

# HAFCO



**Tube Capacity**  
Ø19~50mm



**Pipe Capacity**  
Ø1-1/2"



**Adjustable**  
**Cutting Angle up to 60°**



**Suits Hole Saw Threads**  
1/2" x 20TPI & 5/8" x 18TPI



Edition : 1.0  
Date: (21/05/24)

## Instruction Manual

# PIPE & TUBE NOTCHER ATTACHMENT PN-50D

Order Code: (P090)

## SPECIFICATION

Order Code	P090
<b>MODEL</b>	<b>PN-50D</b>
Machine (Type)	Pipe & Tube Notcher
Notching Cutter (Type)	Hole Saw (Optional)
Tube Capacity (OD) - Mild Steel (mm)	Ø19.05 ~ Ø50.8
Pipe Capacity (NB) - Mild Steel (Inch / mm)	Ø1-1/2"
Angle Adjustment (degree)	0 ~ 60°
Hole Saw Mounting Thread (Inch)	1/2" x 20TPI, 5/8" x 18TPI

## SAVE THIS MANUAL

You will need this manual for the safety warnings and precautions, assembly instructions, operating and maintenance procedures, parts list and diagram. Keep your invoice with this manual. Write the invoice number on the inside of the front cover. Keep the manual and invoice in a safe and dry place for future reference.

## SAFETY WARNINGS AND PRECAUTIONS

**WARNING:** When using this tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage.

**Read all instructions before using this tool!**

- 1. Keep the work area clean.** Remove any slip or trip items in the work area.
- 2. Observe work area conditions.** Do not use machines or power tools in damp or wet locations. Don't expose to rain. Keep work area well lite. Do not use electric powered tools in the presence of flammable gases or liquids.
- 3. Keep children away.** Children must never be allowed in the work area. Do not let them handle the machines, tools, or extension cords.
- 4. Store idle equipment.** When not in use, tools must be stored in a dry location and coated with light oil to prevent rust. Always lock up tools and keep them out of reach of children.
- 5. Do not force the tool.** It will do the job better and more safely at the rate for which it was intended. Do not use inappropriate attachments in an attempt to exceed the tool capacity.
- 6. Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. Do not modify this tool and do not use this tool for a purpose for which it was not intended.

## SAFETY WARNINGS AND PRECAUTIONS

- 7. Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
- 8. Use eye and ear protection.** Always wear ANSI approved impact safety goggles. Wear a full face shield if you are producing metal filings or wood chips. Wear an ANSI approved dust mask or respirator when working around metal, wood, and chemical dusts and mists.
- 9. Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines. Keep hands and fingers clear of moving parts when operating.
- 10. Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and, if damaged, have them repaired by an authorized technician. Handles must be kept clean, dry, and free from oil and grease at all times.
- 11. Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before plugging it in.
- 12. Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- 13. Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment and binding of moving parts; any broken parts or mounting fixtures; and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician. Do not use the tool if any switch does not turn on and off properly.
- 14. Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool.
- 15. Do not operate tool** if under the influence of alcohol or drugs. Read warning labels if taking prescription medicine to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.
- 16. Maintenance.** For your safety, service and maintenance should be performed regularly by a qualified technician.
- 17. Workpiece may be sharp.** After bending or cutting workpieces use caution. Be aware of sharp edges or sharp shreds of metal that may be created. Use heavy duty gloves when handling the workpiece.



### **CAUTION**

*It is impossible to cover all possible safety guidelines. Every workshop environment is different. Always consider safety first, as it applies to the individual working conditions. Always use this and any other machinery with caution and respect. Failure to do so could result in, serious personal injury or. damage to equipment*

## FEATURES

1. This precision Pipe/Tube Notcher is a useful fixture for your drill press, allowing you to make round cuts in pipes and tubing of various shapes at any angle from 0° to 45° .
2. Sturdy and durable steel frame holds your workpieces rigid during operation.
3. Adjustable Angle Joint Plate (17#) is adaptable to any worktable, and is especially suited to be mounted on a drill press.
4. The Adjustable Angle Joint Plate (17#) may be swiveled and rotated, which in conjunction with the adjustable holder makes cutting compound angles very easy.
5. Works with any standard drill press, and is adaptable to use a large variety of round cutters, hole saws, and milling bits.

