



## TUBE NOTCHER P/N TN1000

### WARNING

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1. Always pay close attention to what you are doing. Turn off cell phone, pager, etc when using this machine.
2. This machine is meant to be operated by competent individuals who have a thorough understanding of tube notchers and machines in general.
3. Always wear eye protection while operating tube notcher.
4. Never put your hands or other body parts into tube notcher apparatus.
5. Never wear loose clothing while operating tube notcher.
6. Always work in a clean, safe, well lit, level work area.
7. Never use the wrong hole saw for the material being worked.
8. Never operate the tube notcher with broken, worn or damaged parts.
9. DO NOT attempt to repair and reuse any damaged tube notcher parts.
10. User assumes all risks when using this product.
11. Properly clamp the material to be notched in the tube vise. DO NOT use shims/spacers on the material. Accuracy of the notch and stability of the material in the vise could be affected.

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## OVERALL

1. Figure 1 is an overall view of the tube notcher.
2. For ease of shipment, the tube notcher is shipped with the tube vise rotated 180° and locked at that position. See Figure 2.

## MOUNTING

3. To mount the tube notcher on a work surface/stand, the tube vise must be removed from the base.
4. Remove the four 3/8" Allen bolts from the bottom of the tube vise.

### CAUTION

**DO NOT clamp the base of the notcher in vise.  
Clamp only using the optional mounting block. See Figure 3.**

5. Mount the tube notcher base. The tube notcher can be mounted on a work surface using the three 3/8-16 bolts in the base as shown in Figure 3.

### NOTE

If the tube notcher is mounted directly to a work surface, access to the tube vise positioning bolts will be limited.

6. The tube notcher may also be mounted using the optional mounting block which can be welded to a stand (or similar) and mounted using three 5/16-18 bolts as shown in Figure 3.
7. A mounting kit (NMT100) or a complete stand (NS100) is available separately thru JMR Manufacturing to mount the notcher.

## OPERATION OF THE TUBE NOTCHER

8. To position the tube vise to the proper notch angle:
  - Loosen the large nut on the bottom of the tube notcher.
  - Rotate the tube vise to the desired position using the protractor on the cutter head base. See Figure 2.
  - Tighten the large nut on the bottom of the tube notcher.

### NOTE

Always move the cutter towards the tube vice for the best performance of the hole saw and the tube notcher. See Figure 2.

4. Mount the desired hole saw on the end on the cutter shaft. The tube notcher is supplied with two adapters, one for saws that mount using a 1/2-20 adapter and one 5/8-18 adapter.

5. Make sure that no more than one or two threads are showing on the inside of the hole saw. See Figure 4.
6. Pass tube into tube vise and position as required for notch and tighten the tube vise on the material.
7. Mount a 1/2" drive drill motor on the cutter shaft.
8. Follow the hole saw manufacturer's recommendation on the use of cutting/cooling fluids.

## **WARRANTY**

1. One year limited warranty on tube notcher.
2. Warranty item must be sent to JMR Manufacturing postage pre-paid for inspection. JMR Manufacturing will replace or repair item at their discretion.
3. JMR Manufacturing makes every attempt to satisfy customers as quickly as possible.
4. JMR Manufacturing will not accept any responsibility for personal injury or property damage arising from the failure of any parts manufactured and/or sold by JMR Manufacturing, LLC.

