

Instructions



**or THE INSTALLATION
AND OPERATION
OF THE PMC
DIE CUTTING MACHINE
AND
PARTS LIST**

for Style "B" and Style "C" Machines

PMC PRINTING MACHINERY DIVISION

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The PMC Die Cutting Machine

offers production possibilities in the die cutting of labels and similar printed products, and small books and pamphlets, that are not possible with any other equipment. To obtain the greatest capacity from the PMC Die Cutting Machine it is necessary that certain preparatory steps be taken in the planning of the printed product which is to be die cut on the PMC Die Cutting Machine. The information in the balance of this instruction book will give suggestions for the preparation of the printing form regardless of the process so that the maximum results will be obtained in the most efficient manner. It must be remembered that the product to be die cut is fed into the machine against guides that have been set for a particular job. The machine will not die cut any more accurately than the printed product has been square cut.

The high production of the machine offsets the extra time required for square cutting the individual stacks of labels.

It is recommended that the purchaser of a PMC Die Cutting Machine immediately make preparations in his printing plates to facilitate accurate square cutting. Labels that are to be die cut on the Style "B" PMC Die Cutting Machine must be square cut first into individual stacks not over 2" high. Labels that are to be die cut on the Style "C" PMC Die Cutting Machine must be square cut first into individual stacks not over 4" high.

Users have found that square cutting is facilitated and the accuracy increased by providing cutting marks in the trim areas of the press sheet. The square cut stacks are then placed on the shuttle table in the path of the moving shuttle. The shuttle pushes these labels along one guide, called the side guide, to the front guide.

These two guides are positioned so that the stack of labels will stop at the right location on the ram. The ram then pushes the stack of labels up through the die which

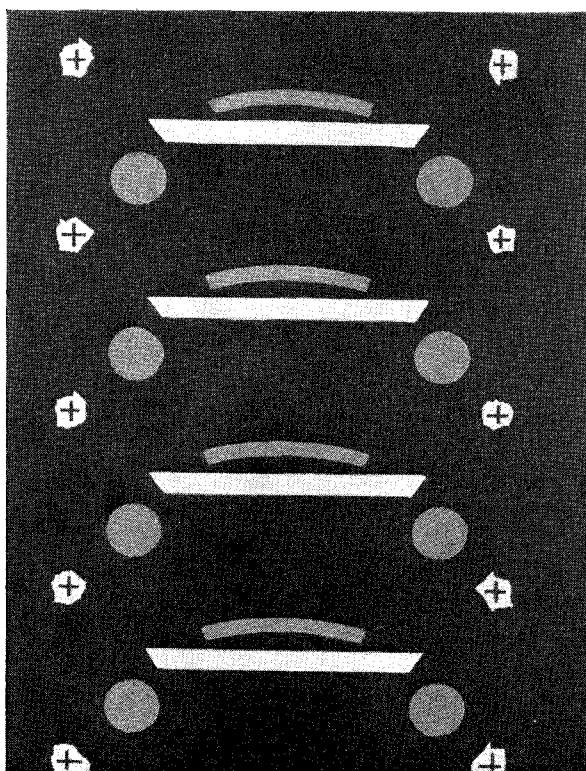


Figure 1

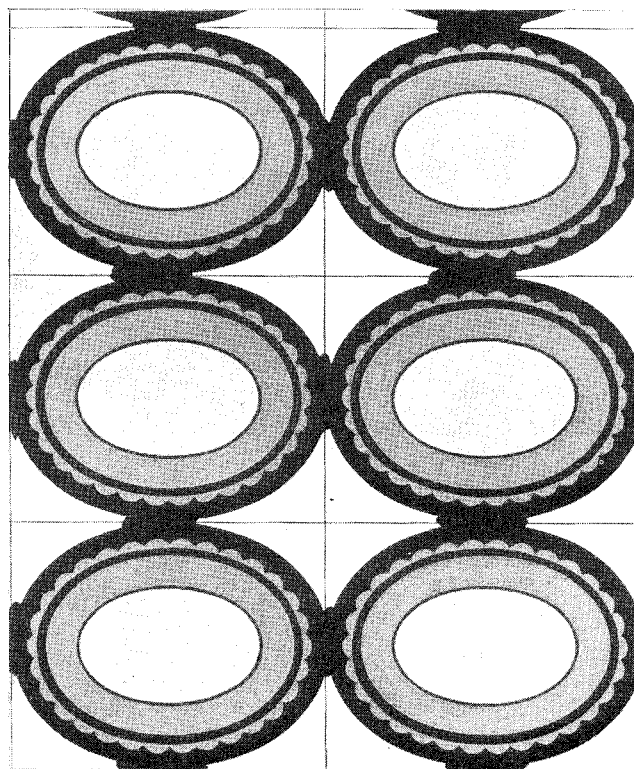


Figure 2

is positioned in relation to the square cut stack of labels and the side and front guide. Accurate square cutting is necessary. Cutting marks in the form facilitate accurate square cutting.

If the labels are produced by offset lithography, most users rule horizontal and vertical lines at the points to be square cut. Letterpress printers usually put corner marks in the same areas on their pattern plate. This enables these corner marks to be accurately reproduced in the duplicate plates. It is important to remember that these cutting marks should be on the same color plate that is used for checking the die cutting. Figures 1 and 2 show a portion of two forms of labels that have been ruled with cutting marks for printing by offset lithography. Figures 3 and 4 show two forms of plates that have been prepared for printing by the letterpress process.

Labels are best die cut on the PMC machine when the waste margin is as close to $\frac{1}{8}$ " as possible on all sides of the label. Too little or too much margin has been found to cause difficulty. The cutting marks should not be made too heavy.

Accurate square cutting is easily accomplished when the paper cutter splits the cutting marks.

Occasionally on a die cut label requiring extreme accuracy, additional square cutting may be necessary. On occasions like this, the strip of labels is square cut and then each stack is turned around and a sliver cut taken on the reverse side. This compensates for any draw in the knife of the paper cutter. Most printers usually separate the individual stacks of labels with a cardboard. This is used to designate a given quantity of labels between cardboards.

