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#40 STYLE TOOLING

PARTS MANUAL

This manual is for our current

65 Ton and larger

Ironworkers.

**For older machines, please
call the factory for assistance.**

605-859-2542



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#40 STYLE TOOLING PARTS MANUAL

PRINTED NOVEMBER 2024

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1.0 INTRODUCTION

This manual contains all of the optional tools available for all Scotchman model Ironworkers, except the PORTA-FAB 45, 4014CM, 4014TM, 50514CM, Model 5014-TM, 50514-EC, 5014-ET and the 610 Shear Master.

► **NOTE: THERE MAY BE PARTS PICTURED THAT DO NOT PERTAIN TO THE PARTICULAR MODEL THAT YOU OWN. PLEASE PAY ATTENTION TO SPECIFIC MODELS WHEN ORDERING PARTS.**

This manual is for parts ordering information only. All operating and set-up instructions are contained in the operator's manual that you received with your machine or the instructions that came with the tool.

2.0 TOOLING PARTS

2.1 6 X 6 ANGLE SHEAR (Used on machines after 08/1995)

6509: Ser.# 5298FF

9012: Ser.# 20874

12012: Ser.# 50843

Item	Qty.	Part #	Description	R	2	026744	Spring Block Ass'y M.A.S. (Inc. Below)
A	4	154004	#66 Aluminum Pop Rivet		2	219040	M10 x 10 Set Screw (with above)
B	2	026242	Sight Glass - Lexan	S	1	016230	6" Shim and Miter Guide - Right
C	2	201210	M10 x 20 HHCS	T	4	026735	Lower Blade 6 x 6 A.S.
D	4	213012	M10 Black Washer	U	1	016232	6" Shim and Guide Left
E	1	003140	Finger Beyond Tool Shear	V	1	016234	Lower Blade Shim - Left 6"
F	1	330251	Knob A.S. Guard	W	1	016233	Lower Blade Shim - Right 6"
G	1	220014	M6 x 10 BHCS	X	4	221210	M10 x 25 SHCS
H	1	003195	3 x 3 x 1/4 Max Sticker	Y	1	026732	Base Meric Angle Shear
I	1	026749	6" A.S. Front Painted	Z	6	201230	M10 x 70 HHCS
J	4	243101	M6 x 13.5 OAL Grease Zerk	AA	1	026237	Upper Blade Metric A.S.
K	8	201212	M10 x 35 HHCS	BB	2	208012	M10 DIN 934 Hex Nut
L	1	026209	Blade Pressure Block	BB1	2	212012	M10 DIN127 Lock Washer
M	2	026728	6x6 Side Plate Met A.S.	CC	2	204225	M10 x 60 HHCS
N	2	026243	Wear Strip 6" A.S.	DD	1	016247	Angle and Rod Shear Cap
O	2	026746	Retainer Wear Strip	EE	1	026751	6" A.S. Guard Painted
P	2	201110	M6 x 12 HHCS	FF	1	220016	M6 x 10 BF Screw
Q	2	016118	3/4 x 6 in. Die Spring	GG	1	026727	COMPLETE TOOL Angle Shear 6 X 6 X 3/8"

OPTIONAL TOP BLADES

016238 - 4 x 3-1/2, 3-1/2 x 3 & 3 x 2-1/2

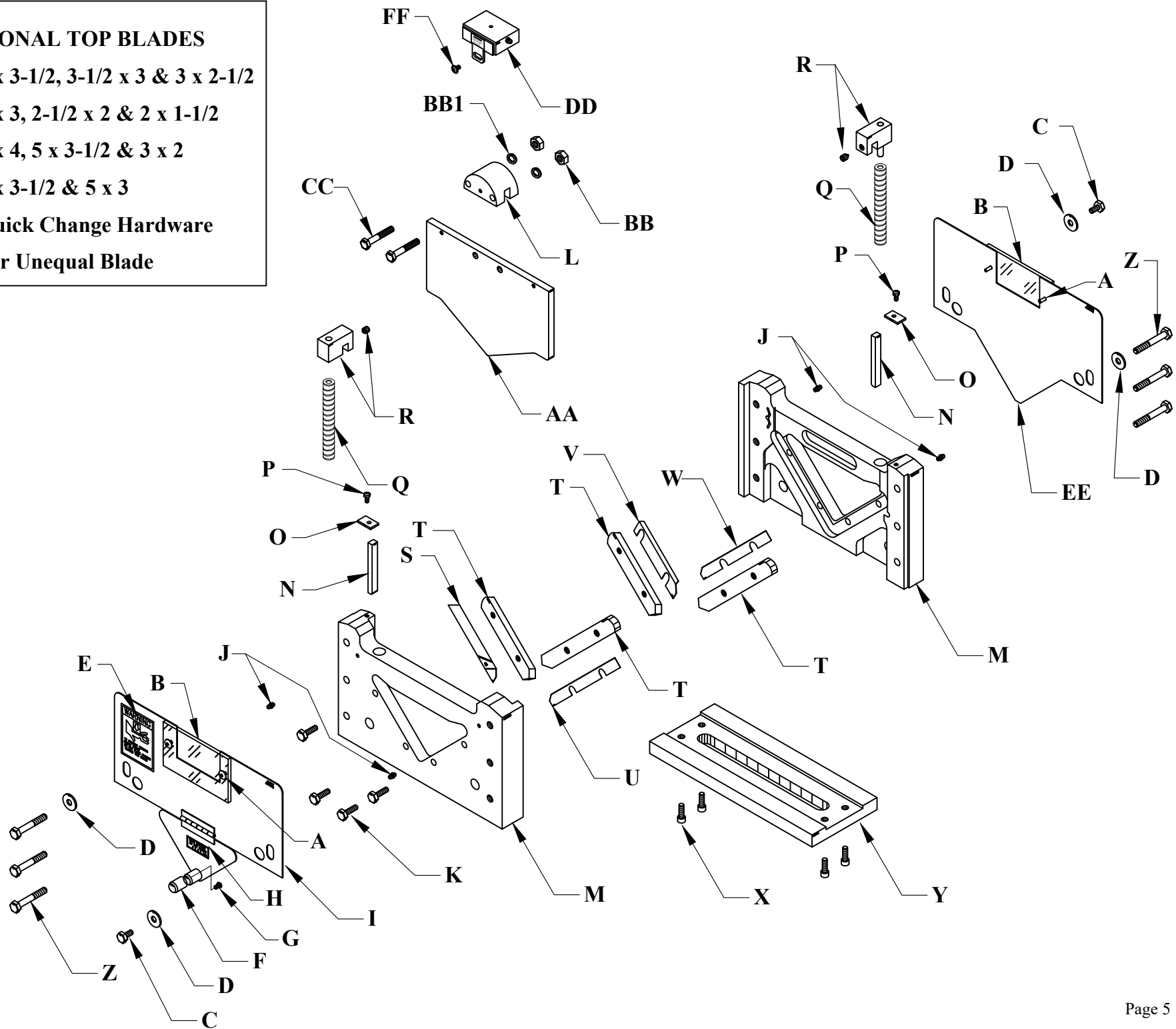
016239 - 4 x 3, 2-1/2 x 2 & 2 x 1-1/2

016240 - 6 x 4, 5 x 3-1/2 & 3 x 2

016241 - 6 x 3-1/2 & 5 x 3

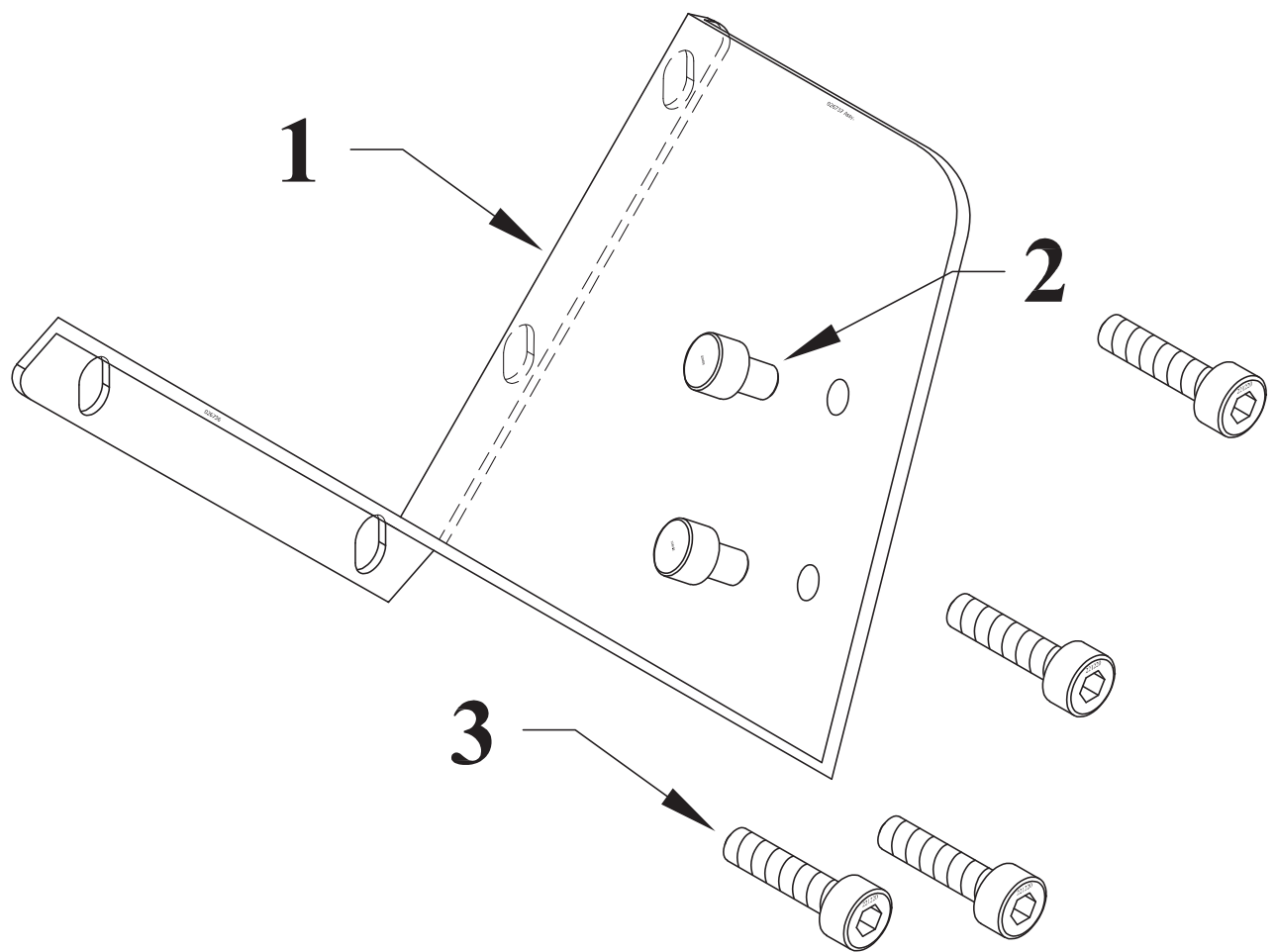
026708 - Quick Change Hardware

For Unequal Blade



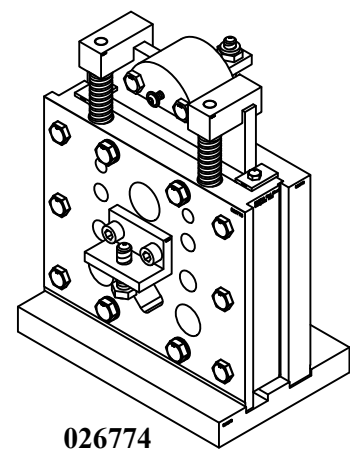
2.1A ANGLE SHEAR MITER GUIDE

ITEM	QTY	PART #	DESCRIPTION
1	1	026736	Angle Shear Miter Attachment
2	2	026698	Rest Button
3	4	221220	M-10 x 40 DIN912 SHCS
4		026737	6" Angle Shear Miter Attachment Ass'y

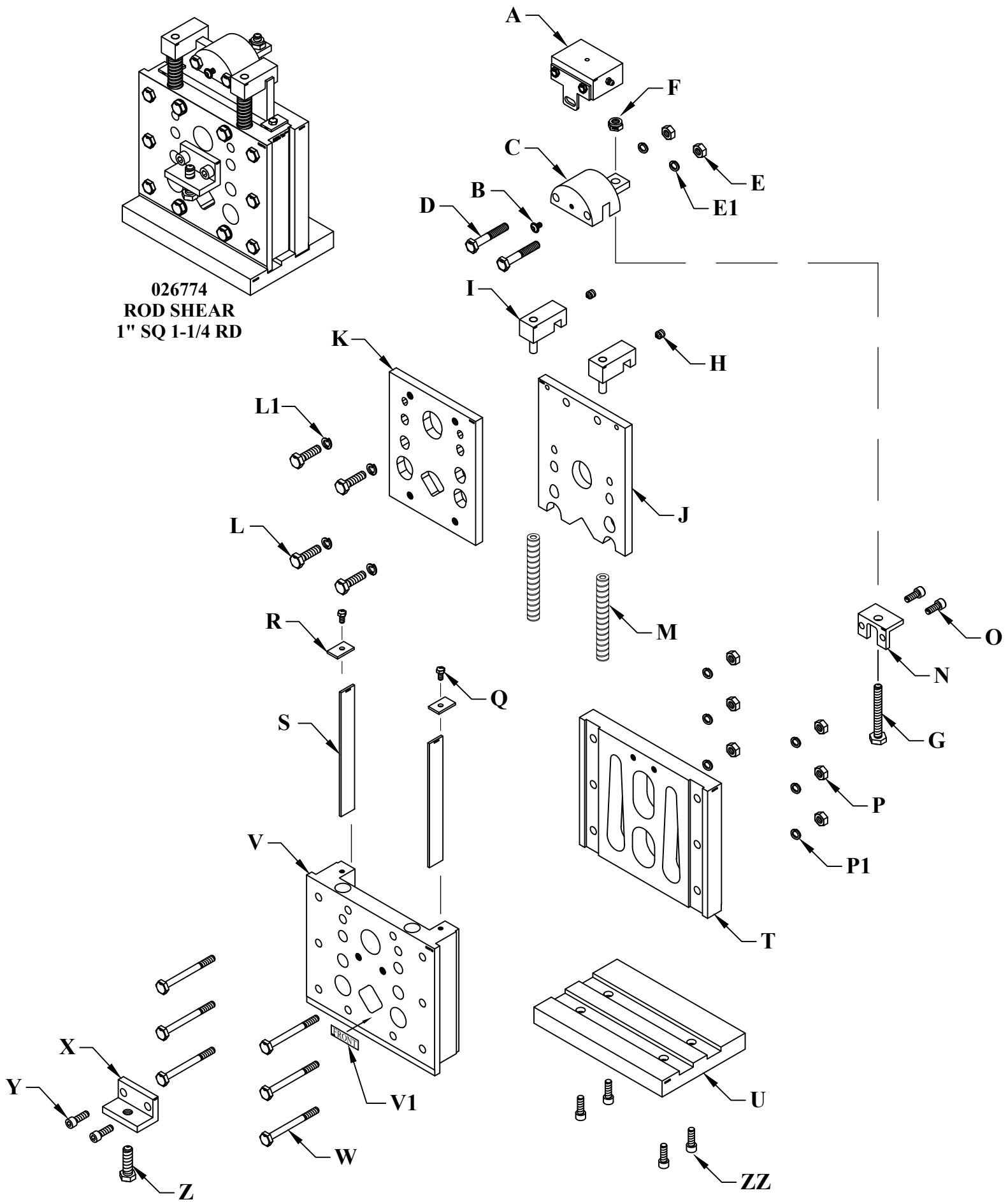


2.2 ROD SHEAR

<u>ITEM</u>	<u>COMMON PART #'S</u>	<u>9012</u>	<u>6509 DO-70 DO-95 12012</u>	<u>FI-5109 DO-100 DO-120 DO-135 DO-150</u>	<u>FI-8507 FI-8510</u>	<u>DESCRIPTION</u>
A		016247	026247	026247	027375	Slider Block
B	224005					M-6 x 12 BHCS
C		026258	026258	026258	N/A	Pressure Cap
D	204225					M-10 x 60 HHCS
E	208012					M10 DIN 934 Hex Nut
E1	212012					M10 DIN127 Lock Washer
F	215012					M-10 Nylon Lock Nut
G	201235					M-10 x 80 HHCS
H	219040					M-10 x 10 Set Screw
I	026283					Spring Return Block
J	026281					Moving Blade
K	026280					Stationary Blade
L	201215					M-10 x 40 HHCS
L1	212012					M-10 Lock Washer
M	016119					Die Spring
N	026778					Stroke Mount
O	221115					M-8 x 20 SHCS
P	208012					M10 DIN 934 Hex Nut
P1	212012					M10 DIN127 Lock Washer
Q	201110					M-6 x 12 SHCS
R	026746					Retainer
S	016279					Wear Strip
T	026775					Rear Side Plate
U	026278					Base
V	026776					Front Side Plate
V1	016328					Angle Shear Front Decal
W	203235					M-10 x 90 HHCS
X	026779					Front Stop
Y	221210					M-10 x 25 SHCS
Z	201415					M-12 x 40 HHCS
ZZ	221210					M-10 x 25 SHCS
	026774					Complete Tool

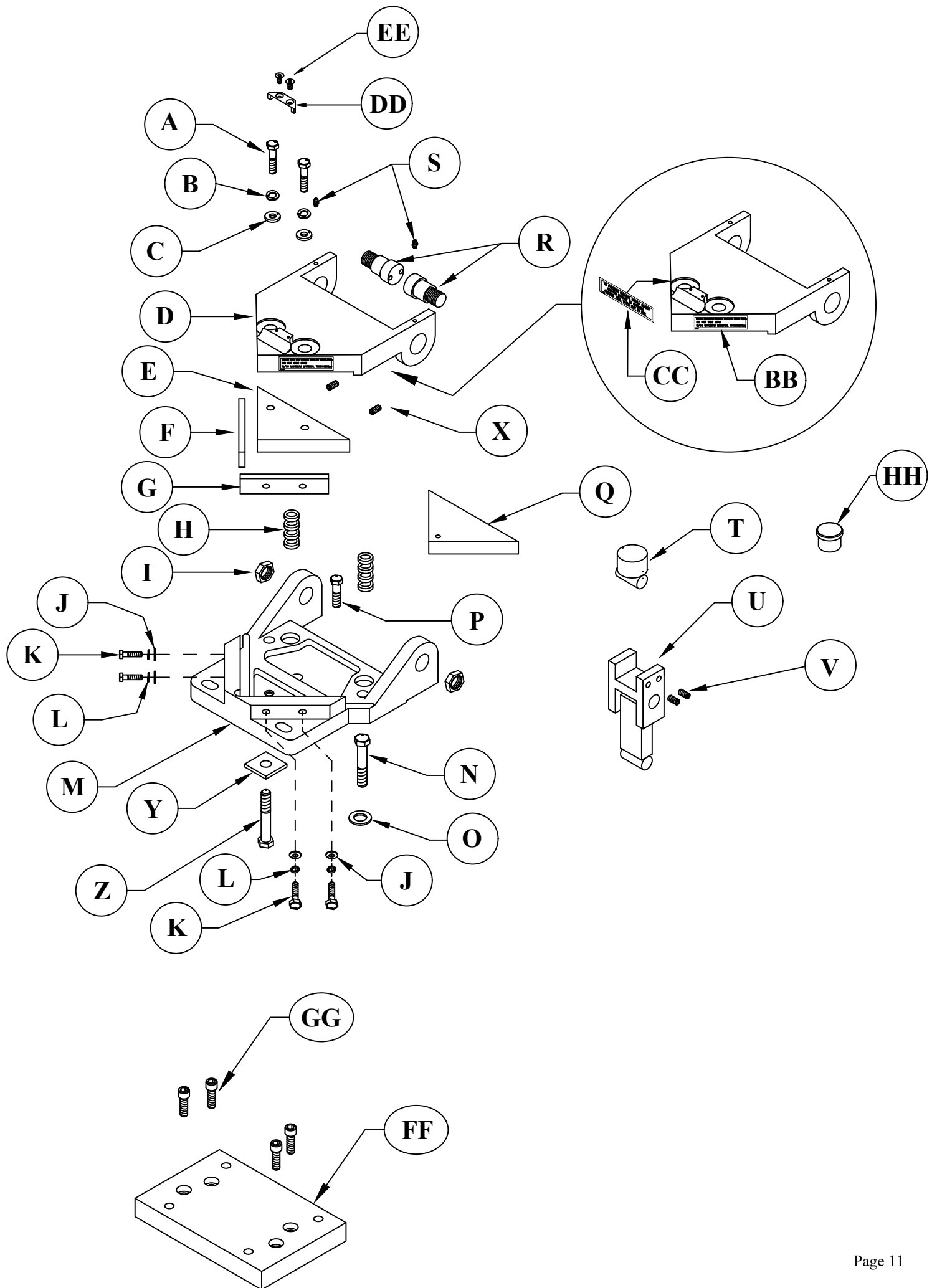


026774
ROD SHEAR
1" SQ 1-1/4 RD



2.3 6 X 6 NINETY DEGREE NOTCHER

ITEM	COMMON PART #'S	6509	9012	12012	DO-70 DO-95	DO-100 DO-120 DO-135 DO-150	FI-8510	DO-85	DESCRIPTION
A	205422								M-12 x 55 HHCS
B	212014								M-12 Lock Washer
C	162005								1 1/8 OD X 17/32 ID REID
D	026160								Top Casting
E	026166								Upper Blade
F	026164								Lower Blade-Short
G	026165								Lower Blade-Long
H	160047								1 x 3 Die Spring
I	026169								M-24 Greer Nut
J	214012								M-10 Washer
K	201215								M-10 x 40 HHCS
L	212012								M-10 Lock Washer
M	026163								Lower Casting
N	201640								M-16 x 90 HHCS
O	113017								M-16 Washer
P				201625	201625	201625	201620		M-16 x 65 HHCS
Q	016162								Rubber Slug Return
R	026167								Pivot Pin
S	243101								M-6 Grease Zerk
T	016174								Punch Ram Pusher
U		016161	016161	016163	016161	016163			Beam Block Assembly
V	218048								M-10 x 20 Set Screw
X	218048								M-10 x 20 Set Screw
Y		016177							Heavy Washer
Z		201650							M-16 x 100 HHCS
BB	003155								Label (Magnetic Probe)
CC	003145								Label (Remove Tool)
DD	016165								Notcher Clip
EE	230005								M6 X 12 FSHCS
FF				080860		080860	080860		Riser
GG						221420	221420		M-16 x 50 SHCS
HH		001304	080831	080831	001200	080831	001212	001212	Punch Pusher
		016600	016610	016615	016628	016635	016617	016632	Complete 6 x 6 Notcher

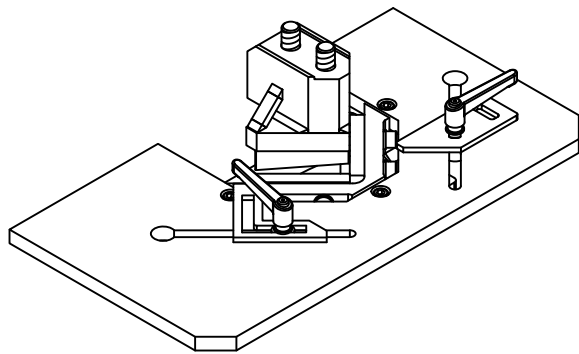


2.4 3 X 3 NINETY DEGREE VEE NOTCHER

(NOTCH STATION DO-85 ONLY)

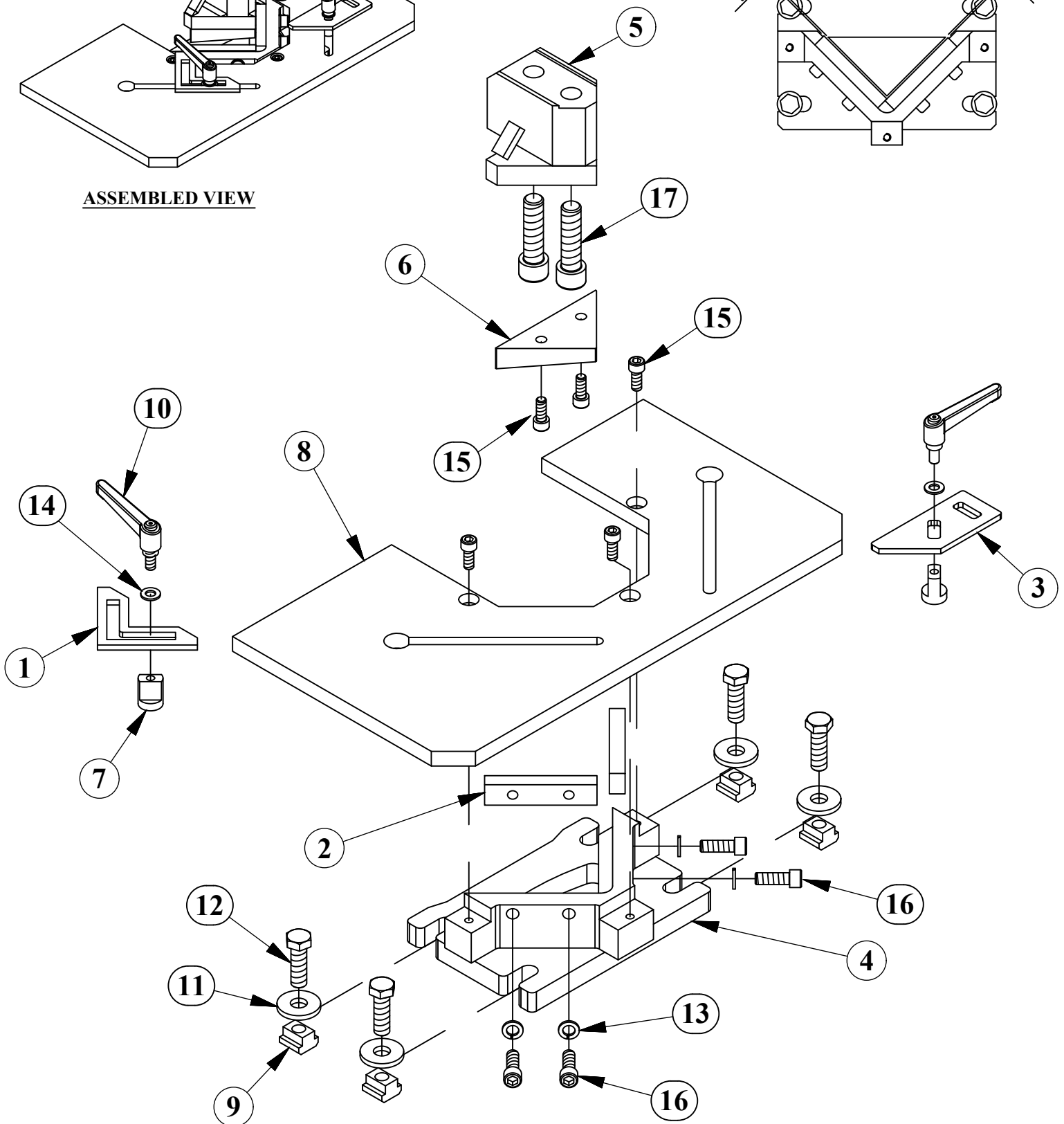
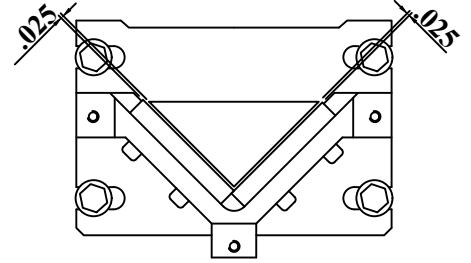
PARTS LIST			
ITEM	QTY	PART #	DESCRIPTION
1	1	014116	L TABLE STOP
2	2	025269	NOTCHER SIDE BLADE
3	1	025905	TABLE GUIDE
4	1	025906	LOWER VEE BLADE HOLDER
5	1	025924	TOP BLADE CARRIER VEE NR
6	1	025927	TOP BLADE VEE NOTCHER
7	2	025934	TABLE NUT VEE NOTCHER
8	1	025937	SUPPORT TABLE VEE NR
9	4	026625	M16 X 18MM DIN 508 TEE N
10	2	080061	STROKE ADJUSTMENT HANDLE
11	4	113017	1 3/4 OD X 21/32 ID REID
12	4	203620	M16 X 50MM DIN 931 HHCS
13	4	212014	M12 DIN127 LOCK WASHER
14	2	214012	M10 DIN125 REGULAR WASHER
15	5	221210	M10 X 25MM DIN912 SHCS
16	4	221314	M12 X 35MM SHCS
17	2	221825	M20 X 75MM DIN912 SHCS

P/N 025490 - 3" VEE NOTCHER



ASSEMBLED VIEW

Blade Clearance .025 in.



2.5 RECTANGLE NOTCHER XL - P/N 026222

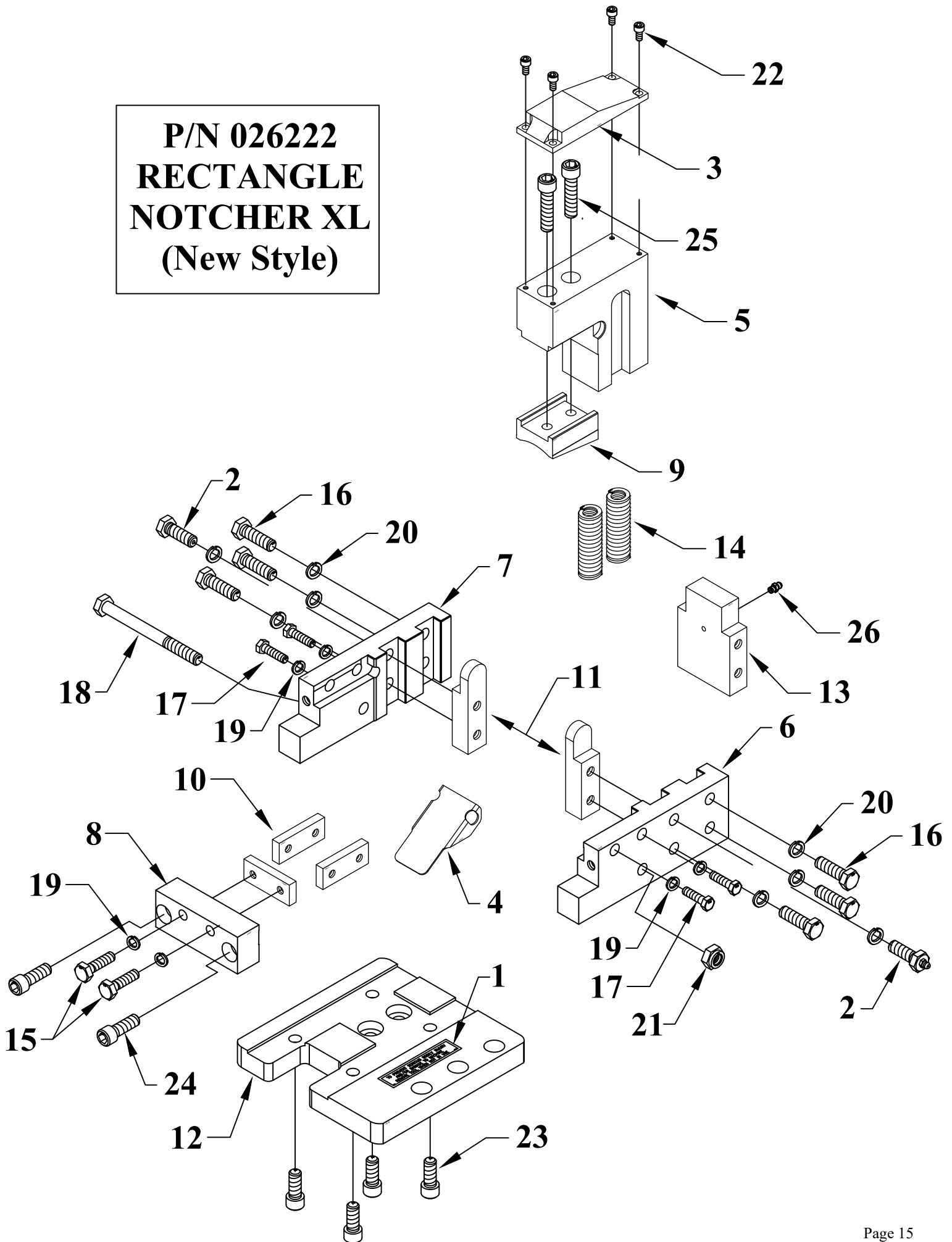
NOTICE: Determine which Rectangle Notcher you have before ordering parts!!
P/N 026222 is our new style notcher and has a 1" thick base (#12).
P/N 026000 is our old style notcher and has a 3/4" thick base.