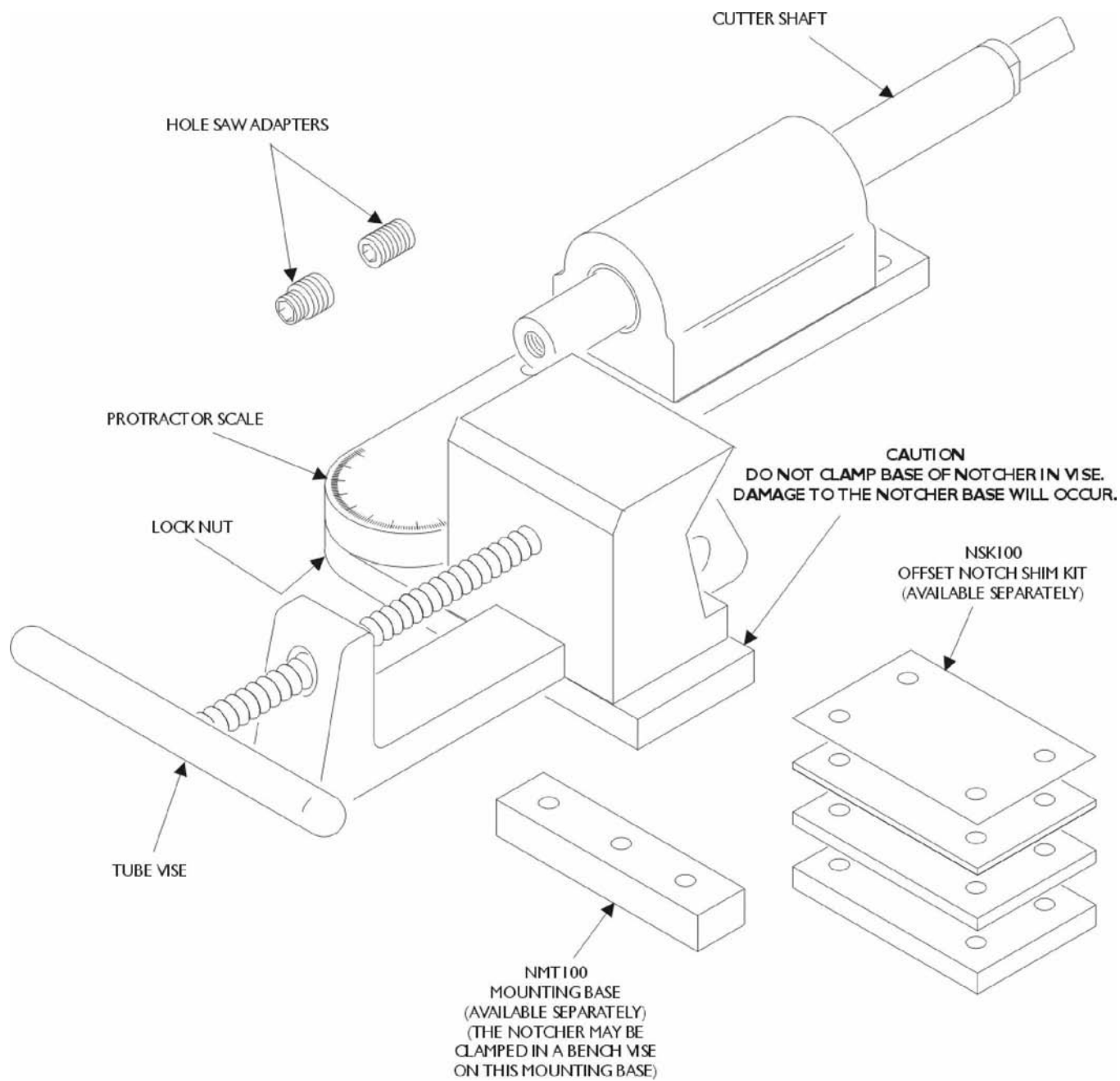
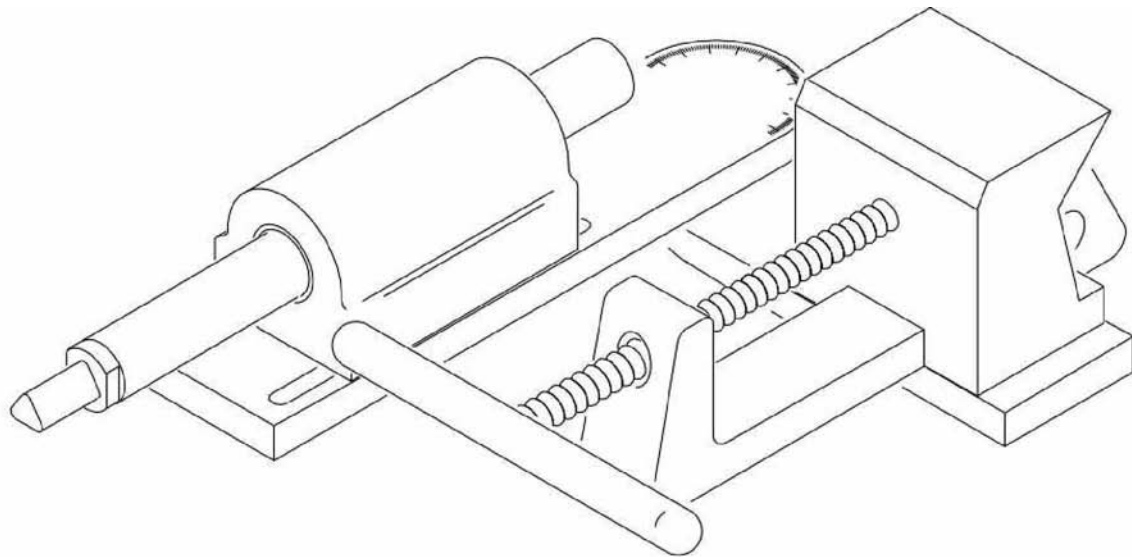
