

Quad-Cutter Operating Instructions

ALL MACHINE COVERS MUST BE ON THE MACHINE DURING OPERATION

Capacity:	24 - 28 Gauge (.024 - .016)
Minimum length:	12"
Maximum length:	5'

OPERATING INSTRUCTIONS

Start the machine and place the material against the entrance gauge on the feed table and enter the material into the cutter. The material must be held firmly against the gauge through the length of the sheet. Also, the sheet must be held at the same level of the table in order for the sheet to be cut properly. The piece cut will be automatically guided downwards into the rollformer and the scrap will be guided up and over the machine.

To disengage the cutting attachment, simply lift the feed table and the pivoting leg will hold it in position. This will remove the power from the cutting attachment. Make sure that the pivoting leg is flat against the top of the cabinet. Precut stock can now be fed into the rollformer.

To engage the cutting attachment, turn the power off and lower the attachment back into position. Make sure that the stationary leg is on the top of the cabinet. If it is not then the gears are not in mesh, lift the cutting attachment back up and "jog" the machine. Now try to engage it again. This may take several times to get the gears lined up properly again.

If the material jams in the cutting attachment, disconnect the power and remove the jammed part.

If the material to be slit is started incorrectly and/or it was not against the feed in guide throughout the length of the material, then the slit edge of the sheet could become something less than straight. If this occurs, the "bowed" edge must be sheared straight before you can continue to run good cleats.

HELPFUL HINTS

Upon Running the machine, after the operator has began a piece into the "S" Cleat Side, if the operator keeps pressure on the sheet with their left hand, and pull the sheet slightly with their right hand. This extra tension helps to keep the sheet against the Feed Gauge.

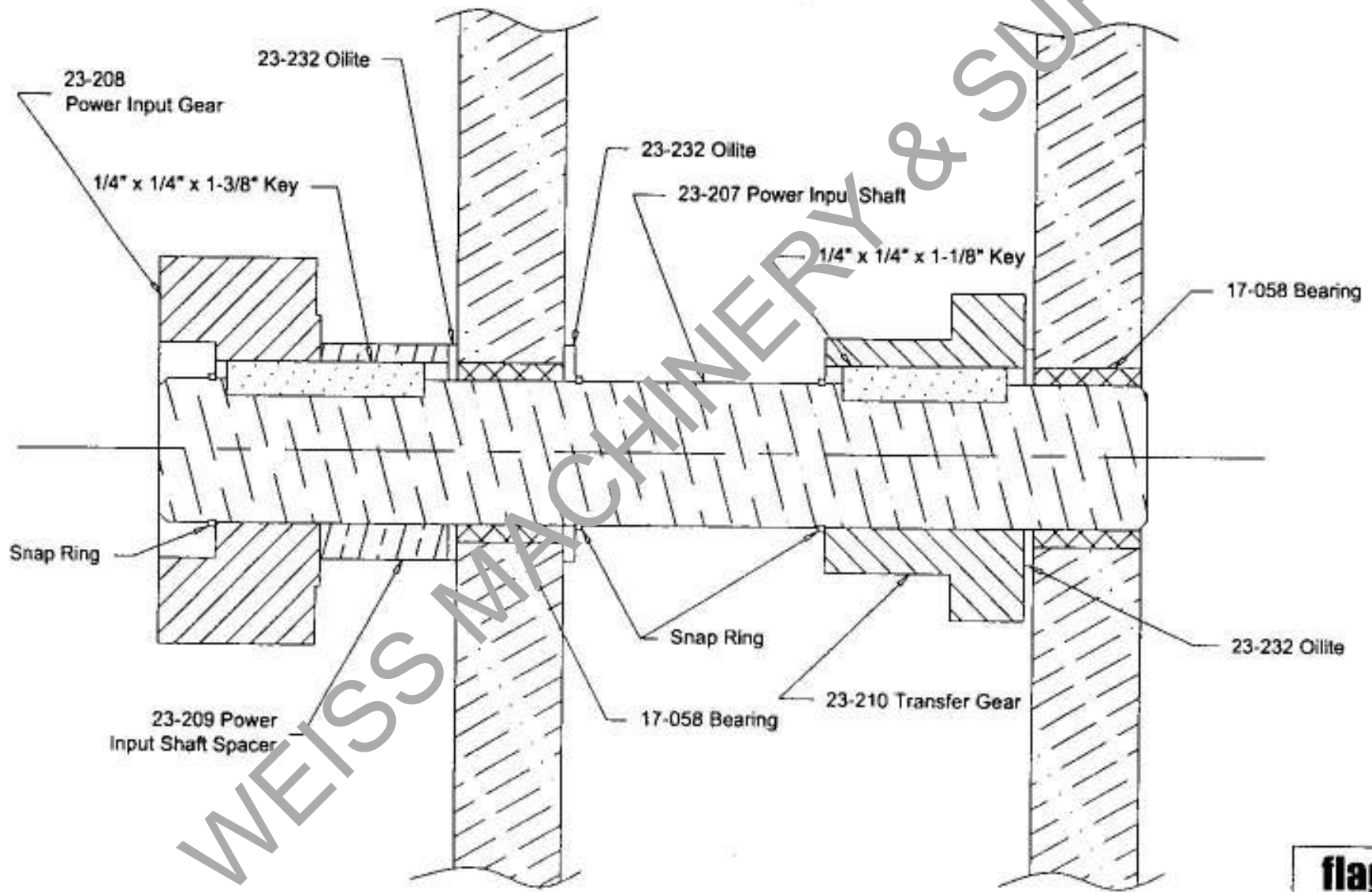
Also, if the operator begins to get a bad part with the "S" Cleat side, try to run the material on the Drive Cleat side, many times the edge on the sheet will be straight again after doing this, then the operator can continue to run the "S" Cleats.