ITEM	QTY	PART #	DESCRIPTION
1	1	003145	REMOVE TOOL NOT IN USE
2	2	006018	GREASE BOLT M12 X 35MM
3	1	024012	STRIKER CAP SQ NOTCHER
4	1	024020	SLUG RAMP SQ NOTCHER
5	1	026003	RAM METRIC SQ. NOTCHER
6	1	026005	SIDE PLATE RIGHT METRIC
7	1	026006	SIDE PLATE LEFT METRIC
8	1	026010	BLADE SEAT METRIC SQ.
9	1	026014	UPPER BLADE METRIC SQ.
10	3	026016	LOWER BLADE METRIC SQ.
11	2	026024	RAM GUIDE METRIC SQ.
12	1	026108	BASE METRIC SQ. NOTCHER
13	1	026122	CROSS MEMBER METRIC SQ.
14	2	160047	1 X 3 DIE SPRING
15	2	201215	M10 X 40MM HHCS
16	6	201415	M12 X 40MM HHCS
17	4	203212	M10 X 30MM HHCS
18	1	203450	M12 X 130MM HHCS
19	6	212012	M10 LOCK WASHER
20	8	212014	M12 WASHER
21	1	215014	M12 GREER NUT
22	4	221005	M6 X 12MM SHCS
23	4	221312	M12 X 30MM SHCS
24	2	221314	M12 X 35MM SHCS
25	2	221320	M12 X 50MM SHCS
26	1	243101	M6 X 13.5 OAL GOLD ZERK
27	1	026222	COMPLETE RECTANGLE NOTCHER XL

XL MACHINES PUSHERS AND JAM NUTS

6509	NO PUSHER OR JAM NUT REQUIRED
9012	NO PUSHER OR JAM NUT REQUIRED
12012	080831 PUSHER & 080220 #45 JAM NUT REQUIRED

P/N 026222
RECTANGLE
NOTCHER XL
(New Style)



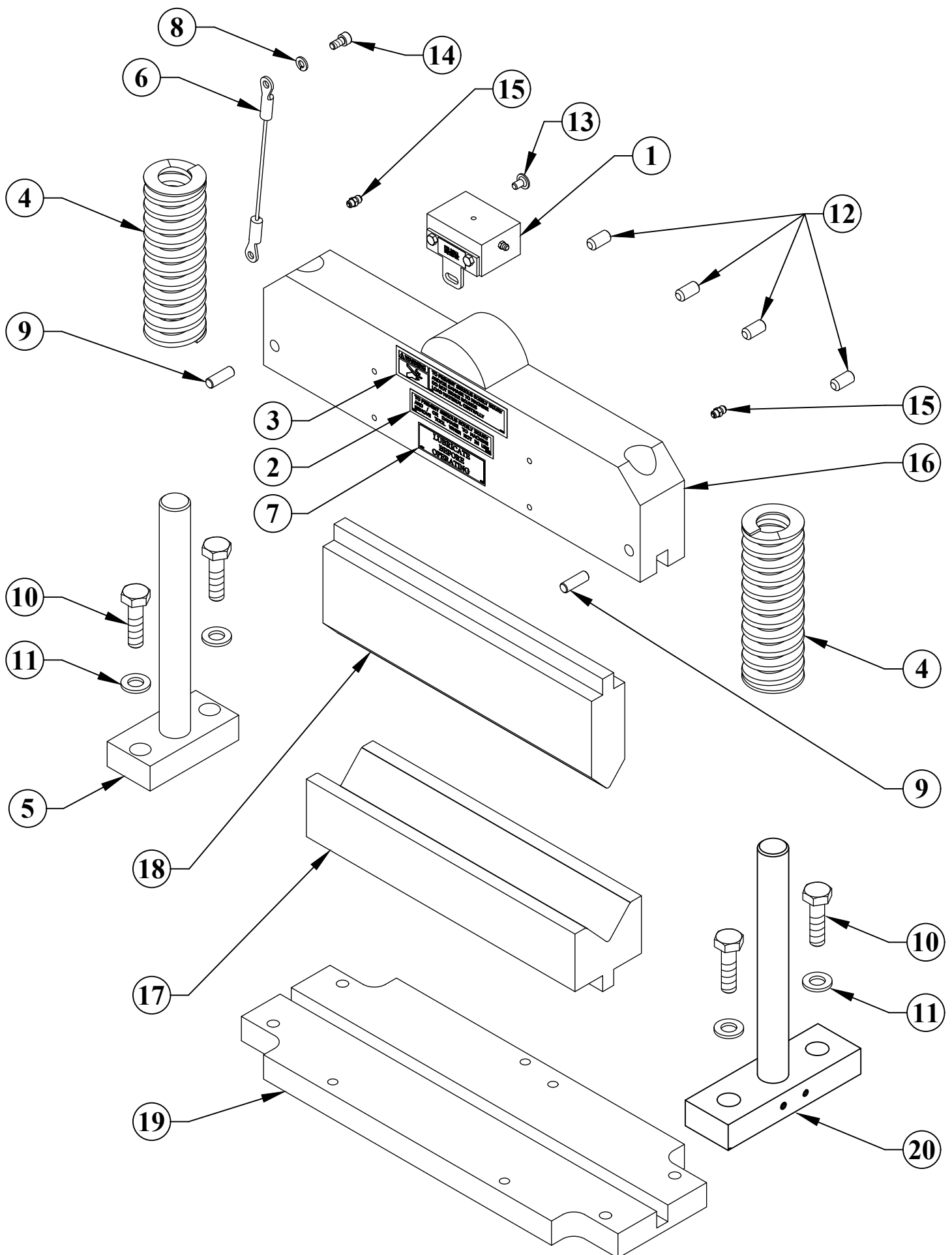
2.6 12 AND 24 INCH BRAKE

ITEM	COMMON PART #'S	6509 DO 70	9012 12012 DO 100 DO 120 DO 135 DO 150	FI 5109 FI 6008 DO 8514	FI 8507 FI 8510	DESCRIPTION
COMMON PARTS						
1		026211	016211			Pusher Cap
2	003145					Label (Remove Tool)
3	003150					Label (Do Not Brake Rounds)
4	016122					2 x 6 Die Spring
5	016317					Brake Post Assy - Short Base
6	016320					Brake Cable
7	019103					Label (Lubricate)
8	073106					M6 Lock Washer (DIN 127B)
9	077100					M10 x 30 6325 Dowel Pin
10	201417					M12 x 45 HHCS (DIN 931)
11	214014					M12 Washer (DIN 125)
12	218048					M10 x 20 Set Screw (DIN 916)
13	220016					M6 x 10 BF Screw (DIN WN11252)
14	221005					M6 x 12 SHCS (DIN 912)
15	243101					M6 x 13.5 OAL Grease Zerk

PARTS (12 INCH ONLY)						
16		026315	026315	027331	027331	Brake Top (Includes: 2, 3, 7, 9, 12, 13, 15)
17	016331					Lower Die
18	016335					Upper Die
19	026304					Base
		026300	026300	027300	027320	12 Inch Brake Complete Assembly

PARTS (24 INCH ONLY)						
16		026314	026314	027335	027335	Brake Top (Includes: 2, 3, 7, 9, 12, 13, 15)
17	016332					Lower Die
18	016336					Upper Die
19	026302					Base
20	016309					Brake Post Assy - Long Base
		026303	026303	027303	027325	24 Inch Brake Complete Assembly

NOTE: 12" Brake uses (2) of Item 5 - The 24" Brake used (1) Item 5 and (1) Item 20.

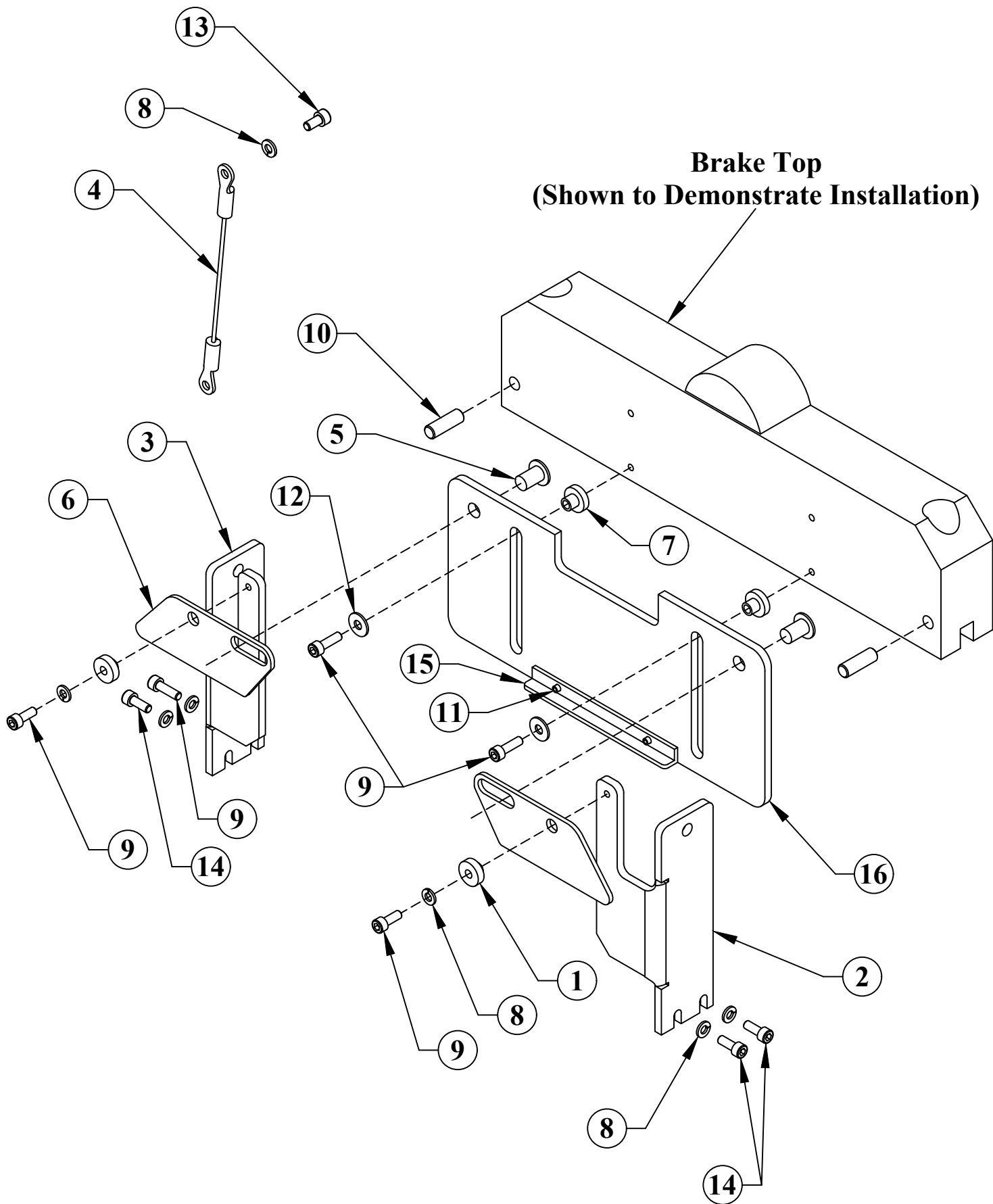


2.6A BRAKE GAURD

ITEM	PART #	DESCRIPTION
COMMON PARTS		
1	016301	Lever Boss
2	016302	Right Support
3	016303	Left Support
4	016320	Brake Cable
5	016342	Shield Peg
6	016355	Lifter
7	016360	Shield Boss
8	073106	M6 Lock Washer (DIN 127B)
9	073619	M6 x 20 SHCS (DIN 912)
10	077100	M10 x 30 6325 Dowel Pin
11	154004	#66 Aluminum Pop Rivet
12	213007	M6 Large Washer (DIN 9021)
13	221005	M6 x 12 SHCS (DIN 912)
14	221010	M6 x 16 SHCS (DIN 912)

PARTS (12 INCH ONLY)		
15	016346	Aluminum Stiffener 5.5 Inch
16	016362	12 Inch Brake Shield
	016354	12 Inch Brake Guard Complete Assembly

PARTS (24 INCH ONLY)		
15	016329	Aluminum Stiffener 17 Inch
16	016344	24 Inch Brake Shield
	016358	24 Inch Brake Guard Complete Assembly

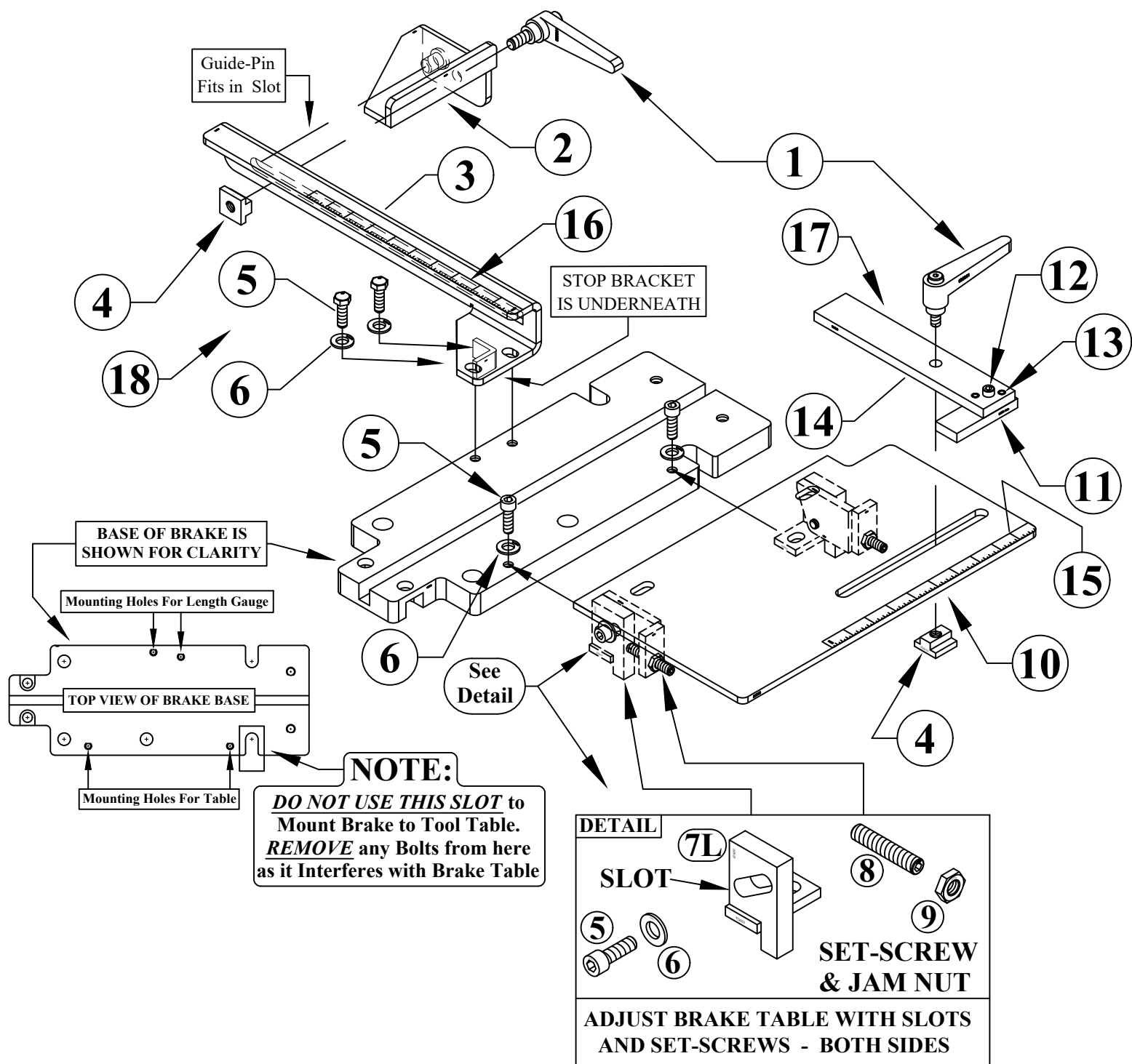


2.8 BRAKE GAUGING TABLES

ITEM	QTY	PART #	DESCRIPTION
1	2	080061	Stroke Adjustment Handle
2	1	026815	Stop Weldment Brake
3	1	026818	Rail Brake Gauge
4	2	026618	Tee Nut (M-10)
5	2	203210	M-10 x 25MM HHCS
6	6	214012	M-10 Washer
7L	1	026848	Base Mount Assembly - Left
7R	1	026836	Base Mount Assembly - Right
8	2	219060	M-10 x 50 FP Set Screw
9	2	210012	M-10 Jam Nut
10	1	026839	12" Brake Table
10	1	026855	24" Brake Table
11	1	026857	Square Arm
12	1	221115	M-8 x 20MM SHCS
13	2	141315	1/4 x 1/2 Roll Pin
14	1	026830	Guide Arm Brake Gauge
15	1	019350	Scale
16	1	019300	Right Hand Rule - 12"
17	1	026860	Squaring Arm Assembly (Includes 1, 11, 12, 13 & 14.)
18	1	026800	Brake Length Gauge w/Scale (Includes 1-6 & 16.)

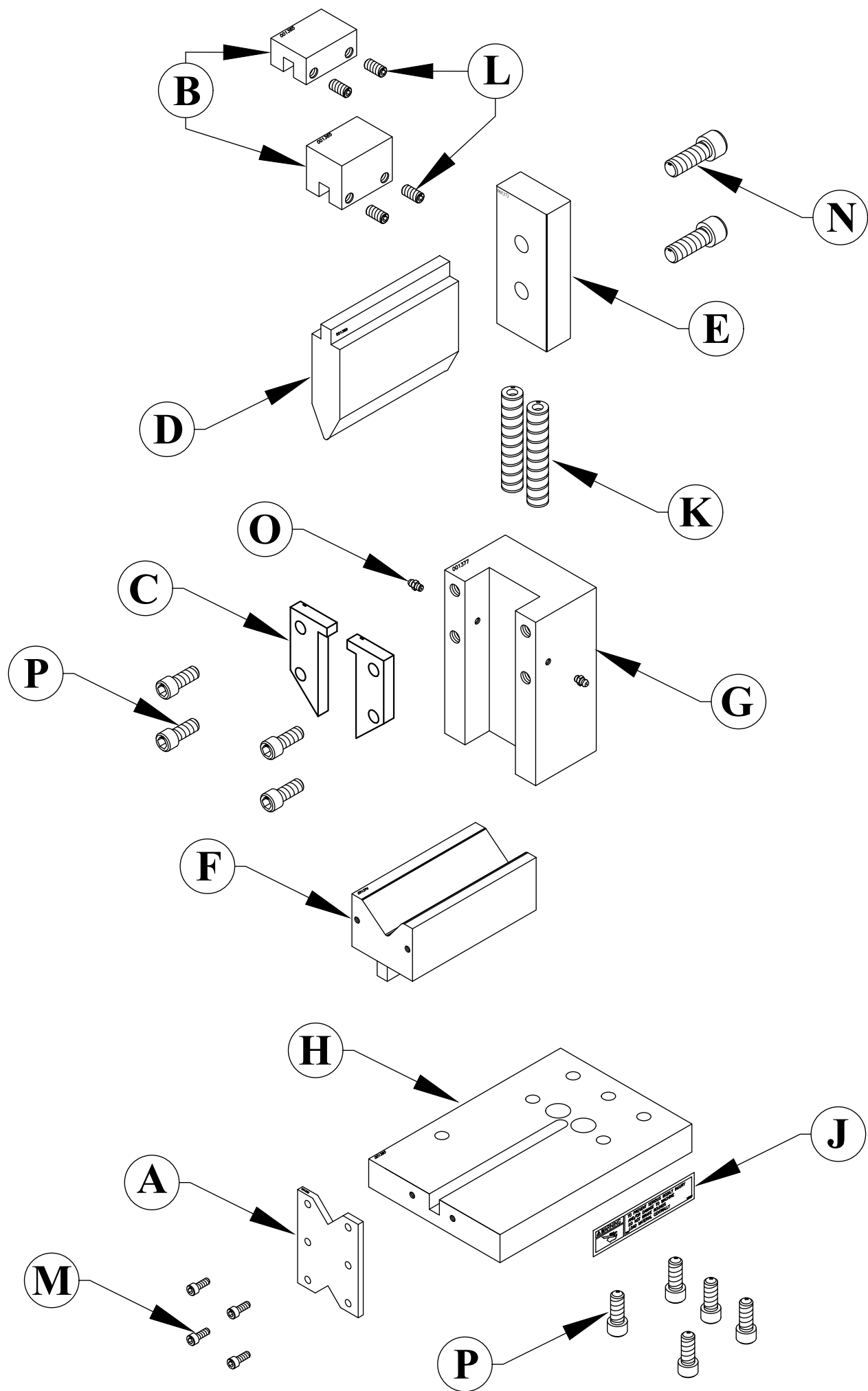
COMPLETE ASSEMBLIES

026865	12" Brake Table w/Scale
026880	24" Brake Table w/Scale



2.9 SIX INCH ANGLE IRON BRAKE

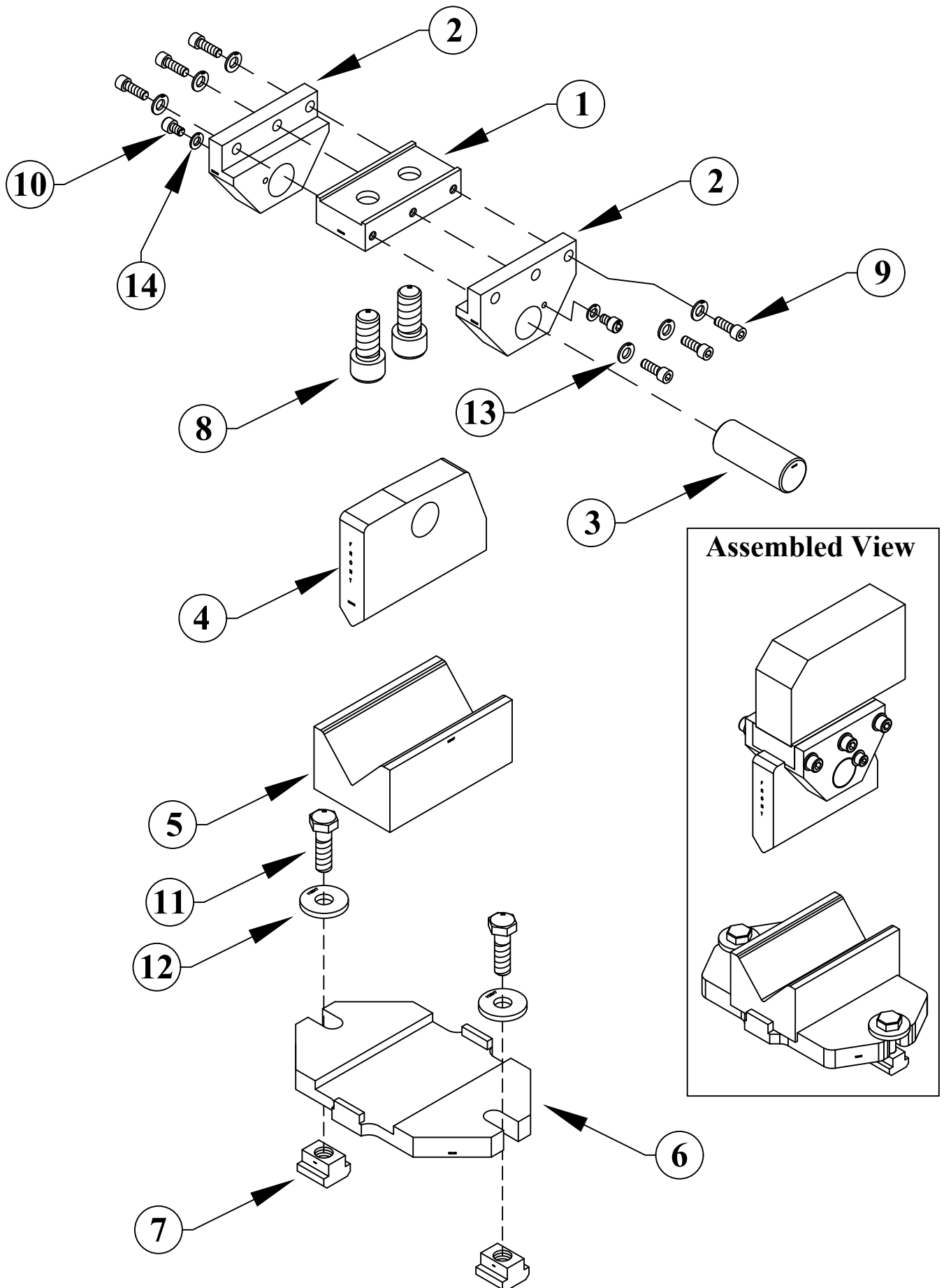
ITEM	COMMON		FI-5109 FI-8507 FI-8510 D0-70 D0-85 DO-95 DO-100 DO-120 12012 DO-135 DO-150	DESCRIPTION
	PART #	6509 9012		
A	001362			Gauge Brake
B		001385	001365	Pressure Cap
C	001367			Retainer
D	001369			Upper Die
E	001371			Ram
F	001374			Lower Die
G	001377			Post
H	001380			Base
J	003150			Label (Rounds)
K	016127			Springs
L	218048			M-10 x 20 Set Screws
M	221010			M-6 x 16 SHCS
N	221417			M-16 x 45 SHCS
O	243101			M-6 Grease Nipple
P	221312 001360			M-12 x 30 SHCS Complete Tool



2.10 SIX INCH BRAKE

ITEM	PART #	DESCRIPTION
1	025466	Top Tool Carrier
2	025469	Top Tool Side Plates
3	025410	Top Tool Pin
4	025472	Upper Die
5	025457	Lower Die
6	025460	Bottom Tool Holder
7	026625	M-16 Tee Nuts
8	221815	M-20 x 45 SHCS
9	221210	M-10 x 25 SHCS
10	073660	M-8 x 12 SHCS
11	203620	M-16 x 50 HHCS
12	113017	16mm Hd Plain Washer
13	214012	10mm Plain Washer
14	214011	8mm Plain Washer
15	025360	Complete Tool

DO-85 BRAKE FOR NOTCH STATION



2.11 CHANNEL SHEAR

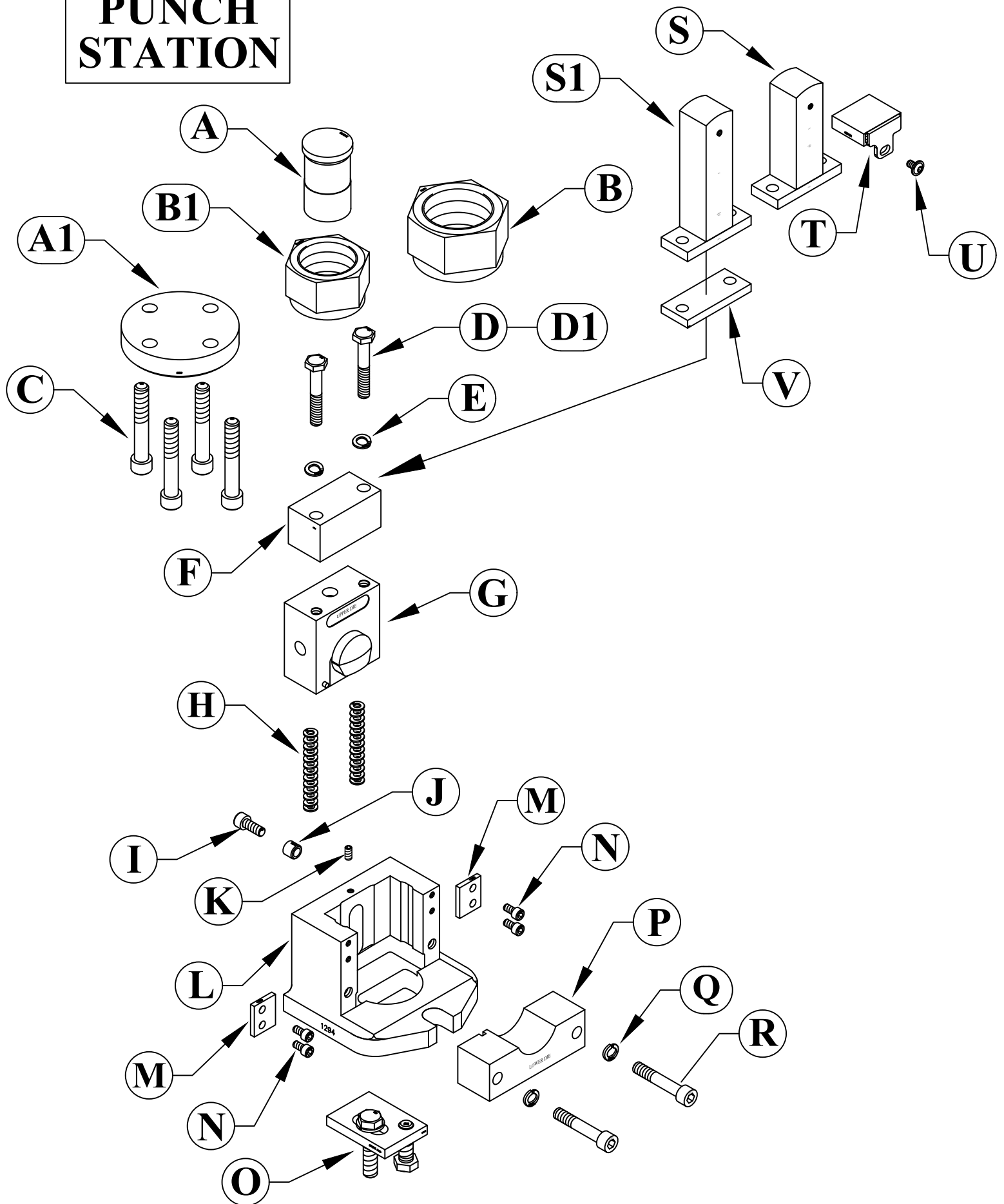
ITEM	COMMON PART #'S	6509 12012 DO-100 DO-120 DO-135 DO-150	9012 DO-70 DO-95	FI-5109 FI-6008 FI-8507 FI-8510 2450	DESCRIPTION
A-C	016211	016211	013247	027375	90 and 120 BRAKE CAP
D	220016				M6 X 10MM DIN WN11252 BF
E	204225				M10 X 60MM DIN931 HHCS
F	208012				M10 DIN 934 HEX NUT
G	026209				BLADE PRESSURE BLOCK
H	219045				M10 X 20MM DIN914 SET S.
I	160030				3/4 X 1-1/2 DIE SPRING
J	026435				SPRING LIFT METRIC CHANN
K	016118				3/4 X 6 DIE SPRING
L	026433				UPPER BLADE METRIC CHANN
M	201110				M6 X 12 DIN933 HHCS
N	218130				M12 X 80MM DIN913FP S.S.
O	026428				POST STAT METRIC CHANNEL
P	026438				SPRING ROD ASS'Y
Q	026426				SIDE PLATE METRIC CH. S.
R	201250				M10 X 130MM DIN931 HHCS
S	016184				BLADE CLAMP STATIONARY CS
SA	016185				BLADE CLAMP ADJ. CH SHER
T	201420				M12 X 50MM DIN931 HHCS
U	203212				M10 X 30MM DIN933 HHCS
V	203225				M10 X 65MM DIN931 HHCS
W	026413				FLANGE METRIC CHANNEL
X	221215				M10 X 35MM DIN912 SHCS
Y	221210				M10 X 25MM DIN912 SHCS
Z	026182				BASE METRIC CHANNEL SH.
AA	026429				VERTICAL BLADE MET. CHAN (4 REQ.)
BB	016183				WEAR STRIP CS
CC	026427				POST ROD END METRIC C.S.
DD	016202				ADJUSTMENT ROD
EE	218022				M6 X 6MM DIN916 SETSCREW
FF	026197				HANDLE ASSEMBLY METRIC
GG	026191				PRESSURE ASSEMBLY
HH	026201				ACME SCREW METRIC
II	210016				M16 DIN936 JAM NUT
JJ	026207				LOWER BLADE METRIC CHANN (2 REQ.)
KK	026432				BLADE SEAT ADJ. MET C.S.

2.12 PIPE NOTCHER

ITEM	ALL PART #'S	COMMON PART #'S ALL MACHINES	IRONWORKER MODELS							DESCRIPTION
			6509	9012	DO75 DO95 DO100	12012 DO120 DO135	DO85 FI6008	FI8510	2450 FI8507 FI5109	
A	001212		001212	001212	001212	001212		001212	001212	Pusher XL Pipe Notcher
A1	025299						025299			Tool Pusher
B	080220					080220				#45 Jam Nut
B1	016096		016096	016096	016096		016096	016096	016096	#45 Retaining Nut
C	221328						221328			M12 X 75MM SHCS
D	204225		204225	204225		204225	204225	204225	204225	M10 X 60MM HHCS
D1	201230		201230		201230					M10 X 70MM HHCS
E	212012				212012					M10 Lockwasher
F	340025	340025								XL Riser Pipe Notcher
G	Pipe Notcher Dies - See G & P									
G & P	001220	001220								3/4" SCH. 40 Pipe Dies
	001222	001222								1" SCH. 40 Pipe Dies
	001224	001224								1-1/4" SCH. 40 Pipe Dies
	001226	001226								1-1/2" SCH. 40 Pipe Dies
	001228	001228								2" SCH. 40 Pipe Dies
H	001208	001208								Pipe Notcher Spring
I	221115	221115								M8 X 20MM
J	001213	001213								Sleeve
K	218023	218023								M6 X 12MM Set Screw
L	001294	001294								Pipe Notchwe Housing
M	001209	001209								Keeper Plate
N	221005	221005								M6 X 12MM SHCS
O	001216	001216								Adj. Finger Clamp Ass'y
P	Pipe Notcher Dies - See G & P									
Q	212012	212012								M10 Lock Washer
R	203225	203225								M10 X 65MM HHCS
S	012450		012450							Tool Table Pusher For PN
S1	340041			340041	340041	340041	340041			Tool Table Pusher For PN
T	433151						433151			Rocker Cap Assy-8" Brake
U	220016						220016			M6 X 10MM BF
V	001231		001231		001231					DO 70/95 PIPE NOTCHER PUSHER SPACER
Pipe Notcher Packages			002304*	002303	002308	002305	002307	002306	002306	
*6509 S/N 8444FF1016 & Prior			002303							

PUNCH STATION

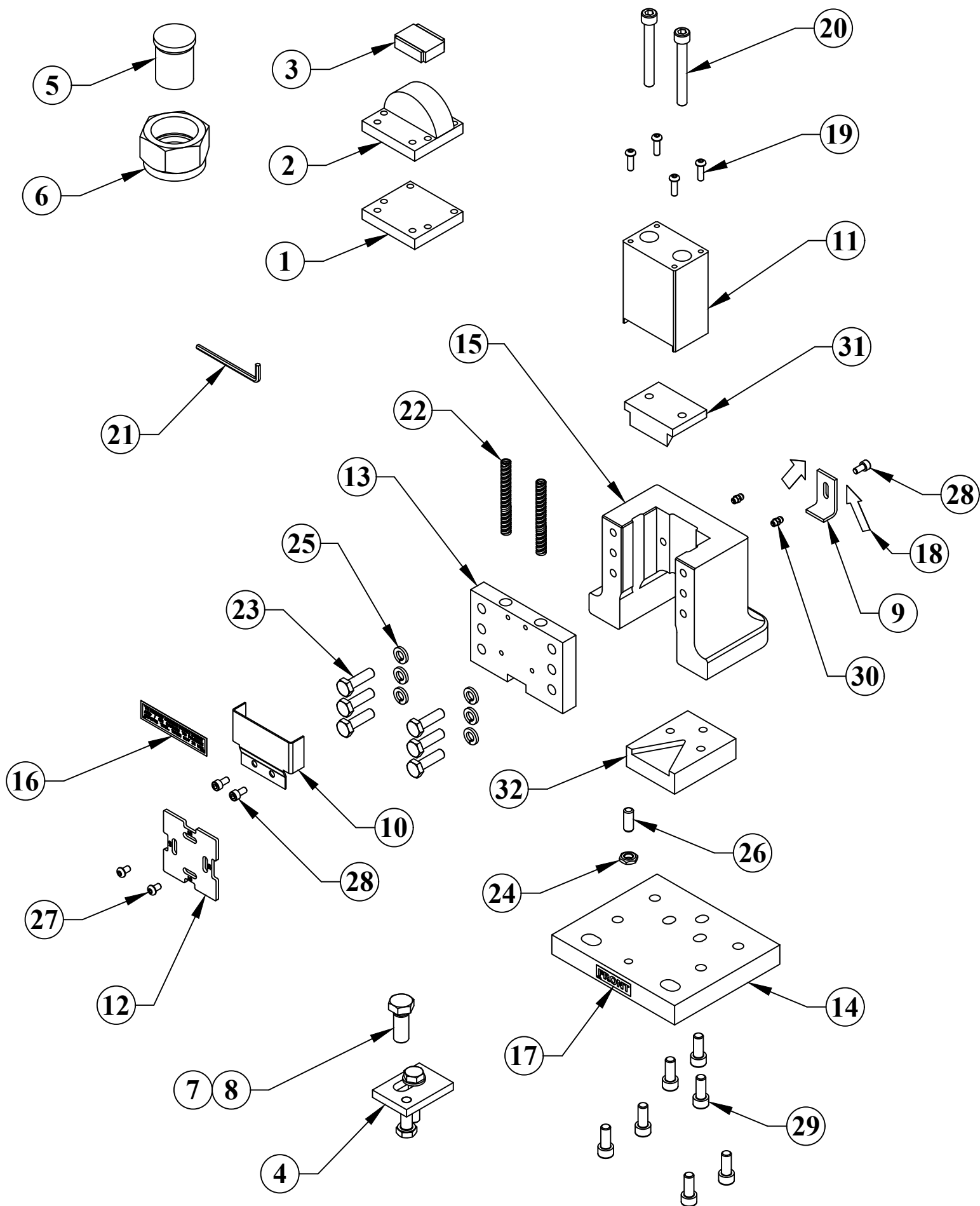
TOOL TABLE



2.13 PICKET TOOL (CAST HOUSING)

ITEM	COMMON PART #'S	6509 9012	DO 70 DO 95	FI 8510	DO 85	12012 DO 120 DO 135 DO 150	DESCRIPTION
1		001163	001163	001163		001163	Pressure Cap
2					001172		Welded Cap
3					001175		Rocker Cap
4		001216	001216	001216	001216	001216	Finger Clamp Assembly
5			080831	001212	001304	080831	Punch Pusher
6			016096	016096			#45 Retaining Nut
7		201615		201615	201615		M16 x 40 HHCS (DIN 933)
8			201620			201620	M16 x 55 HHCS (DIN 931)
		016550	001298	001163-015205	016605	001163-080835	Complete Pusher Package
9	001165						Tube Stop
10	001166						Spring Guard
11	001167						Ram
12	001178						Tube Guide
13	001272						Spring Plate
14	001275						Base
15	001280						Housing
16	003145						Label (Remove Tool)
17	016328						Label (Front)
18	019105						Label (Grease Point)
19	073615						M6 x 20 BHCS (ISO 7380)
20	073634						M10 x 80 SHCS (DIN 912)
21	080193						M8 Hex Key
22	160050						1/2 x 3-1/2 Die Spring
23	201212						M10 x 35 HHCS (DIN 933)
24	210012						M10 Jam Nut (DIN 439)
25	212012						M10 Lock Washer (DIN 127)
26	219050						M10 x 25 Set Screw (DIN 913)
27	220014						M6 x 10 BHCS (DIN BN19)
28	221005						M6 x 12 SHCS (DIN 912)
29	221210						M10 x 25 SHCS (DIN 912)
30	243101						M6 x 13.5 OAL Grease Zerk
	001293						Complete Housing Assembly

