

RAPID-AIR STOCK CUTTER OPERATING INSTRUCTIONS

<u>MODEL</u>	<u>MAXIMUM MATERIAL WIDTH</u>	<u>DIRECT FEED MOUNTING</u>	<u>BLADE OPENING</u>
FSC-4	4"	C & D	.15"
FSC-6	6"	D, W & F	.18"
FSC-8	8	F & H	.09"
FSC-12	12"	H, J, FX & L	.10"
FSC-18	18"	FEED MTD. SEPARATE	.18"
FSC-24	24"	FEED MTD. SEPARATE	.09"

Flat stock cutters 4" thru 12" allow Rapid-Air feeds to be mounted directly to them. These cutters are also available with short bases and or prox. switches for positive "blade up" signal.

The cutter is a pneumatic unit designed to operate safely up to 150 psi. Air pressure of 80-120 psi and adequate volume are important for function. Shop air, filtered and lightly lubricated is plumbed directly into the pipe tapped port at cutter top. The cutter operates by air pressure down, spring return. Energize 110 vac solenoid valve for cut de-energize for return. The cutter head has a built in quick exhaust and muffler for fastest cycle time.

Different thickness of material will require valve to be energized more or less time. For example; .010 thick material allows valve to be energized less than .030 thick material. This allows tuning for maximum speed.

Blade adjustment – The upper blade may be lowered manually with the eccentric cam located at the top center of the cutter. The purpose for this manual operation is for horizontal blade clearance adjustment. Blade clearance affects the quality of the cut. The cutter is shipped with the blade clearance set at the factory. To adjust blade clearance:

1. Cam upper blade down.
2. Loosen lower blade holder lock screws.
3. Move lower blade in or out with knurled knobs.
4. When desired clearance is achieved, lock lower blade holder screws.
5. Check cut by manually cutting bond paper.

Each blade has four cutting edges. The upper blade is mounted with a 2-degree shear angle. When blade dulls, rotate 90 degrees for sharp edge. When all four edges have been used, flat grind the large faces on both sides of the blade.

FSC18 & FSC-24 Cutters

The 18" and 24" cutters have a selector switch for high or low cutting force. This is an air economy feature. The 18" and 24" cutters have interlock that disables the air circuit if guard is removed.

Outline drawing of FSC-4 and FSC-24 cutter is provided for reference.