**WARNING: When using this Pipe/Tube Notcher with any powered tool, observe all safety precautions relevant to that equipment. Refer to the owner's manual of the power equipment for safe practices in the use of attachments.**

## UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

**NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.**

## ASSEMBLY

1. The Spindle (7#) is shipped in the reverse position. Remove it and re-insert it in the correct position prior to using the tool.
2. Your Pipe/Tube Notcher must be mounted to your drill press table, using the adjustable angle joint plate (17#) Depending on the configuration of your drill press table, you may use T-bolts, carriage bolts, or machine bolts, washers and nuts. (Hardware not supplied.)
3. After mounting, be sure that the Spindle (7#) travels smoothly without binding against the Bushings (5#). Any undue friction will cause excessive wear of the Bushings (5#).
4. The angle of the Pipe/Tube Notcher can be adjusted by loosening the Bolts (16#) that adjust the Adjustable Angle Joint Plate (17#), and moving the Assembly as necessary.
5. For side to side adjustments, adjust the Bolts (15#) that hold the Adjustable Angle Joint Plate (17#) to the Body (13#).
6. When installing the hole saw, check first to see if its arbor is 1/2" or 5/8". The thread on the spindle is for 1/2", however, there is a Hole Saw Adapter (3#) for 5/8" thread that can be screwed on over the 1/2" thread. You may need to use the Hole Saw Adapter Washer (4#) to assure a good, secure fit.
7. To install a saw blade or bit, first fix the Spindle (7#) in place with the Locking Pin (14#). Do not use locking pliers or clamps to hold the Spindle (7#), as this will cause damage. Slide the Locking Pin (14#) through the hole in the side of the Spindle Support (6#) and through the Spindle (7#). Install the blade, then remove the Locking Pin (14#).

**WARNING: Make sure the Locking Pin (14#) is removed prior to engaging the drill.**

## OPERATION

1. Insert the tubing you wish to cut in the Clamp Assembly (#1), underneath the inverted “V”. The inverted “V” feature of the clamp will hold your tubing (up to 2” long) in place. Do not insert the tubing more than half of its length. When cutting in severe angles, only insert the tubing far enough to start the cut. Secure the tubing in place using the Handle (#2).
2. Screw desired hole saw onto shaft. Refer to Fig. 1 & Fig. 2 depending on your hole saw thread size 1/2” or 5/8”. Attach the Adaptor (#7) if using larger 5/8” cutters.
3. Set the speed of your drill press to approximately 500rpm for most materials. When cutting thin wall, hard alloy tubing such as chrome-molly, higher speeds will be required. When cutting softer, coarser materials, use slower speeds.



**NOTE: Practice on scrap material before making cuts on your work material.**

4. As you work, lubricate hole saw with cutting oil for smooth running & to lengthen hole saw life.
5. When doing severe angle cuts with large diameter tubing, you will need to put the Spindle Support (#6) in its uppermost position in order to accommodate its size. However, you should always position the Spindle Support (6#) as low as possible to preserve accuracy. To move the Spindle Support (6#), simply loosen the two Bolts (9#) that affix it to the Body (#8) reposition and secure the Bolts (#9).
6. To adjust the angle of the clamp, loosen the Bolts (10#) that secure it to the Body (#8), proceed to the desired angle on the Angle Indicator, and re tighten the Bolts (#10).
7. When the tube is clamped in the Pipe/Tube Notcher and the angle is properly set, you can proceed to cut the workpiece.
8. To remove the blade or bit, shut off the drill press & unplug power, use tools to remove the bit.