STANDARD DIES			
31	001150		1/2" Upper Die
32	001249		1/2" Lower Die
31	001190		3/4" Upper Die
32	001292		3/4" Lower Die
31	001162		1" Upper Die
32	001264		1" Lower Die



2.14 SQUARE TUBE SHEAR

IRONWORKER MODELS

6509	FI-8510	DO-8514	DO-70
9012	FI-8507		DO-95
12012			
DO-120			
DO-135			
DO-150			

<u>ITEM</u>	<u>PART #</u>					<u>DESCRIPTION</u>
1	001310					Upper Blade
2	001311					Sq. Tube Shear Blade
3	001312					Rear Plate Tube Shear
4	001313					Front Plate Tube Shear
5	026306					Base XL Tube Shear
6	203210					M10 x 25 HHCS
7	203217					M10 x 45 HHCS
8	214012					M10 Washer
9	221210					M10 x 25 SHCS
10	243101					M6 Gold Zerk
11	001309	001309	001309	001309	001309	Square Washer
12	203212	203212	203212	203212	203212	M-10 x 30 HHCS
13	026211			013247	013247	65T Brake Cap
14	001302	001302	001302	001302	001302	Blade Cap - XL
15		001304	001304			Pusher
16		001303	001303			Blade Cap - FI
17	001301	001301	001301	001301	001301	Springs
18	001216	001216	001216	001216	001216	Adj. Finger Clamp

MOUNTING PACKAGES

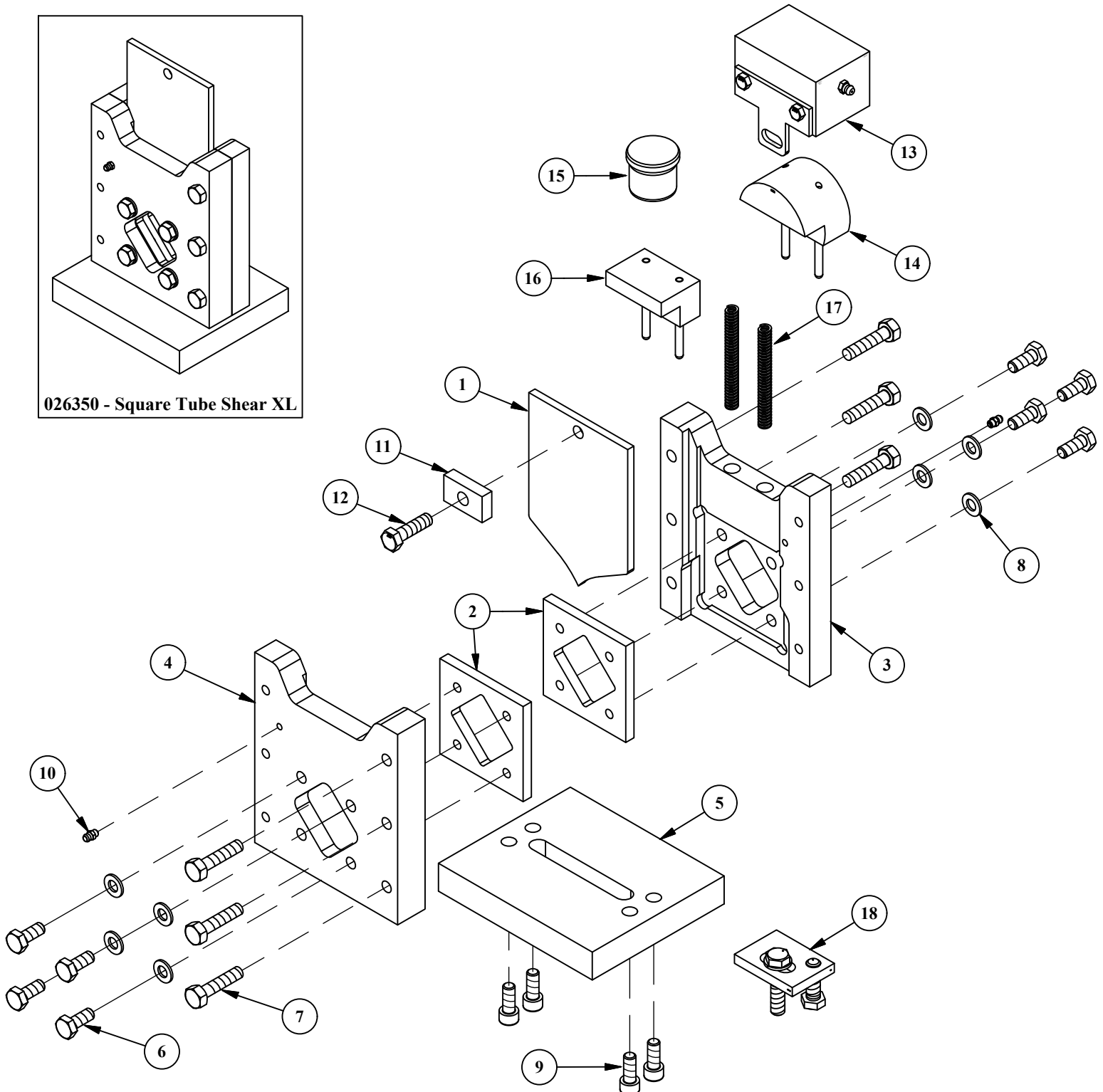
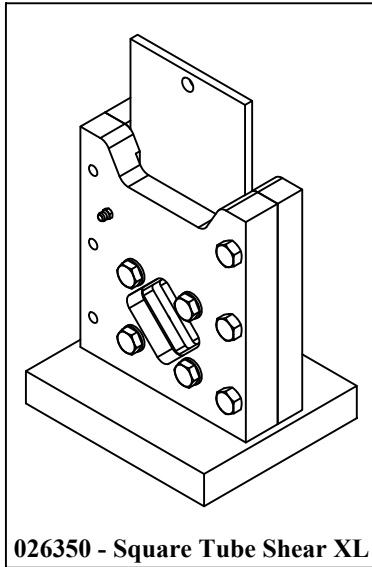
016555 - FIDO TUBE SHEAR PACK

016560 - FI TUBE SHEAR MOUNT PACK

016590 - XL TUBE SHEAR MOUNT PACK

016595 - DO 70 TUBE SHEAR MOUNT PACK

NOTE: ITEMS 1 thru 10 are the parts for the Tube Shear. ITEMS 11 thru 18 are the parts in the Mounting Packages. A Mounting Package is required to operate this tool.



2.15 STRUT CHANNEL SHEAR

Item	Qty.	Part #	Description	FASTENERS			
A	1	024541	Positive Stop	Item	Qty.	Part #	Description
B	1	024512	Right Brace	AA	4	220014	M6 X 10MM Din BN19 BHCS
C	1	024511	Left Brace	BB	2	221120	M8 X 25MM Din 912 SHCS
D	2	026243	Wear Strip 6" AS	CC	12	221212	M10 X 30MM Din 912 SHCS
E	1		Fixed Blade (see below)	DD	2	218032	M8 X 20MM Din 915 Set Screw
F	1	446170	Pressure Cap Assy	EE	2	243101	M6 X 13.5 OAL Gold Zerk
G	1	024526	Pusher Assy	FF	2	073634	M10 X 80 Din 912 SHCS
H	1		Moving (see below)	GG	4	210010	M8 Din 439 jam nut
I	2	500034	3/4 X 2 Die Spring	HH	1	220016	M6 x 10 BF Screw
J	1	024510	Multi Shear Base	II	2	073420	M8 X 16 DIN912 SHCS
K	1	024560	Guard Multi Shear	JJ	1	210016	M16 Jam Nut
L	1	003140	Warning Label	KK	2	001216	Adj. Finger Clamp Assy
M	1	076930	Material Stop	Optional Hold-Down For 1-5/8 Wide Strut Profile			
N	1		Guide (see below)				
O	1	24535	Slug Chute				
P*	1	001318	Multi Shear Pusher FI85 DO85	A1	1	024563	Strut Guide Base
Q*	1	024565	Pusher Riser	A2	1	024562	1 5/8" Strut Holddown Clamp
R*	2	073626	M10 X 25MM DIN912 SHCS	A3	2	221210	M10 X 25MM DIN912 SHCS

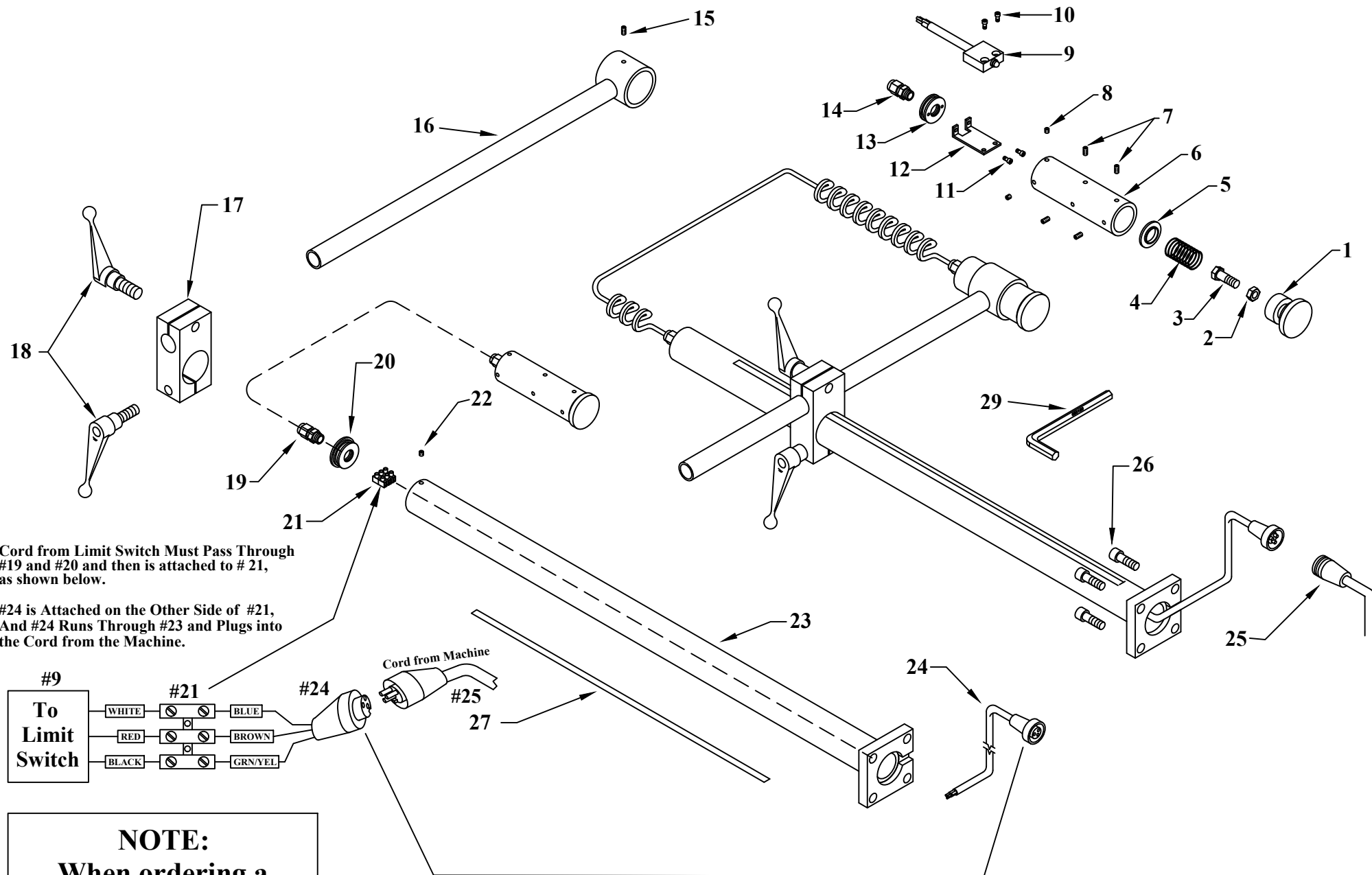
*Multi Shear Pusher for the FI-85 / DO-85 Machines

E, H, & N - To purchase Blades and Guide, sample material is required in order to machine the correct profile. Call factory for assistance. 605-859-2542

2.16 FORTY-EIGHT INCH ELECTRIC BACK GAUGE

P A R T S L I S T							
Item	Qty	Part #	Description	15	2	219047	M10 x 12 Set Screw
1	1	025338	Stop Back Gauge	16	1	025317	Length Stop Assembly
2	1	208012	M10 Hex Nut	17	1	025320	Slide Block Length Stop
3	1	201220	M10 x 50 HHCS	18	2	025361	M12 x 50 Adj. Handle
4	1	025332	Bump Spring	19	2	000202	1/2" Liq. Type Cord Conn.
5	1	025335	Spring Plate	20	1	025330	Gland Plate Length Stop
6	1	025323	Housing Length Stop	21	1	075207	PC Terminal Block
7	6	218023	M6 x 12 Set Screw	22	2	218022	M6 x 6 Set Screw
8	3	218022	M6 x 6 Set Screw	23	1	025308	Tube Assembly Back Gauge
9	1	562113	M.S. Limit Switch	24	1	025342	Cord Set Female RKM-30 [P/N 026600 only!]
10	2	073450	M4 x 16 SHCS	25	1	025340	Cord Set Male RSM-30-2M
11	2	220010	M4 x 10 BHCS	26	4	221420	M16 x 50 SHCS
12	1	025329	Mount Micoswitch	27	1	029220	L/H Tape 1/2" x 12' R/L
13	1	025326	Gland Switch Plate	28	1	550065	KM Relay DIL ER-110v [P/N 026600 only!]
14	2	000202	1/2" Liq. Type Cord Conn.	29	1	080189	14mm Allen Wrench

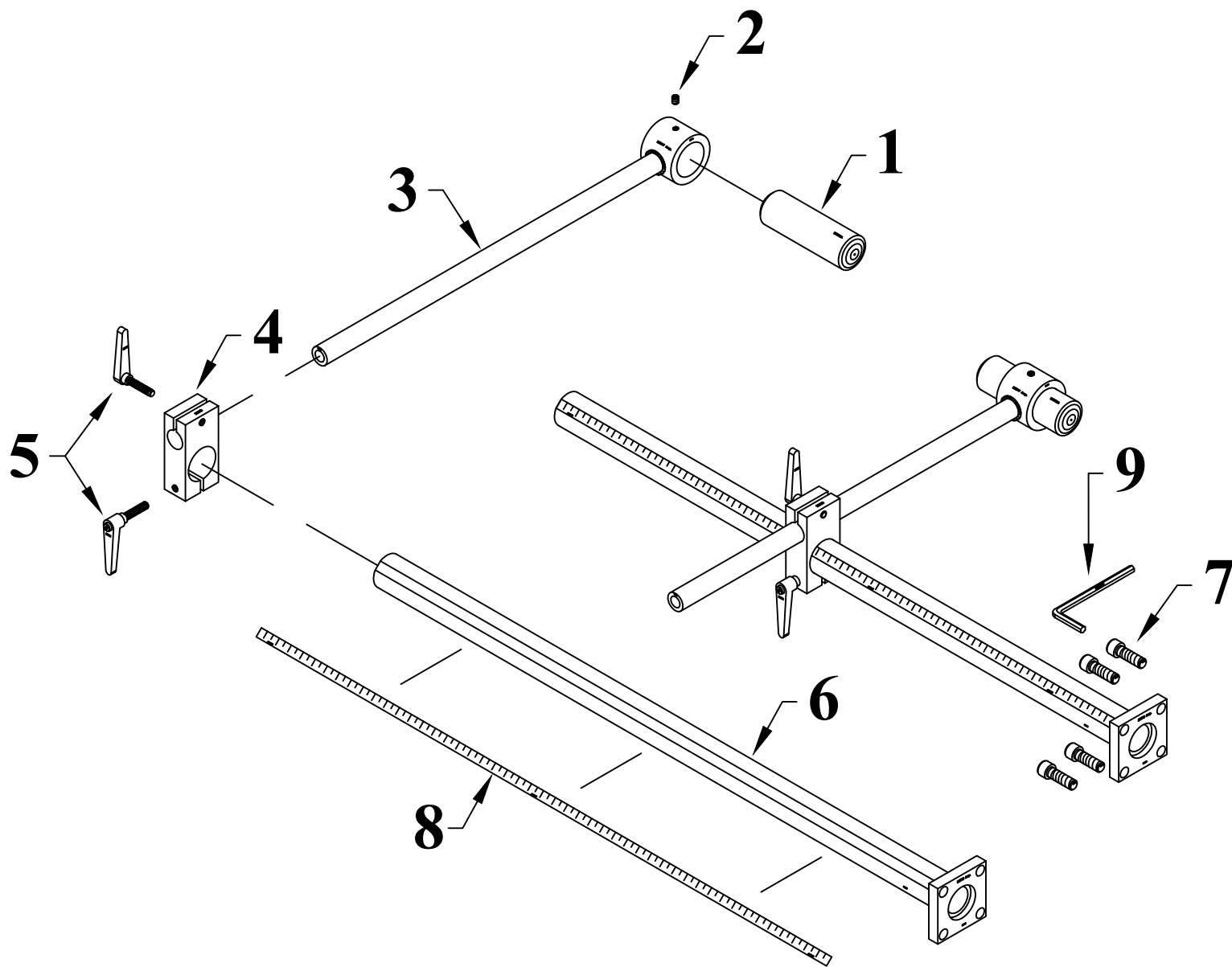
Complete P/N's - To order an Electric Backgauge, get the Serial Number for your machine and contact the factory at 605-859-2542 or email at info@scotchman.com for the correct Part Number.



NOTE:
When ordering a Back Gauge, it will include instructions on how to wire it to your specific machine

2.17 FORTY-EIGHT INCH MANUAL BACK GAUGE ASSEMBLY

ITEM	PART #	DESCRIPTION
1	025324	Length Stop
2	219047	M-10 x 12 Set Screw
3	025317	Length Stop Assembly
4	025320	Slide Block Length Stop
5	025361	Adjustable Handle
6	025312	Tube Assembly
7	221420	M-16 x 50 SHCS
8	029220	LH TAPE 1/2" X 12'
9	080189	M-14 Allen Wrench
10	025603	Complete Deluxe Back Gauge 48"

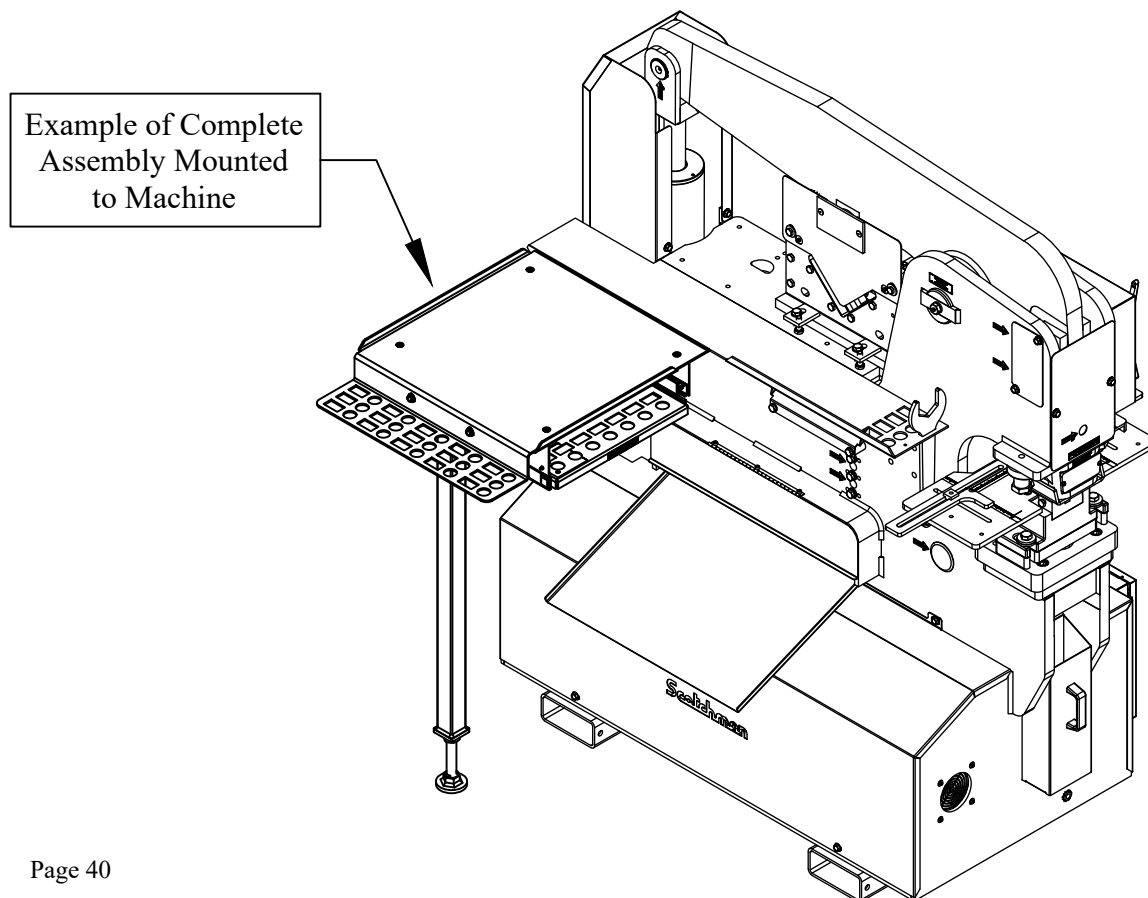


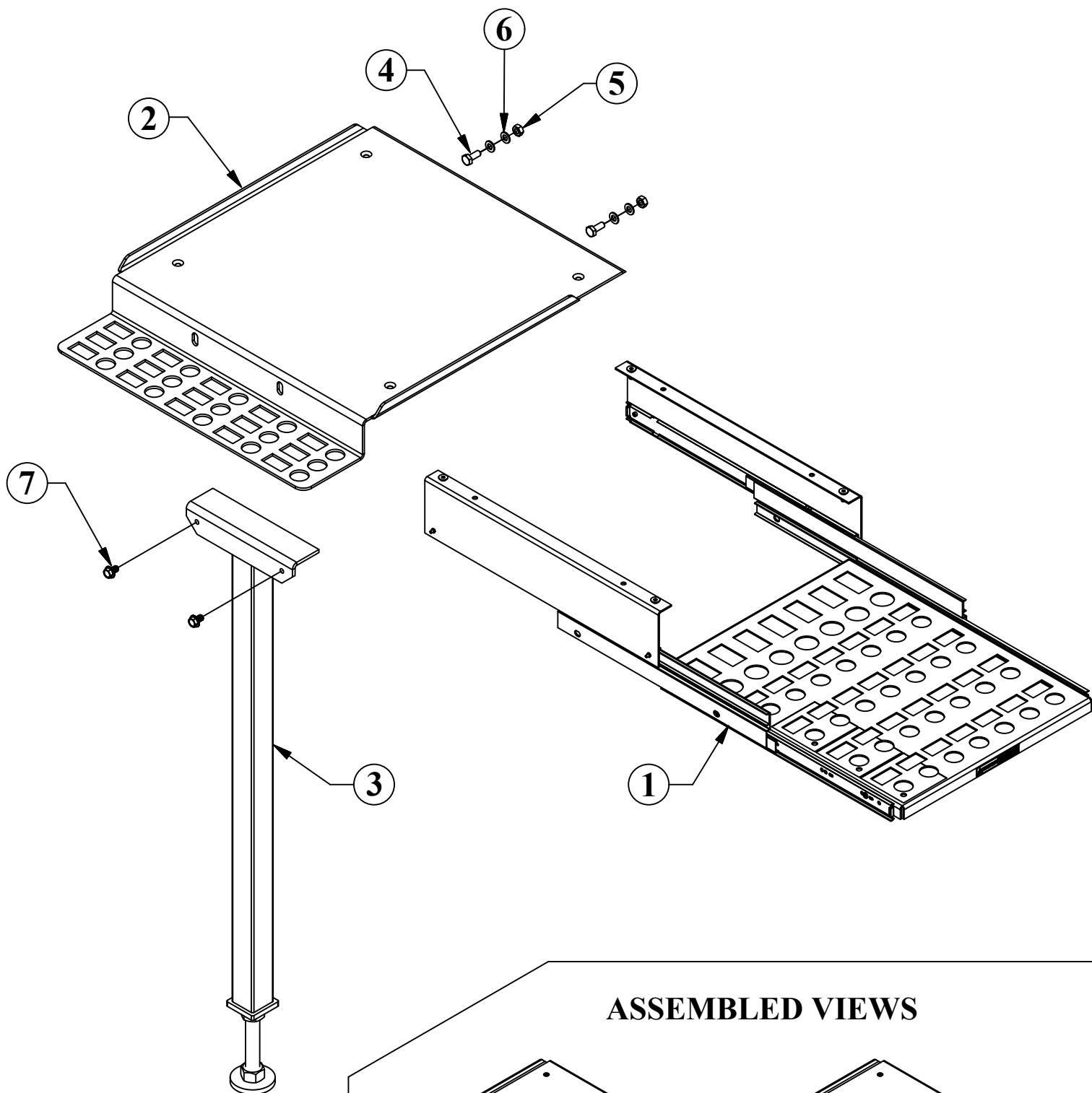
2.18 TOOL TABLE EXTENSION

MODELS: 6509, 9012, 12012, D0-70, DO-95, DO-120, DO-135 & DO-150

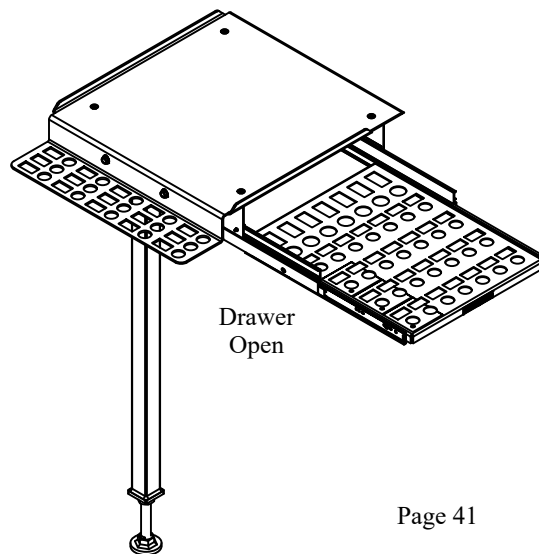
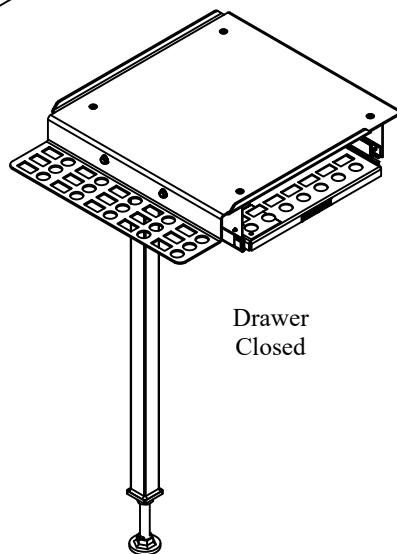
PARTS LIST			
ITEM	QTY	PART #	DESCRIPTION
1	1	032995	#40 P & D STORAGE DRAWER ASSY
2	1	033207	TABLE STAND
3	1	033208	LEG ASS'Y TOOL STAND
4	2	203210	M10 X 25MM DIN933 HHCS
5	2	208012	M10 DIN 934 HEX NUT
6	4	214012	M10 DIN125 REGULAR WASHER
7	2	224205	M10 X 16MM DIN-BN73 WLCS
8	1	032980	#40 TOOL TABLE EXT. W/ DRAWER (Complete Assembly)

NOTE: Full instructions are provided for assembly and mounting.





ASSEMBLED VIEWS

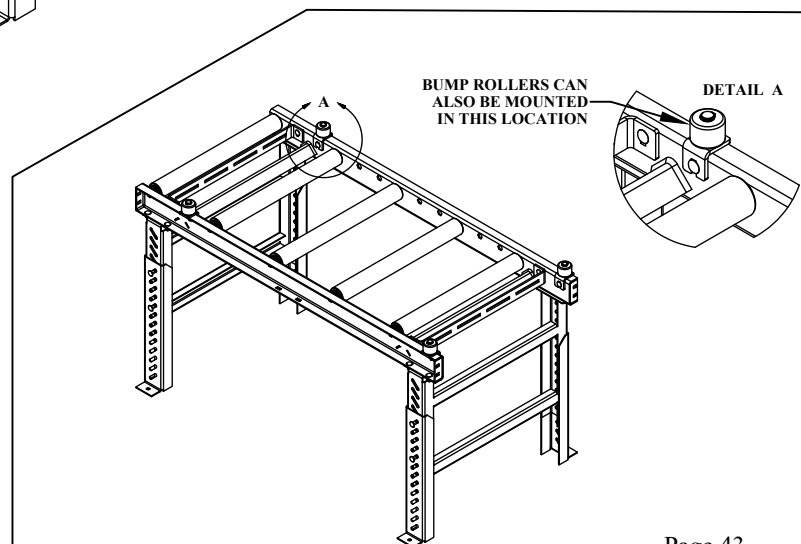
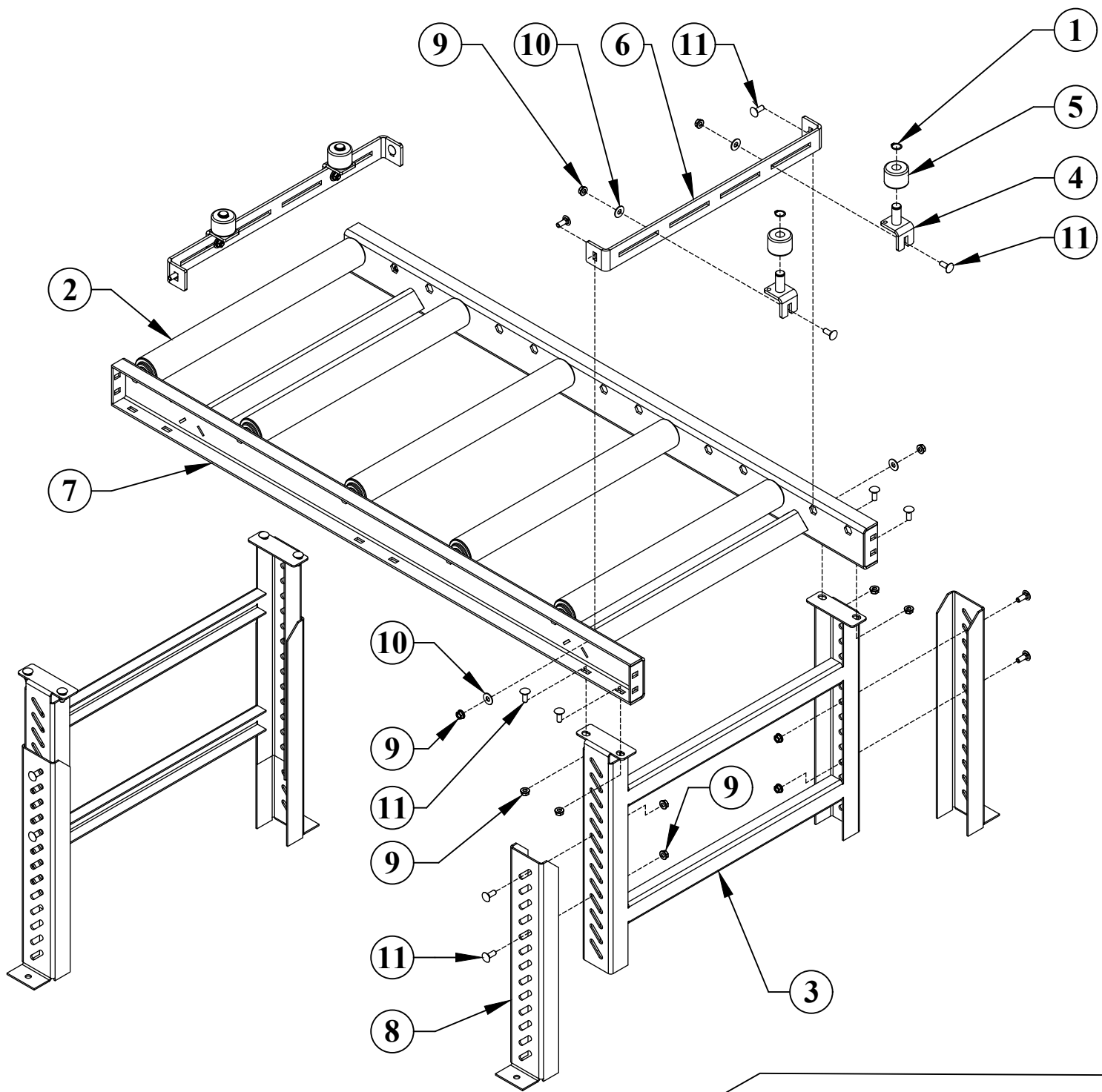


2.19 P/N 026976 INFEED CONVEYOR (24" X 5')

(NO ANGLE SHEAR)

PARTS LIST		
ITEM	PART #	DESCRIPTION
1	016402	3/4 OD SNAP RING
2	026905	25" REPLACEMENT ROLLER
3	026945.2	UPPER LEG 25"
4	026955	BUMP ROLLER MOUNT ASSEMBLY
5	026962	BUMP ROLLER
6	026965	MOUNT BUMP ROLLER-PAINTED
7	026988	25" CONVEYOR WELD
8	029244.1	LOWER LEG
9	111000	3/8-16 SERRATED FLANGE LOCKNUT
10	114012	3/8 USS FLAT WASHER
11	130210	3/8-16 X 1 CARRIAGE BOLT

SALES ASSEMBLIES		
PART #	INCLUDES	DESCRIPTION
026945	3, 8, 9, 11	LEGS FOR 25" CONVEYOR
026960	1, 4, 5	BUMP ROLLER SALES
026970	2, 7	25" CONVEYOR 5' LONG