DIES

In most cases the PMC Die Cutting Machine can use the same dies that have been used on other types of machines.

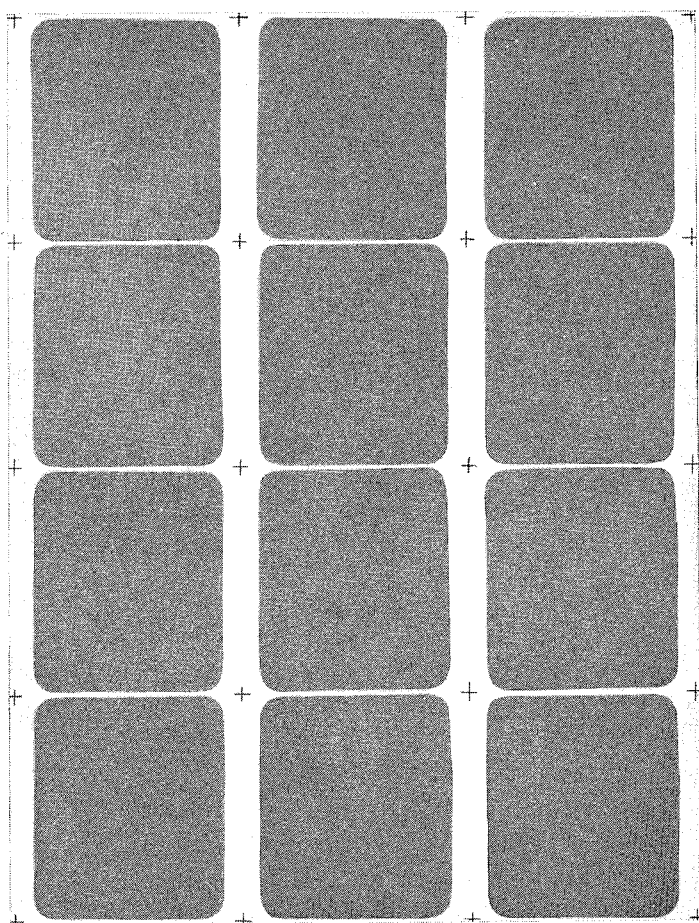


Figure 3

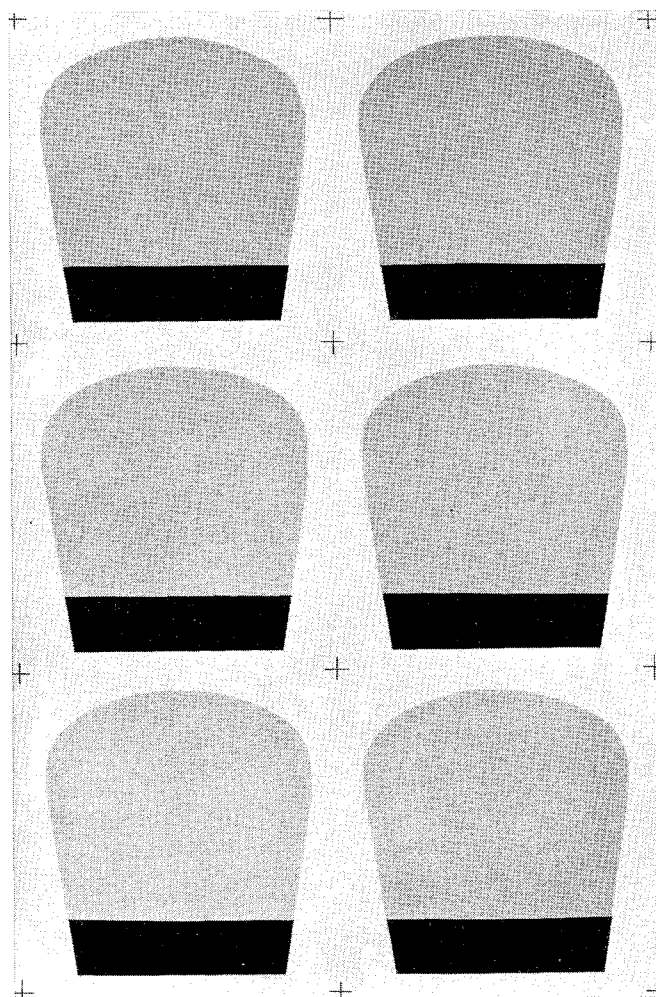


Figure 4

Occasionally these dies require alteration but that is not often. However, when new dies are being made for use on the PMC machine, we recommend that our suggestions be given to your die maker. The highest die that can be used in the PMC machine is $2\frac{3}{8}$ " and the lowest die that can be used is $1\frac{1}{4}$ ". The smallest closing of the die clamps is $1\frac{3}{8}$ " x $1\frac{3}{8}$ " and the most the die clamps will spread is $7\frac{3}{4}$ " x $7\frac{7}{8}$ ". The longest measurement is the direction between the front and back guide. The measurement of the ram top of the Style "B" machine is $6\frac{1}{2}$ " x $6\frac{1}{2}$ ". In every day operation the Style "B" machine will safely handle labels that have a minimum square cut size of 1" x 1" and a maximum square cut size of $6\frac{1}{2}$ " x $6\frac{1}{2}$ ". The measurement of the ram top of the Style "C" machine is $7\frac{1}{4}$ " x $7\frac{1}{4}$ ". In every

day operation the Style "C" machine will safely handle labels that have a minimum square cut size of 1" x 1" and a maximum square cut size of 7 $\frac{1}{4}$ " x 7 $\frac{1}{4}$ ".

If the top of a die is smaller than 1 $\frac{3}{8}$ " x 1 $\frac{3}{8}$ ", it cannot be clamped in the machine and the die must either be remade, the die maker increasing the size of the top of the die so that the clamps will hold it, or the necessary metal can be welded to old die.