PARTS LIST

(See attached drawings)

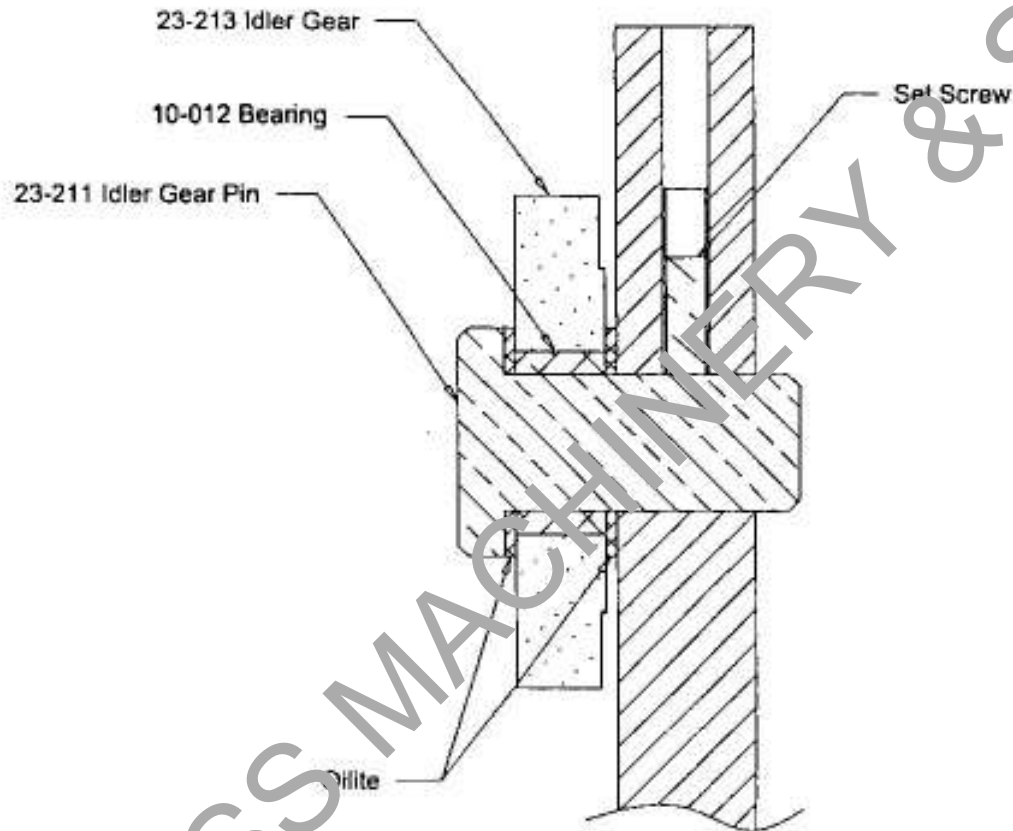
Part No.	Description	Size	Amount
23-201	Front Casting	--	1
23-202	Back Casting	--	1
23-203	Face Plate	.500 x 4.6875 x 5.500	1
23-204	Deflector Plates	16 Ga. x .750 x 9.00	2
23-205	Deflector Guide	.188 x 3.00 x 5.50	1
23-206	Deflector Guide Gauge Bar	.625 x .625 x 4.25	1
23-207	Power Input Shaft	1 1/64" rd. x 6.6875	1
23-208	Power Input Gear	2.750 rd. x 1.250	1
23-209	Power Input Shaft Spacer	1 1/2 rd. x .887	1
23-210	Transfer Gear	#YSS-816 modified	1
23-211	Idler Gear Pin	1.25 rd. x 1.875	2
23-213	Idler Gear	2.750 rd. x .500	2
23-214	Top Slitting Shaft	1 1/2" rd. x 6.375	1
23-215	Clutch Gear	#YSS-816 modified	1
23-216	Top Slitting Shaft Gear	2.750 rd. x .500	1
23-217	Bottom Slitting Shaft	1 1/2" rd. x 7.375	1
23-218	Bottom Slitting Shaft Gear	2.750 rd. x .500	1
23-205	Plain Spacer	1.00" rd. x 8.75	1
23-219	Top Cutting Blade	2.375 rd. x .500 Hy-Ten	2
23-220	Bottom Cutting Blade	2.375 rd. x .500 Hy-Ten	2
23-221	Bottom Drive Roll	2.580 rd. x .500	2
23-222	Feed Table	250 x 15" x 16.50	1
23-223	Feed Table Mounting Angle	2" x 2" x .188" x 4.6875	1
23-224	Feed Gauge	.625 x .625 x 13.00	1
23-225	Feed Table Leg	.75 rd. x 3.25	1
23-226	Feed Table Pivot Leg	.25 x .75 x 6.50	1
23-227	Feed Table Pivot Leg Mount	.75 x 1.00 x 3.00	1
23-228	Angle Iron Bracket	1.00 x 1.00 x .125 x 4.875	1
17-058	Bearing	B-1612	5
10-012	Bearing	B-128	2
23-229	Bearing	B-2412	1
23-230	Clutch Bearing	RCB-162117	1
23-231	Thrust Race	TRB-2435	1
23-232	Oilite	TT-1502-02	8
17-084	Oilite	TT-1502	3
31-027	Oilite	TT-1205	2
	Collar	1L702	2