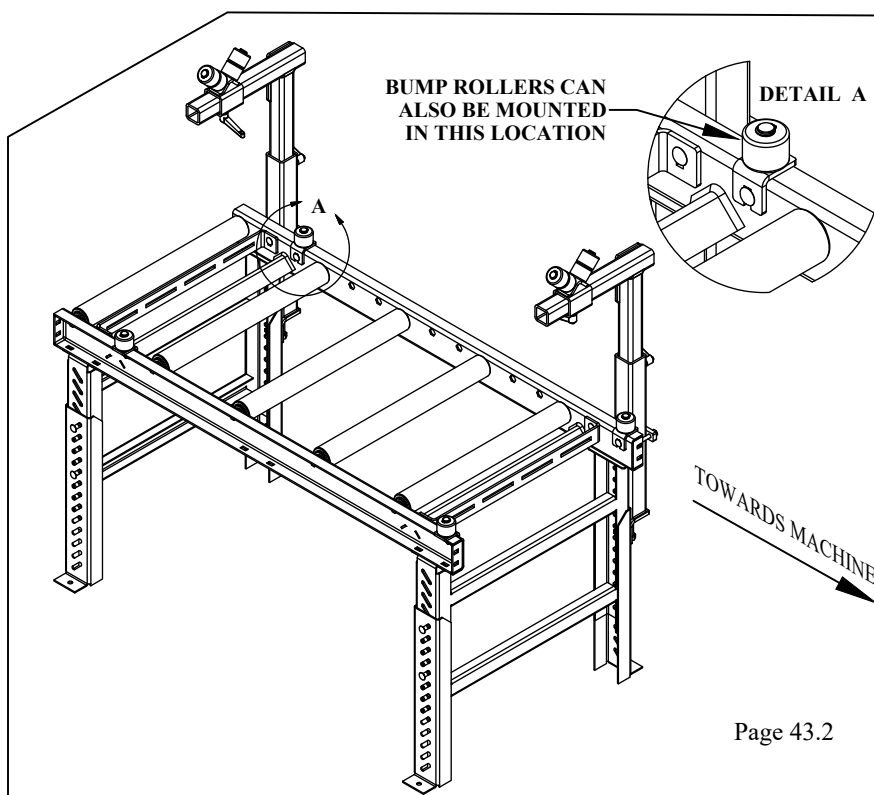
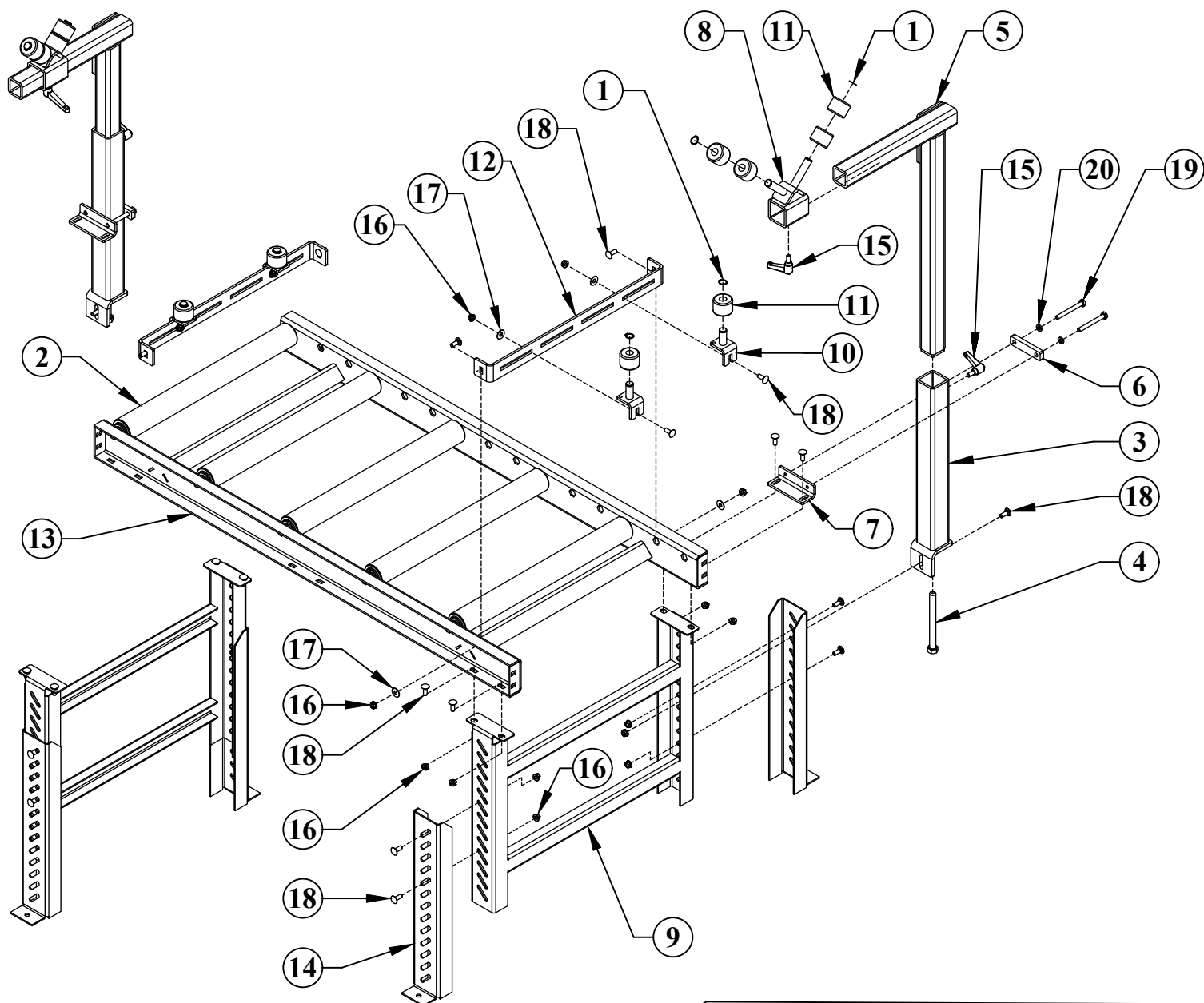


2.19A P/N 026980 INFEED CONVEYOR (24" X 5')

(TOOL TABLE ANGLE SHEAR)

PARTS LIST		
ITEM	PART #	DESCRIPTION
1	016402	3/4 OD SNAP RING
2	026905	25" REPLACEMENT ROLLER
3	026911	SLEEVE ASS'Y
4	026920	ADJ. SCREW ASS'Y
5	026930	BRACKET ASS'Y
6	026939	SLEEVE BRACE
7	026940	MOUNTING BRACKET
8	026941	GUIDE ASS'Y
9	026945.2	UPPER LEG 25"
10	026955	BUMP ROLLER MOUNT ASSEMBLY
11	026962	BUMP ROLLER
12	026965	MOUNT BUMP ROLLER-PAINTED
13	026988	25" CONVEYOR WELD
14	029244.1	LOWER LEG
15	080061	STROKE ADJUSTMENT HANDLE
16	111000	3/8-16 SERRATED FLANGE LOCKNUT
17	114012	3/8 USS FLAT WASHER
18	130210	3/8-16 X 1 CARRIAGE BOLT
19	203235	M10 X 90MM DIN 931 HHCS
20	212012	M10 DIN 127 LOCK WASHER

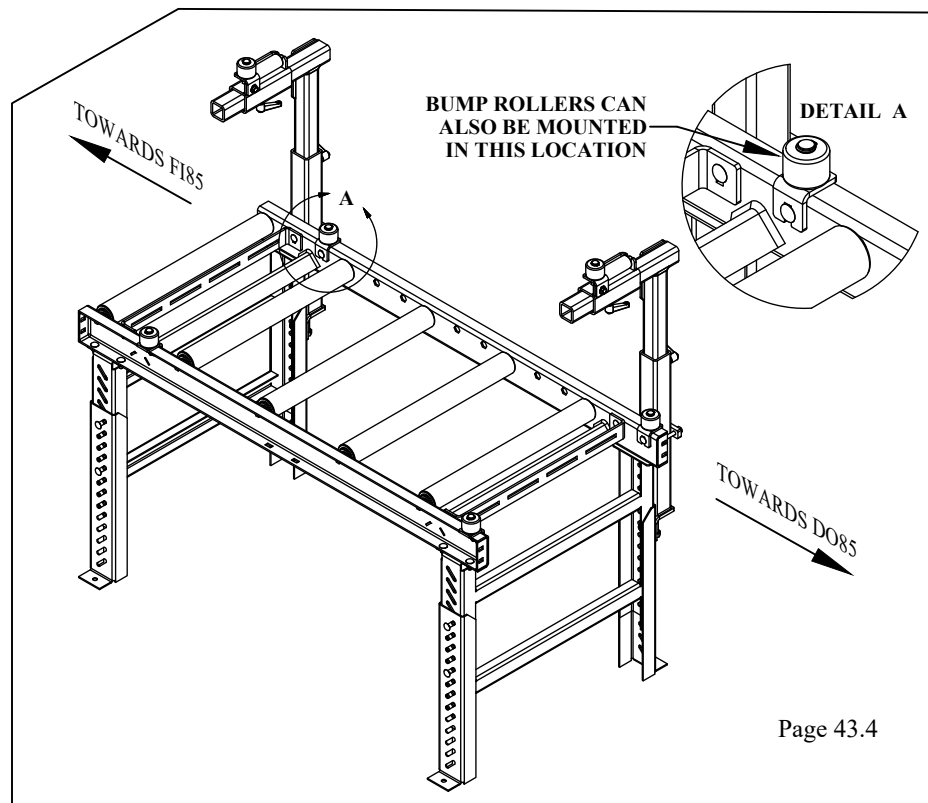
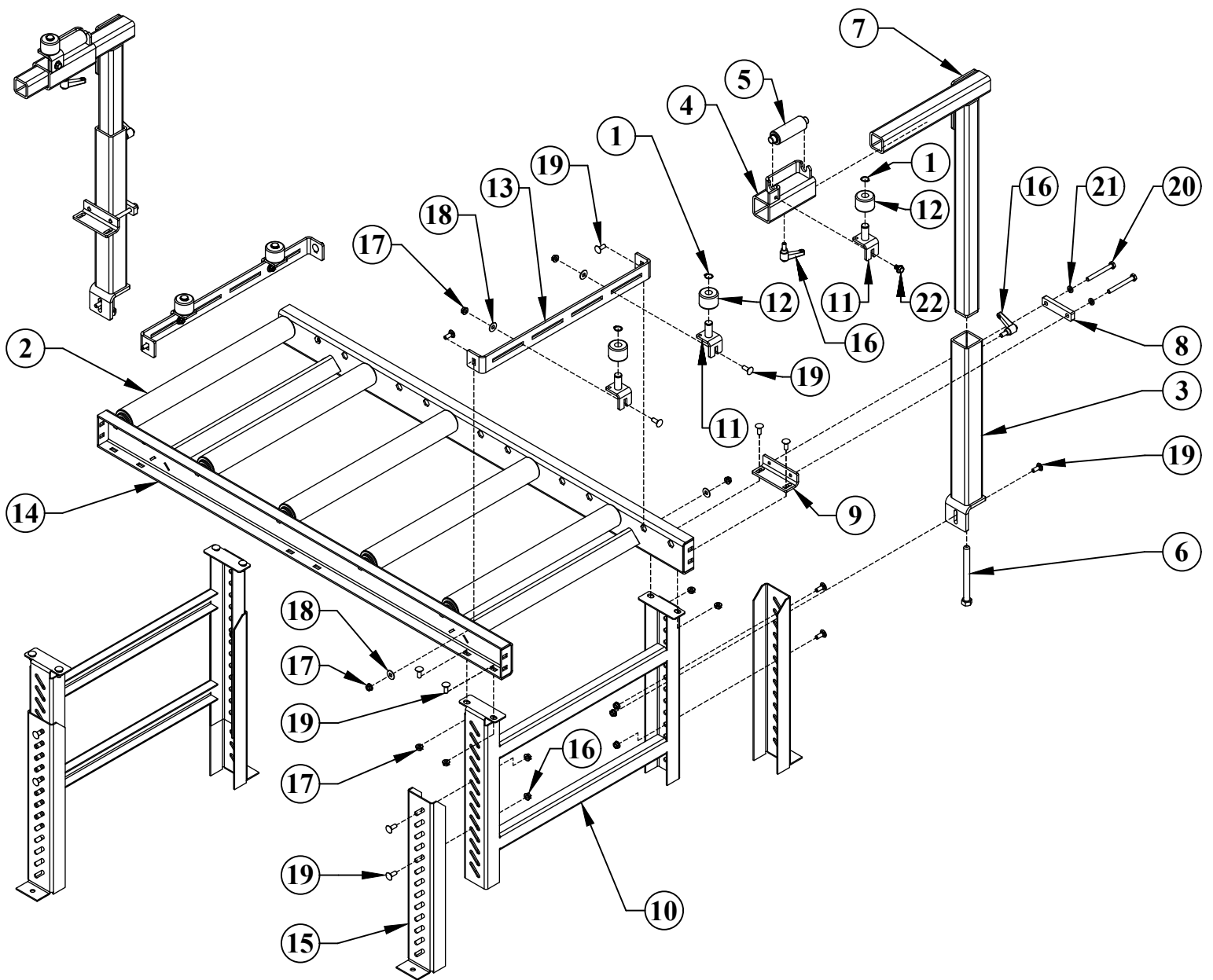
SALES ASSEMBLIES		
PART #	INCLUDES	DESCRIPTION
026945	9, 14, 16, 18	LEGS FOR 25" CONVEYOR
026951	1, 8, 11	V-GUIDE ASSEMBLY
026960	1, 10, 11	BUMP ROLLER SALES
026970	2, 13	25" CONVEYOR 5' LONG



2.19B P/N 026997 INFEED CONVEYOR (24" X 5') **(INTEGRATED ANGLE SHEAR)**

PARTS LIST		
ITEM	PART #	DESCRIPTION
1	016402	3/4 OD SNAP RING
2	026905	25" REPLACEMENT ROLLER
3	026911	SLEEVE ASS'Y
4	026915	ROLLER HOUSING ASS'Y FI
5	026919	STEEL ROLLER
6	026920	ADJ. SCREW ASS'Y
7	026930	BRACKET ASS'Y
8	026939	SLEEVE BRACE
9	026940	MOUNTING BRACKET
10	026945.2	UPPER LEG 25"
11	026955	BUMP ROLLER MOUNT ASSEMBLY
12	026962	BUMP ROLLER
13	026965	MOUNT BUMP ROLLER-PAINTED
14	026988	25" CONVEYOR WELD
15	029244.1	LOWER LEG
16	080061	STROKE ADJUSTMENT HANDLE
17	111000	3/8-16 SERRATED FLANGE LOCKNUT
18	114012	3/8 USS FLAT WASHER
19	130210	3/8-16 X 1 CARRIAGE BOLT
20	203235	M10 X 90MM DIN 931 HHCS
21	212012	M10 DIN 127 LOCK WASHER
22	224205	M10 X 16MM DIN-BN 73 WLCS

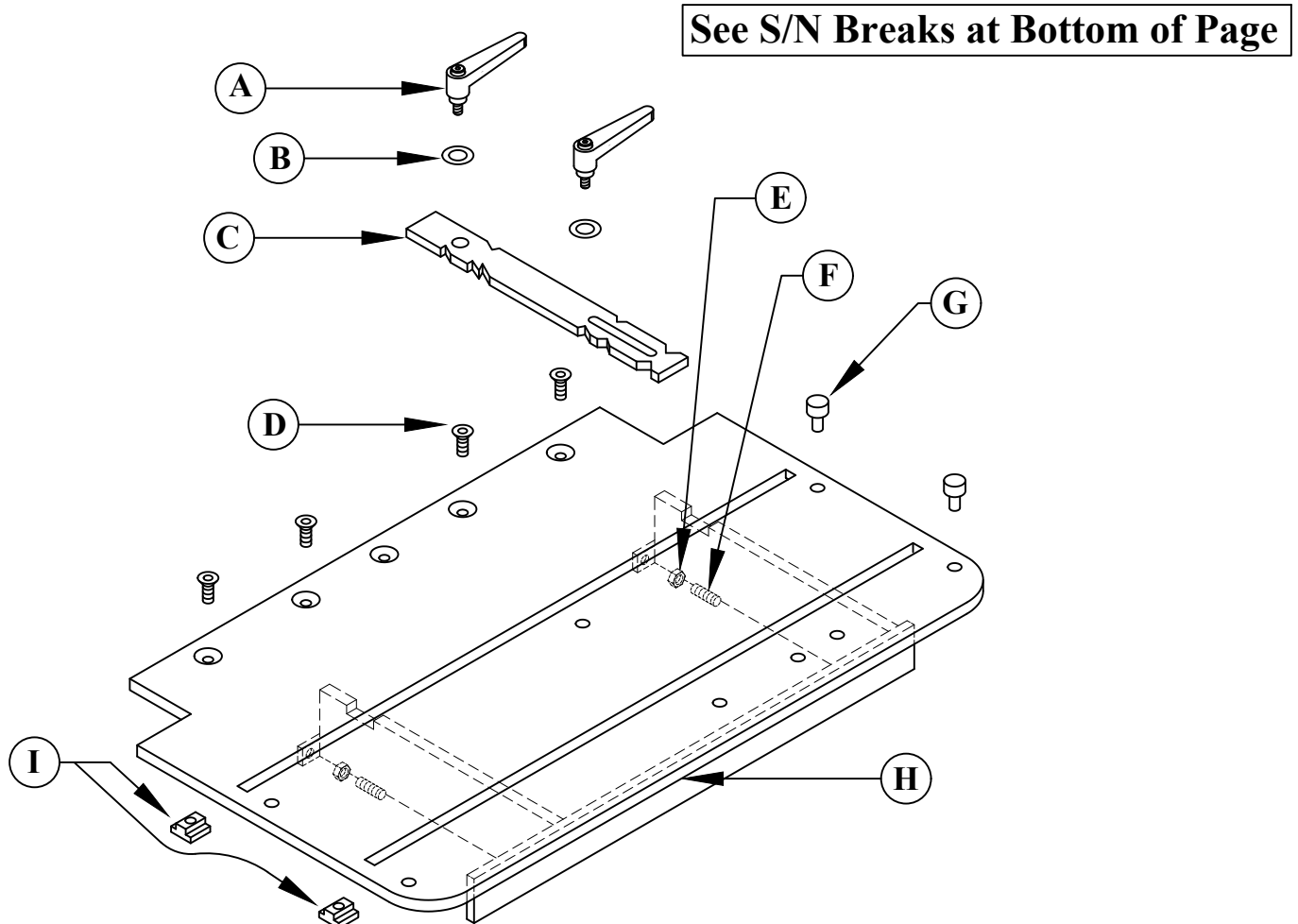
SALES ASSEMBLIES		
PART #	INCLUDES	DESCRIPTION
026923	1, 4, 5, 11, 12, 16, 22	FI ROLLER GUIDE SALES
026945	10, 15, 17, 19	LEGS FOR 25" CONVEYOR
026960	1, 11, 12	BUMP ROLLER SALES
026970	2, 14	25" CONVEYOR 5' LONG



2.20 GAUGING TABLES - PUNCH, SHEAR & NOTCHER

SHEAR TABLE (Old Style)

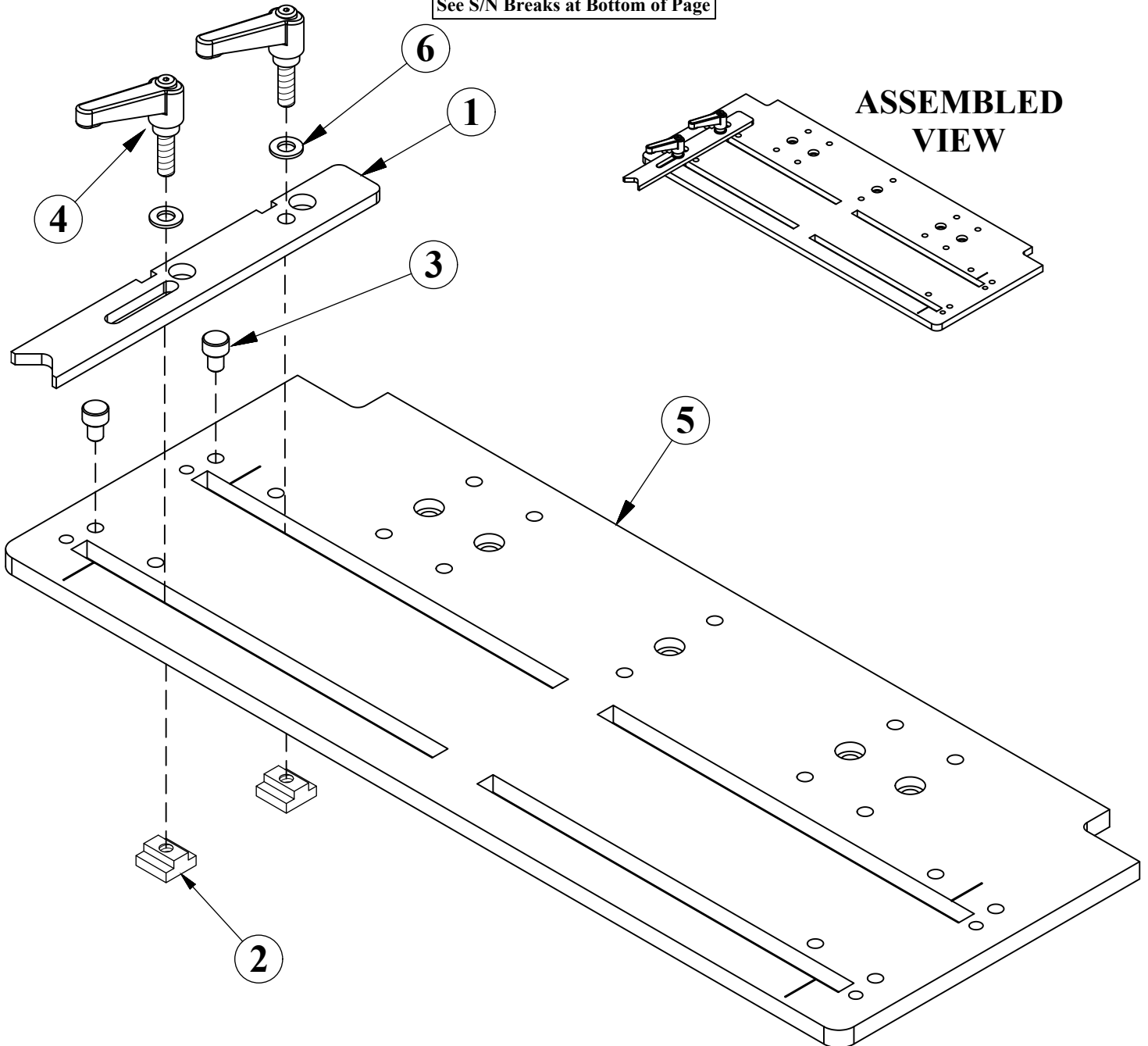
ITEM	COMMON PART #'S	6509 9012 12012	FI-5109 FI-6008 FI-8507	DO-70 DO-100 DO-120 DO-150	DESCRIPTION
A	080061				Handles
B	214012				M-10 Washer
C	026692				Guide
D	230207				M-10 FSHCS
E		210012	210014	210012	Jam Nut
F		219060	201435	219060	Set Screw
G	026698				Rest Button
H		026688	026591	026688	Table
I	026618				Tee Nuts
		026680	026580	026680	Complete Table



SHEAR TABLE (New Style)

PARTS LIST			
ITEM	QTY	PART #	DESCRIPTION
1	1	025705	GUIDE FINISHED
2	2	026618	TEE NUT (M10)
3	2	026698	REST BUTTON
4	2	080063	RS/JIG HANDLE
5	1	080430	SHEAR TABLE
6	2	214012	M10 DIN125 REGULAR WASHER
7	1	080435	SHEAR TABLE SALES

See S/N Breaks at Bottom of Page



6509 S/N 7815FF0907 & Up 9012 S/N 21601M0807 & Up 12012 S/N 50948M0607 & Up

DO-70 & DO-95 S/N 1402M0108 & Up DO-120 & DO-135 S/N 1216M0108 & Up

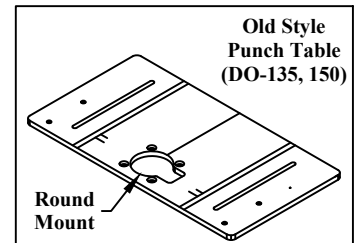
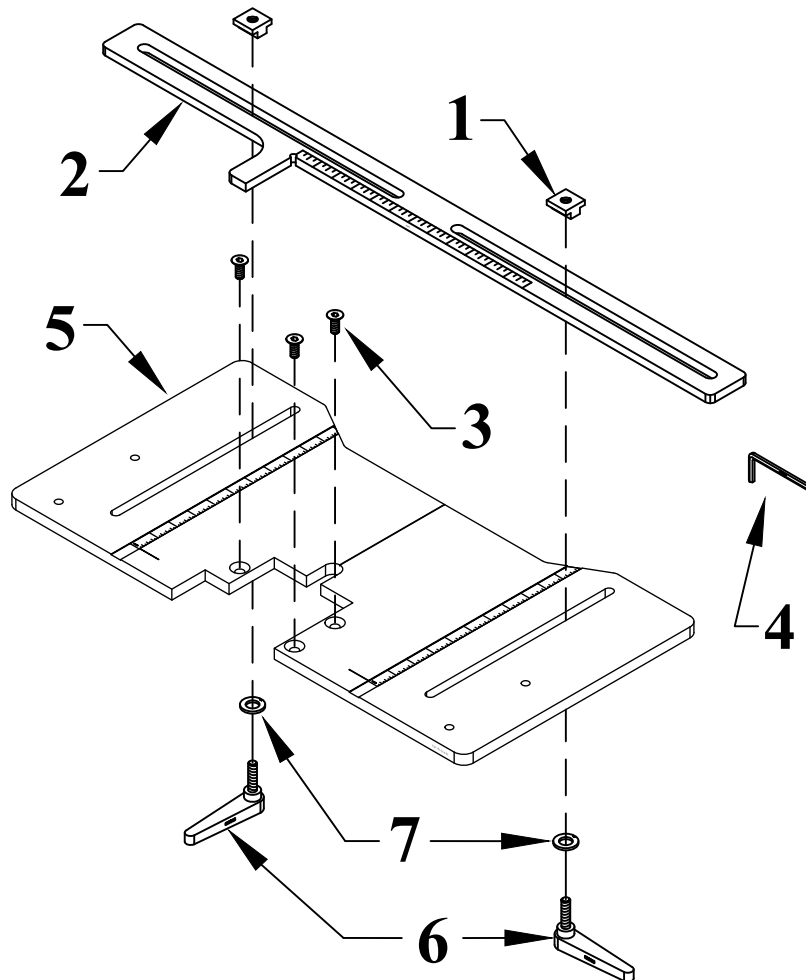
DO-150 S/N 1048M0108 & Up FI-8510, DO-8514

PUNCH TABLE

ITEM	COMMON	6509	9012	FI-5009	DO-135	DESCRIPTION
	PART #'S	DO-70	12012	FI-5109	DO-150	
		DO-95	DO-85	FI-6008		
		FI-8510	DO-100	FI-8507		
			DO-120			
1	026618					Tee Nuts
2	026697					Guide
3	230107					M-8 x 16 FSHCS
4	080182					M5 Allen Wrench
5		026713	026710	026716	*037107 ☐ *037018 ☐	Punch Table Only
6	080063					Handle
7	214012					M-10 Washer
8		026712	026709	026715	*033050 ☐ *037019 ☐	Punch Table Assy. (Includes All except #3)

***NOTE for DO-135 & DO-150: MUST determine if Square ☐ or Round ☐ Mount before ordering!!**
Square is standard on DO-135 S/N 1041M and up and on the DO-150 S/N 1177M and up.

The punch table for your machine may look different than the example shown below.



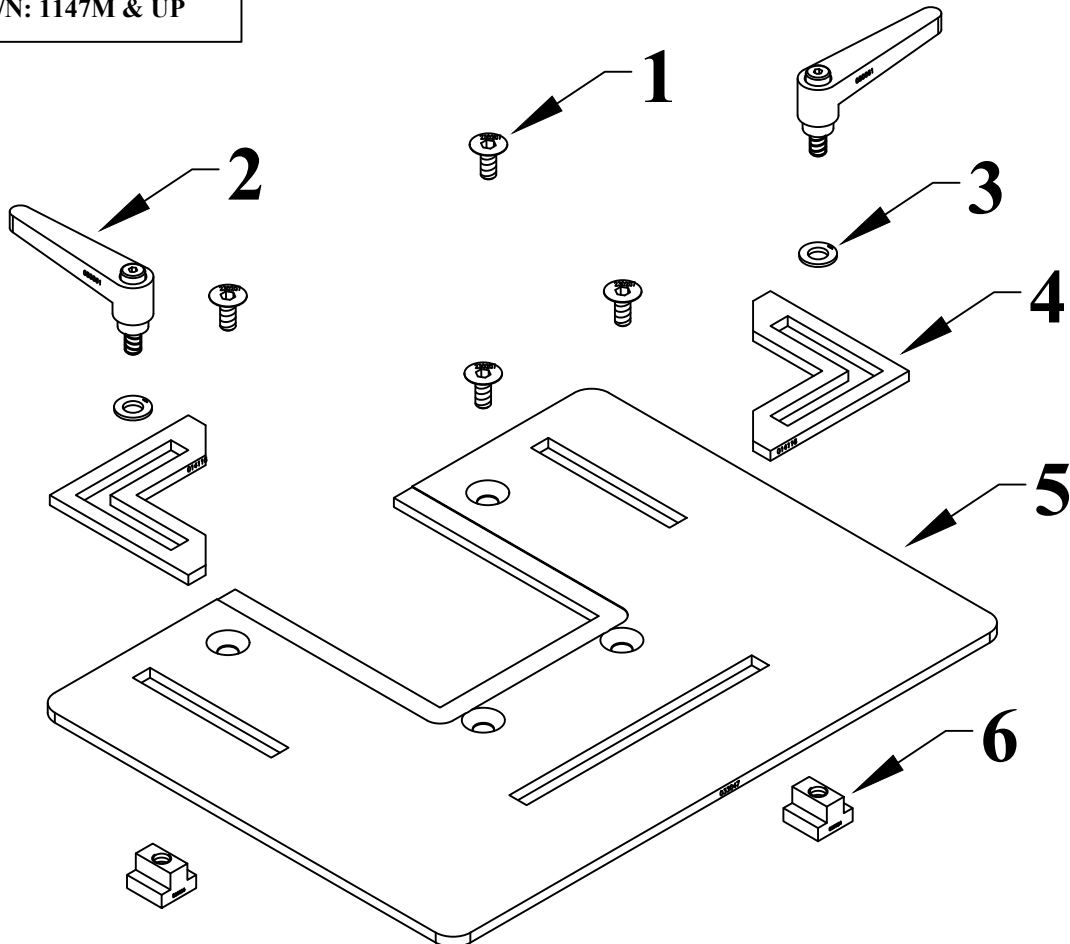
NOTCHER TABLE

ITEM	QTY.	PART #	DESCRIPTION
1	4	230207	M10 X 20 FSHCS
2	2	080061	STROKE ADJUSTMENT HANDLE
3	2	214012	M10 REGULAR WASHER
4	2	014116	L TABLE STOP
5	1	033047	D.O. NOTCHER TABLE SEE BELOW Above Table is Now Standard
5A	1	014119	D.O. NOTCHER TABLE SEE BELOW
		014215	Notcher Table W/Guides - See 5A Below
5B	1	033152	NOTCHER TABLE DRILL SEE BELOW
		033151	Notcher Table W/Guides - See 5B Below
6	2	026624	TEE NUT NOTCH TABLE

5. DO70 S/N: 1512M0116 & UP
DO95 S/N: 1694M0116 & UP
FI85 S/N: 1294M0216 & UP
DO120 S/N: 1319M & UP
DO135 S/N: 1039M & UP
DO150 S/N: 1147M & UP

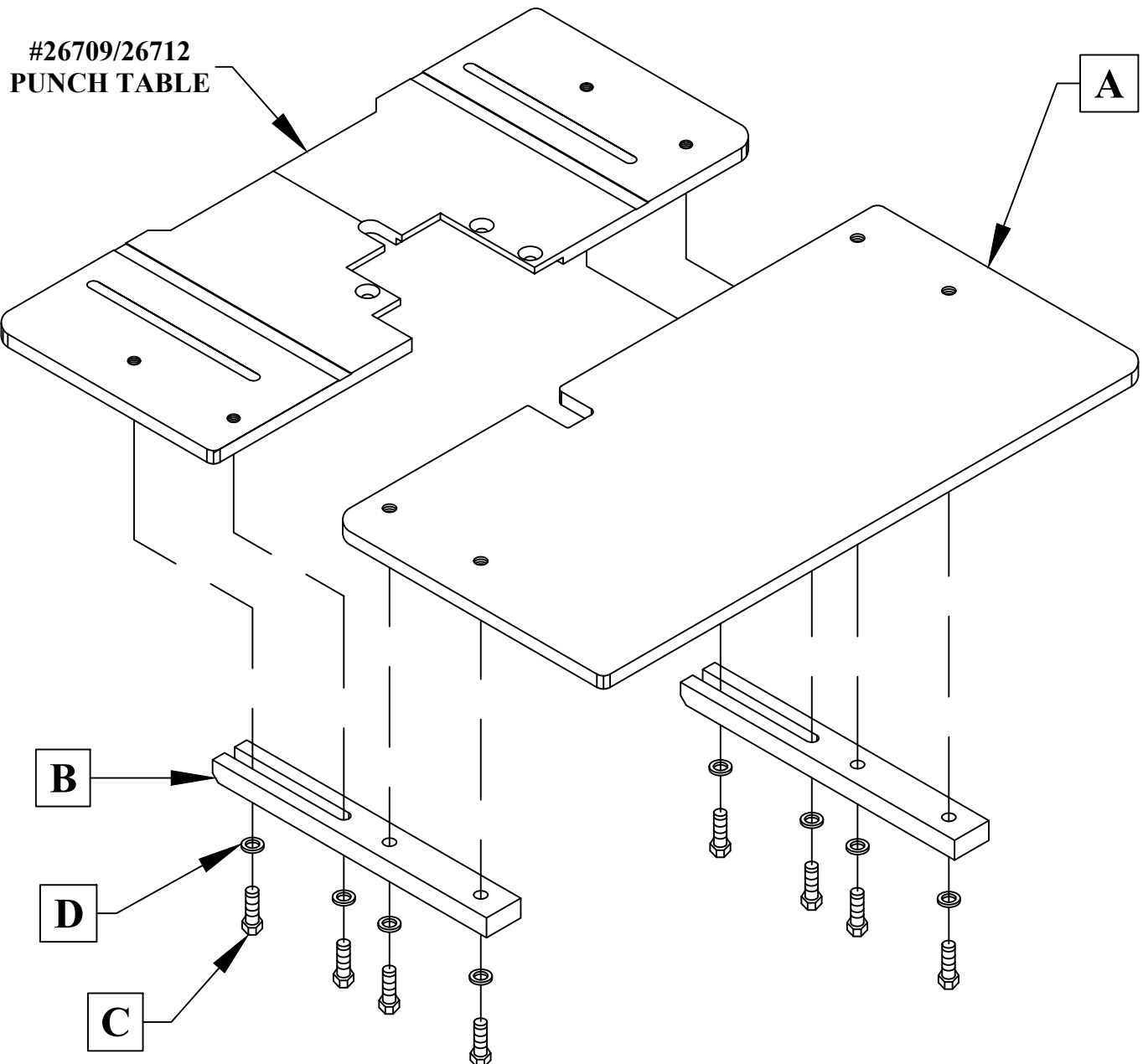
5A. DO70 S/N: 1511M0116 & PRIOR
DO95 S/N: 1693M0116 & PRIOR
FI85 S/N: 1293M0116 & PRIOR
MODELS: FI-5109, FI-6008,
FI-8507, FI-8510, DO-100

5B. DO120 S/N: 1318M0616 & PRIOR
DO135 S/N: 1038M0216 & PRIOR
DO150 S/N: 1146M0616 & PRIOR



PUNCH TABLE EXTENSION

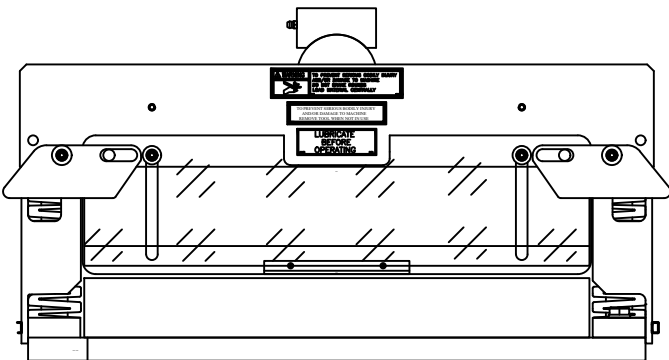
P A R T S L I S T		
ITEM	PART #	DESCRIPTION
1	026760	PUNCH EXTENSION TABLE
2	026757	EXTENSION TABLE SUPPORTS
3	201210	M10 X 20MM DIN933 HHCS
4	214012	M10 DIN125 REGULAR WASHER
5	026765	COMPLETE PUNCH EXTENSION TABLE



