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ULTIMATE TUBING NOTCHER SAFETY

All supervisory and operating personnel should read these instructions to prevent injury and assure proper and safe operation of the machine.

Proper safety precautions are the responsibility of each and every machine operator. Conscientiously followed safety programs will help prevent injury to personnel and damage to equipment.

The following Basic Guidelines are a Minimum for Safe Operation

1. Wear safety glasses when operating.
2. Avoid loose fitting clothing around moving machinery.
3. Maintain machine in proper operating condition keep clean of chips and debris.
4. Always stop cutter before adjusting machine operation.

OPERATION

1. **Single Speed** machine operates on 110 Volt single (1) phase electric. **Variable Speed** machine operates on 208 / 220 / 230 / 240 Volt (1) phase electric.
2. **Variable Speed:** Use the **MASTER** on / off switch at bottom right of control box to turn off the machine for end of day or maintenance only. Use the **RUN / STOP** switch at the upper right for normal on / off between notches. Repeated use of the master switch can cause damage to the control unit.
3. Tubing is clamped in V Block Vise leaving a minimum of overhanging material, past vise edge toward the cutter, for best operation. Be careful not to run cutter into vise.
4. Primary feed direction is in & out. Cut on O.D. (side not end) of cutter. Left to Right feed is to position material relative to the cutter. For best operation, position tubing as close to spindle as possible.
5. Material should be positioned & clamped in vise. Set swivel vise at desired angle and tighten down. Position table left to right as required for best cut. Be sure to position material as close to spindle as possible.
6. Use in & out feed to achieve proper depth of notch. A smooth constant feed will give best results. Back cutter away from work as soon as cut is completed.
7. Stop cutter before removing tubing from vise.
8. Lubrication is required at grease fittings on feed table. Use any general purpose grease as required for smooth operation. As with any machine keep as clean as possible for long life.

We hope this machine provides you with many years of productive use. If you have any questions please feel free to call us at anytime. Thank you, we appreciate your business!