INSTRUCTION BOOKLET FOR

MOTORIZED SCRAP CUTTERS
MODEL#: 100, 300, 400

MANUFACTURERS OF COIL HANDLING EQUIPMENT
Durant Tool Company

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ATTENTION: PLANT MANAGER

Thank you for purchasing Durant equipment. Enclosed are very important safety instructions, operating instructions, and setup procedures.

Read all these materials completely and carefully. Please distribute copies to your SAFETY MANAGER, PRODUCTION MANAGER, and MACHINE OPERATORS.

If there is any help required in setup or operation, we will be readily available for your assistance.

Thank you again and we look forward to developing and maintaining a fine relationship with your company.

Sincerely,

DURANT TOOL COMPANY

SAFETY INSTRUCTIONS FOR ALL DURANT EQUIPMENT

The enclosed information and instructions must be forwarded and distributed to the Plant Safety Director, Plant Manager, Production Manager, and all Operators of Durant equipment.

Operators of Durant equipment must have a minimum of (3) three years operating experience with similar Durant press room equipment or a minimum of (3) three years experience with identical equipment manufactured by other press room equipment manufacturers.

WARNING

Never operate, install, or maintain this machine without understanding the complete and safe operation thereof.

It is the employer's responsibility to provide proper safety devices and equipment to safeguard the operator from harm and to safeguard this machine at all times to meet all current government safety codes and standards.

CAUTION

All Durant equipment must be securely fastened to the floor. This will prevent the machine from tipping. Failure to follow the above instructions could cause harm to the operator or machine.

ATTENTION

If any danger points are observed:

1. Immediately stop machine.
2. Do not run machine until danger point is eliminated.
3. Report danger point in writing to your employer.
4. Keep a copy of your report for your records.
5. Do not run machine again until danger point has been corrected.
6. It is your employer's responsibility to safeguard this machine to meet all government safety codes and standards.
7. There are U.S. companies that specifically specialize in safe guarding machines to plant requirements and government codes. The safe guarding companies are located throughout the United States, Canada, and foreign countries. Representatives will visit your site to advise and recommend safe guarding procedures for your company.

IMPORTANT

Before the first use and monthly thereafter, all nuts, screws, and bolts should be checked for tightness. Gears, sprockets, chains, and belts should also be checked for tightness.

Grease and oil fittings and reducers monthly.

OPERATING INSTRUCTION
MOTORIZED SCRAP CUTTERS

Durant Motorized Scrap Cutters are independent units that operate with their own motors. They are set up on legs supplied and operate at a constant speed.

On most applications it is essential that the scrap cutter run at a faster speed than does the power press. Our units are supplied at a standard speed of 120 strokes per minute or high speed models at a speed of 240 strokes per minute. For press speeds of up to 120 strokes per minute and feed lengths up to 4" the standard speed cutter normally does the most satisfactory job.

It is essential to mount the scrap cutter in a position so that there is a curvature of scrap coming from the feed or the die to take care of any speed differential between the press and the cutter.

For thin materials operating at high speeds "straight cut blades" can be supplied to allow material to pass through the cutter more readily without buckling. This is advantageous for feed lengths of more than 4". When this type of blade is supplied the thickness capacity of the cutter is decreased.

INSTALLATION INSTRUCTIONS

1. Mount cutter securely on the legs supplied. Insert chute guide supplied.
2. Place cutter in a position so that a natural curve of material is develped from the feed or press to the cutter.
3. Energize cutter so that it is running.
4. Start strip of scrap material into cutter.
5. Start power press and let scrap material feed into cutter. If necessary repositon cutter so that material feeds freely into chute of cutter.

ELECTRICAL INSTRUCTIONS

Wiring to meet local electrical codes as required. Wire connection to motor per motor manufacturer nameplate instruction.

NOTE: Because of OSHA restrictions we do not supply an electrical cord on these machines. It is necessary to wire the cutter properly to your electric circuit.

BLADE SHARPENING

Blades on Models #100 and #300 cutters are sharpened on the flat surface and packed to compensate for the material removed. On Model #400 the blades are sharpened on the edge and adjusted forward using a backup to compensate for the material removed.

TROUBLESHOOTING

1. Material not feeding into cutter - this condition is caused by the cutter not being in the correct position relative to the press.

2. Material not being cut by cutter - this is caused by dull blades or blades not being correctly adjusted. #100 and #300 blades are sharpened on the flat surface and packed up for proper clearance. Clearance should be from .003 to .004. On the #400 Scrap Cutter the blades are sharpened on the edge with the blade on the operating arm being adjustable by sliding forward and a spacer being inserted behind the blade. The thickness on these blades are ground so that there is from .003 to .004 between the blades.

3. If the blades on the #400 Scrap Cutter have too much clearance then the pivot bolt should be checked to be sure it is tight.

4. Overloading the Scrap Cutter by having too thick material, dull blades, improperly adjusted blades, etc., will result in damage to the Scrap Cutter. This usually results in the cast iron arm breaking. This arm is purposely made of cast iron so that it will break and prevent breaking of the frame or stripping the gear reducer.