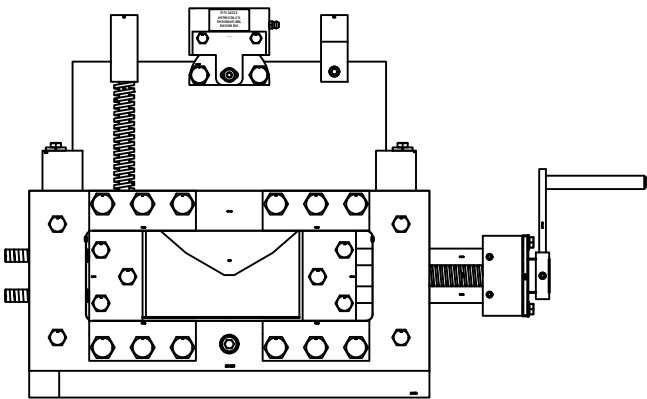
Scotchman

Metal Fabricating Solutions

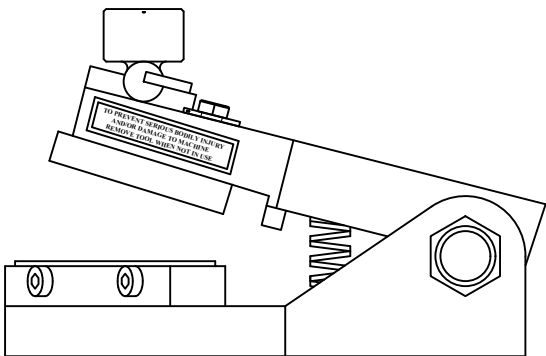
SCOTCHMAN # 40 TOOLING MANUAL



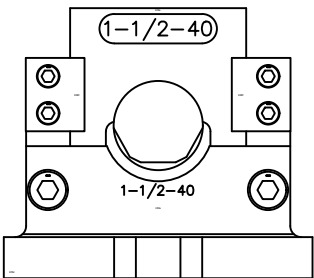
12" and 24" Brakes



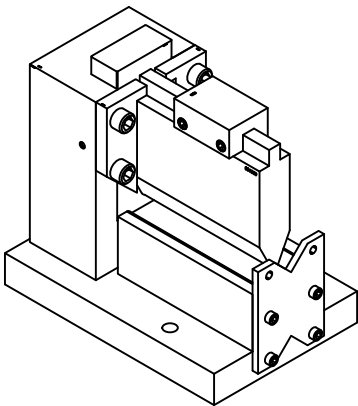
Channel Shear



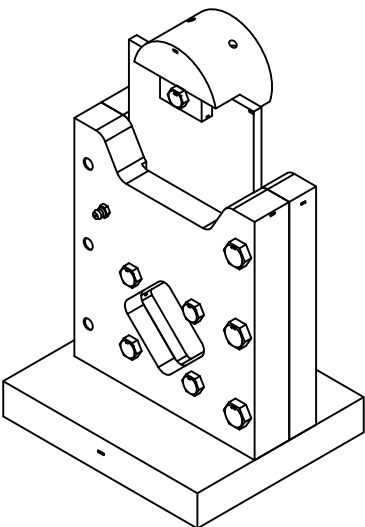
6 x 6 x Ninety Degree Notcher



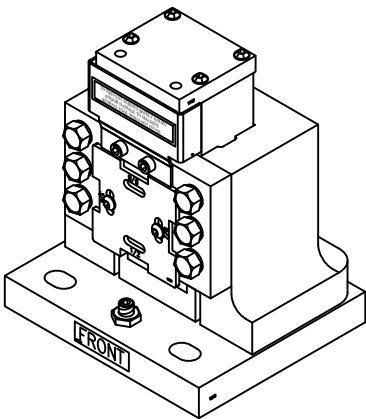
Pipe Notcher



6" Angle Iron Brake



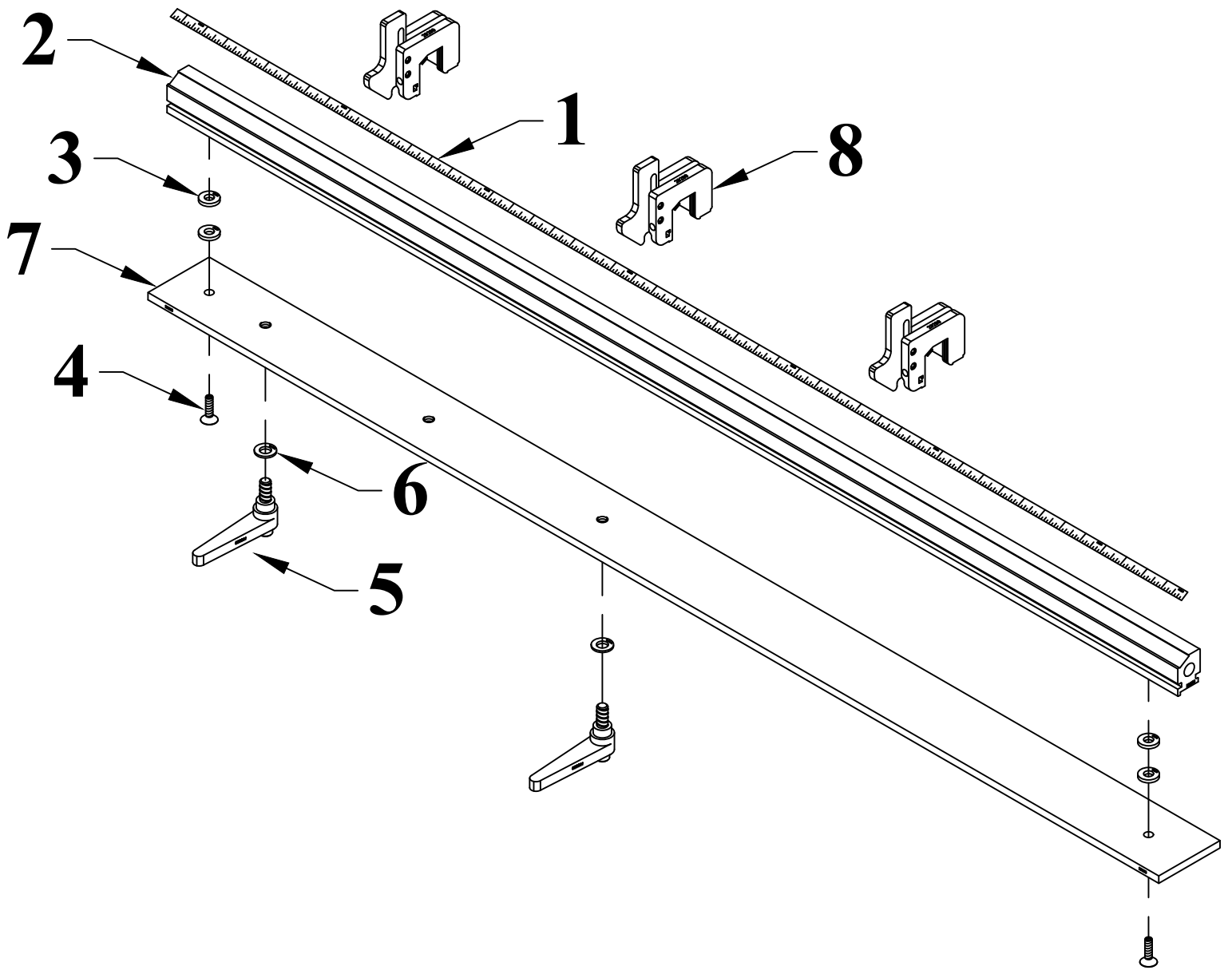
Square Tube Shear



Picket Tool

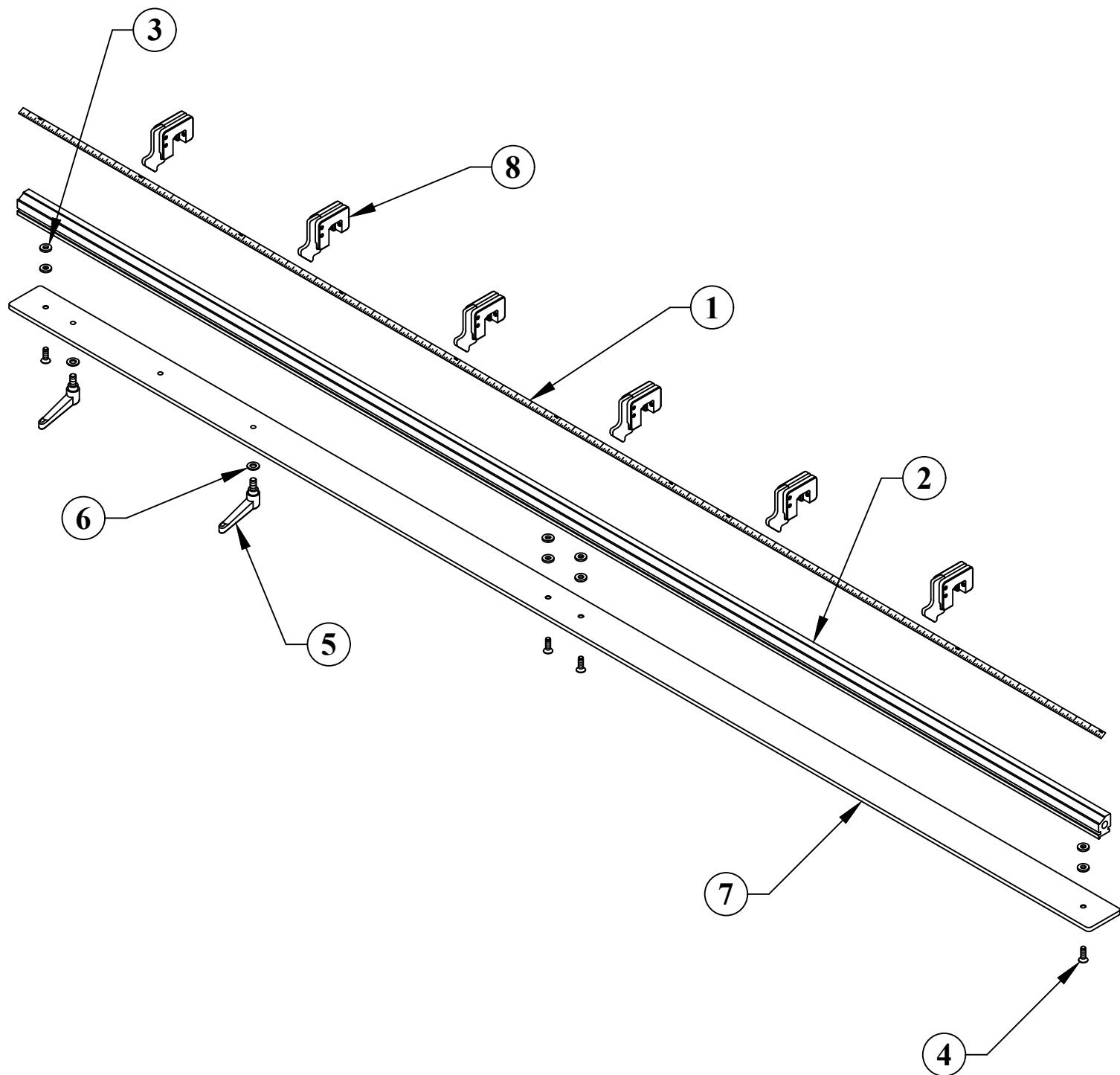
2.21 FOUR FOOT PUNCH GAUGING SYSTEM

ITEM	LEFT HAND	RIGHT HAND	DESCRIPTION
1	029220	029226	Scale
2	029200	029200	4' Rail
3	029294	029294	1/8 Washer
4	130107	130107	5/16 x 18 FSHCS
5	080061	080061	Handles
6	214012	214012	10mm Washer
7	029295	029295	Mounting Plate
8	029298	029299	Multi-Vertical Stop
9	029291	029289	Complete Assembly



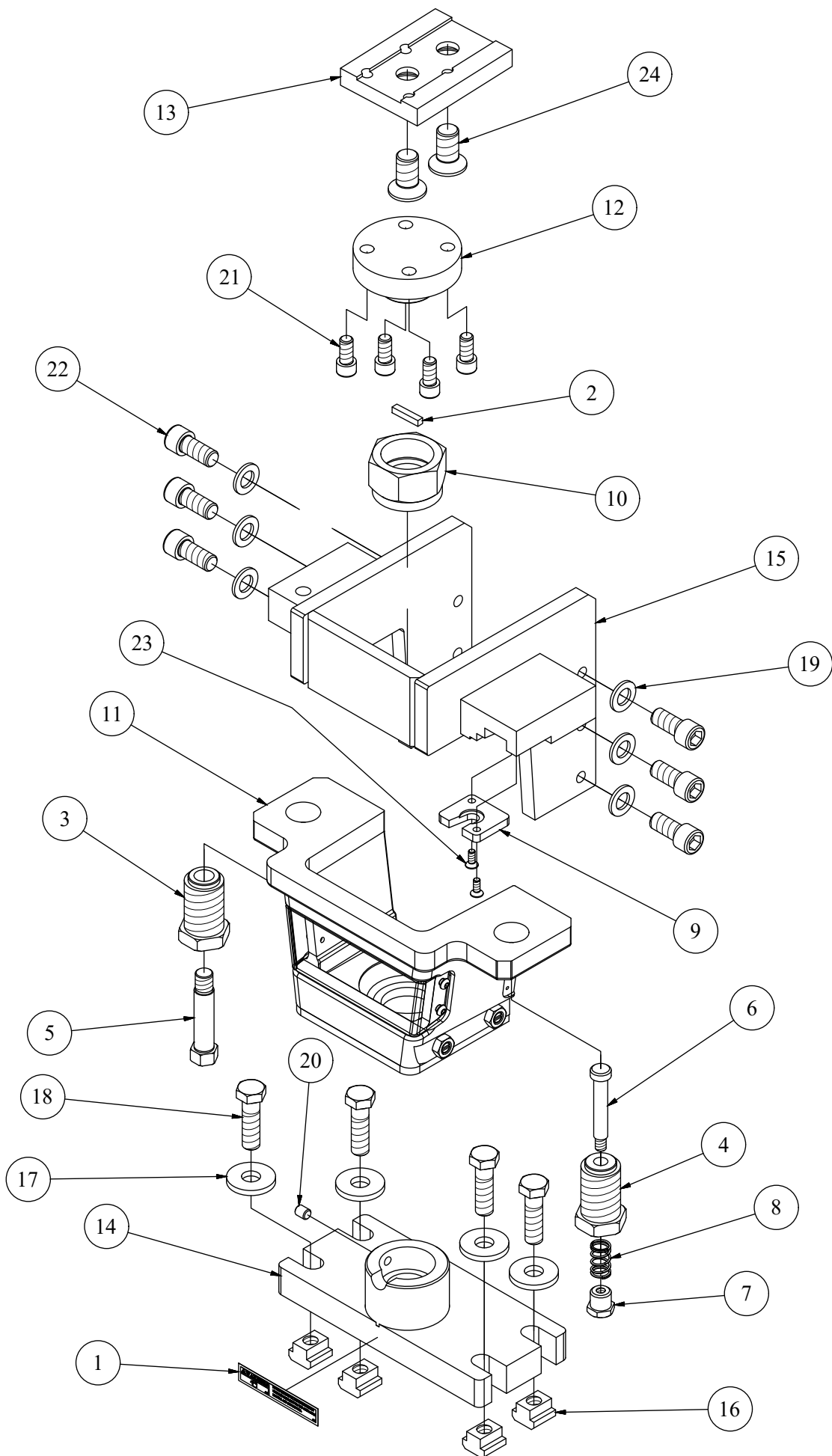
2.22 EIGHT FOOT PUNCH GAUGING SYSTEM

ITEM	LEFT HAND	RIGHT HAND	DESCRIPTION
1	029220	029226	Scale
2	029204	029204	8' Rail
3	029294	029294	1/8 Washer
4	130107	130107	5/16 x 18 FSHCS
5	080061	080061	Handles
6	214012	214012	10mm Washer
7	029296	029296	Mounting Plate
8	029298	029299	Multi-Vertical Stop
9	029292	029293	Complete Assembly



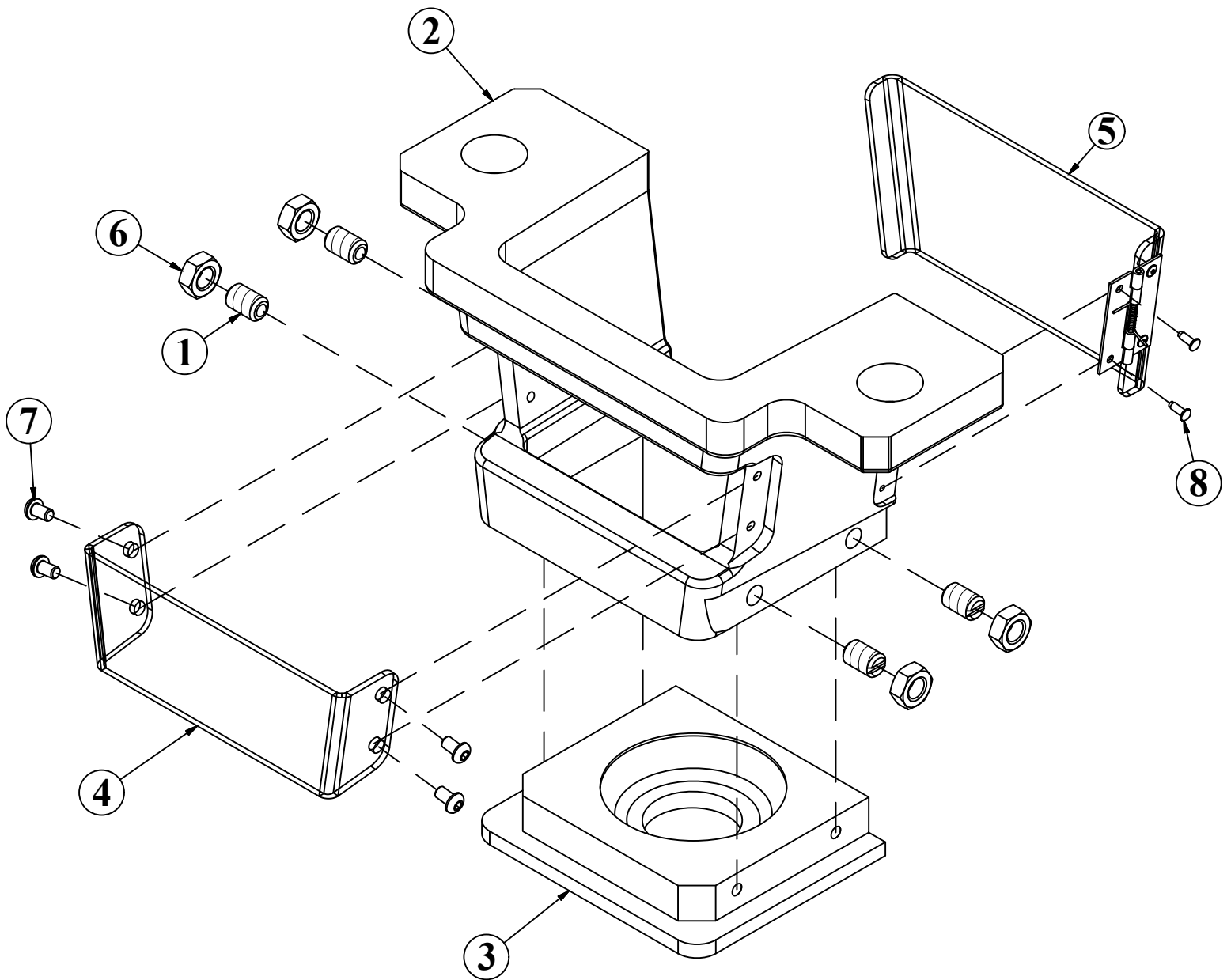
2.23 SECOND HOLE PUNCH

PARTS LIST			
ITEM	QTY	PART #	DESCRIPTION
1	1	003110	PUNCH & DIE WARNING
2	1	004123	1/4" KEY
3	1	007229	ADJ.SCREW STRIPPER LEFT
4	1	007236	ADJ.SCREW STRIPPER RIGHT
5	1	007237	HEX HEAD STRIPPER STUD
6	1	007239	SPRING ROD STRIPPER
7	1	007240	SPRING RETAINER
8	1	007241	STRIPPER SPRING 27LBS
9	1	007244	RETAINER STRIPPER
10	1	016095	#40 XL PUNCH RET NUT
11	1	025012	STRIPPER EURO 85
12	1	025193	PUNCH RETAINER FIDO
13	1	025496	PUNCH ADAPTER
14	1	025506	#82 DIE HOLDER
15	1	025524	STRIPPER OPTIONAL PUNCH
16	4	026625	M16 X 18MM DIN 508 TEE N
17	4	113017	1 3/4 OD X 21/32 ID REID
18	4	201620	M16 X 55MM DIN931 HHCS
19	6	214016	M16 DIN125 REGULARWASHER
20	1	219047	M10 X 12MM DIN913FP S.S.
21	4	221310	M12 X 25MM DIN912 SHCS
22	6	221412	M16 X 35MM DIN912 SHCS
23	2	230007	M6 X 16 DIN 7991-10 FSHCS
24	2	230620	M20 X 40 DIN 7991-10.9 FSHCS



2.24 SECOND HOLE PUNCH STRIPPER (D.O. 85 ONLY)

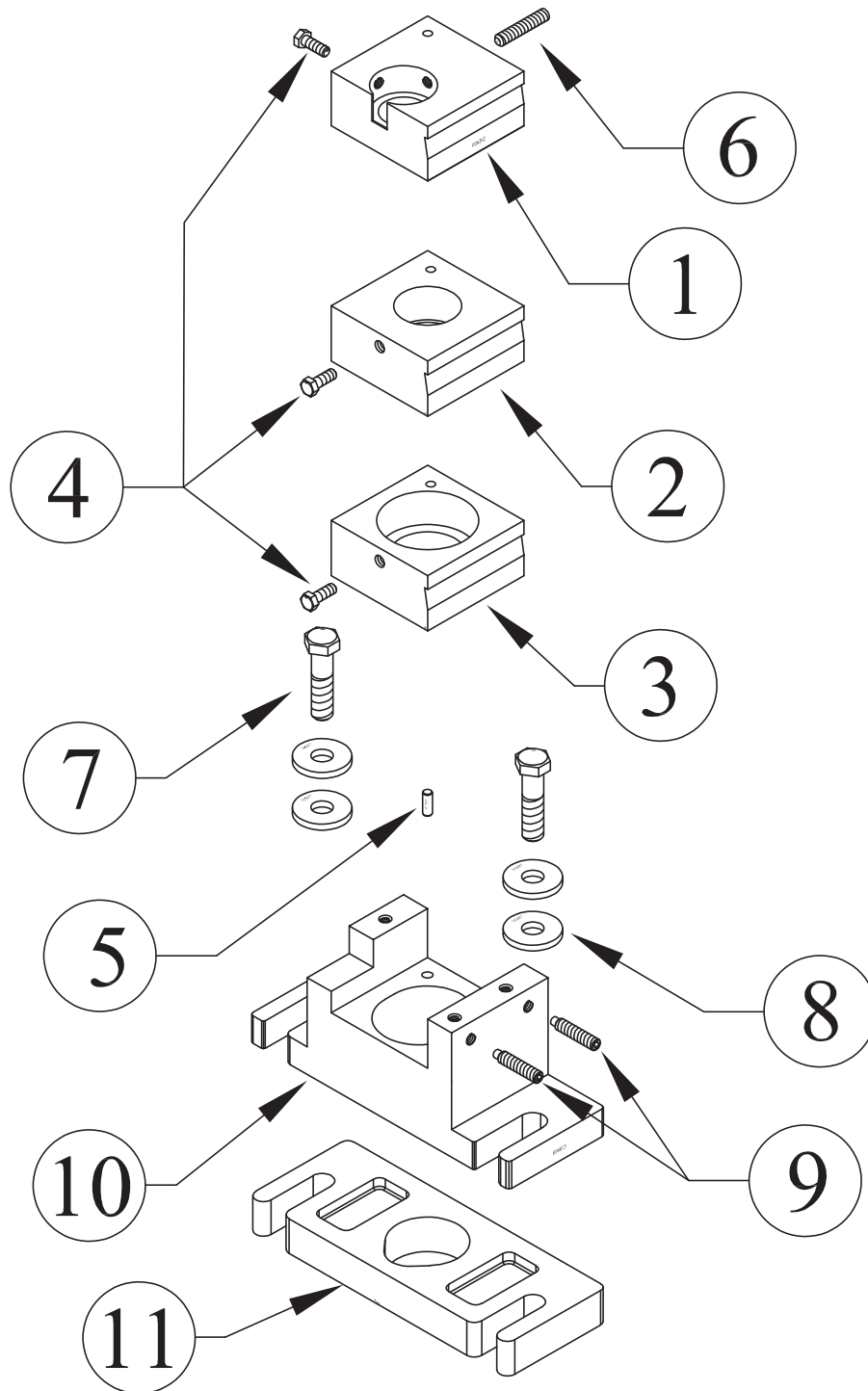
PARTS LIST			
ITEM	QTY	PART #	DESCRIPTION
1	4	001541	BALL SPRING SCREW
2	1	025011	STRIPPER SUB FIDO
3	1	025018	INSERT STRIPPER EURO 85
4	1	025383	POLY STRIPPER GUARD
5	1	025733	LEXAN STRIPPER DOOR ASS'Y
6	4	110014	1/2-13 JAM NUT
7	4	220014	M6 X 10MM DIN BN19 BHCS
8	2	660255	#6 X 3/8" DRIVE SCREW



2.25 STANDARD DIE HOLDER (EXCEPT DO-135 & DO-150)

ITEM	QTY	PART #	DESCRIPTION
1	1	006202	#82 Metric Die Insert
2	1	006252	Insert for 2-1/2" Dies
3	1	006302	Insert for 3" O.D. Dies
4	1	204220	M-10 x 30 (1 each per Insert)
5	1	077145	M-7.5 x 20 PIN (1 each per Insert)
6	1	219060	M-10 x 50 FP SS
7	2	201625	M-16 x 65MM HHCS (6509 & 9012 ONLY)
7A	2	201640	M-16 x 90MM HHC
8	4	113017	1-3/4 OD x 21/32 ID Washer
9	2	218058	M-10 x 45MM DP SS
10	1	006013	Die Holder Metric
11	1	015440	Die Holder Spacer (exc. 5075, 6509 & 9012)

STANDARD DIE HOLDER (exc. DO-135 & DO-150)

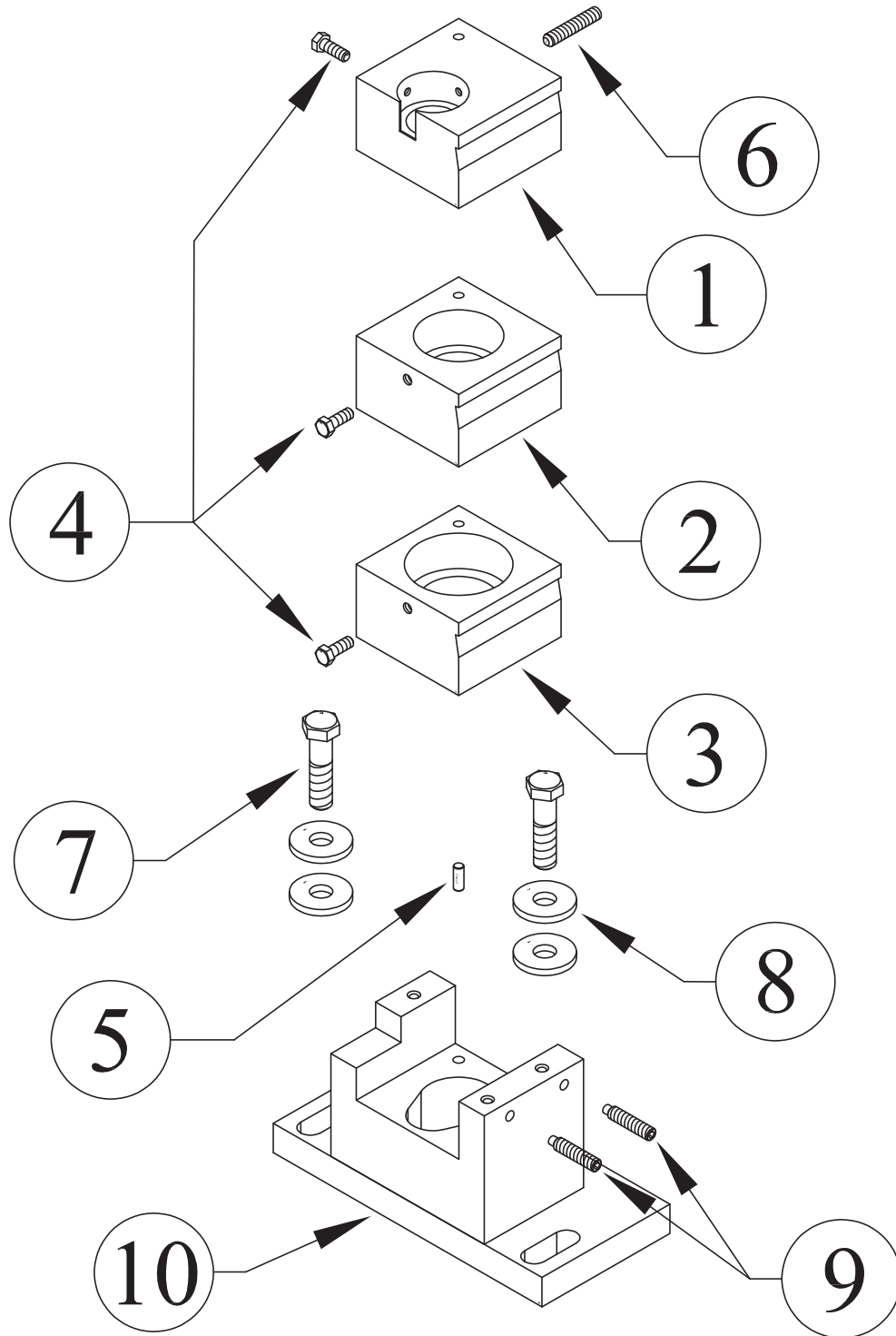


2.25A DIE HOLDER (DO-135 & DO-150 ONLY)

NOTE: Below is for **DO-135 S/N 1041M AND UP** and **DO-150 S/N 1177M AND UP**
See Pages 96-97 for the older machines.

ITEM	QTY	PART #	DESCRIPTION
1	1	037110	2" Die Insert
2	1	037115	2-1/2" Die Insert
3	1	037120	3" Die Insert
4	1	204220	M-10 x 30 (1 each per Insert)
5	1	077145	M-7.5 x 20 PIN (1 each per Insert)
6	1	219060	M-10 x 50 FP SS
7	2	201625	M-16 x 65MM HHCS
8	4	113017	1-3/4 OD x 21/32 ID Washer
9	2	218058	M-10 x 45MM DP SS
10	1	037105	D.O. 135 & D.O. 150 Die Holder

DIE HOLDER DO-135 & DO-150 ONLY



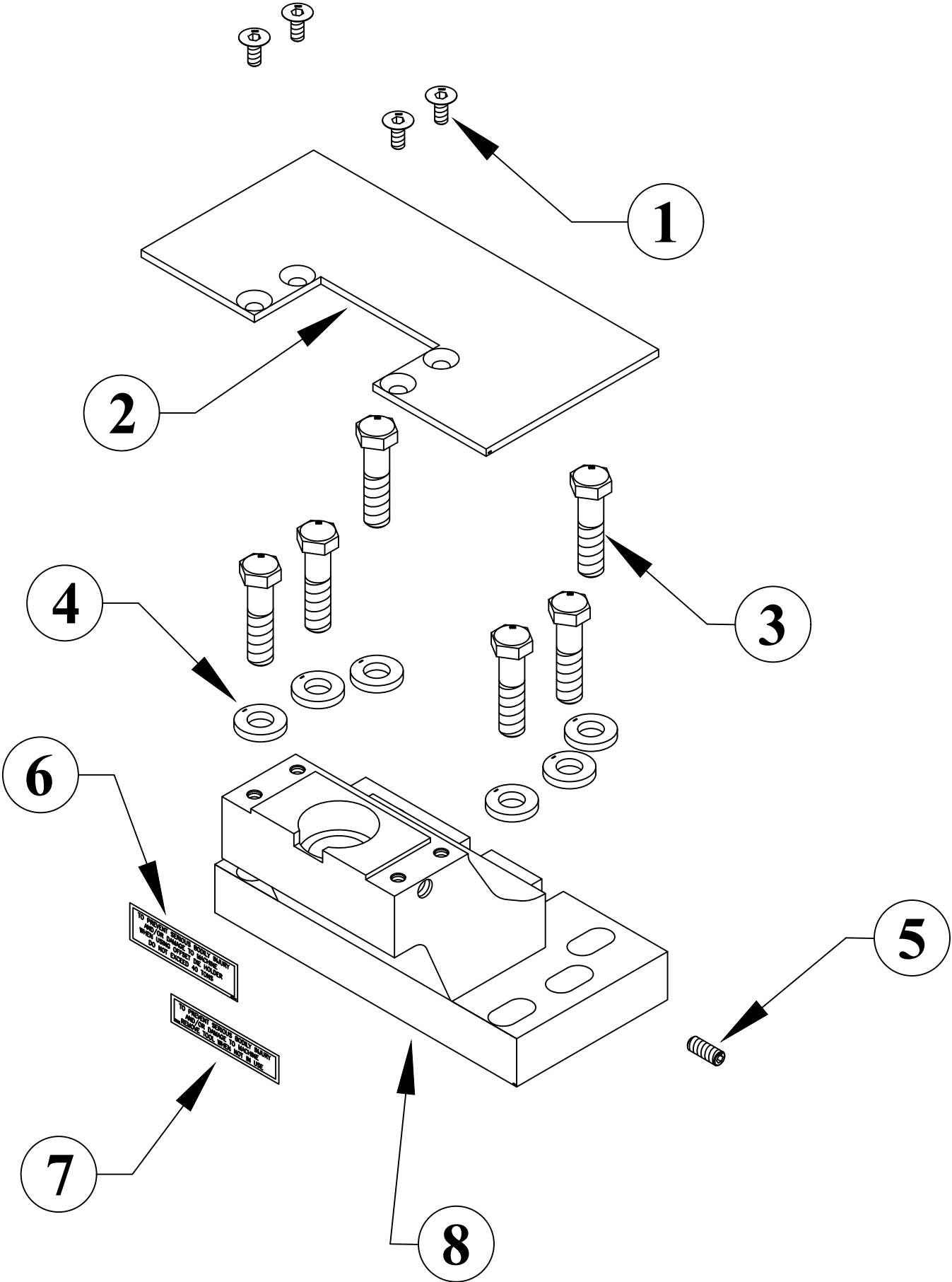
2.25B OFFSET DIE HOLDER

ITEM	QTY	PART #	DESCRIPTION
1	4	230207	M-10 x 20 FSHCS
2	1	004275	Punch Table
3	6	201625	M-16 x 65MM HHCS
4	6	113017	1-3/4 OD x 21/32 ID Washer
5	1	219050	M-10 x 25MM FP SS
6	1	003135	40 Ton Offset Capacity
7	1	003145	Remove Tool Label
8	1	013186	Offset Die Holder (Inc. all of the above.)