### SETUP for 1/2” Hole Saw Cutters

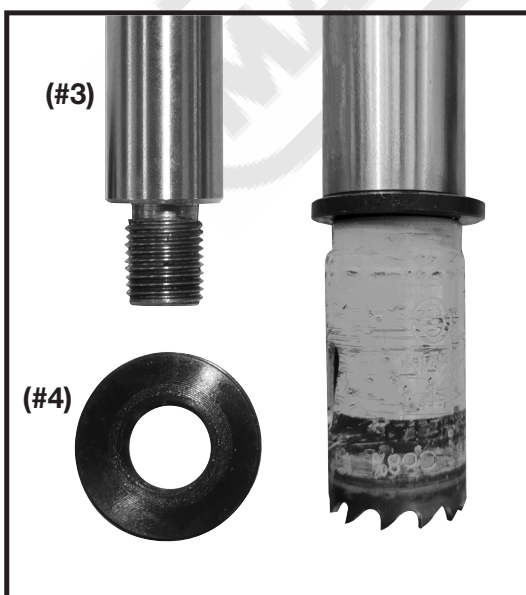


Fig. 1

### SETUP for 5/8” Hole Saw Cutters

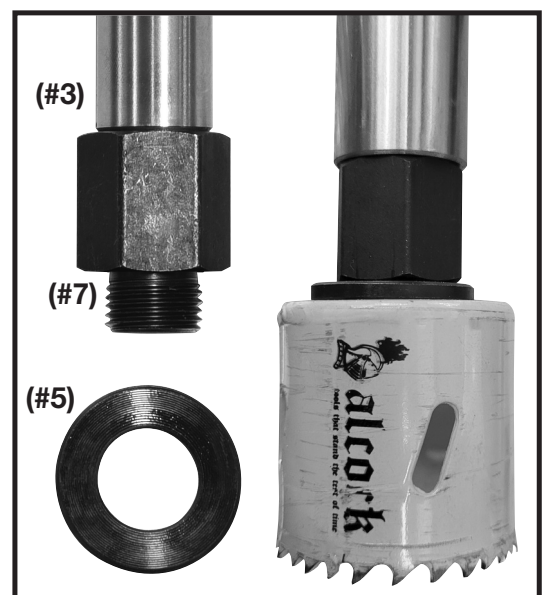
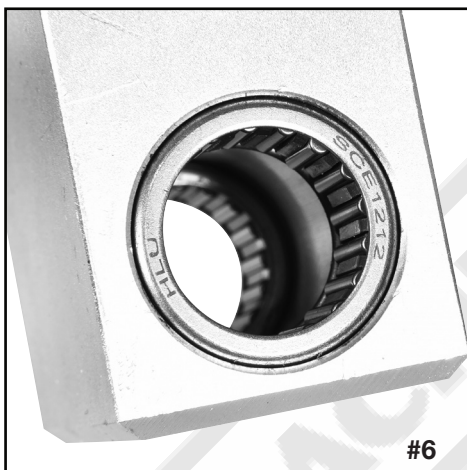


Fig. 2

## MAINTENANCE

1. Please observe good shop practices for your safety and to extend the work life of your tools.
2. Periodically brush away cuttings and debris from the Pipe/Tube Notcher, especially the bushings and spindle area to avoid scoring or binding these components.
3. Use a suitable light grease on the bushings to prevent overheating and wear.
4. When cutting metal tubes, use plenty of cutting fluid to prevent tool or material overheating, and to remove cuttings from the work area.
5. Be sure to carefully align the drill press spindle and the Pipe/Tube Notcher spindle to prevent binding.
6. After use, clean the Pipe/Tube Notcher, and apply a light lubrication to all moving parts and unpainted metal to prevent rust.
7. Remove the spindle (#3) from the spindle support (#6) when moving or storing.
8. Store the Pipe/Tube Notcher covered and in a dry, dust free place.
9. Help avoid injury by preventing access to this tool by unauthorized persons and children.



*Apply a light lubrication to all moving parts*



# SPARE PARTS SECTION

## PIPE & TUBE NOTCHER ATTACHMENT

**Model. PN-50D**

Order Code P090

DATE OF ISSUE : 5/2024

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

### HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine.
2. A scanned copy of your parts list/diagram with required spare part/s identified.