For best results we have found that the inside of the die from the cutting edge and extending upward for 1" should be parallel. After that point the die can funnel out in accordance with the usual practice. If the shape of the die is such that there is very little clamping surface, it is recommended that a flat surface be ground on the upper outside of the die to facilitate clamping. The waste which breaks outside of the die should break on the right guide side so that by gravity and the assistance of one of the operators, it falls in the same direction as the waste pan.

There are times when the design of the label prevents the waste from breaking on the side of the right guide. When this happens a slit should be attached to that side of the die. The slit should never be more than $\frac{5}{16}$ " wide. Also, it must be designed so that the cutting edge is completely against the side of the die. If the slit is not properly positioned closely against the die, waste will soon get between

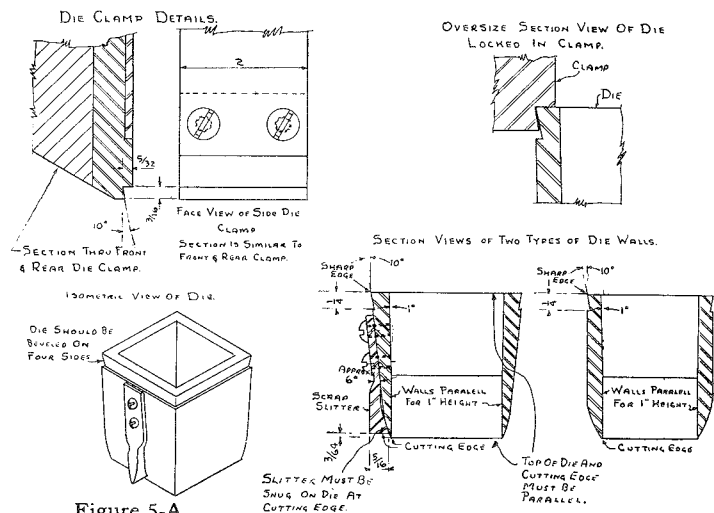


Figure 5-A

it and the die and break it off. The cutting edge of the slit should be about $\frac{3}{64}$ " above the cutting edge of the die. This is important so that the labels will be die cut before the waste is slit. Figure 5 shows a cutting die with a slit attached.

When the use of a slit becomes necessary, a slot should be filed in the waste pan on the right guide to provide clearance in case of the waste chute opening up.

It is important that the dies be kept sharpened. It is equally as important that the dies be sharpened correctly. If the sharpening is done in your own plant, it should be done by someone who has the characteristics required for that kind of work and one who has received instructions from a commercial maker of dies. The cutting dies should be handled carefully because it is very easy to damage the cutting edge.

Every die will not cut every different weight and kind of paper. Occasionally we have found it necessary for the die maker to cooperate with the printer and experiment with dies to obtain the best results.

Although we usually recommend that the inside wall of a die be parallel for 1", it is occasionally necessary to vary this to meet different conditions. A slight draft is sometimes necessary.

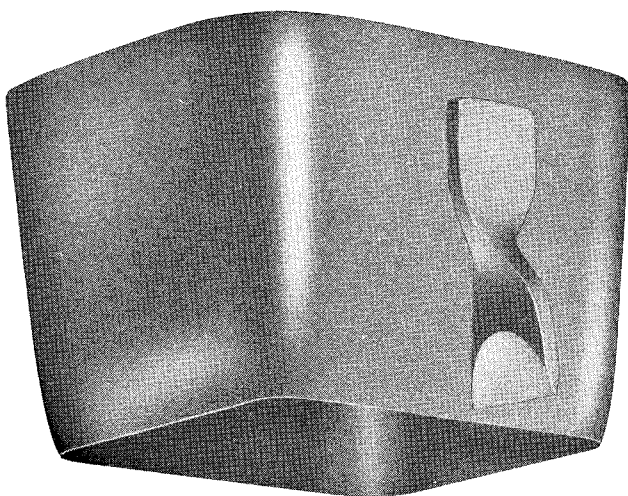
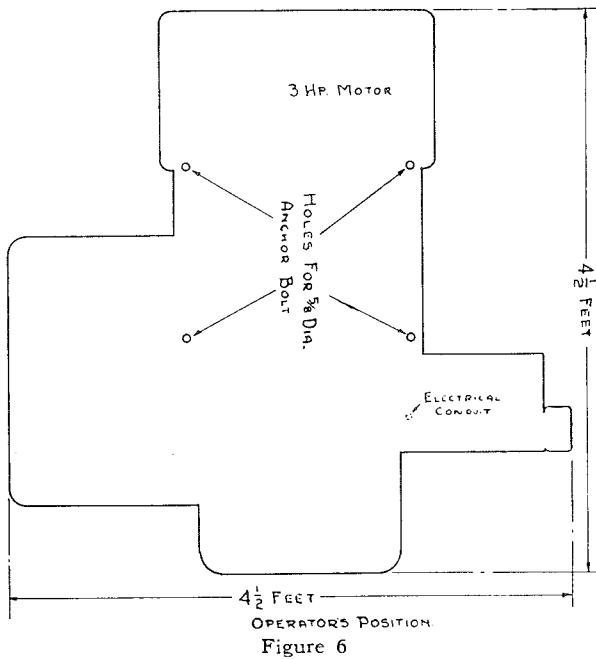


Figure 5

INSTALLATION OF THE MACHINE



The PMC Die Cutting Machine is easily installed. The one-piece base permits the machine to be correctly leveled. Figure 6 shows the floor layout and the position where the electrical connection is made.

Because of the high production of the machine, it is important that sufficient floor space be given the machine so that sufficient square cut labels can be kept near the machine and that other space be available for stacking the die cut labels.

WIRING

The terminals to be used are marked L1, L2, and L3 inside the switch box located on the column.