OLDER MACHINES

6509	SER. #'S 78140907 & PRIOR	Part # 026109
9012	SER. #'S 216000807 & PRIOR	Part # 026152
12012	SER. #'S 509460507 & PRIOR	Part # 080845
FI-5109, FI-6008, FI-8507, DO-100 & 2450		Part # 004270

OFFSET DIE HOLDER

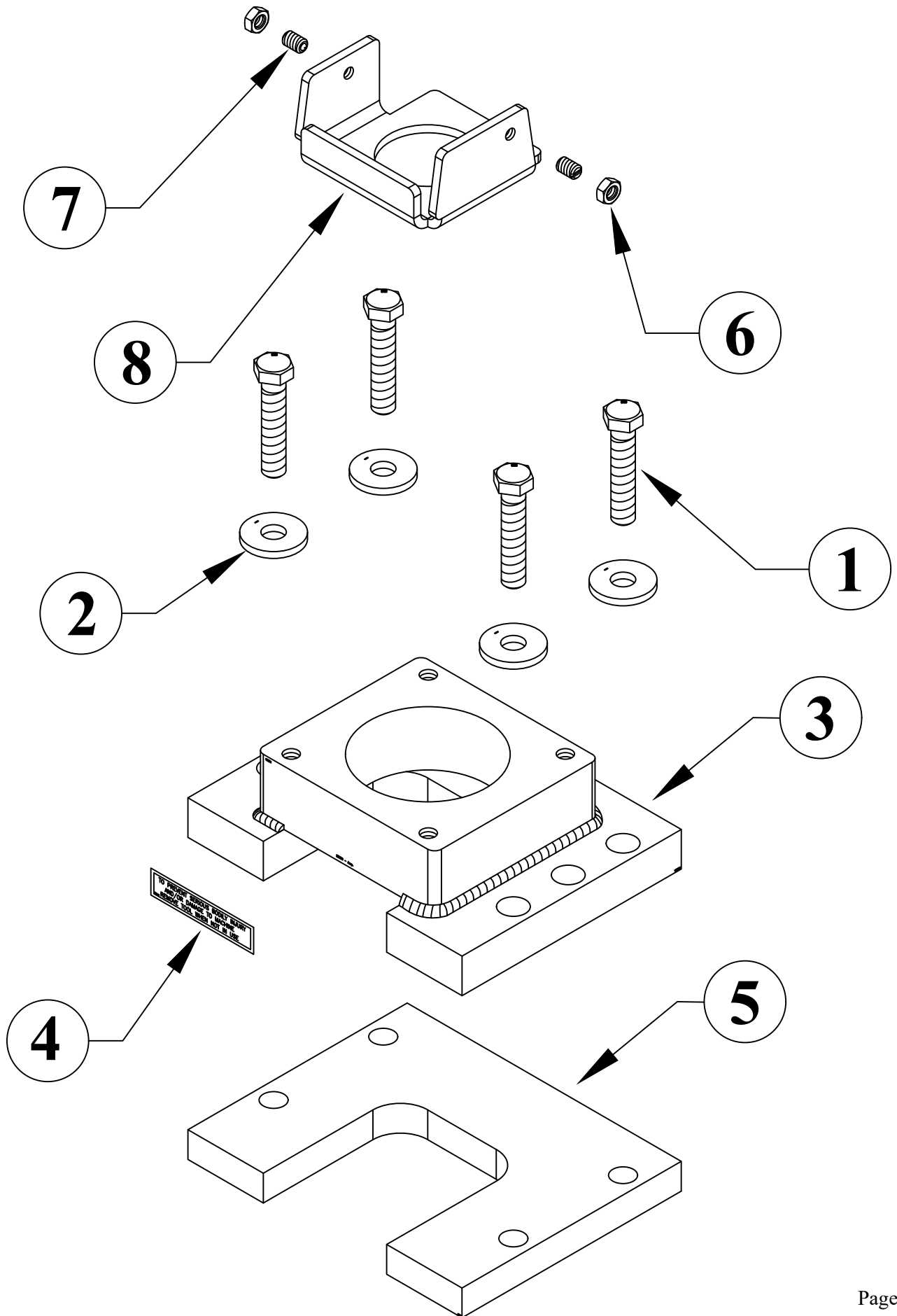


2.25C 6 X 6 DIE HOLDER

ITEM	QTY.	Part #	DESCRIPTION
1	4	203630	M16 X 80MM HHCS
2	4	113017	1 3/4 OD X 21/32 ID WASHER
3	1	028300	DIE HOLDER FOR 6 X 6 DIE
4	1	003145	REMOVE TOOL LABEL
5	1	028275	6 X 6 DIE HOLDER SPACER (exc. 6509 & 9012 - use std. bolts)
6	2	110014	1/2-13 JAM NUT
7	2	001541	BALL SPRING SCREW
8	1	028325	OVERSIZED STRIPPER PLATE
9		028330	OVERSIZED STRIPPER PLATE ASSY (Includes ITEM's 6, 7, & 8)

NOTE: ITEM 9 is OPTIONAL for up to 3-3/8 Diameter

6 X 6 DIE HOLDER



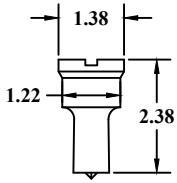
2.26 PUNCH RETAINING NUTS

ITEM	COMMON	PART #'S	DESCRIPTION
	6509	12012	
	9012	DO-120	
	DO-70	DO-135	
	DO-95	DO-150	
	DO-85		
	DO-100		
	FI-5109		
	FI-6008		
	FI-8507		
A	026500	080895	Complete Heavy Duty Nut
B	N/A	037020	#49 Punch Retaining Nut
C	016096	080220	#45 Punch Retaining Nut
D	016095	080215	#40 Punch Retaining Nut
E	019099	080232	Wrench For B, C & D
F	018507	018507	Wrench For A
G	026501	080897	Ring Nut (Part of A)
H	026502	080896	Split Ring (Part of A)
I	026503	080898	Retaining Ring (Part of A)
J	221212	221220	M-10 SHCS (Part of A)
K	026504 (M-8)	026505 (M-10)	Brass Set Screw (Part of A)

FOR 120 & 150 TON
MACHINES ONLY

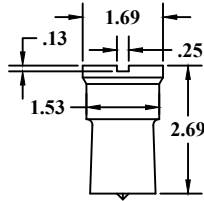
#40 PUNCH

1/8" THRU 1 1/4"
3MM THRU 31MM



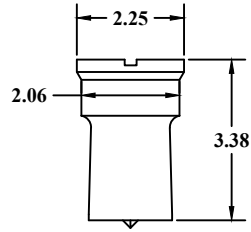
#45 PUNCH

1 9/32 THRU 1 9/16
32MM THRU 36MM



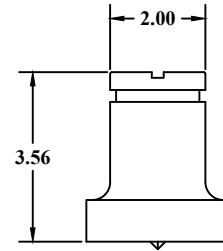
#49 PUNCH

1 5/8" THRU 2"
37MM THRU 52MM
#18400-18423

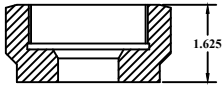


SPLIT RING PUNCH

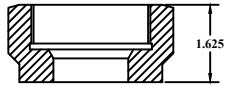
THRU 4.0"



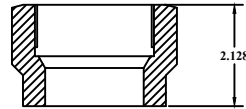
D #40 RETAIN NUT



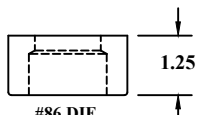
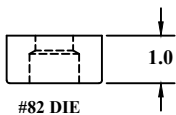
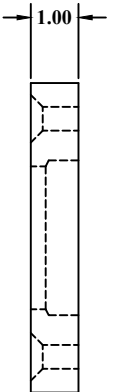
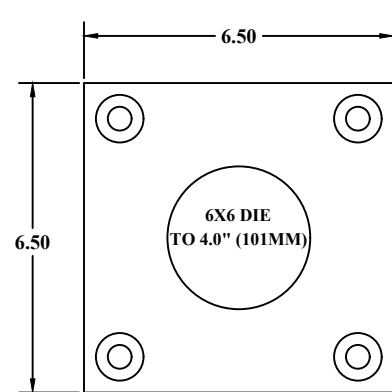
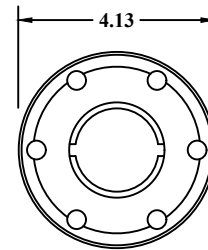
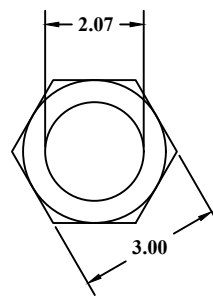
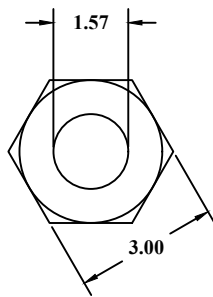
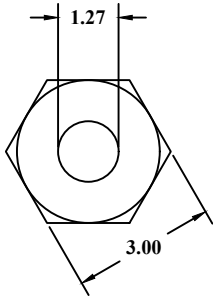
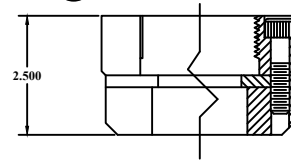
C #45 RETAIN NUT



B #49 / 31 RETAIN NUT



A SPLIT RING NUT

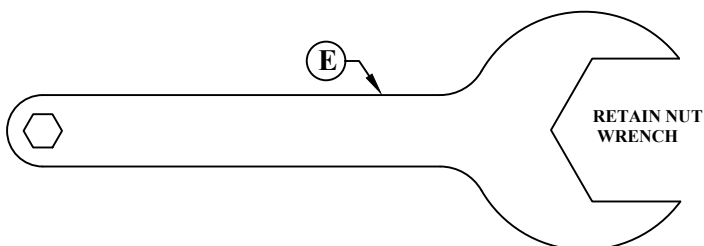


#82 DIE
TO 1 9/32 (32MM)

#86 DIE
1 5/16 TO 1 19/32
33MM TO 37MM

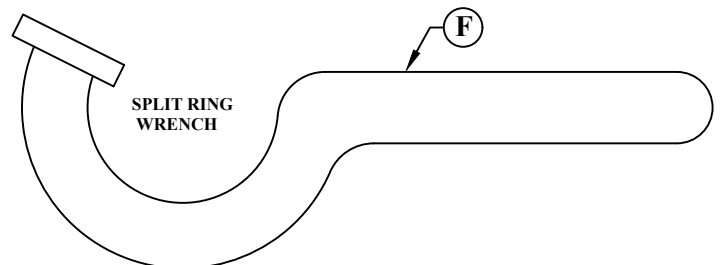
3" DIE
1 19/32 TO 1 31/32
37MM TO 51MM

E



RETAIN NUT
WRENCH

F

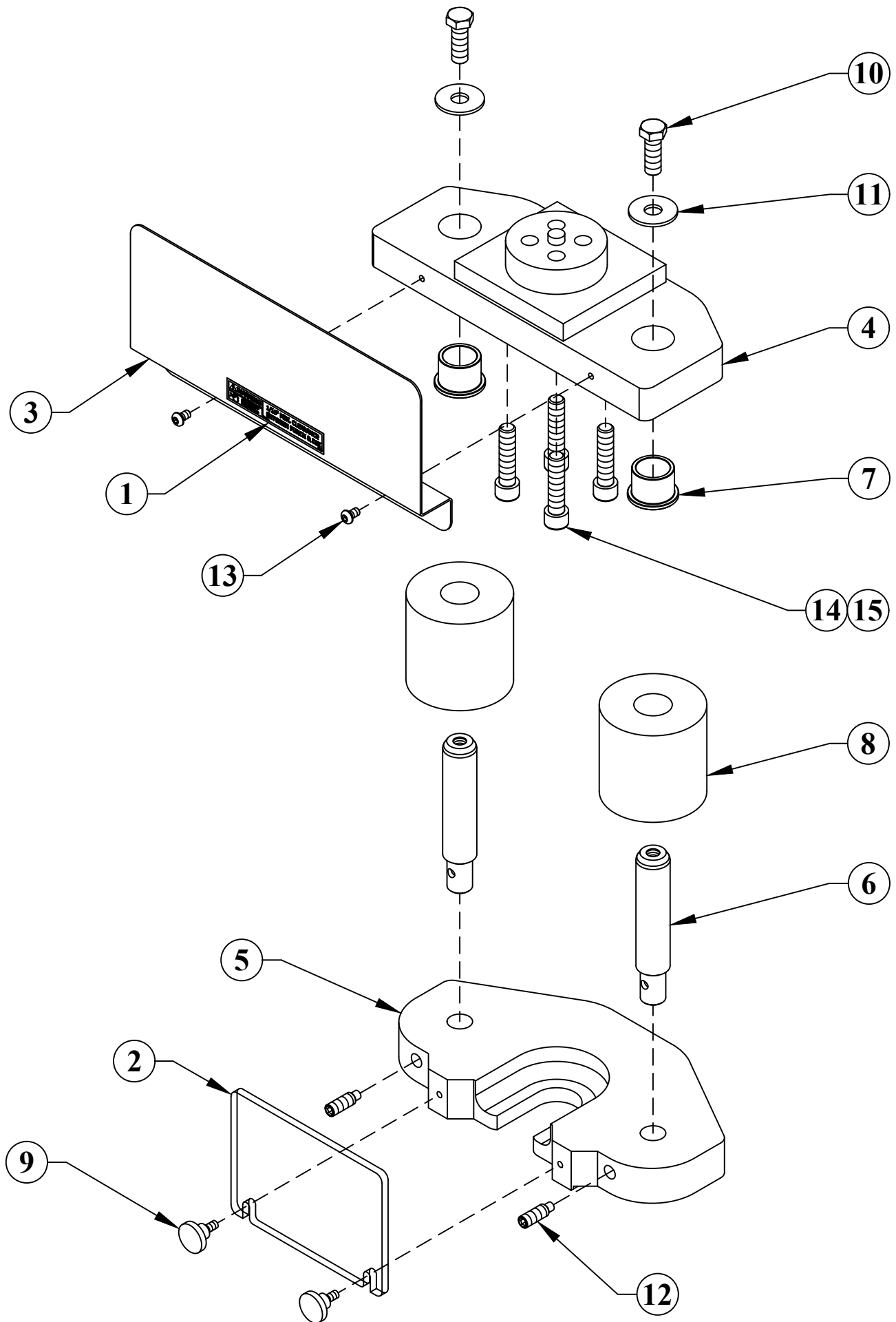


SPLIT RING
WRENCH

2.27 URETHANE STRIPPER

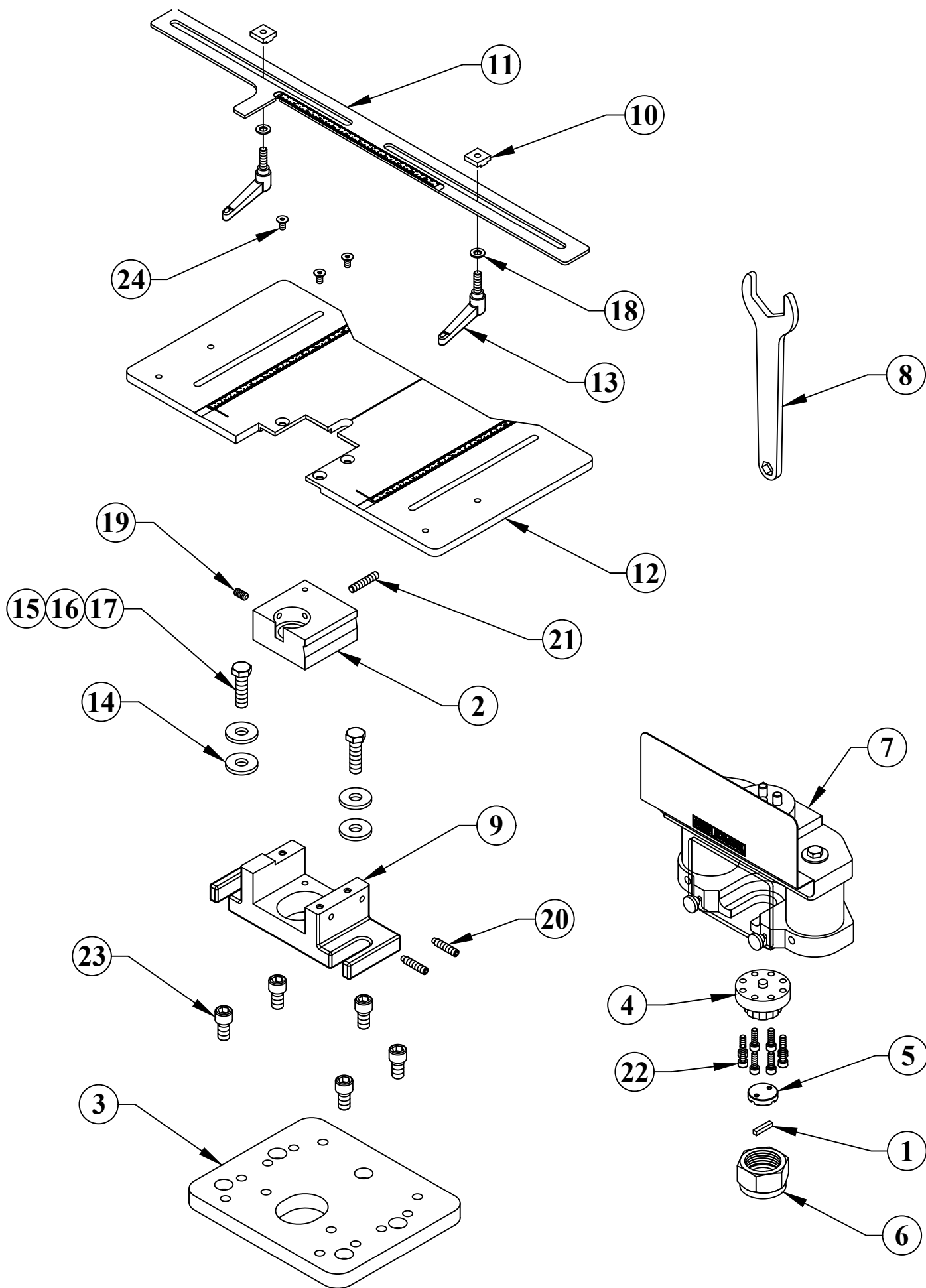
ITEM	DO 8514	6509 9012 DO 70 DO 95 FI 8510	12012 DO 120 DO 135 DO 150	DESCRIPTION
1		003105	003105	Label (Warning)
2	025450	025450	025450	Shield
3		026082	026082	Guard (Includes: 1)
4	026095	026093	026094	Top Plate
5	026097	026097	026097	Bottom Plate
6	026099	026099	026099	Spring Post
7	026100	026100	026100	1" Lubricated Flange Bushing
8	026103	026103	026103	Urethane Spring
9	073691	073691	073691	M6 x 12 Knob (DIN 464)
10	201415	201415	201415	M12 x 40 HHCS (DIN 933)
11	213014	213014	213014	M12 Large Washer (DIN 9021)
12	218056	218056	218056	M10 x 30 Set Screw (DIN 915)
13		220014	220014	M6 x 10 BHCS (DIN BN19)
14	221320			M12 x 50 SHCS (DIN 912)
15		221329	221329	M12 x 70 SHCS (DIN 912)

	026090	026091	026092	Complete Tool Assembly
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2.27A URETHANE STRIPPER KITS

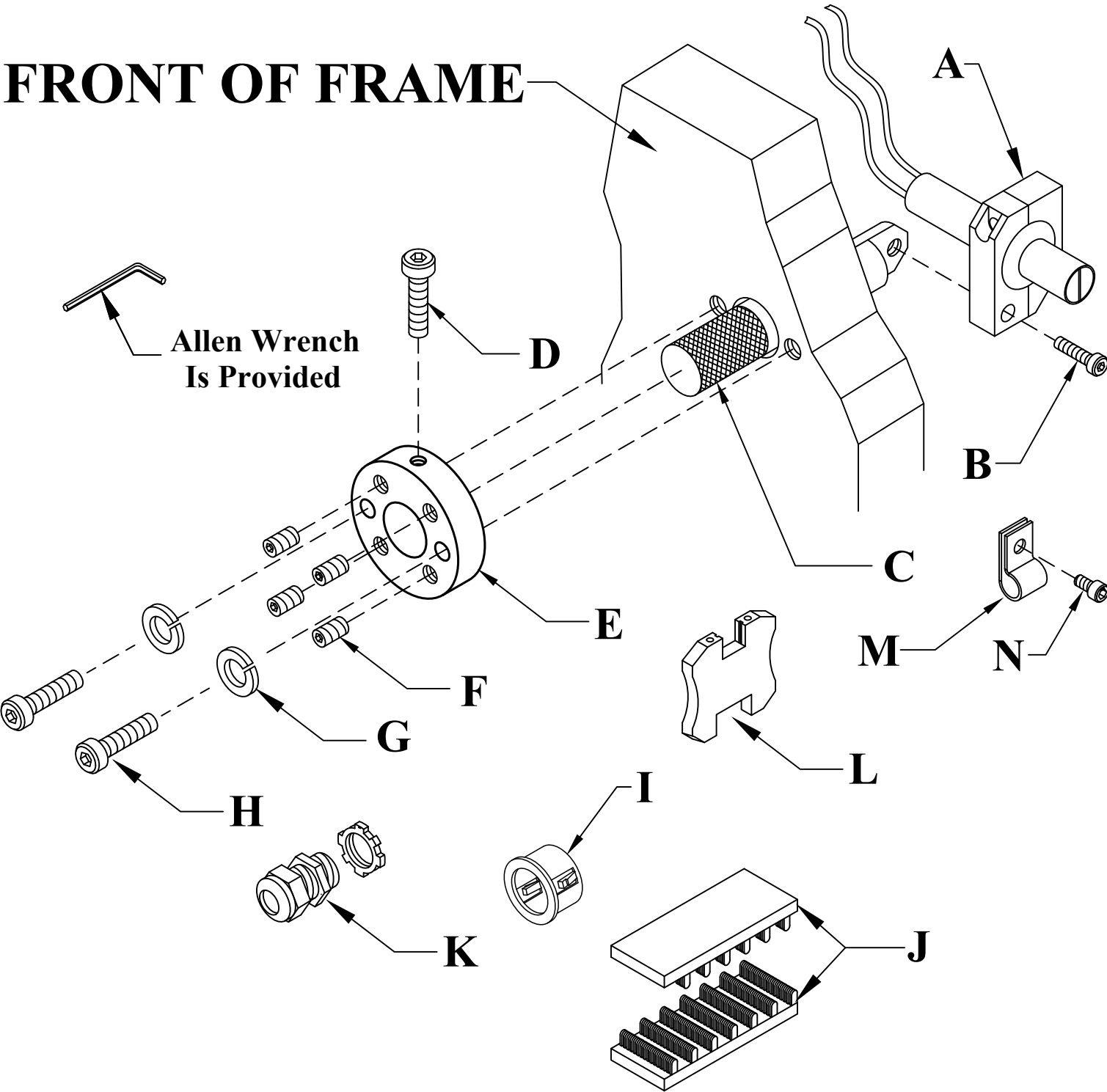
ITEM	6509	DO 70 DO 95	FI 8510	9012	12012 DO 120 DO 135 DO 150	DO 8514	DESCRIPTION
1					004123	004123	1/4" KEY
2	006202	006202	006202	006202	006202	006202	#82 Die Insert (Includes: 21)
3	006262			026042			Punch Bolster
4					012078	012078	3" Ram Adapter (Includes: 1, 5, 22)
5					015033	015033	Insert (Includes: 1)
6					016095	016095	#40 Retaining Nut
7	026091	026091	026091	026091	026092	026090	Urethane Stripper (See Previous Page)
8	026101	026101	026101	026101	026101	026101	Urethane Stripper Wrench
9	026105	026106	026104	026105	026106	026106	Die Holder (Includes: 20)
10	026617	026617	026617	026617	026617	026617	Low Profile Tee Nut
11	026696	026696	026696	026696	026696	026696	Low Profile Guide
12	026713	026713	026713	026710	026710	026710	Punch Table
13	080063	080063	080063	080063	080063	080063	M10 Handle
14	113017	113017	113017	113017	113017	113017	1-3/4 OD x 21/32 ID Washer
15	201620		201620	201620			M16 x 55 HHCS (DIN 931)
16		201625			201625		M16 x 65 HHCS (DIN 931)
17						201640	M16 x 90 HHCS (DIN 931)
18	214012	214012	214012	214012	214012	214012	M10 Washer (DIN 125)
19	218048	218048	218048	218048	218048	218048	M10 x 20 Set Screw (DIN 916)
20	218058	218058	218058	218058	218058	218058	M10 x 45 Set Screw (DIN 915)
21	219060	219060	219060	219060	219060	219060	M10 x 50 Set Screw (DIN 913)
22					221120	221120	M8 x 25 SHCS (DIN 9121580)
23	221410			221410			M16 x 30 SHCS (DIN 912)
24	230107	230107	230107	230107	230107	230107	M8 x 16 FSHCS (DIN 7991)
	026041	026051	026056	026061	026071	026081	Complete Assembly



2.28 LASER LIGHT

ITEM	PART #	DESCRIPTION
A	033261	Laser w/Mounting Bracket
B	073619	M-6 x 20 SHCS
C	033258	Laser Rod
D	221120	M-8 x 25 SHCS
E	033255	Laser Rod Holder
F	218030	M-8 x 12 SS
G	073106	M-6 Lock Washer
H	073621	M-6 x 30 SHCS
I	158003	Hole Plug
J	013167	Velcro 5"
K	077183	Cord Grip
L	033228	WDU Terminal Block
M	562040	Wire Clamp
N	221005	M-6 x 12 SHCS

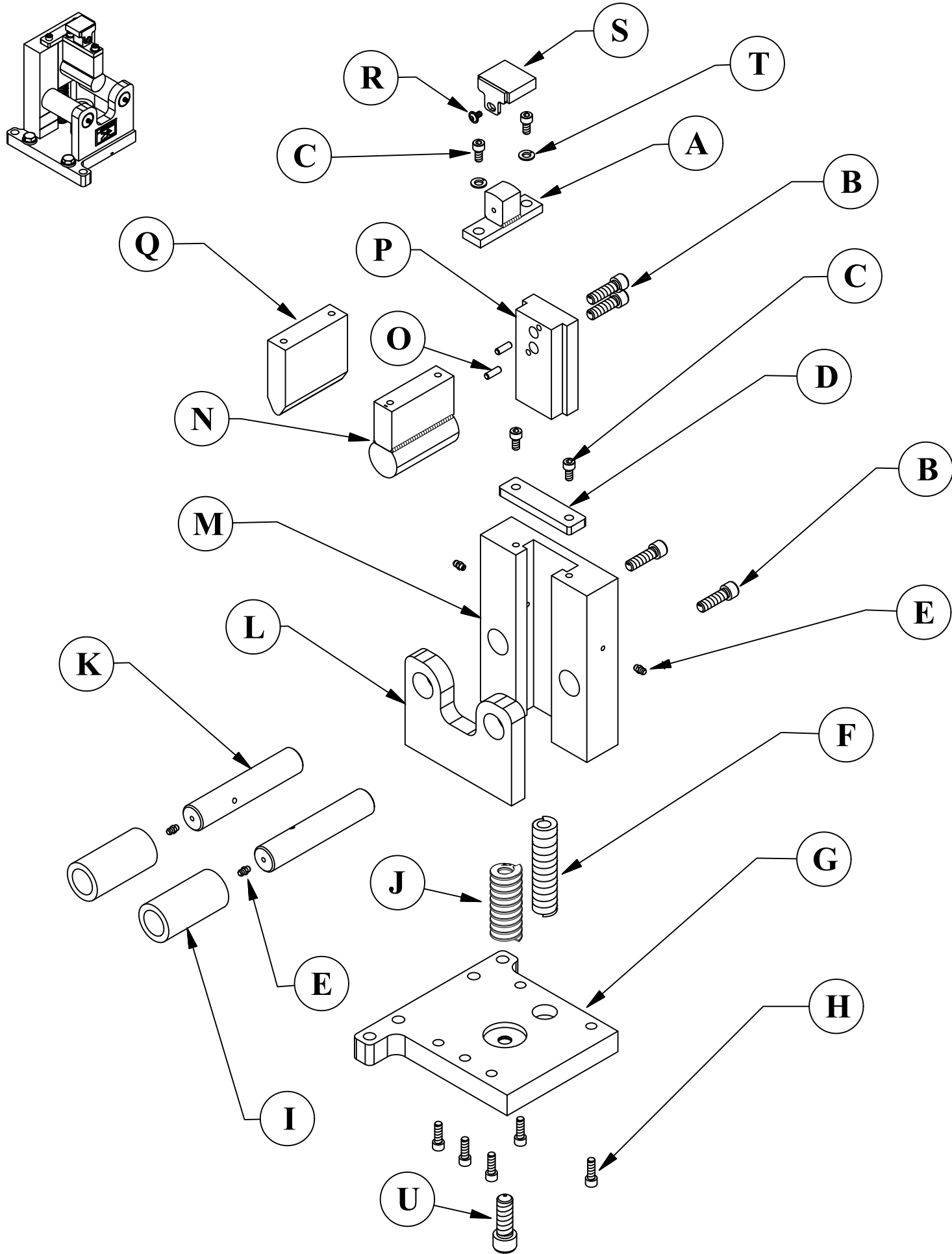
FRONT OF FRAME



I & J ARE USED IN THE ELECTRICAL BOX

2.29 WELD QUALITY COUPON BENDER

			6509	9012 12012 DO70 DO95	DO120 DO135 DO150	DO85 FI85
ITEM	QTY	PART#				
A	1	Pushers	024730	024740	024750	024760
			DESCRIPTION			
B	4	221315	M12 x 40 SHCS			
C	4	073420	M8 X 16 SHCS			
D	1	024716	Ram Stop			
E	4	243101	Grease Zerk			
F	1	024714	Spring			
G	1	024702	Base			
H	5	221210	M10 x 25MM SHCS			
I	2	024705	Roller			
J	1	024703	Weld Test 1-1/2 X 4 Die Spring			
K	2	024704	Pin			
L	1	024701	Pin Support			
M	1	024708	Back Support			
N	1	024713	U-Die Assembly			
O	2	343002	1/4 x 3/4 Dowel Pin			
P	1	024709	Ram			
Q	1	024715	V-Die			
R	1	220016	M6 X 10MM BF			
S	1	433151	Rocker Cap Assy-8" Brake			
T	2	214011	M8 Regular Washer			
U	1	221417	M16 X 45 SHCS			

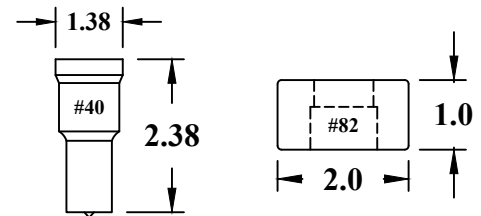


3.0 PUNCHES AND DIES

All Scotchman punches and dies are designed and manufactured for Scotchman products. All punches and dies are made from high quality tool steel. The following charts give punch and die dimensions for various styles and sizes. They also show what tooling is required to hold the various sizes. In addition to the punches and dies shown, Scotchman manufactures punches and dies for special applications. Please contact your dealer or the factory if you have such an application.

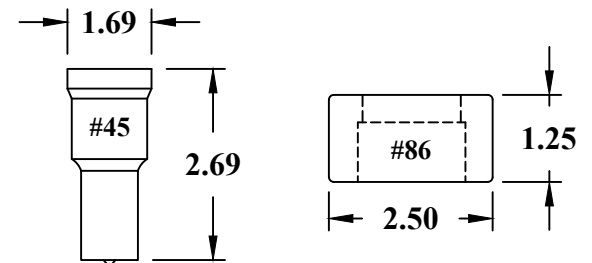
#40 ROUND PUNCHES & #82 DIES (USE #40 PUNCH RETAINING NUT & STANDARD 2" DIE HOLDER OR INSERT)

1/8, 5/32, 3/16, 7/32, 1/4, 9/32, 5/16, 11/32, 3/8, 13/32, 7/16, 15/32, 1/2, 17/32, 9/16, 19/32, 5/8, 21/32, 11/16, 23/32, 3/4, 25/32, 13/16, 27/32, 7/8, 29/32, 15/16, 31/32, 1, 1-1/32, 1-1/16, 1-3/32, 1-1/8, 1-5/32, 1-3/16, 1-7/32, 1-1/4



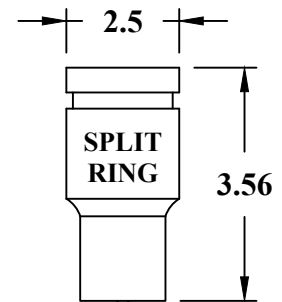
NUT & 2-1/2" DIE HOLDER OR INSERT)

1-9/32, 1-5/16, 1-11/32, 1-3/8, 1-13/32, 1-7/16, 1-15/32, 1-1/2, 1-17/32, 1-9/16

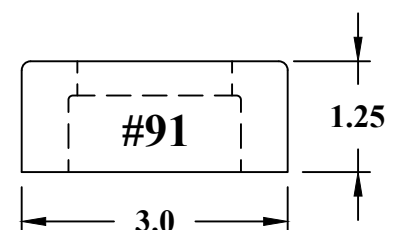


OVERSIZED ROUND PUNCHES (USE HEAVY DUTY SPLIT-RING RETAINING NUT)

1-19/32" UP TO 1-15/16"



OVERSIZED ROUND DIES (USE OVERSIZED 3" DIE HOLDER OR INSERT)



1-5/8" TO 1-31/32"

OVERSIZED ROUND PUNCHES

(USE OVERSIZED SPLIT-RING RETAINING NUT)

1-31/32" UP TO 2-7/16"

OVERSIZED ROUND DIES (USE 6" x 6" DIE HOLDER)

I.D. SIZES LARGER THAN 1-31/32"

MUST USE 6" x 6" DIE HOLDER

OVERSIZED ROUND PUNCHES (USE HEAVY DUTY RETAINING NUT & OVERSIZED 6" x 6" DIE HOLDER)

2-1/2" TO 3"

3-1/32" TO 4"

#40 OVAL SLOT PUNCHES & DIES

(USE #40 PUNCH RETAINING NUT AND STANDARD 2" O.D. DIE HOLDER OR INSERT)

9/32 x 3/4, 5/16 x 3/4, 11/32 x 3/4, 3/8 x 3/4,

13/32 x 3/4, 7/16 x 3/4, 15/32 x 3/4,

1/2 x 3/4, 17/32 x 3/4, 9/16 x 3/4, 19/32 x 3/4, 5/8 x 3/4,

9/32 x 1, 5/16 x 1, 11/32 x 1, 3/8 x 1,

13/32 x 1, 7/16 x 1, 15/32 x 1, 1/2 x 1,

17/32 x 1, 9/16 x 1, 19/32 x 1, 5/8 x 1,

21/32 x 1, 11/16 x 1, 23/32 x 1

3/4 x 1, 25/32 x 1, 13/16 x 1, 7/8 x 1, 15/16 x 1

9/32 x 1-1/4, 5/16 x 1-1/4, 11/32 x 1-1/4,

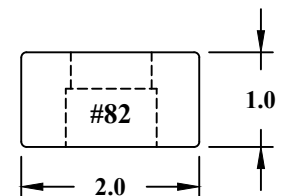
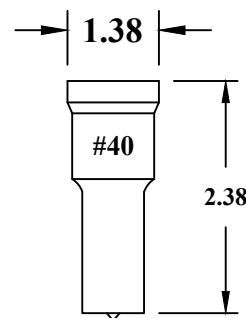
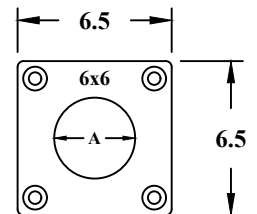
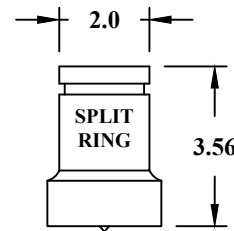
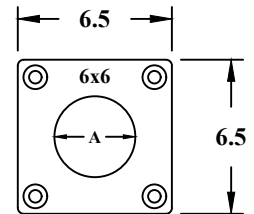
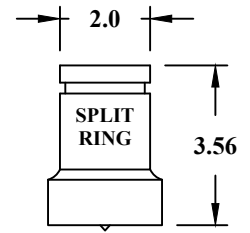
3/8 x 1-1/4, 13/32 x 1-1/4, 7/16 x 1-1/4,

15/32 x 1-1/4, 1/2 x 1-1/4, 17/32 x 1-1/4,

9/16 x 1-1/4, 19/32 x 1-1/4, 5/8 x 1-1/4,

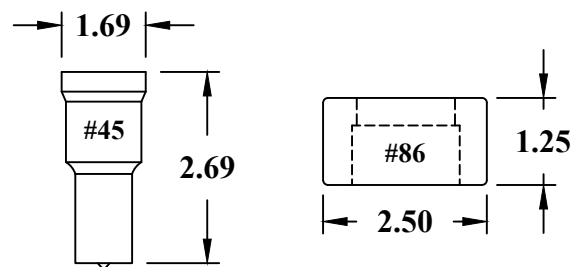
21/32 x 1-1/4, 11/16 x 1-1/4, 23/32 x 1-1/4,

3/4 x 1-1/4, 25/32 x 1-1/4, 13/16 x 1-1/4, 7/8 x 1-1/4, 15/16 x 1-1/4

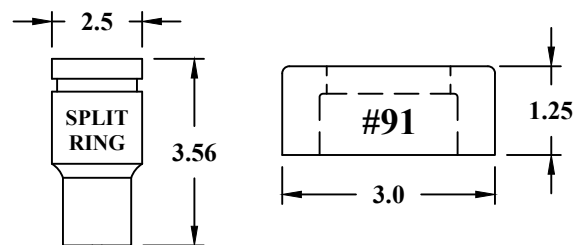


FOR 1-17/64" TO 1-9/16" SLOT LENGTHS

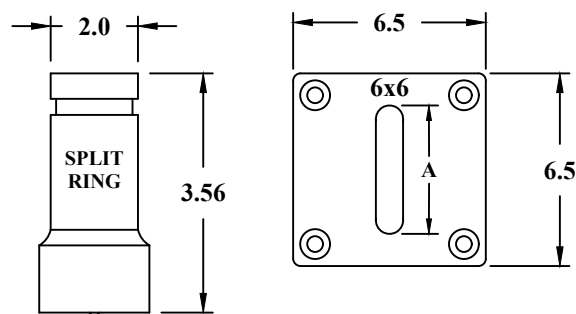
(USE #45 PUNCH RETAINING NUT & 2-1/2" DIE HOLDER OR INSERT FOR 2-1/2" O.D. DIES)



**FOR 1-19/32" TO 2-1/32" SLOT LENGTHS
(USE HEAVY DUTY SPLIT-RING NUT AND
3" DIE HOLDER OR 3" O.D. INSERT)**



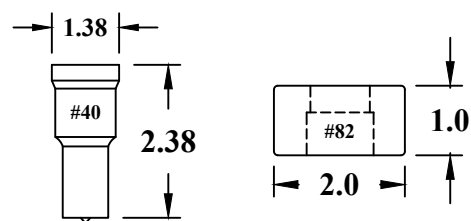
**FOR 2-3/64" TO 4" SLOT LENGTHS
(USE HEAVY DUTY SPLIT-RING NUT
AND 6" x 6" DIE HOLDER)**



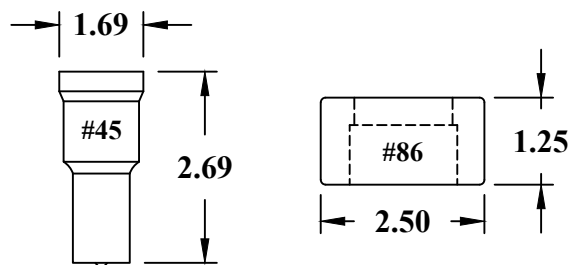
**#40 SQUARE PUNCHES & #82 DIES
(USE #40 RETAINING NUT & 2" DIE HOLDER OR INSERT)**

3/8, 13/32, 7/16, 15/32, 1/2, 17/32,

9/16, 21/32, 3/4, 25/32, 7/8



**#45 1" SQUARE PUNCH
#86 1-1/32" SQUARE DIE**

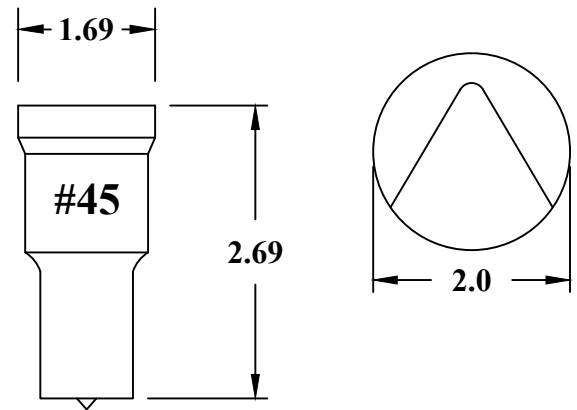


PICKET PUNCHES & DIES FOR SQUARE TUBING
1" (USE SPLIT-RING NUT & #86 DIE)

5/8" (USE #45 NUT & #82 DIE)

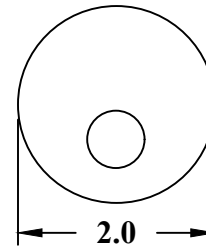
#86 DIE IS 2.50" O.D.