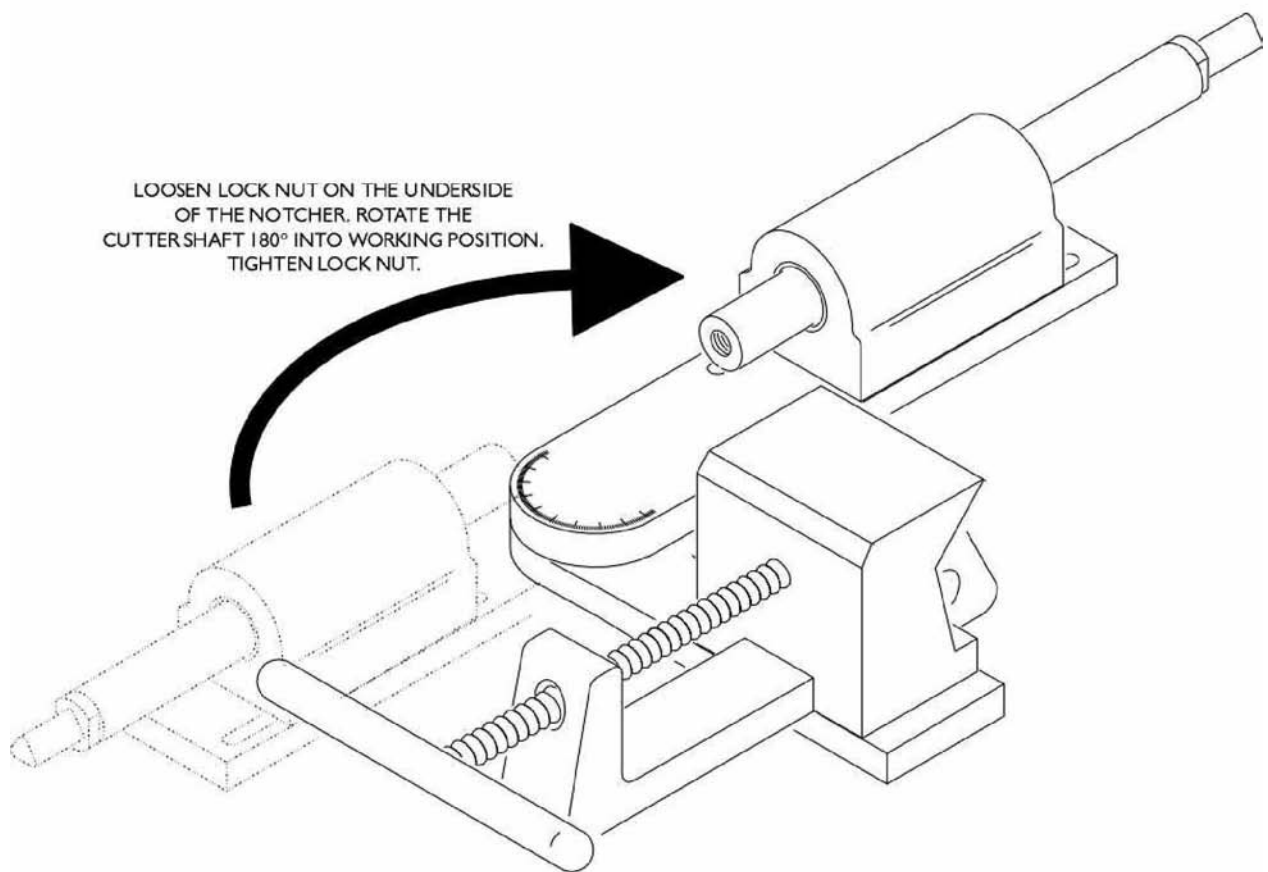