1. Remove the steel plate on the column exposing the ram mechanism. An arrow on the ram housing indicates the direction in which the cam, located on the drive shaft, should rotate. This is clockwise. After the machine has been wired, check the rotation by noting whether the shaft of the motor exposed on brake end is rotating counter-clockwise. The motor should rotate counter-clockwise which will turn drive shaft clockwise.

After wiring, should the motor be running in the wrong direction, it will be necessary that the wires be shifted from pole to pole until you have the right connection. After the machine has been wired, should it fail

INSTALLATION INSTRUCTIONS FOR PMC DIE CUTTING MACHINES

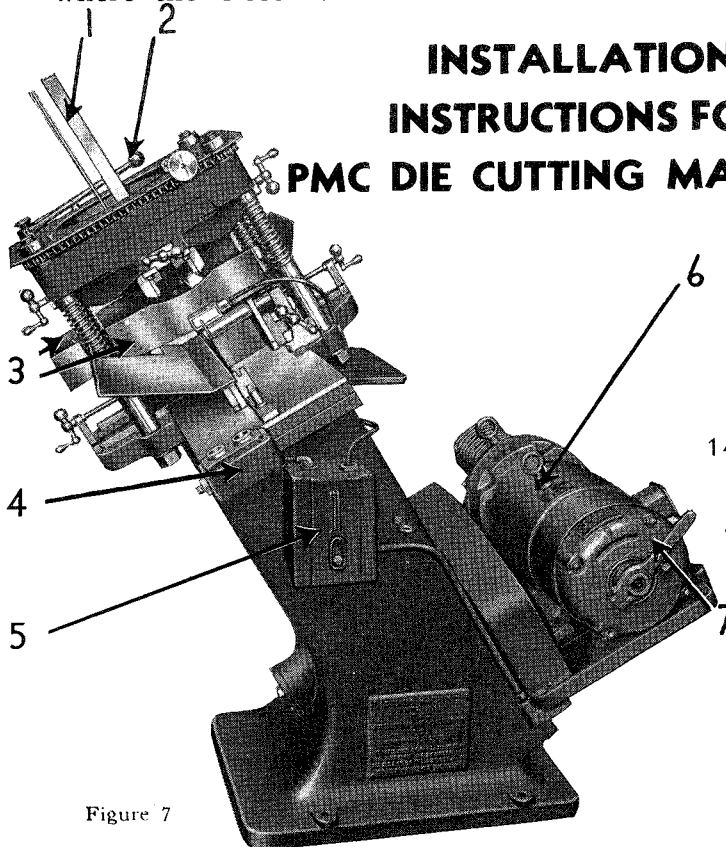


Figure 7

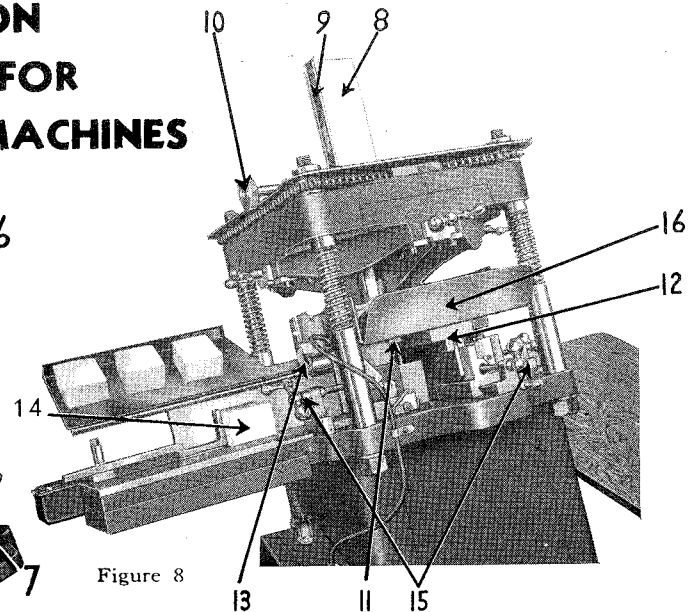
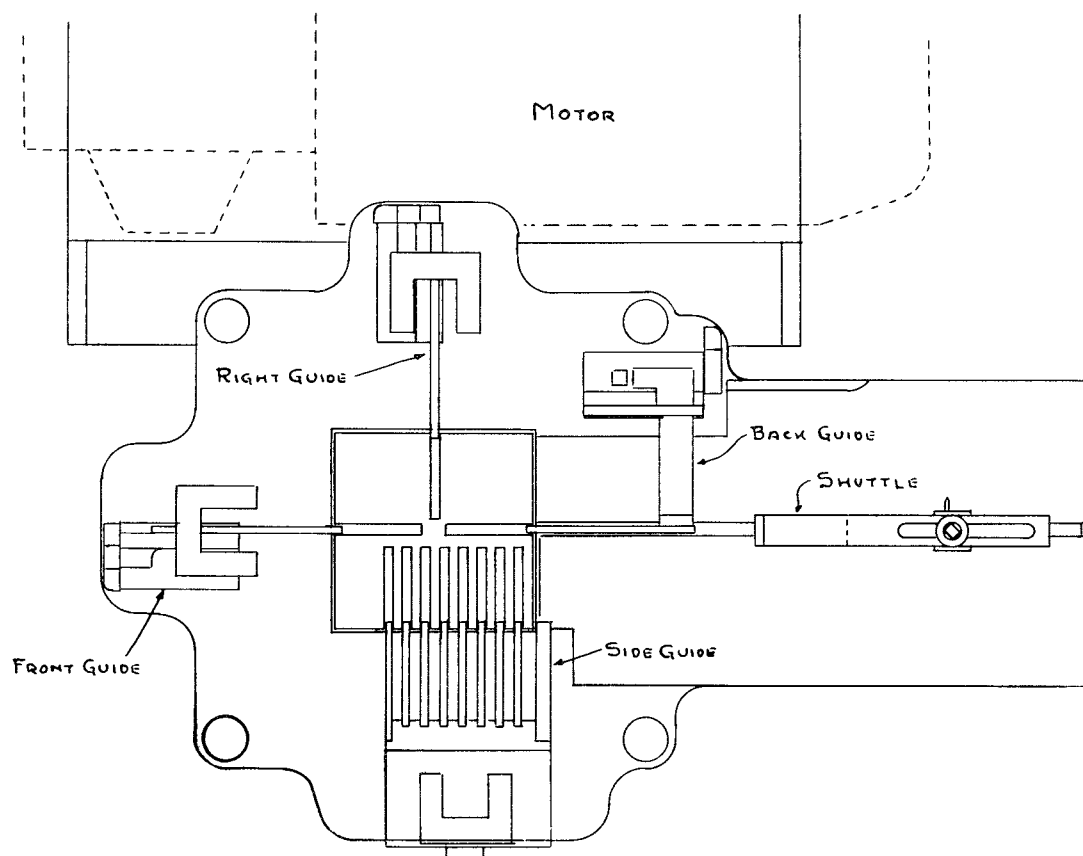


