

TIN KNOCKER TK GANG SLITTER

INSTRUCTIONS & PARTS DIAGRAM



TAAG INDUSTRIES CORP.
1550 SIMPSON WAY, ESCONDIDO, CA 92029
Tel: (800) 640-0746 Fax: (760) 727-9948
Website: www.tinknocker.com Email: info@taagind.com

SAFETY RULES TK GANG SLITTER

1. **WARNING:**

Electrical Danger---Misuse or improper installation of machinery connected to a source of electricity may result in accidental shock that could cause injury or death. Installation must conform to National Electric Code (Article 250-Grounding, etc.)

A trained and qualified electrician must make electrical connections. Electrical characteristics shown on motor plate and control panel must match the power source; and all electrically powered equipment must be grounded.

2. **WARNING:**

Mechanical Danger- The cutting blades of the Slitter rotate at all times when power is supplied to the motor. Never place any part of the body including loose clothing near or onto the rotating rolls (KEEP HANDS AWAY). Failure to comply will lead to personal body injury. Do not exceed the work-piece material capacity – otherwise serious damage will occur to your Slitter.

3. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual.
4. Do not operate Slitter without reading Operator's Manual and without proper supervisory instructions.
5. Perform all installation and set-up operations before applying power for electrical start-up.
6. Never operate machine with any guard removed; i.e., all required guarding to be installed and effective. Do not override the safety features of the equipment. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
7. Never leave machine running unattended. When not in use, turn off electrical power.
8. Never adjust machine with power on.
9. Avoid accidental start-up.
10. Do not use machine if servicing is required.
11. Use safety glasses and required protective tools.
12. Keep work areas clean and in proper order.
13. Be alert to all potential hazards. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.

The TK Gang Slitter

STANDARD:

- Adjustable entry guide
- Scale on the exit guard for ease of setup
- Quieter gearbox and motor
- Cleaner look of the end housings, legs integrated into them for more stability on your shop floor
- Stripper Rings come standard on this slitter and is beneficial for light gauge pre-painted material

INTRODUCTION:

To simplify the machine set up and to maintain proper operating, the following recommended set up steps have been outlined. Please read these carefully.

Once positioned and ready to operate, remove the rust protective spray that was applied at the factory. You are now ready to hook power to the machine.

These machines are 110 Volts as a standard and will have a standard plug.

MACHINE CAPACITY:

Going over the machine capacity can cause the machine to not cut the material. This is caused by deflection of the arbors. Below is a chart of the rated machine capacities.

THICKNESS

GA.	IN.	MM.	TK GANG SLITTER
31	.010	.25	20
30	.015"	.38	12
28	.18"	.45	8
26	.021"	.53	6
24	.027"	.68	4
22	.033"	.83	4
20	.039"	.99	3
18	.051"	1.2	2
16	.0063"	1.6	1

KNIFE SET UP:

You will need to set the knives for the size cuts required. The knives are equipped with a setscrew and gib key arrangement that locks it to the shaft. To make an adjustment use the "T" Handled Allen Wrench to loosen these setscrews and slide the knives in the position required. This position is determined by measuring from the sheet gauge to the cutting edge of the knife. Once the placement of the knife has been determined, secure the setscrews by alternately snugging (NOT TIGHTENING) up each setscrew. Move the mating knife to this knife and set the proper clearance between the knives. Set the remaining knives up in the same manner. Once this is done, jog the machine at several revolutions, and then snug them up a second time to help prevent "twisting" the knife. You should do this a few times until all the tooling is tight. (Be careful NOT to over tighten as this will twist the knives and cause the blades to ride up over one another and destroy the edges requiring re-sharpening or replacement of the knives).

Use this chart to set the proper horizontal clearance:

STOCK THICKNESS	CLEARANCE
.006 AND UNDER	NO CLEARANCE
.006" - .010"	.0005" TO .00075"
.010" - .018"	.00075" - .001
.020" AND OVER	8% OF STOCK THICKNESS

To obtain satisfactory results with any slitting machine it is vital that the horizontal clearances be properly set. Final clearance adjustments are best determined by making test runs with the actual material to be slit. However, these settings have proven to be fairly accurate.

Allowance should be made for deflection of the arbors, which occurs due to the thickness and type of material being cut.

Note: Softer materials may need less side clearance and harder materials may need more side clearance.

Parts for TK Gang Slitter

Fine No.	Part No.	Description	No. REQ'D.
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WARRANTY

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: 1. This machine has been tested and adjusted prior to shipment but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you

will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you. Call us at: (800) 640-0746.

2. Opening rolls (for Philipsburg Lock) are consumable items and not subject to warranty.

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