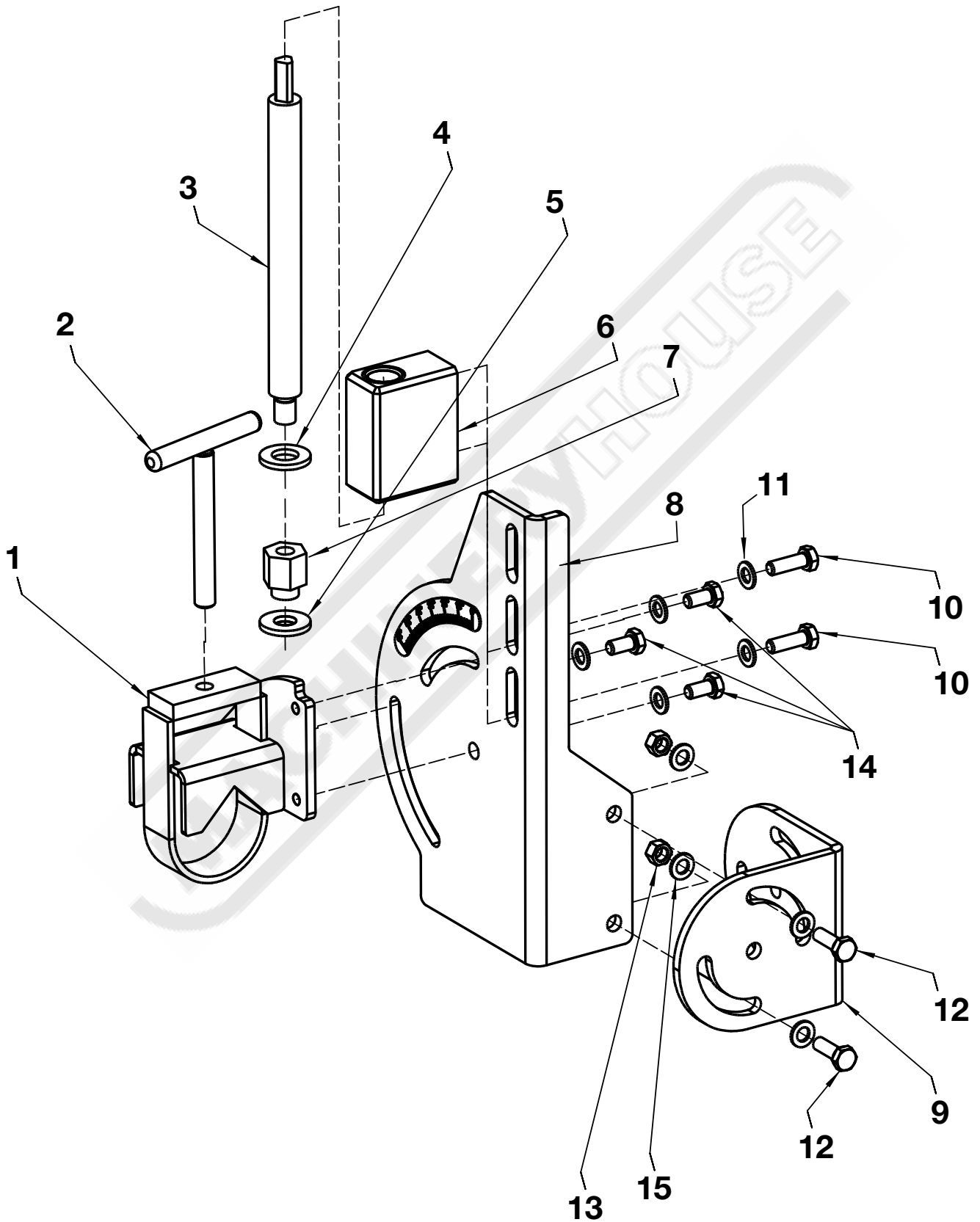
***NOTE: SOME PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY***

3. Go to [www.machineryhouse.com.au/contactus](http://www.machineryhouse.com.au/contactus) and fill out the inquiry form attaching a copy of scanned parts list.

### **Please read the following carefully**

The manufacturer and distributor have provided the parts diagram in this manual as a reference tool only. The manufacturer and distributor expressly state that all repairs and parts replacement must be undertaken by a qualified service technician and not by the buyer. The buyer assumes all risk and liability arising from repairs and parts carried out by the buyer. The manufacturer or the distributor reserve the right to void warranty of the product if non standard parts have been used or repairs carried out incorrectly.

## SPARE PARTS DIAGRAM





**PARTS LIST**

<b>Item</b>	<b>Description</b>	<b>Qty.</b>
1	Clamp Assembly	1
2	Handle	1
3	Spindle	1
4	Hole Saw Adapter Washer (1/2")	1
5	Hole Saw Adapter Washer (5/8")	1
6	Spindle Support	1
7	Hole Saw Adapter	1
8	Body	1
9	Adjustable Angle Joint Plate	1
10	M10 x 20mm Bolt	2
11	M10 Washer	2
12	M8 x 25mm Bolt	2
13	M8 Nut	2
14	M8 x 16mm Bolt	3
15	M8 Washer	7

**NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY**

# WARNING

## General Machinery Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.

# WARNING

## Manual Notching Machine Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure all moving parts are locked down before any inspection, adjustment or maintenance is carried out. Place a block of timber between the blades to save blades from shearing hands or fingers.
- 2. Notcher Condition.** Notcher must be maintained for a proper working condition. Never operate a Notcher that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Blade Condition.** Never operate a Notcher with a damaged or badly worn blades. Replace if required.
- 4. Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur if hand or finger tips come between blades.
- 5. Personal Protection.** Gloves are recommended when handling the workpieces.
- 6. Authorized and trained personnel.** The machine must be operated by authorized and trained personnel. The shear is designed to be operated by a single user. Using the machine with more than one operator is forbidden, except for certain maintenance situations.
- 7. Work area hazards.** Keep the area around the Notcher clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents. The working area of the machine must be properly lit up.
- 8. Guards.** Do not operate Notcher without the correct guards in place. Necessary guards protect you from injuries by the shear blades & moving parts.
- 9. Material.** Do NOT shear granular, hydrous or over-capacity sheet pieces. Also do not attempt to shear more than one workpiece one over another.
- 10. Shearing .** Do NOT operate the machine without proper blade gap adjustment according to sheet thickness. Lubricate blade edges by thin oil prior to cutting.
- 11. Operation.** During the shearing process, the workpiece may slide or move unexpectedly. Therefore, the material must be handled carefully.
- 12. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 13. Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.
- 14. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