Figure 8

to run when pushing the starting button, this will indicate that the safety micro switch is open. It will then be necessary to reset safety micro switch by pushing on top of the lever indicated (No. 13, Fig. 8).



SETTING UP THE MACHINE

Figure 9

See Figure 9 for location and name of guides. The front guide of the machine is the one against which the labels are pushed by the shuttle. The side guide is the wide guide on the left of the machine as you face the table from the end. The right guide is the guide directly opposite the side guide. The back guide is the guide containing the safety micro switch and is opposite the front guide.

1. Inch the machine by alternately pushing the start and stop buttons until the ram is in the lowest position and pointer on shuttle carrier lines up with line on table. Release guide locks (No. 28, Fig. 11, Page 8).

Each of the guides has a crank handle (No. 15, Fig. 8, Page 6) for adjustment.

Open all guides so that square cut label can be easily centered on ram with long side of label parallel to side guide. Put a square cut label in the center of the ram (No. 23, Fig. 10, Page 8). Adjust the front and side guides to the position of the label.

2. Place a stack of square cut labels on ram, against the front and side guides. Adjust right guide to within $\frac{1}{16}$ " of stack of labels. Inch the ram upward until the stack of labels is above the bottom of the back guide. Then adjust the back guide to within $\frac{1}{16}$ " of stack of labels.

Inch machine until ram is in lowest position and pointer on shuttle carrier lines up with line on table. Loosen clamp screw on shuttle. Place a stack of labels at least $\frac{1}{4}$ " high on ram against front guide.

Adjust shuttle tight against stack of labels. Tighten clamp screw on shuttle. Inch machine until shuttle leaves stack. Loosen clamp screw and move shuttle forward $\frac{1}{8}$ ". Tighten clamp screw.

Run head of machine up to highest position with wrench (No. 22, Fig. 10, Page 8).

Loosen clamp screws (Nos. 18 and 19, Fig. 10, Page 8) with the wrench furnished. Now place your hollow die in the clamps (No.

21, Fig. 10). Be sure that the top edges of the die are held securely under the shoulders of all four clamps. Please note that the two wide jaws, for holding the hollow die, swivel to facilitate the holding of triangular dies or dies which have non-parallel sides. After the die is placed in the clamps, lock each of these swivel jaws by tightening screw with screw driver slot in jaw holder. Very little pressure on the die clamps is required for holding the die tight. *Too much pressure might spring the edges inward.*

Run the head down by turning wrench (No. 22, Fig. 10) until there is a clearance of $\frac{1}{32}$ " between the cutting edge of the die and the over-lapping (top) waste chute (No. 3, Fig. 7, Page 6). Lock the adjustment wrench; if it is not in position for one of the locking studs, move head upwards (never downwards) to the nearest aligning stud.

The die can be moved backward or forward or to the right or left by loosening the die holder clamp (No. 24, Fig. 11) and tightening the opposing clamp.

Should you find it necessary to swing the die in a rotary plane to obtain register with the design of the print, this is accomplished by loosening locks (No. 18, Fig. 10) and turning the screw (No. 10, Fig. 8, Page 6). When you are sure, by looking down through the die at your work, that you have your die in perfect alignment

