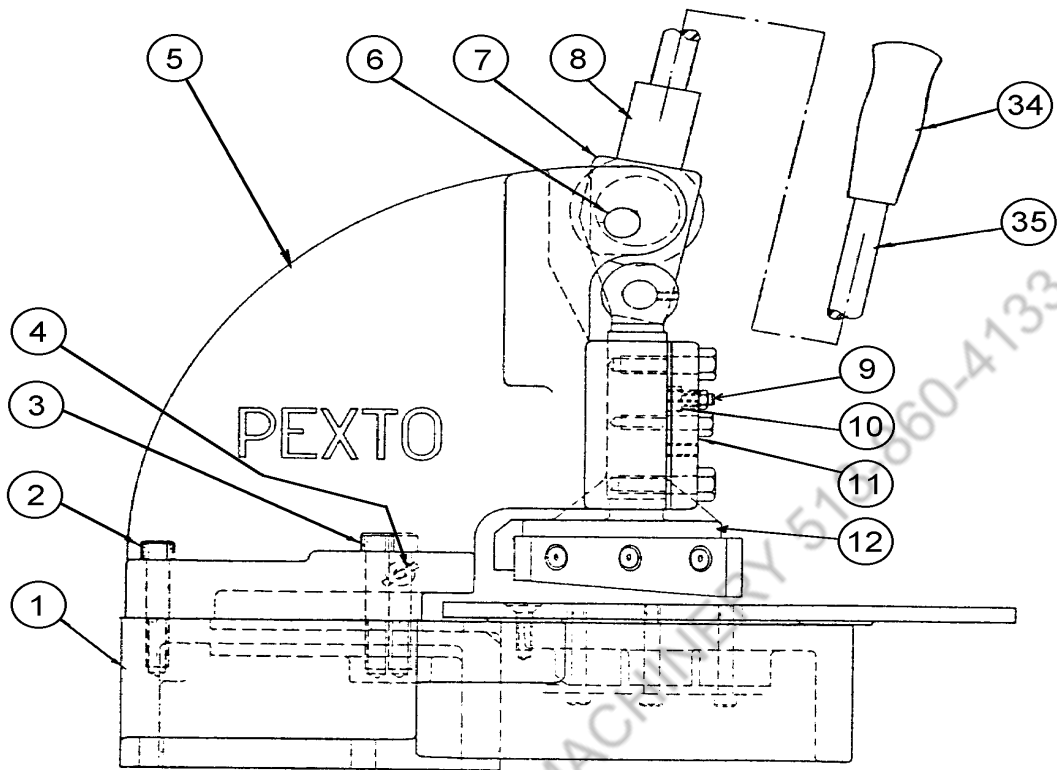
11. Frequent lubrication of slide ways and cam pivots will insure continued smooth operation.

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.

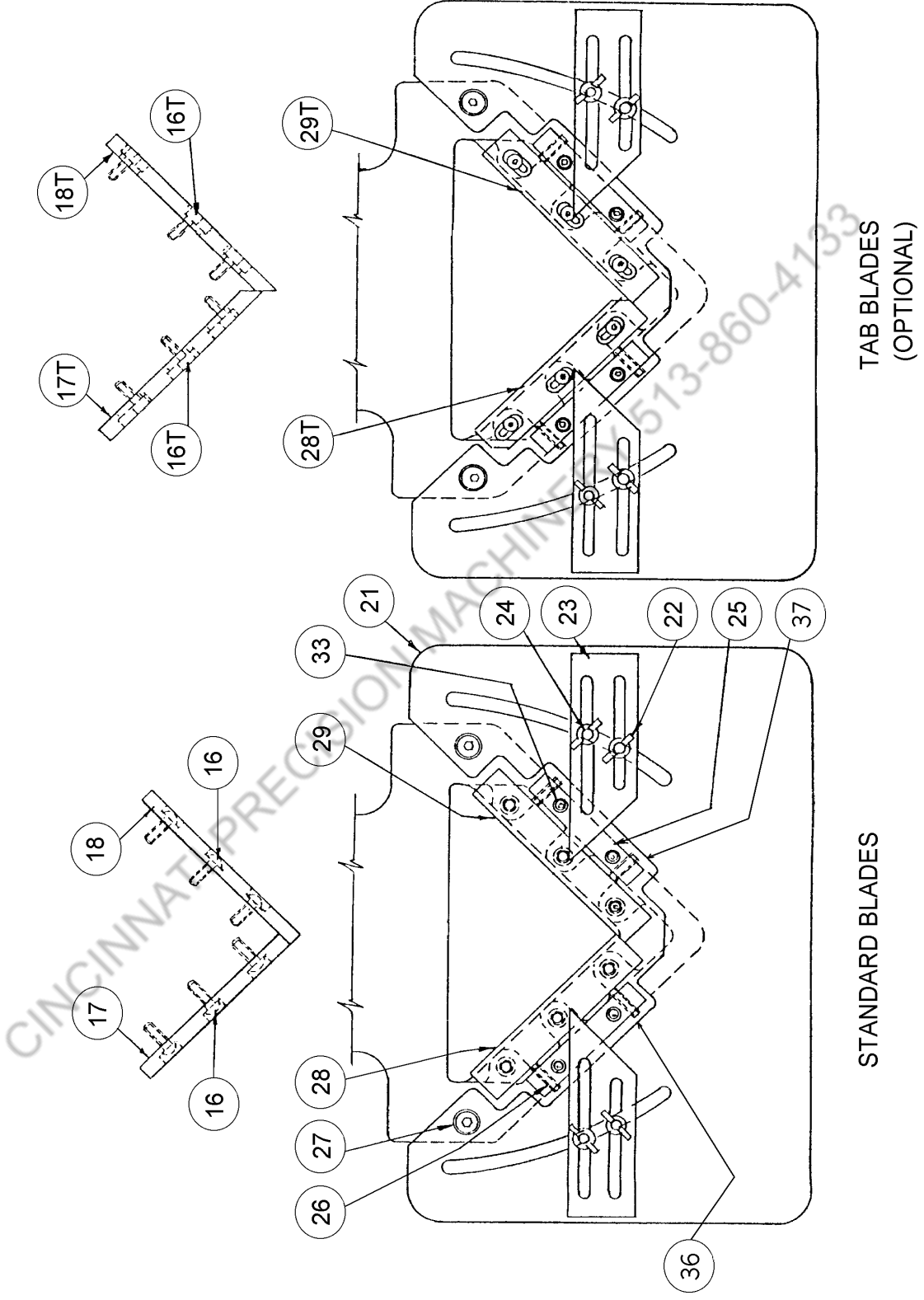
13. Gage Setting - can be accomplished by using combination square. Table edges machined at 45 degrees to cutting edges.