# PLANT SAFETY PROGRAM

## **NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL**

### **Manual Notching Machine**

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures  
 This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace ( WHSA 2011 No10 )

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
B	CRUSHING	LOW	Secure & support work material on table.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts.
D	SHEARING	MEDIUM	Hands should be kept clear of blade. Ensure guards are secured properly.
F	STRIKING	MEDIUM	Ensure material hold downs are correctly adjusted. Wear safety glasses.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.


Plant Safety Program to be read in conjunction with manufactures instructions



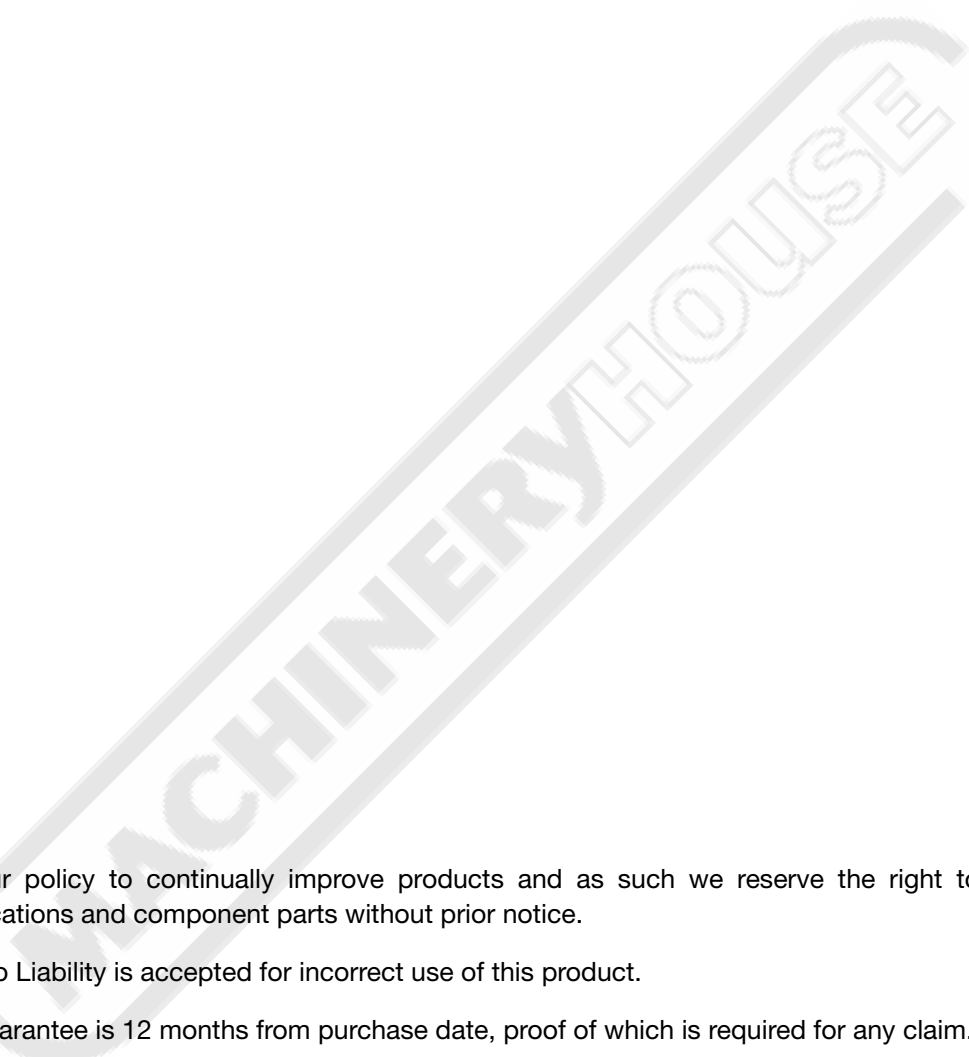
[www.machineryhouse.com.au](http://www.machineryhouse.com.au)



[www.machineryhouse.co.nz](http://www.machineryhouse.co.nz)

Authorised and signed by:  
 Safety officer: .....  
 Manager:  .....

Revised Date: 12th March 2012



**Note:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**Important:** No Liability is accepted for incorrect use of this product.

**Warranty:** Guarantee is 12 months from purchase date, proof of which is required for any claim.

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