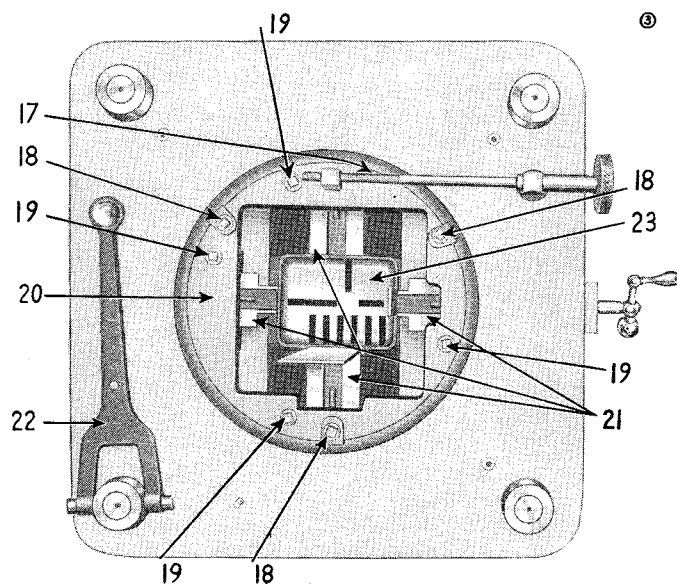


Figure 10

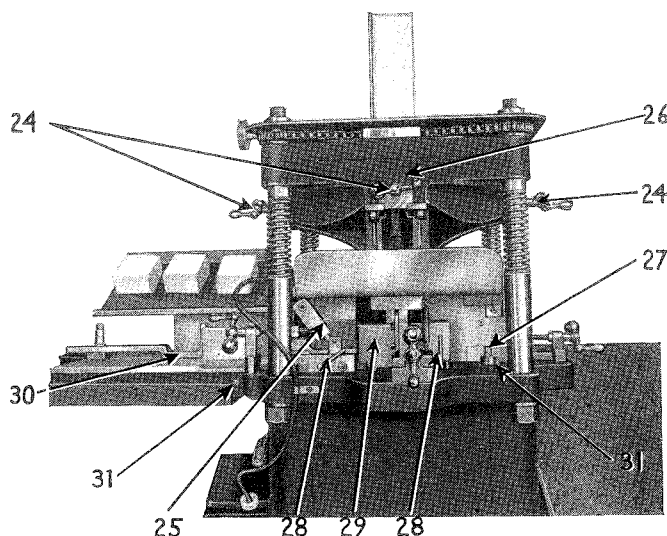


Figure 11

with the print of the label, tighten clamp screws (Nos. 18 and 19, Fig. 10) so as to hold die in position, cut one stack or a few labels backed up by a stack of special cut board of the same size to check register. For final registering make adjustments by shifting the front and side guides; do not change position of die. Tighten guide locks.

YOU ARE NOW READY TO START OPERATION

Should, for any reason, the machine be stopped by work or foreign materials hitting the safety switch (No. 13, Fig. 8, Page 6), it will be necessary to lower the ram by using the crank furnished, inserting this crank over the square end of the motor shaft and turning clockwise. This lowers the ram and makes it possible to remove the obstruction.

On A. C. motors only, it is necessary to release the brake by pulling brake handle (No. 7, Fig. 7, Page 6) upward. After removing the obstruction, relock this brake by pushing handle downward.

A CAUTION FOR OPERATION

Never cut labels before tightening clamps (Nos. 18 and 19, Fig. 10).

The four guides which are adjustable to the size of different labels you will observe, are adjustable into slots which are milled

into the ram. Because of the nature of paper, a certain amount of lint or scrap will fall into these slots in the ram. If too much of this lint or scrap is allowed to accumulate, when the guides are adjusted to a smaller sized label, this lint will become packed underneath these guides and is very apt to break them when the machine is started. A cleaning tool is furnished with the machine to clean slots in ram. Tool should be inserted in center of ram and accumulation of waste should be cleaned toward outer edge of ram.

This same condition also arises on certain types of stock where the scrap breaks up into small particles when the labels are being cut. To eliminate the possibility of breaking a guide because of this accumulation of lint or scrap, it is advisable, where compressed air is available, to blow out these slots each morning before starting the machine. Any portable electrically operated blower will serve this purpose. If no compressed air is available, by removing the front plate of the machine and a small plate on the back of the machine and by means of a hole in the left side of the machine, you will find slots which have been milled in the steel plate upon which the ram is fastened, which makes

it possible to clean these apertures by using a bent wire.

ADDITIONAL INSTRUCTIONS

Brake

The brake on the motor is there for the purpose of stopping the machine instantly in case of the labels not being pushed into the front guide, or if some object, such as a tool, is left on the ram.

Before the start of each job, the operation of this brake should be tested by putting a piece of paper under the micro-switch lever (No. 13, Fig. 8, Page 6). If the ram does not stop within the $\frac{1}{4}$ " after the paper touches the lever, the brake should be adjusted by backing out the screw on the brake (No. 7, Fig. 7, Page 6) until you have the proper adjustment. Be sure to fasten the lock nut after this operation.

Lubrication

Two oilers (Nos. 27 and 31, Fig. 11, Page 8) are easily located on the machine. A third oiler is located on the front of the column directly above the motor. Oil daily with any good grade of light weight machine oil.

IMPORTANT

- 1. Be sure that shuttle, which delivers stock to guide, operates freely. If it does not, look for obstruction. Set shuttle so as to push labels snugly against front guide.**
- 2. The die should be at least $\frac{1}{32}$ " or the thickness of one chip board above the highest waste pan. Never set cutting edge of die below highest waste pan.**
- 3. Before starting job, after set-up is complete, be sure that clamp screws on rotating die turret and guide locks are tightened.**
- 4. Keep slots in ram free from lint and small particles of paper. Long handled tool is provided for this purpose. Blow out with compressed air if available.**
- 5. If crank handle for reversing machine is used, be sure to take crank handle off end of motor before starting machine.**

There is a metal tag attached to the motor giving lubricating instructions for the speed reduction unit of the motor. These are manufacturer's recommendations and should be followed. Don't lose the tag. The rear bearing of the motor should be lubricated with a good grade of ball bearing grease after each 750 hours operation. This lubricating connection is under the steel band covering the motor.

POSSIBLE USES OF THE PMC DIE CUTTING MACHINE

Although this machine was originally designed and manufactured for die cutting fancy shaped labels, early purchasers have found it very efficient for other kinds of work. The machine has been found to be very successful for three-way trimming and round-cornering small books and pamphlets within its size range. The bound edge of the book is fed against the side guide as shown in Figure 9. This is accomplished by having a blank edge on the side of the die that is parallel to the bound edge of the book. Because the round-cornering is done at the same time as the three-way trimming, a perfect blend of the round corners and the straight sides is obtained. (See Fig. 12.) You will find illustrated a New Testament job which was printed and bound two-up, cut apart with a single cut on a guillotine-type cutter. The square cut end was used as the front guide end. Other illustration shows finished book.