3/4" (USE SPLIT-RING NUT & #82 DIE)



ECCENTRIC DIES FOR PUNCHING NEXT
TO WEB OF ANGLE IRON

#82 - 9/32, 11/32, 13/32, 7/16, 15/32, 17/32, 9/16, 19/32, 21/32,
23/32, 25/32, 27/32

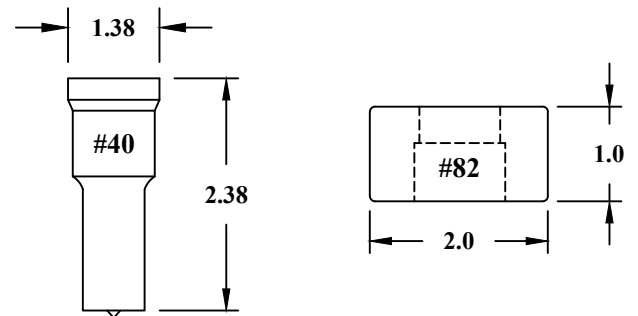


#40 HEXAGON PUNCHES
(USE #40 RETAINING NUT)

1/2, 17/32, 11/16, 3/4

#82 HEXAGON DIES

(USE 2" DIE HOLDER OR INSERT)



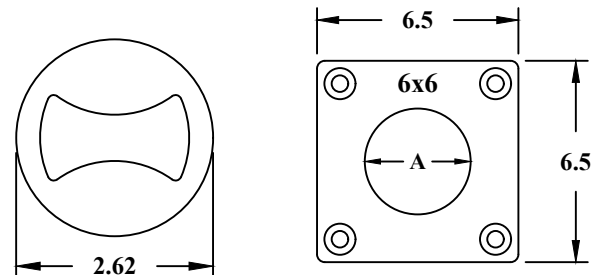
17/32, 9/16, 23/32, 25

TRIMMING & CUTOFF PUNCHES & DIES
1" PUNCH (USE HEAVY DUTY SPLIT-RING NUT)
1" DIE (USE 2-1/2" DIE INSERT)

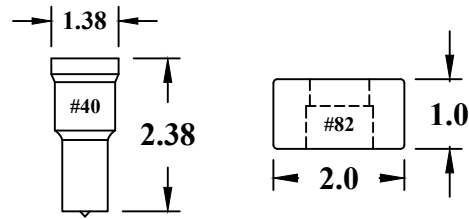
1-1/4" PUNCH (USE HEAVY DUTY SPLIT-RING NUT)
1-1/4" DIE (USE 3" DIE INSERT
(SEE DIAG. OF DIE — 3.00" O.D.)

1-1/2" PUNCH (USE HEAVY DUTY SPLIT-RING NUT)

1-1/2" DIE (USE 6" X 6" DIE HOLDER)



RECTANGLE PUNCHES & DIES



ALL SIZES ARE AVAILABLE THROUGH OUR SPECIAL TOOLING DEPARTMENT.

PLEASE CALL FOR PRICING AND DELIVERY.

INFORMATION ON ORDERING PUNCHES & DIES

THE #40 & #45 PUNCHES AND THE #82 & #86 DIES LISTED ARE STANDARD SIZES KEPT IN STOCK FOR YOUR CONVENIENCE.

MANY METRIC SIZES FROM 5MM TO 30MM ARE ALSO KEPT IN STOCK.

ALL OF THE OVERSIZED PUNCHES & DIES ARE SPECIALS AND REQUIRE UP TO FOUR WEEKS FOR DELIVERY.

THE #40 & #45 PUNCHES AND THE #82 & #86 DIES REQUIRE DIFFERENT DIE CLEARANCES DEPENDING ON THE TYPE & THICKNESS OF MATERIAL BEING PUNCHED.

FOR PUNCHING MILD STEEL, WE RECOMMEND 1/32 INCH DIE CLEARANCE WHEN PUNCHING MATERIAL LESS THAN 5/8 INCH.

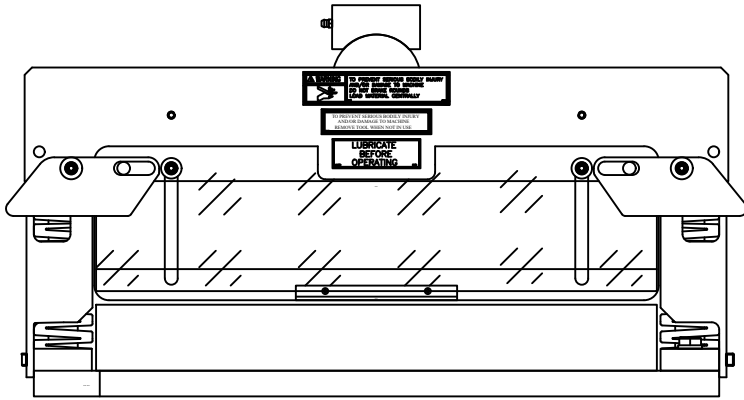
WE RECOMMEND 1/16 INCH DIE CLEARANCE WHEN PUNCHING MATERIAL 3/4 INCH OR OVER.

PLEASE SPECIFY TYPE & THICKNESS OF MATERIAL BEING PUNCHED, TO ASSURE PROPER DIE CLEARANCE.

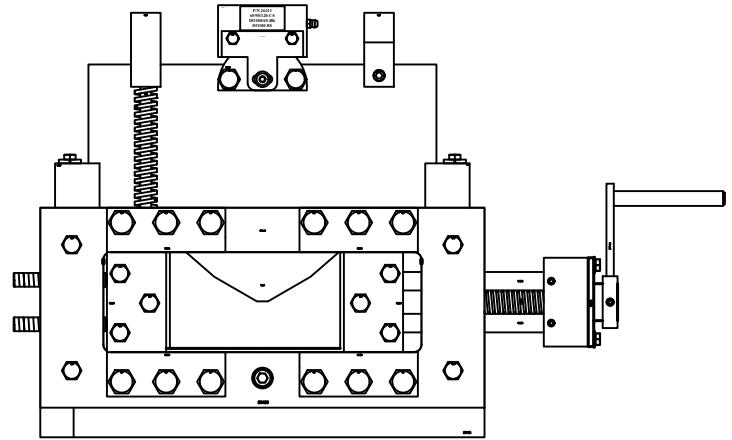
IN ADDITION TO THE SHAPES LISTED, WE MANUFACTURE TEARDROP, KNOCK-OUT, KEYHOLE AND OTHER SPECIALTY PUNCHES & DIES.

PLEASE WRITE, CALL OR FAX FOR PRICES AND DELIVERY.

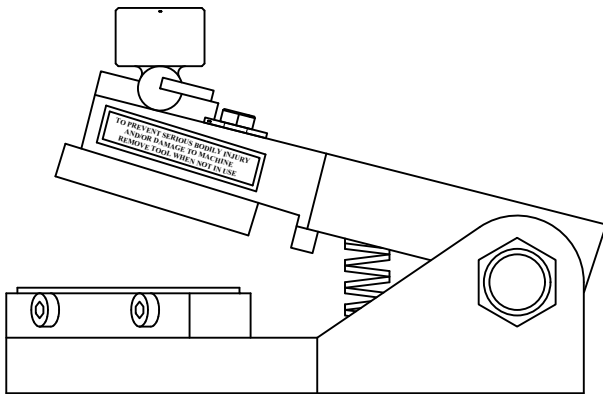
SCOTCHMAN # 40 TOOLING MANUAL



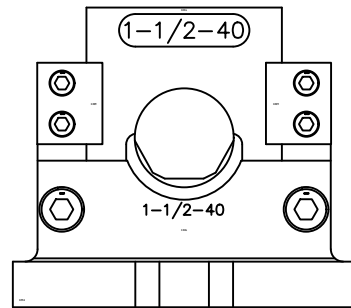
12" and 24" Brakes



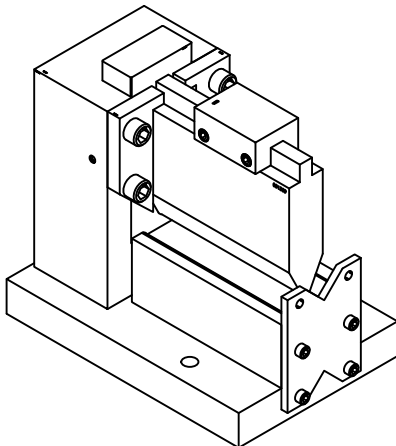
Channel Shear



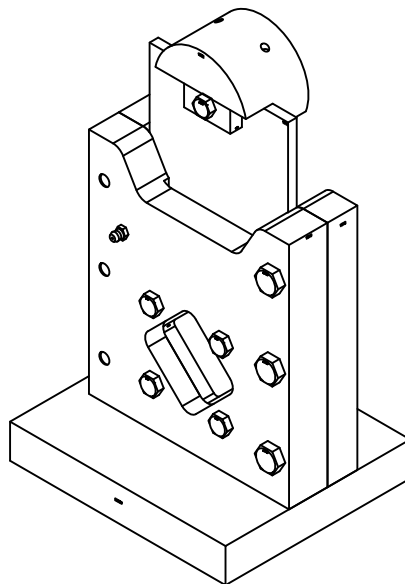
6 x 6 x Ninety Degree Notcher



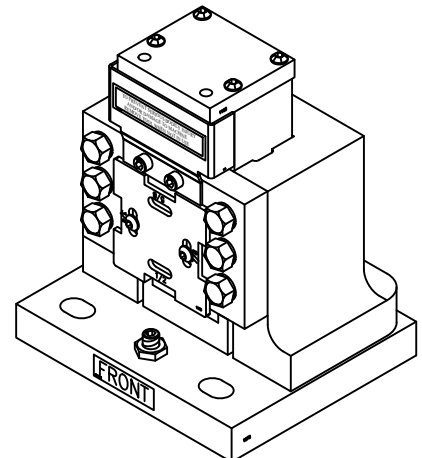
Pipe Notcher



6" Angle Iron Brake



Square Tube Shear

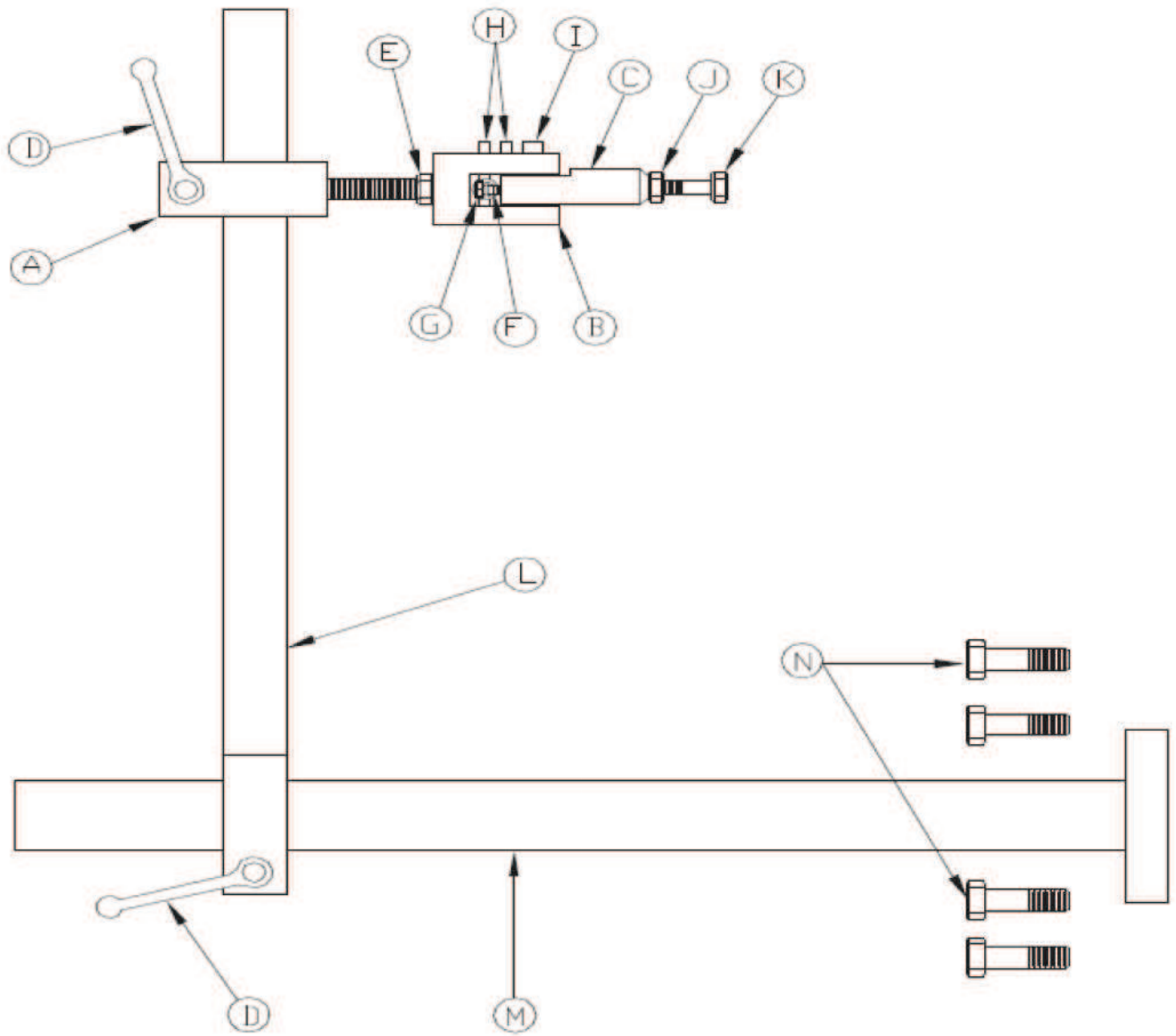


Picket Tool

4.0 SUPPLEMENT FOR OLDER TOOLING

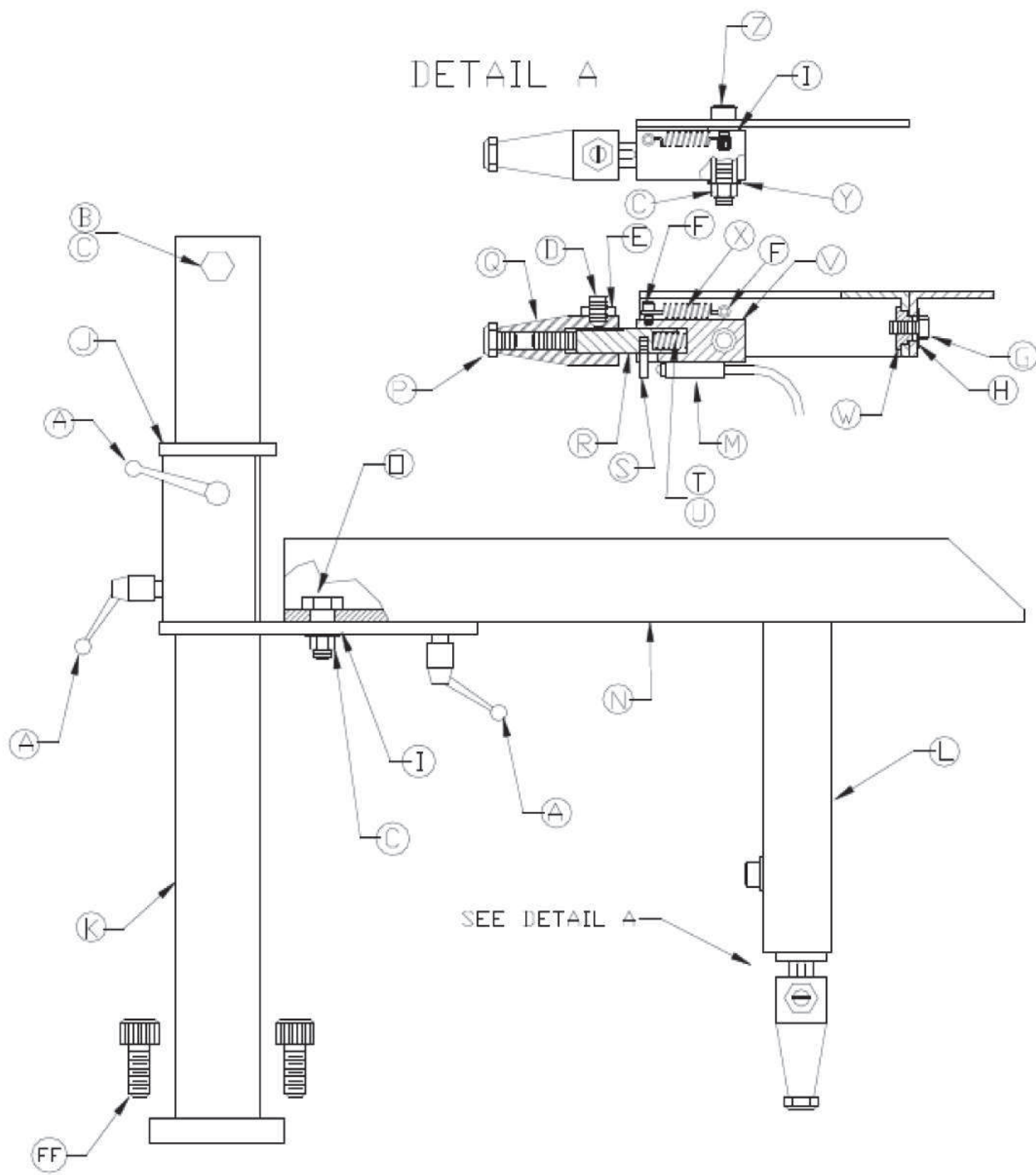
4.1 SIX FOOT BACK GAUGE

ITEM	PART #	DESCRIPTION
A	597011	Stop Clamp Assembly
B	597009	Stop Clevis
C	597007	Material Stop
D	597032	Adjustment Handle
E	210016	M-16 Jam Nut
F	597030	Spring
G	221005	M-6 SHCS
H	141420	1/4 x 2 Roll Pin
I	141720	1/2 x 2 Roll Pin
J	210014	M-12 Jam Nut
K	205425	M-12 HHCS
L	597017	Support Arm
M	597023	Main Support
N	201620	M-16 Mounting Bolts
	597008	Stop Assembly (Includes A, B, C, E, F, G, H, I, J & K)
	597005	Complete Back Gauge



4.2 FIFTY-FOUR INCH BACK GAUGE ASSEMBLY

ITEM	PART #	DESCRIPTION
A	080061	Handle
B	201410	M-12 x 25 HHCS
C	208014	M-12 Hex Nut
D	001541	Ball Spring Screw
E	110014	1/2 x 13 Jam Nut
F	221005	M-6 x 12 SHCS
G	203210	M-10 x 25 HCS
H	213012	M-10 Flat Washer
I	213014	M-12 Flat Washer
J	550012	Slide
K	550020	Support Tube
L	550015	Probe Support
M	550067	Optional Limit Switch
N	550013	Swing Arm
O	550027	Pivot Bolt
P	550034	Probe Cap
Q	550033	Boss
R	550031	Probe Rod
S	550032	Contact Pin
T	550035	Plug (For Manual Back Gauge)
U	550036	Spring (For Electric Back Gauge)
V	550030	Probe Body
W	550028	Tee Nut
X	550037	Spring
Y	550038	Bushing
Z	221005	M-6 x 12 SHCS
AA	550018	Complete Stop Assembly (Includes all of Detail A)



4.3 6 X 6 ANGLE SHEAR

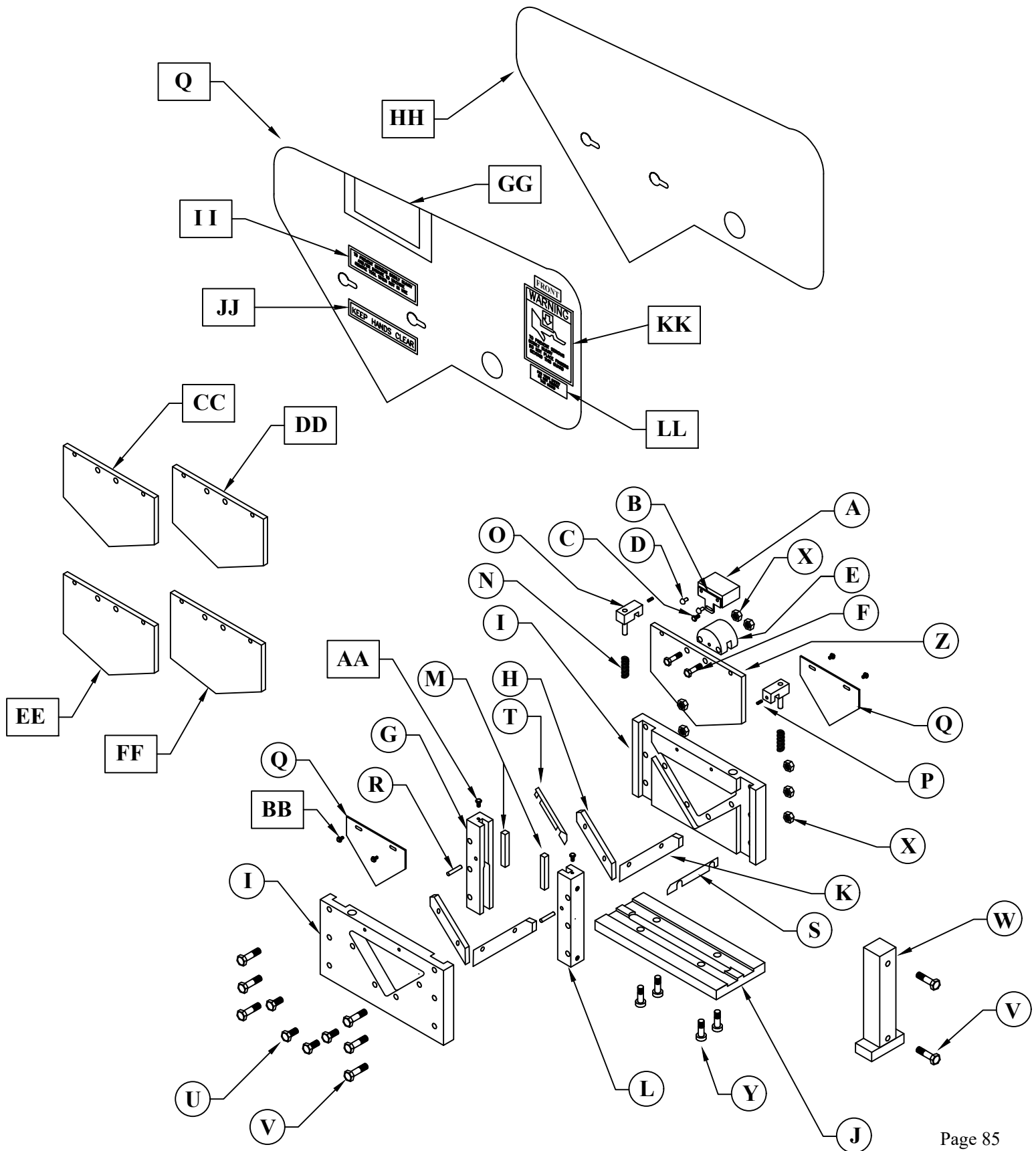
USED PRIOR TO THE FOLLOWING SERIAL #'S:

6509 (5297FF895) 9012 (20873M895) 12012 (50482M895)

ITEM	PART #	DESCRIPTION
A-D	016247	Slider Block Assembly
E	026209	Pressure Block
F	203225	M-10 HHCS
G	026229	Post
H	026735	Lower Blade-Left (2 Required)
I	026228	Side Plate
J	026232	Base
K	026735	Lower Blade-Right (2 Required)
L	026229	Post
M	016243	Wear Strip
N	016118	Spring
O	026244	Spring Lifting Block
P	218044	M-10 Set Screw
Q	026240	Front Guard Assembly
R	141515	5/16" Roll Pin
S	016234	Blade Shim-Left (2 Required)
T	016233	Blade Shim-Right (2 Required)
U	203212	M-10 HHCS
V	203225	M-10 HHCS
W	016250	Positive Stop Post
X	217012	M-10 Lock Nut
Y	221210	M-10 SHCS
Z	026237	Upper Blade-Standard
AA	201110	M-6 HHCS
BB	220030	M-6 Self Tapping Screw
CC	016238	4 x 3-1/2, 3-1/2 x 3, 3 x 2-1/2 Blade
DD	016239	4 x 3, 2-1/2 x 2, 2 x 1-1/2 Blade
EE	016240	6 x 4, 5 x 3-1/2, 3 x 2 Blade
FF	016241	6 x 3-1/2, 5 x 3 Blade
GG	026255	Lexan Sight Panel
HH	010241	Rear Guard
II	003145	Label (Remove Tool)
JJ	003125	Label (Hands Clear)

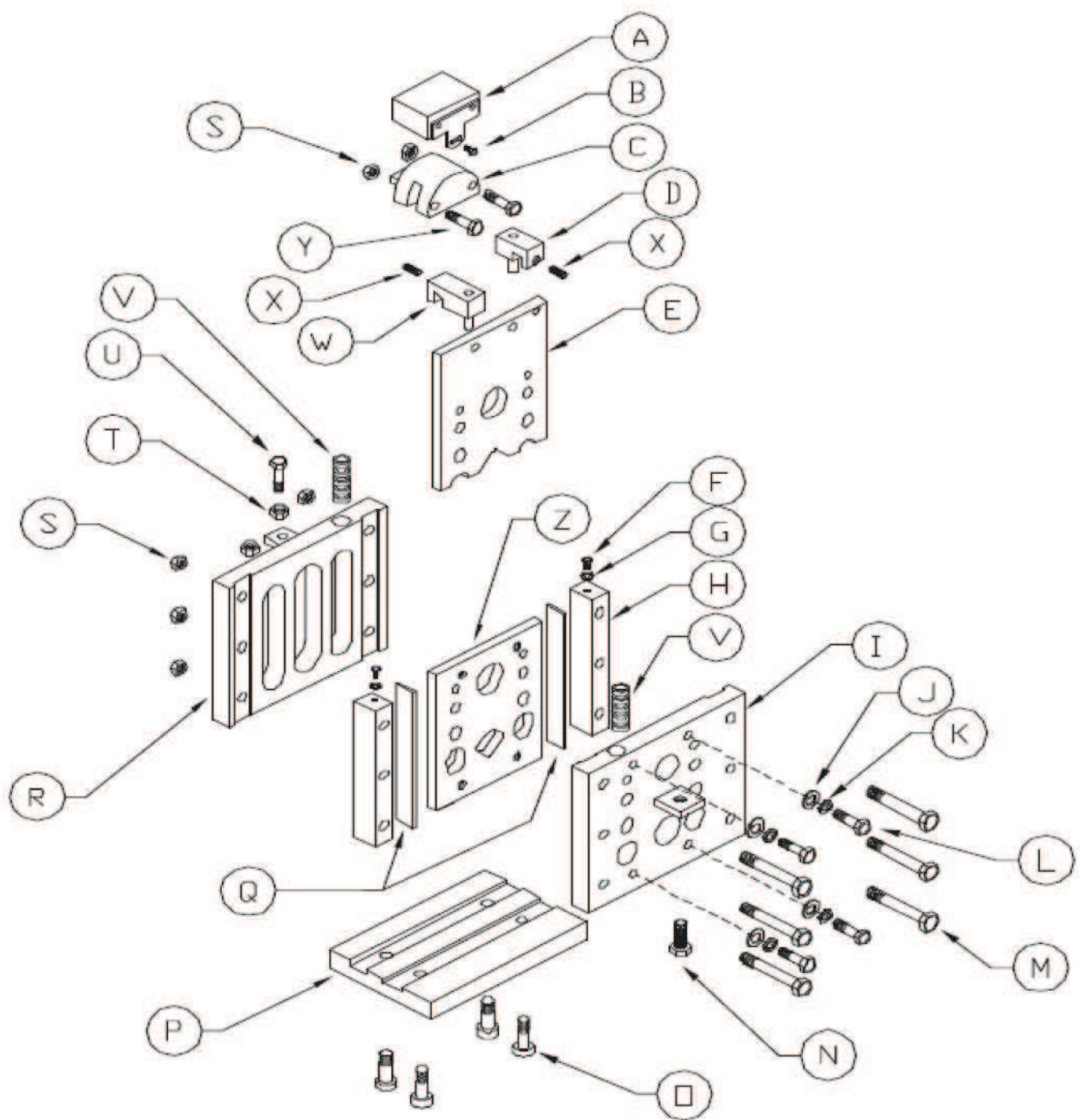
003140
003115
026408

Label (Fingers)
Label (Do Not Remove)
Quick Change Hardware
For Unequal Blades (E, F, O, P, X)



4.4 ROD SHEAR (USED UP UNTIL JUNE OF 2002)

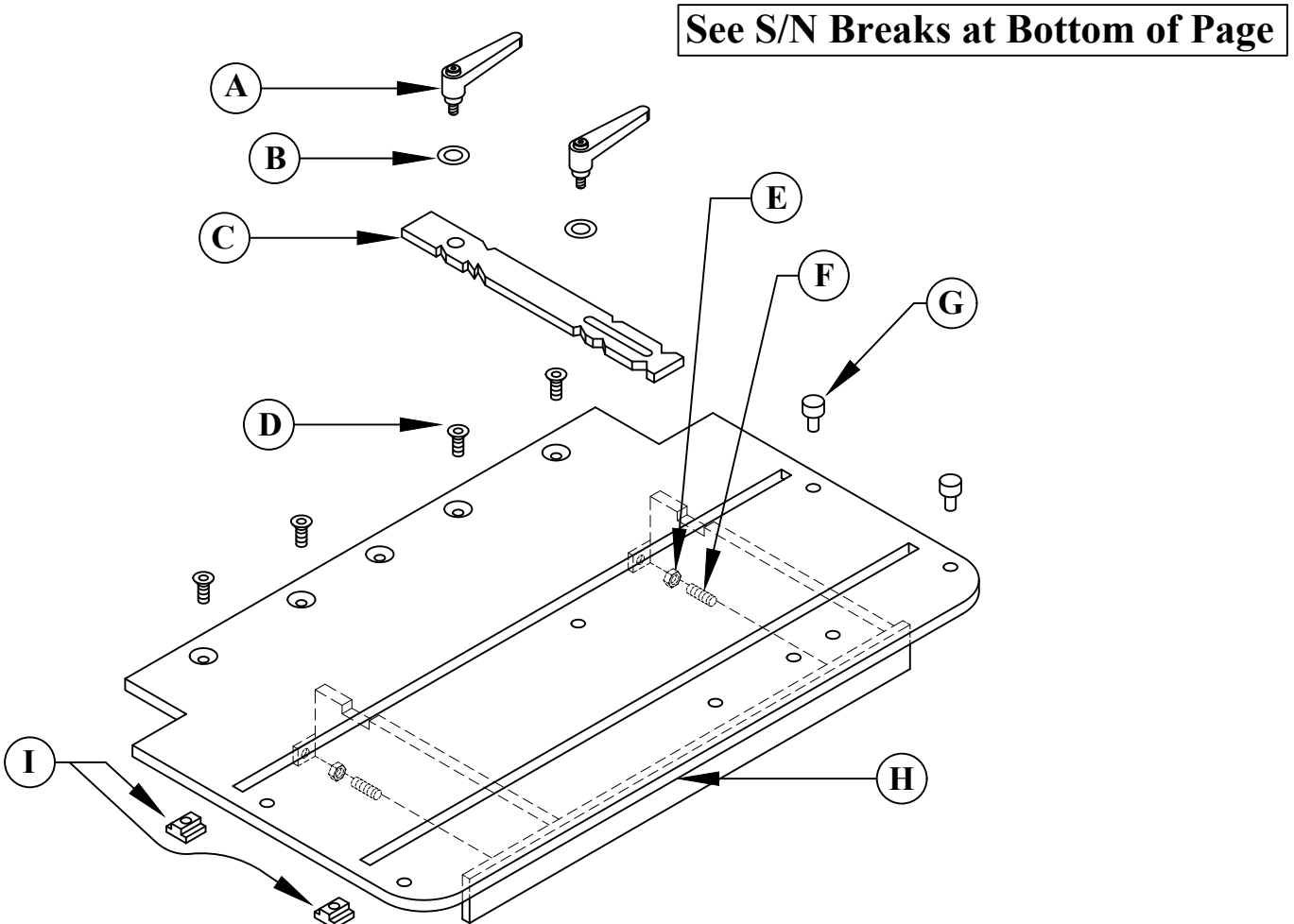
ITEM	COMMON	6509	9012	DO-70	FI-8507	FI-5109	DESCRIPTION
	PART #'S		12012	DO-100			
				DO-120			
A		026247	016247	026247	027375	027375	Slider Block
B	220014						M-6 BHCS
C	026258	026258	026258	026258	N/A	N/A	Pressure Cap
D	026282						Spring Lifting Block-Right
E	026281						Moving Blade
F	201110						M-6 HHCS
G	214011						M-8 Washer
H	026277						Post
I	026276						Front Side Plate
J	214012						M-10 Washer
K	212012						M-10 Lock Washer
L	201215						M-10 HHCS
M	203235						M-10 HHCS
N	201415						M-12 HHCS
O	221210						M-10 SHCS
P	026278						Base
Q	016279						Wear Strip
R	026275						Rear Side Plate
S	217012						M-10 Lock Nut
T	210012						M-10 Jam Nut
U	201232						M-10 HHCS
V	016119						3/4" x 5" Die Spring
W	026283						Spring Lifting Block-Left
X	219040						M-10 Set Screw
Y	204225						M-10 HHCS
Z	026280						Stationary Blade
	026274	026274	026274	026274	027727	027727	Complete Rod Shear