QUAD CUTTER - POWER TRANSFER SHAFT ASSEMBLY

**flagler**

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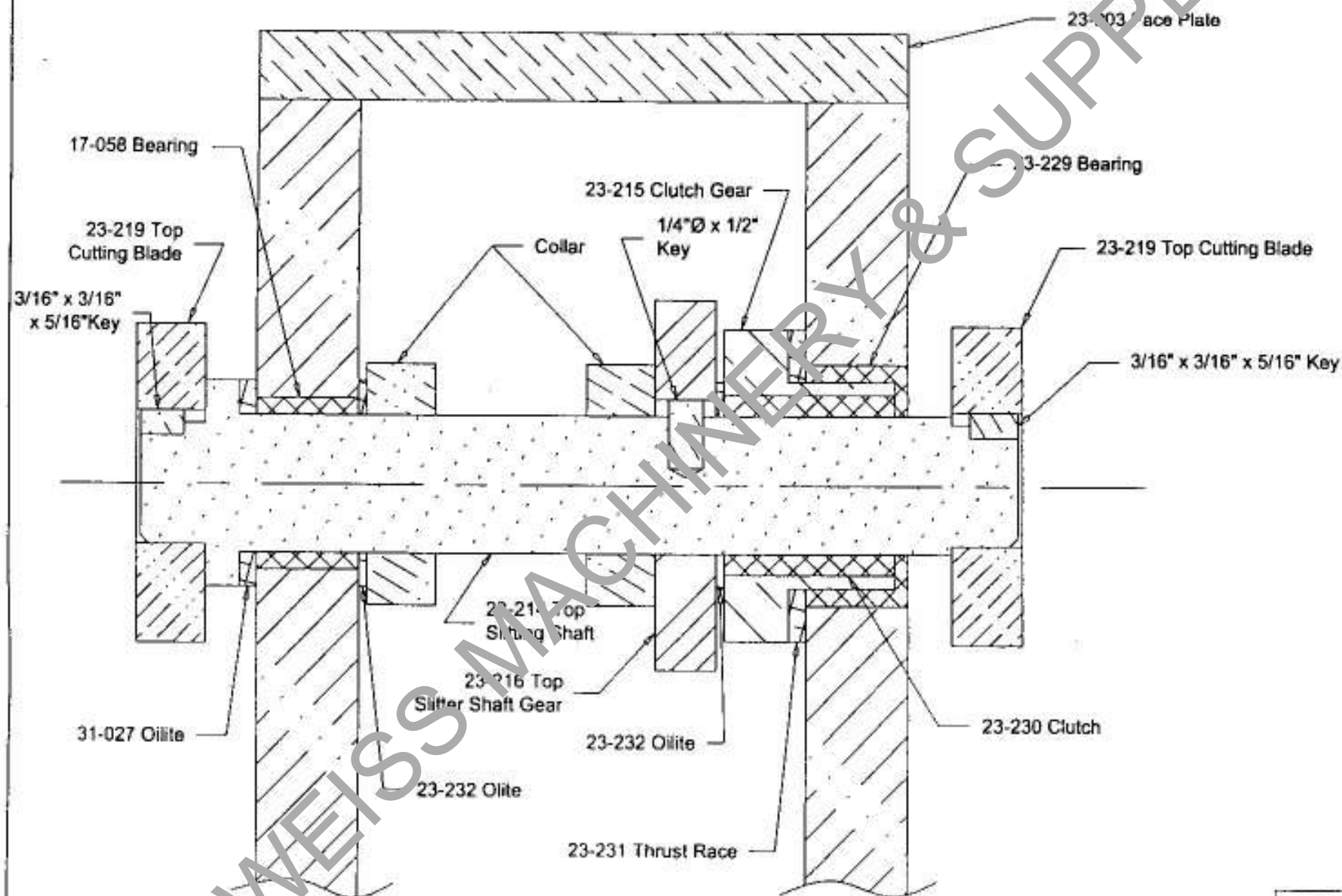
QUAD CUTTER - IDLER SHAFT ASSEMBLY