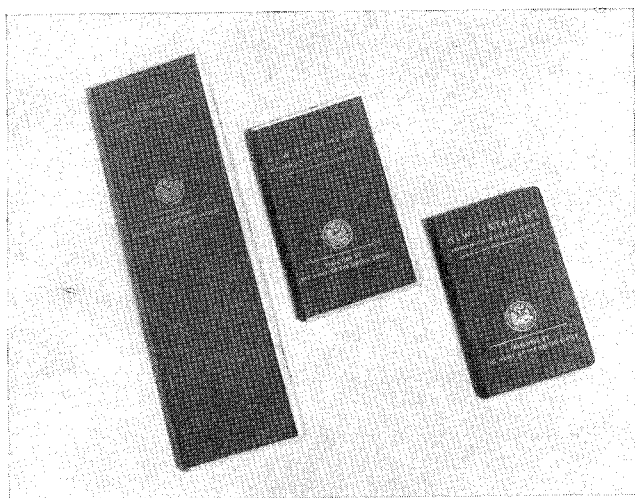


Figure 12

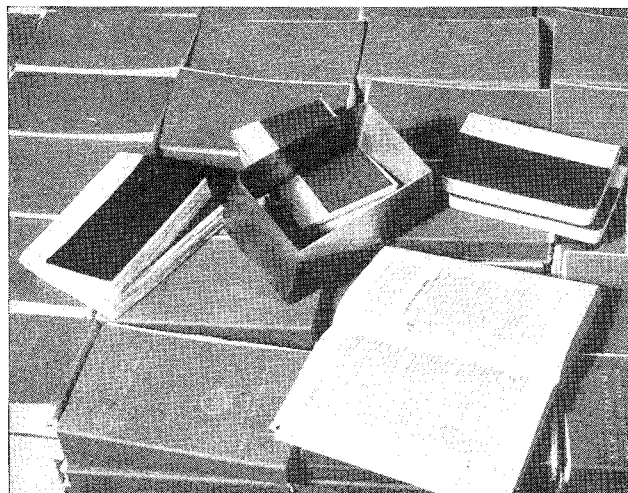


Figure 13

Figure 13 shows the kind of die used for three-way trimming and round-cornering small books along with some books before and after die cutting.

The PMC Die Cutting Machine has also produced fancy shaped advertising memo books. The experience of our users, since the machine has been on the market, has demonstrated that it has uses beyond the type of work for which it was originally designed.

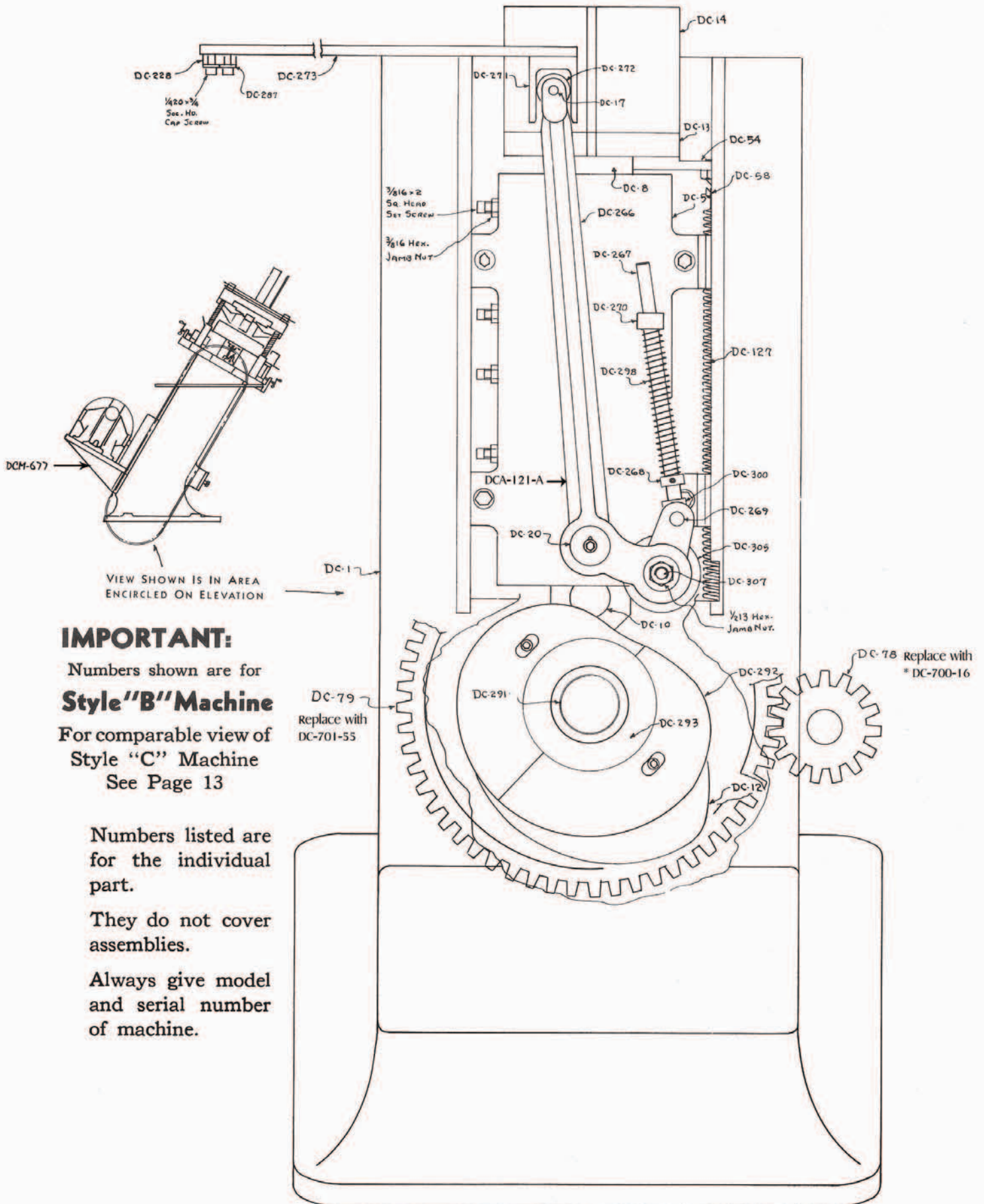
One of our users has been cutting large quantities of small discs. To facilitate the handling of these discs, he devised this arrangement. A piece of metal tubing was purchased with the same inside diameter as the finished diameter of one of the discs. A portion of the inside of the die, from the top down, was machined away and the tube fitted into the die. Near the top of the tube two slots were cut about five or six inches down from the top. The finished discs were die cut and came up through the tube. Over the top of the tube the user placed the box into which these discs were to be packed. When the box became full, a sharp tool was placed in the tube slot and used to hold the labels in the box as the box was removed from the tube. The top of the box was closed and the discs were ready for packing in larger containers.