14. Check clearances between upper and lower blades occasionally to see that normal .002 clearance is maintained!

PS-66 PARTS IDENTIFICATION CHART



PS-66 PARTS IDENTIFICATION CHART



STANDARD BLADES

TAB BLADES
(OPTIONAL)

PS-66 PARTS IDENTIFICATION CHART

PS-66 NOTCHER, COPER & SHEAR PARTS LIST

REFER TO PARTS IDENTIFICATION CHART

INDEX	PART NO.	PART NAME	OLD PART NO.
1	740060139	Base	D6021
2	611012283	SHC Screw 1/2-13 x 3" (Short Frame)	
3	611012281	SHC Screw 1/2-13 x 2 1/2" (Long Frame)	
4	601012131	HHC Screw 5/16-18 x 3/4" (Thumb)	WS-16
5	740140138	Frame	D6020
6	600053389	Cam Pivot Pin	
7	740240148	Link	A-60223
8	740210143	Cam	A-60218
9	621012131	SSCP Screw 5/16-18 x 3/4" (Friction Shoe)	WS-834
10	740570151	Friction Shoe	A-52149
11	740220142	Slide Cap	B-60141
12	740730141	Slide	C-6122
13	740630146	Cam Roller	A-60221
14	601012179	HHC Screw 3/8-16 x 1 1/2" (Slide Cap)	WS-35
15	621012131	SSCP Screw 5/16-18 x 3/4" (Slide Adj.)	WS-834
16	684012173	LHSC Screw 3/8-16 x 3/4" (Upper Blade)	
17	350700102	L. H. Upper Blade	A-6552
18	350700101	R. H. Upper Blade	A-6551
19	740160147	Slide Pivot Pin	A-60222
20	621012183	SSCP Screw 3/8-16 x 2" (Slide Stop)	WS-854
21	740090140	Table	D-6022
22	673023004	Wing Nut 5/16-18	
23	740420150	Gauge	A-62155
24	740160152	Tee Slot Bolt	12438
25	740060149	Adjusting Plate	A-60228
26	621012131	SSCP Screw 5/16-18 x 3/4" (Blade Adj.)	WS-834
27	613012177	SHF Screw 3/8-16 x 1 1/4" (Table)	WS-2541
28	350700100	L. H. Lower Blade	A-6554
29	350700099	R. H. Lower Blade	A-6553
30	740060133	L. H. Blade Plate	A-6217
31	740060134	R. H. Blade Plate	A-6218
32	611012137	SHC Screw 5/16-18 x 1 1/2" (Lower Blade)	WS-527
33	611012131	SHC Screw 5/16-18 x 3/4" (Adj. Plate)	WS-524
34	656356301	Flexible Vinyl Grip	710770
35	740460145	Handle	A-60220
36	600000074	L. H. Bed Scale	A-7141
37	600000073	R. H. Bed Scale	A-7140

**PS-66 NOTCHER, COPER & SHEAR
TAB BLADE KIT**

REFER TO PARTS IDENTIFICATION CHART

INDEX	PART NO.	PART NAME	OLD PART NO.
16T	684012173	LHSC Screw 3/8-16 x 3/4" (Upper Tab Blade)	
17T	350700106	L. H. Upper Tab Blade	A-62295
18T	350700105	R. H. Upper Tab Blade	A-62294
28T	350700104	L. H. Lower Tab Blade	A-62297
29T	350700103	R. H. Lower Tab Blade	A-62296
30T	740060133	L. H. Lower Blade Plate	A-6217
31T	740060134	R. H. Lower Blade Plate	A-6218

When ordering Replacement Parts always give Model Number and Serial Number.

CINCINNATI PRECISION MACHINERY 513-860-1133