Figure 1. Tube Notcher overall view.



SHIPPING CONFIGURATION



WORKING CONFIGURATION

Figure 2. Tube Notcher shipping and working configuration.

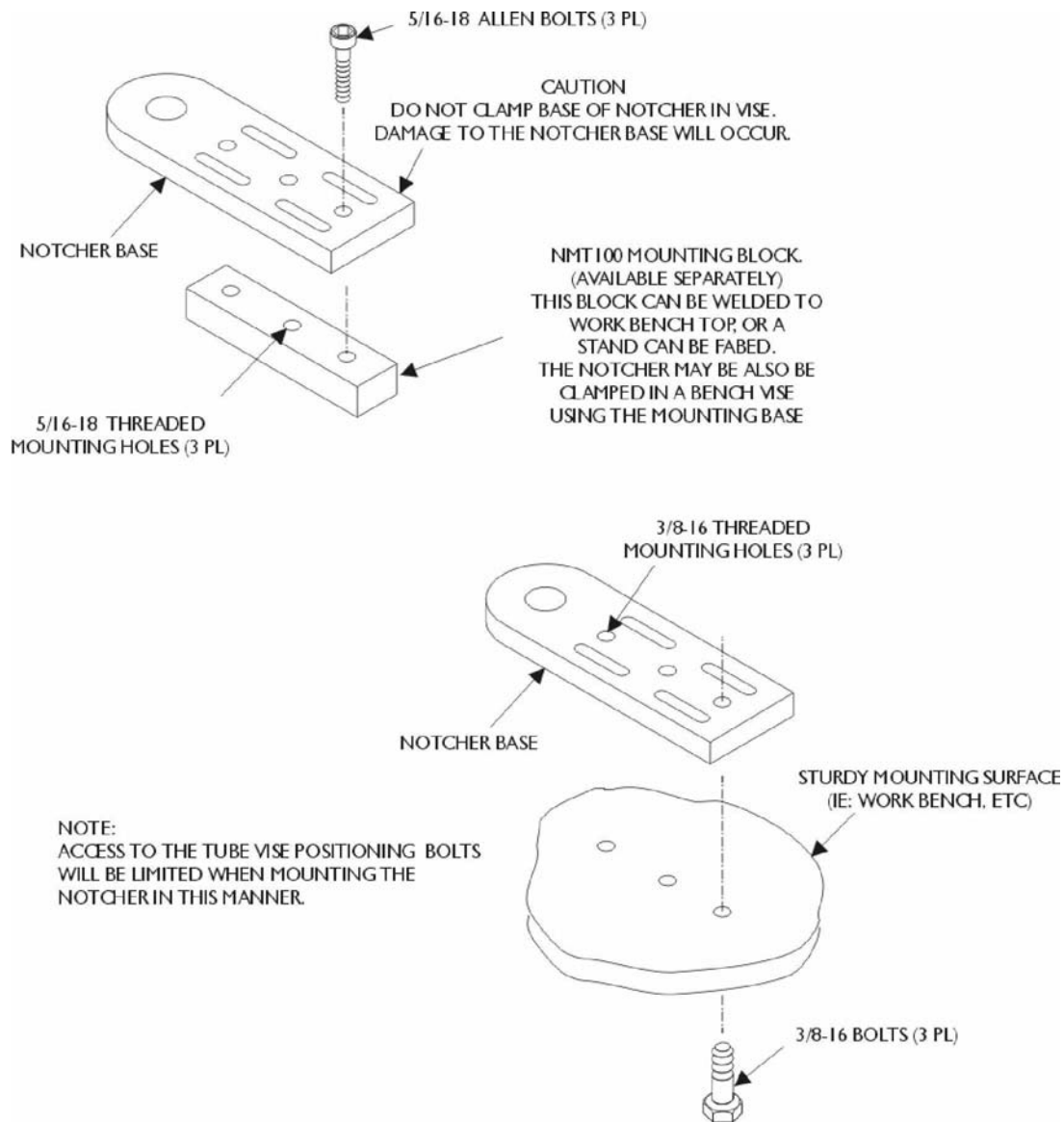


Figure 3. Tube Notcher mounting.

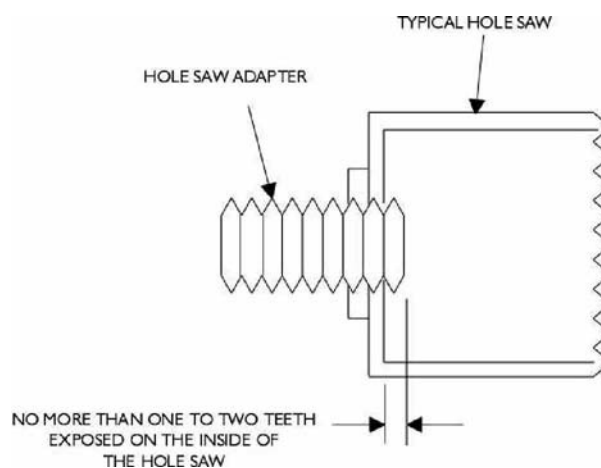


Figure 4. Hole saw mounting.