4.5 GAUGING TABLES - PUNCH, SHEAR & NOTCHER

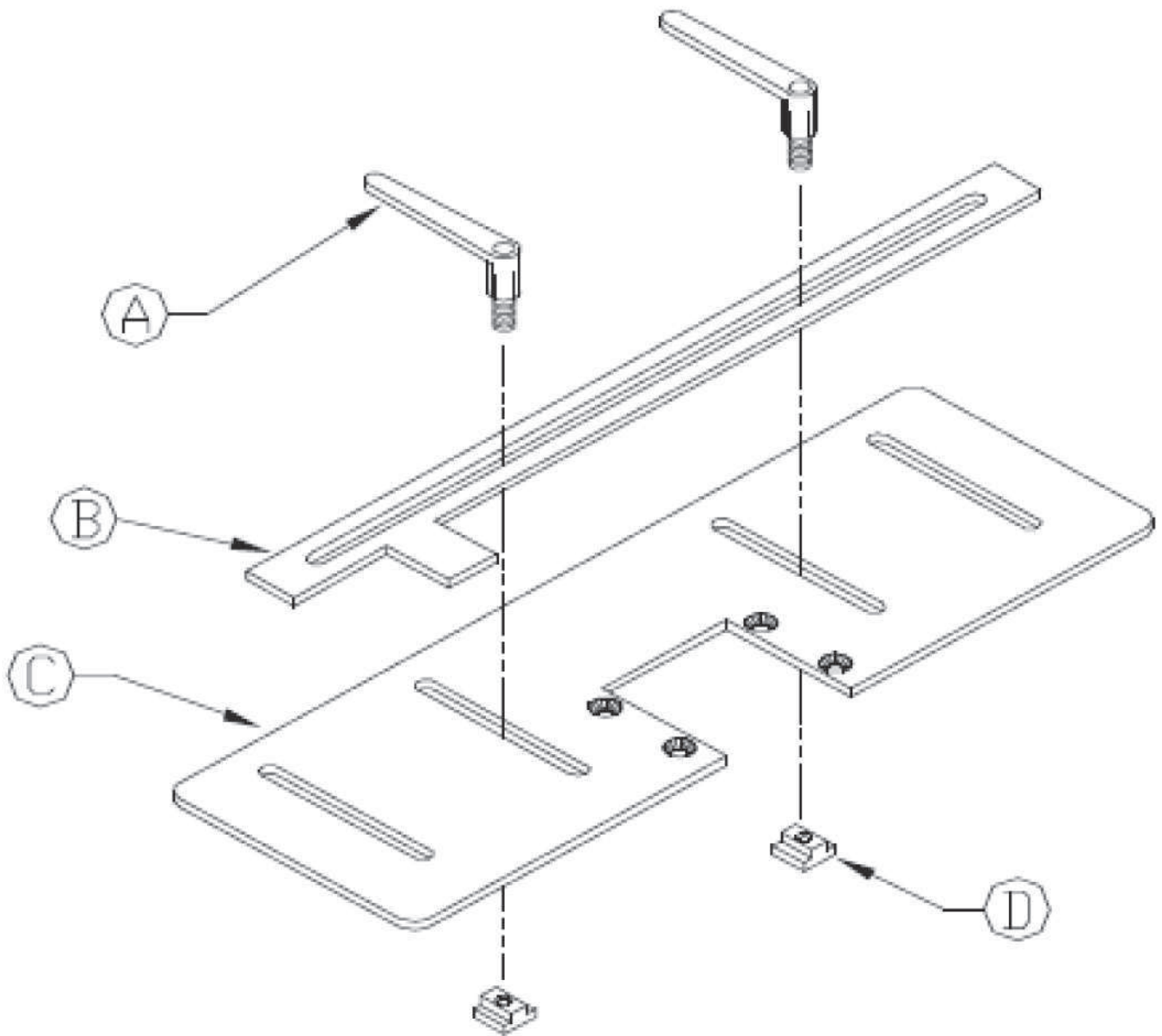
SHEAR TABLE (Old Style)

ITEM	COMMON PART #'S	6509 9012 12012	FI-5109 FI-6008 FI-8507	DO-70 DO-100 DO-120 DO-150	DESCRIPTION
A	080061				Handles
B	214012				M-10 Washer
C	026692				Guide
D	230207				M-10 FSHCS
E		210012	210014	210012	Jam Nut
F		219060	201435	219060	Set Screw
G	026698				Rest Button
H		026688	026591	026688	Table
I	026618				Tee Nuts
		026680	026580	026680	Complete Table



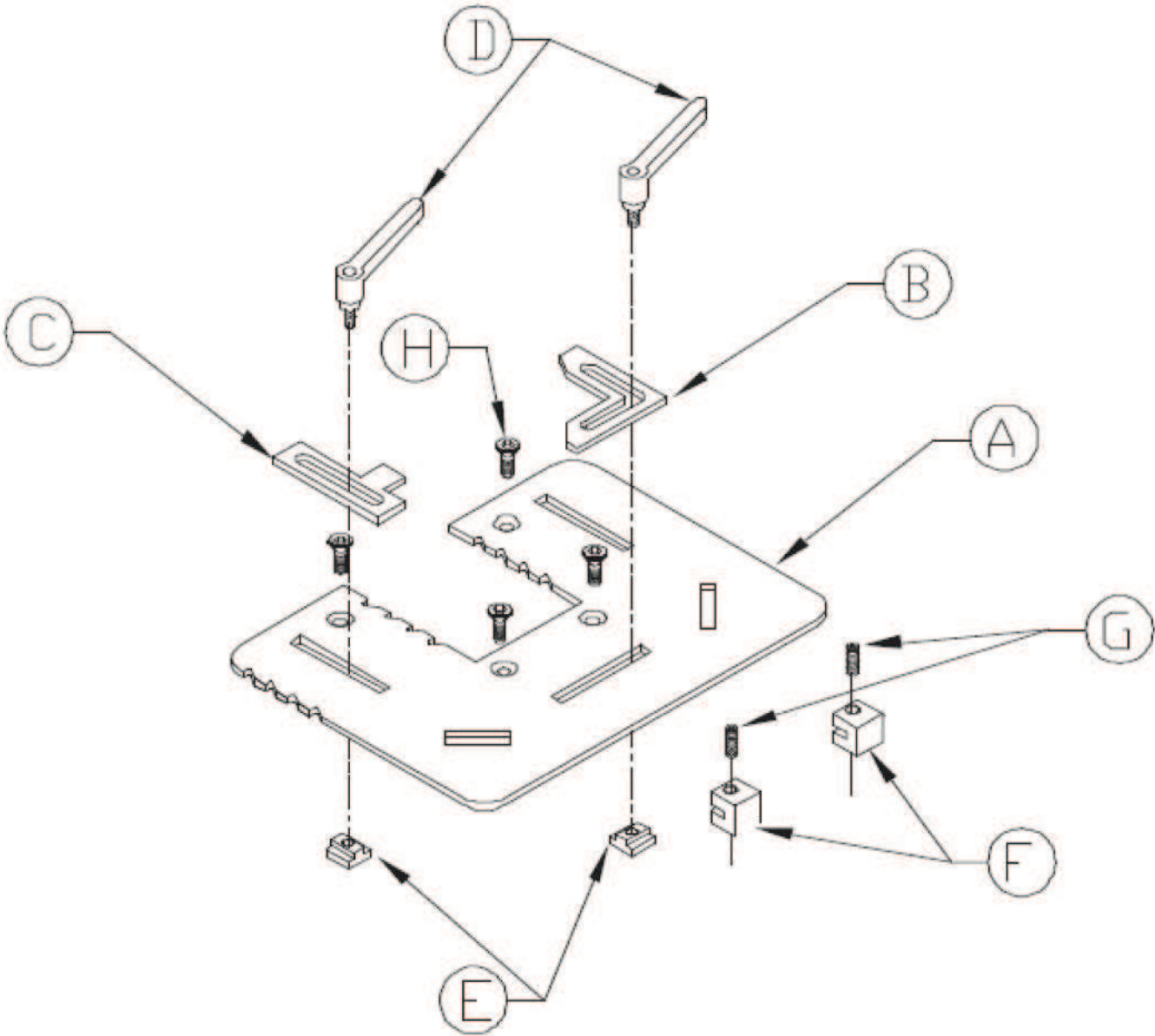
PUNCH TABLE

ITEM	COMMON	6509	9012	FI-8507	DESCRIPTION
	PART #'S	FI-5109	12012		
		FI-6008	DO-100		
		DO-70	DO-120		
A	080063				Handles
B	026697				Guide
D	026618				Tee Nuts
E	230207				M-10 FSHCS



NOTCHER TABLE

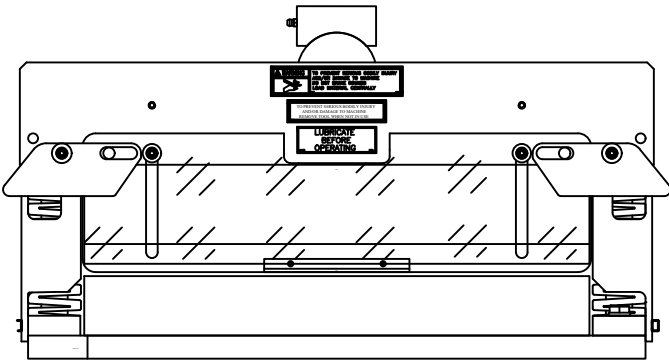
ITEM	COMMON PART #	FI-5109 FI-6008 FI-8507 DO-100 014119	DO-120 033152	DESCRIPTION
A				Table
B	014216			Angle Guide
D	080061			Handles
E	026624			Tee Nuts
H	230207			M-10 FSHCS
I	214012			M-10 Washer (Not Pictured)



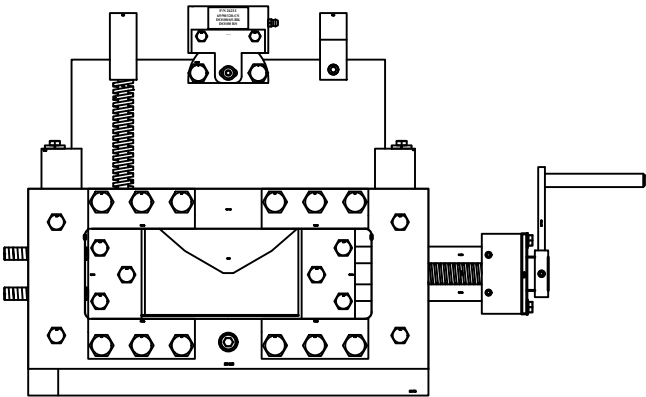
Scotchman

Metal Fabricating Solutions

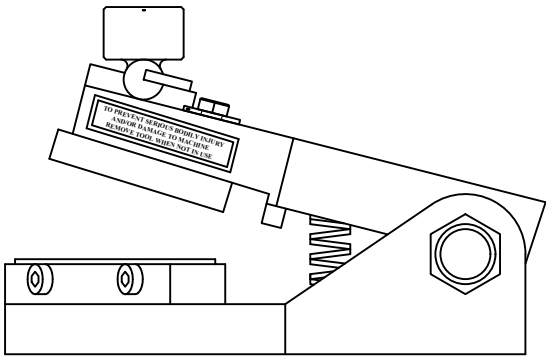
SCOTCHMAN # 40 TOOLING MANUAL



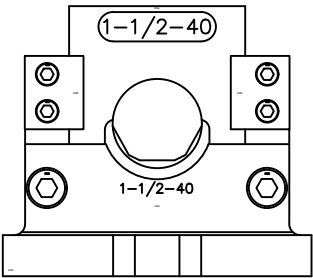
12" and 24" Brakes



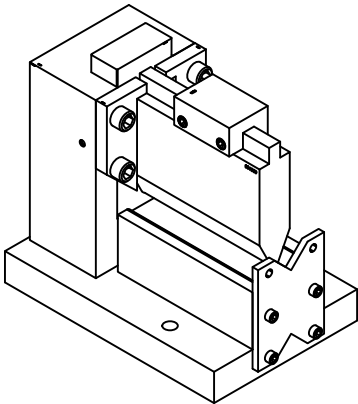
Channel Shear



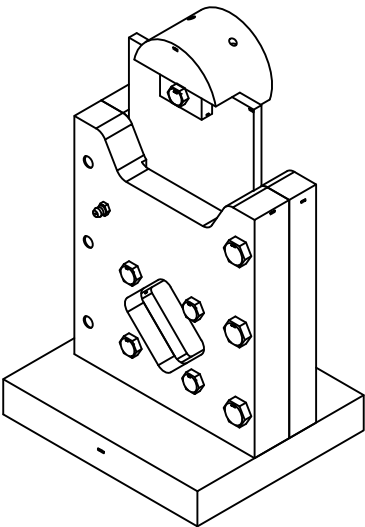
6 x 6 x Ninety Degree Notcher



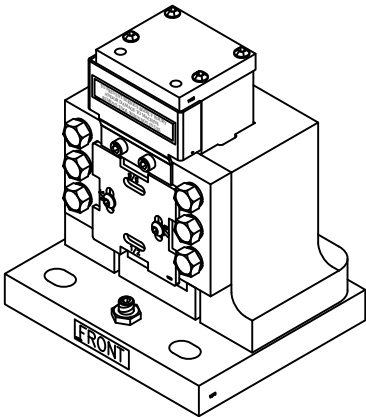
Pipe Notcher



6" Angle Iron Brake



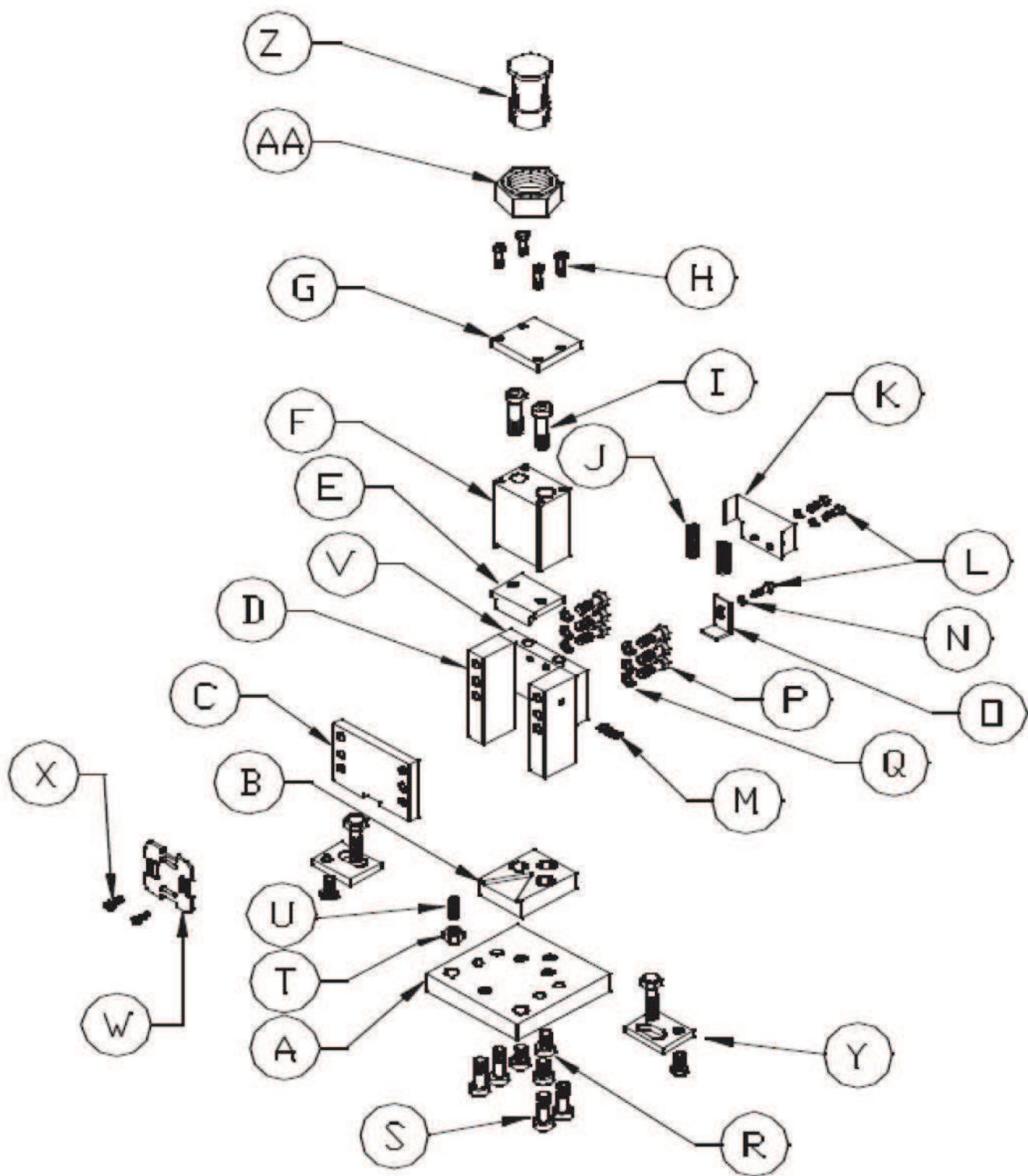
Square Tube Shear



Picket Tool

4.6 PICKET TOOL (WELDED HOUSING)

ITEM	COMMON	6509	12012	DO-70	FI-5109	DO-8510	DO-120	DESCRIPTION
	PART #'S	9012	D0-120	DO-100	FI-8507		DO-150	
A	001271							Base
B	001264							1" Lower Die
	001292							3/4" Lower Die
	001249							1/2" Lower Die
C	001170							Front Plate
D	001168							Side Frame
E	001162							1" Upper Die
	001190							3/4" Upper Die
	001150							1/2" Upper Die
F	001167							Ram
G	001163							Pressure Cap
H	073615							M-6 x 20 SHCS
I	073634							M-10 x 80 BHCS
J	160050							1/2 x 3-1/2 Die Spring
K	001166							Spring Guard
L	221005							M-6 x 12 SHCS
M	243101							M-6 Grease Nipple
N	073097							M-6 Washer
O	001165							Tube Stop
P	201232							M-10 x 80 HHCS
Q	212012							M-10 Lock Washer
R	221210							M-10 x 25 SHCS
S	221210							M-10 x 30 SHCS
T	210012							M-10 Jam Nut
U	219050							M-10 x 25 Set Screw
V	001169							Spring Block
W	001178							Tube Guide
X	221005							M-6 BHCS
Y	001216							Finger Clamps
Z			080835	080835	015205	025299	081205	Punch Pusher
AA			080220	016096	016096			#45 Punch Retaining Nut
BB	001293							Complete Picket Tool

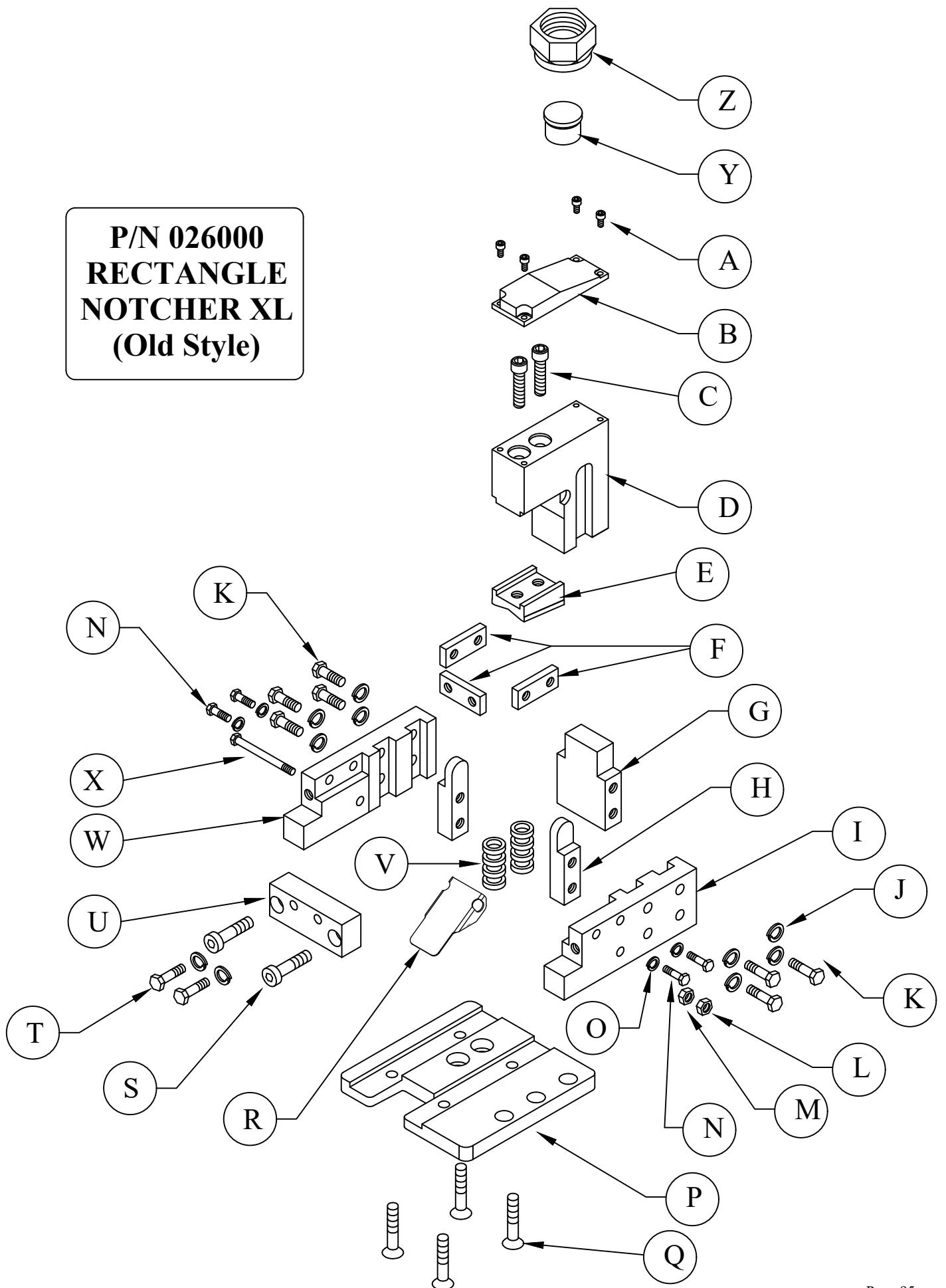


4.7 RECTANGLE NOTCHER XL - P/N 026000

NOTICE: Determine which Rectangle Notcher you have before ordering parts!!
P/N 026222 is our new style notcher and has a 1" thick base (#12).
P/N 026000 is our old style notcher and has a 3/4" thick base.

ITEM	COMMON PART #'S	6509 9012	12012	2450	DESCRIPTION
A	221005				M-16 SHCS
B	024012				Striker Cap
C	221320				M-12 x 50 SHCS
D	026003				Ram
E	026014				Upper Blade
F	026016				Lower Blade (3 Required)
G	026022				Cross Member
H	026024				Ram Guide (2 Required)
I	026005				Side Plate-Right
J	212014				M-12 Lock Washer
K	201415				M-12 x 40 HHCS
L	210012				M-10 Jam Nut
M	215012				M-10 Nylon Lock Nut
N	203212				M-10 x 30 HHCS
O	212012				M-10 Lock Washer
P	026008				Base
Q	230407				M-12 x 20 FSHCS
R	024020				Slug Ramp
S	221315				M-12 x 40 SHCS
T	201215				M-10 x 40 HHCS
U	026010				Blade Seat
V	160047				1 x 3 Die Spring
W	026006				Side Plate-Left
X	201250				M-10 x 130 HHCS
Y		N/A	080831	080831	Punch Pusher
Z		N/A	080220	016096	#45 Punch Retaining Nut
	003145				Label-Remove Tool (Not Pictured)
	026000	N/A			Complete Rectangle Notcher

**P/N 026000
RECTANGLE
NOTCHER XL
(Old Style)**

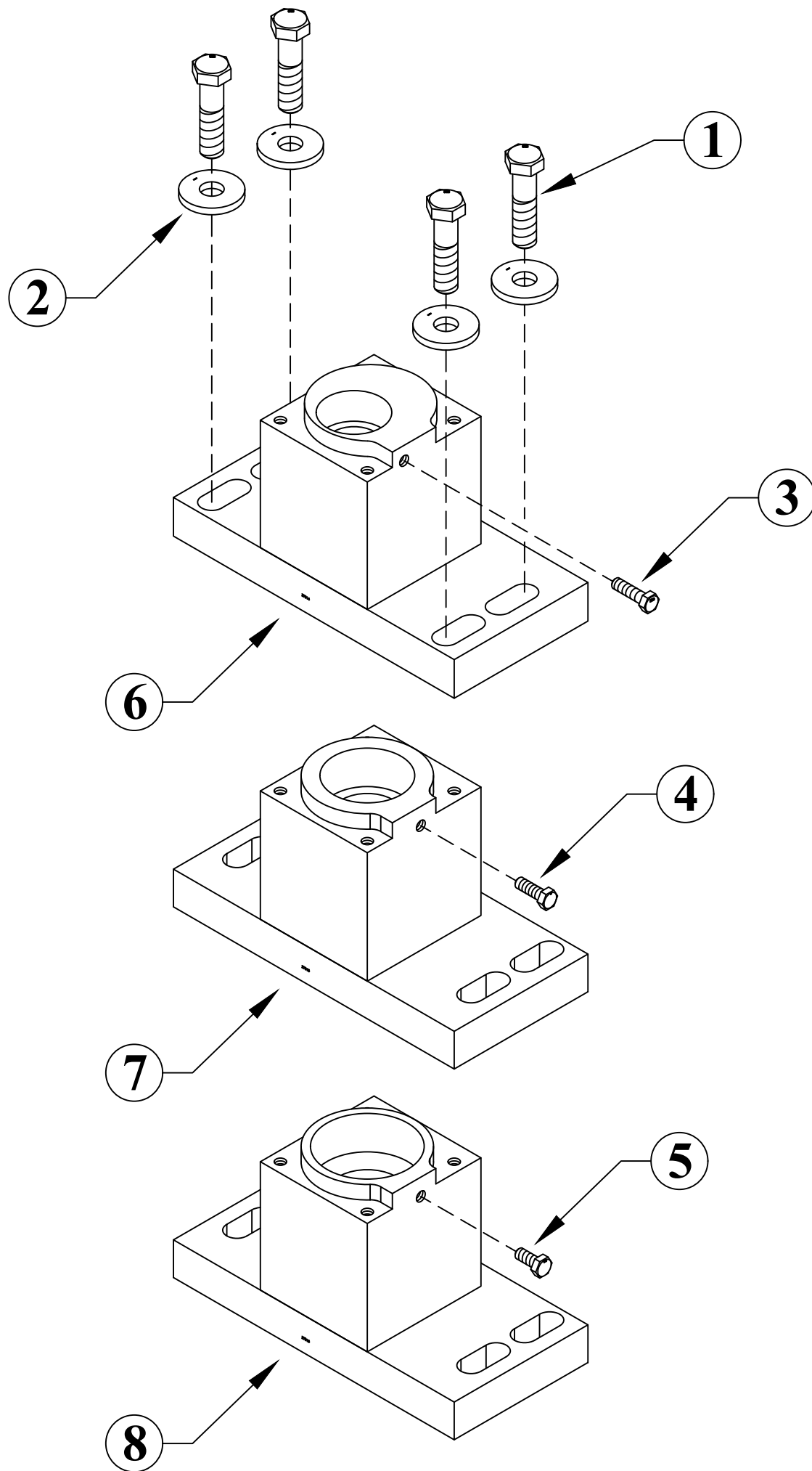


4.8 DIE HOLDER (DO-135 & DO-150 ONLY)

NOTE: For **DO-135 S/N 1040M AND PRIOR** and **DO-150 S/N 1176M AND PRIOR**

This is the solid, one piece die holder used on older DO-135 & DO-150 machines.

ITEM	QTY	PART #	DESCRIPTION
1	1	201625	M16 X 65MM DIN931 HHCS
2	1	113017	1 3/4 OD X 21/32 ID REID
3	1	203212	M10 X 30MM DIN933 HHCS
4	1	203210	M10 X 25MM DIN933 HHCS
5	1	201210	M10 X 20MM DIN933 HHCS
6	1	037014	2" DIE HOLDER
7	2	037015	2-1/2" DIE HOLDER 150
8	4	037016	3" DIE HOLDER 150



4.9 CONVEYOR SYSTEM

(See Sect. 2.19 for current conveyor system)

ITEM COMMON 6509 FI-5109 DO-8514-20 SM-610 DESCRIPTION

PART #'S 9012 FI-8507

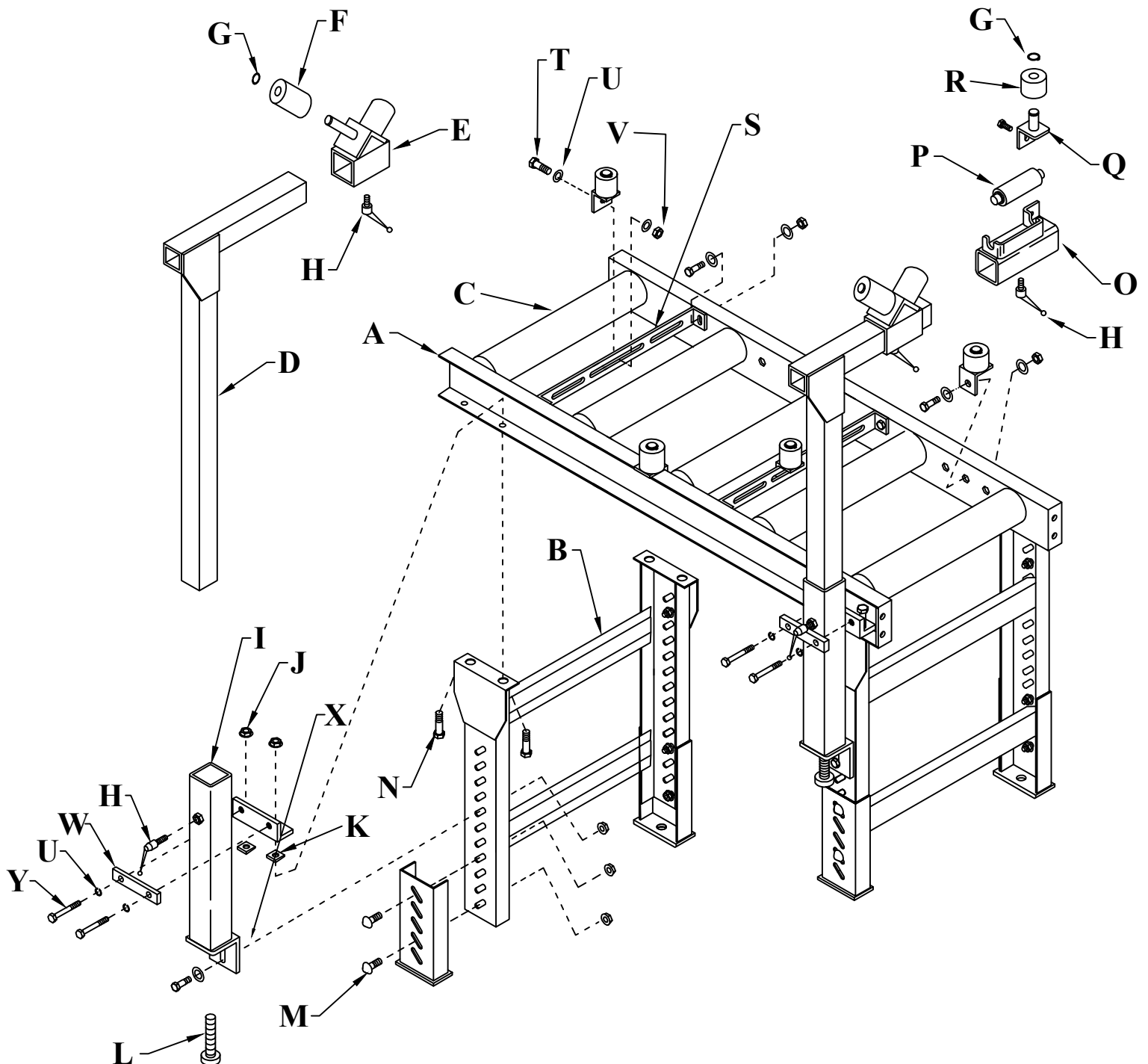
		12012 FI-8510		
		DO-70		
		DO-95		
		DO-120		
		DO-135		
		DO-150		
A		026972 026972	026971	Track Assembly
B		N/A		Leg Assembly
C		026905 026905	026975	026905 Rollers
D		026930 026930	026937	026930 Upper Bracket Ass'y
E		026941		V Guide Bracket
E1		026951		Complete V Guide Ass'y
F		026952		V Rollers
G	016402			3/4 Snap Ring
H	080061			Handle
I	026911			Sleeve
J	216015			M-10 Flange Nut
K	N/A			Wedge Washer
L	026920			Adjustment Bolt
M	228210			M-10 Carriage Bolt
N	203212			M-10 x 30 SHCS
O		026915	026915	026915 Bracket Assembly
O1		026923	026923	Roller Assembly
P		026919	026919	026919 Steel Roller
Q	026955			Bump Roller Mount
R	026962			Bump Roller
R1	026960			Bump Roller Assembly
S		026965	026969	026965 Bump Roller Mount
T	203210			M-10 x 20 SHCS
U	213012			M-10 Flat Washer
V	208012			M-10 Hex Nut
				026977 Leg Extensions (Not Pictured)
W	026939			Sleeve Brace

X
Y

026940
203235
026980 026997

026995

Mounting Bracket
M-10 x 90 HHCS
026976 Complete Conveyor



4.10 URETHANE STRIPPER (Old Style)

(See Sect. 2.27 for current urethane stripper)

ITEM	COMMON PART #							DESCRIPTION
		6509	9012	DO-70 DO-95	12012 DO-120 DO-135 DO-150	FI-85	DO-85	
1		025451	025451	025451	025452	025451	025441	Top Plate
2							025193	Punch Carrier
3								M-8 x 25 SHCS
4	025453							Post Nut
5	025443							Post Retainer
6	025455							Urethane Spring
7	025456							Spring Spacer
8	025454							Spring Post
9	025447							Stripper Plate
10	218056							M10 x 30 SS
11	025447	026038	026038	026039	026039	026037		Die Holder
12		006262	026042					Punch Bolster
13	025450							Lexan Shield
14	073691							Knob
15		026082	026082	026082	026082	026082	025441	Guard
16	660255							M-6 Drive Screw
17	003130							Stripper Warning
18		221329	221329	221329	221329	221329	221329	M-12 x 70 SHCS
19		026030	026030	026030	026032	026030	025475	Complete Unit
Retrofit Kits		026040	026060	026050	026070	026055		