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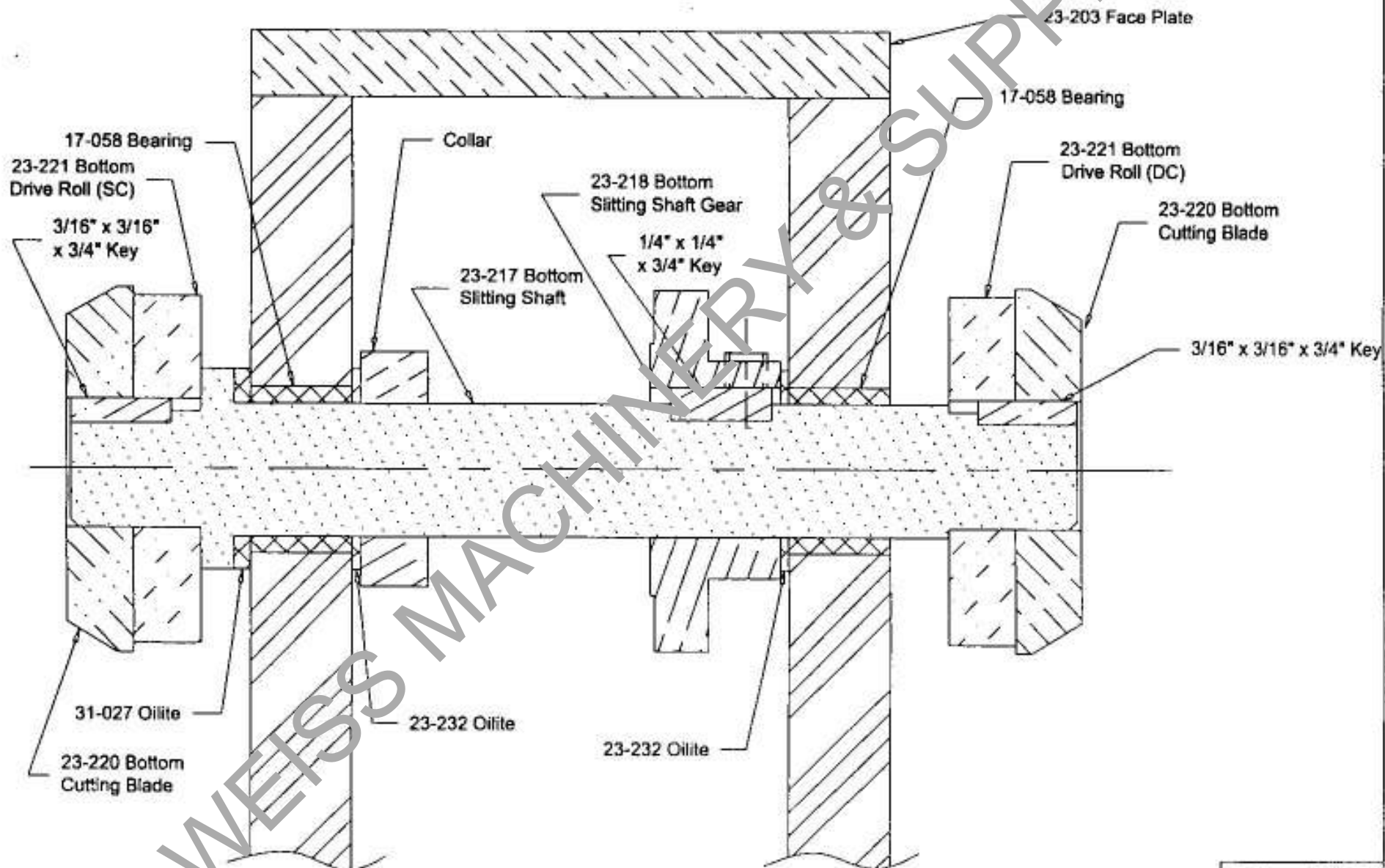
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QUAD CUTTER - TOP SLITTER SHAFT ASSEMBLY

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QUAD CUTTER - BOTTOM SLITTER SHAFT ASSEMBLY



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QUAD CUTTER - KNIFE EDGE SHARPENING

Gap between the knife edges
should be between .001" - .003"

Top Slitting Knife

If the Slitting edge becomes dull, simply turn the roll around, both sides can be used for slitting.

If both sides become dull, machine the face of one side. Please note that whatever is taken off of the face must be made up by placing a shim behind the roll.

Please note: The Drive Roll that is located next to the bottom knife must be reinstalled with the indicated face against the knife edge. This will ensure that the knives pull the material in the correct way.

Also when reinstalling the Slitting Rolls, tighten the bolt for the top knife first, then tighten the bottom. This will prevent the bottom knife binding on the top.

The Bottom Slitting knife has only (1) knife edge, if this knife needs sharpening, machine off of the face. No shimming is needed after machining.

Bottom Slitting Knife

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