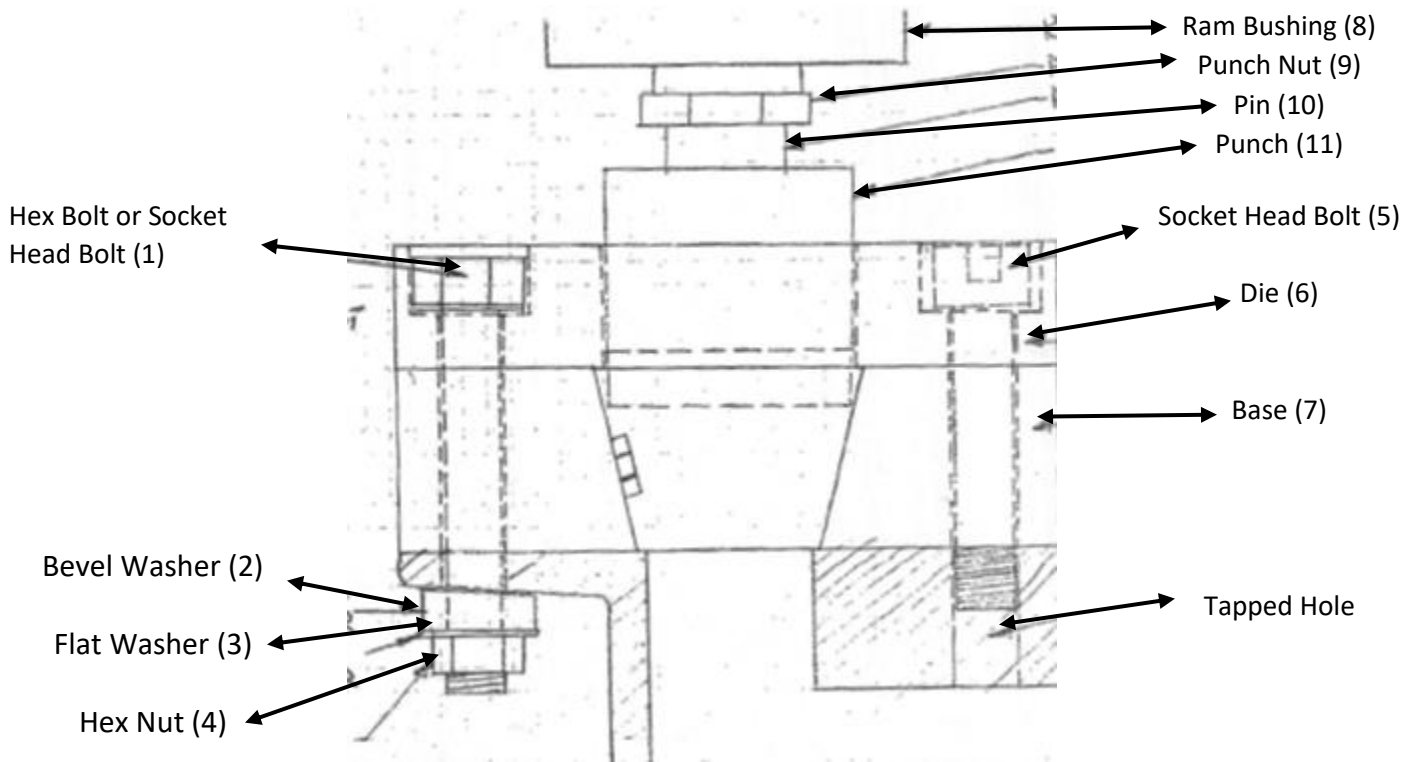


Heavy Duty Notcher Assembly Instructions

(Reference the assembly manual provided with the ironworker)

1. Remove the die holder from the **MP4000/MP4500FS** punch station.
2. Remove the punch nut.
3. Assemble the punch nut to the notcher pin. Insert the pin into the hole in the notcher punch with the flat positioned toward the set screw. Tighten the set screw.
4. Loosen the pin/punch assembly, the die, and the base. Make sure the punch moves freely through the die.
5. Thread the punch nut on the pin/punch assembly into the ram and hand tighten.
6. Slide the die over the punch and locate the base underneath the die. **IMPORTANT** – the “V” shape is upright, not inverted. The “V” is “open” as viewed from the power cavity of the **MP4000** or the punch station end of the **MP4500FS**.
7. Loosely fasten the die and base the ironworker using the hex bolts and hex nuts on the **MP4000** or with socket head bolts on the **MP4500FS** as shown.
8. Tighten the punch nut into the ram. Tighten the bolts holding the die and base to the ironworker making sure the punch is free to move, not wedged or cocked.
9. Operate the ironworker slowly to ensure that the punch moves freely in the die and base with no binding or interference.



MP4000

View from Power Cavity

MP4500FS

View from Punch Station End

Item	Part#	Description
1	7208	½-13 x3-1/2" Hex or Socket Head Screw
2	5021	½" Bevel Washer
3	5012	½" Flat Washer
4	5067	½-13 Hex Nut
5	7209	½-13 x 2-1/2" Socket Head Screw
6	7203	Notcher Die

Item	Part #	Description
7	7204	Notcher Base
8	5003	Ram Bushing
9	5006	Punch Nut
10	7201	Notcher Rod (Pin)
11	7202	Notcher Punch