We will appreciate hearing from any of our users who have discovered additional uses for the PMC Die Cutting Machine.

REFERENCE

To Figures Nos. 7-8-10-11 . . . Pages 6 to 8

1. Finished work delivered here.
2. Vertical adjusting lever for die holding mechanism.
3. Scrap chute.
4. Start-stop push button.
5. Switch box and relay for overload.
6. Electric motor power unit.
7. Electric brake release lever (A. C. machines only).
8. Work after die cutting.
9. Stanchions which keep work evenly jogged after die cutting.
10. Knob for rotary positioning of die.
11. Portion of last lift of stock held between guides by automatic catches—serving as bolster between ram and die on each succeeding cut.
12. Right Guide.
13. Micro safety switch lever and micro switch.
14. Work ready for feeding.
15. Right and back guide adjusting cranks.
16. Scrap shield on right guide.
17. Screw for rotating die turret.
18. Die turret lock screw.
19. Lock screw for die clamp.
20. Die clamp turret.
21. Clamps holding die.
22. Vertical adjusting lever for die holding mechanism.
23. Ram head.
24. Adjusting cranks for die clamp.
25. Safety latch which releases under undue pressure caused by scrap accumulations on Style "B" machines prior to Serial B406.
26. Die clamp turret.
27. Central oiler for cam shaft and ram.
28. Clamp to lock guides in position.
29. Pressure ram.
30. Feed shuttle.
31. Oilers for feed shuttle.



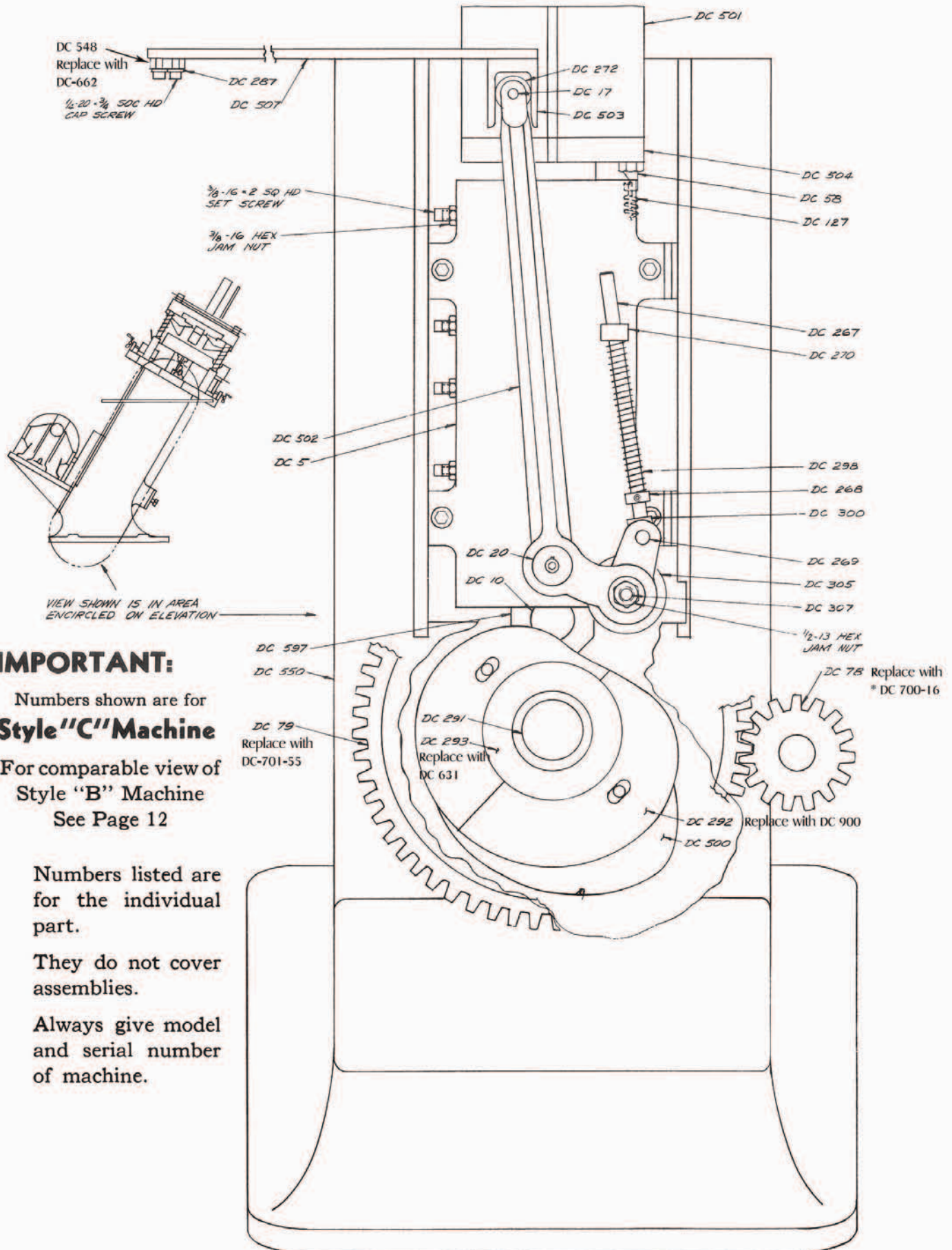
IMPORTANT:

Numbers shown are for
Style "B" Machine
For comparable view of
Style "C" Machine
See Page 13

Numbers listed are
for the individual
part.

They do not cover
assemblies.

Always give model
and serial number
of machine.



IMPORTANT:

Numbers shown are for
Style "C" Machine
For comparable view of
Style "B" Machine
See Page 12

Numbers listed are
for the individual
part.

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assemblies.

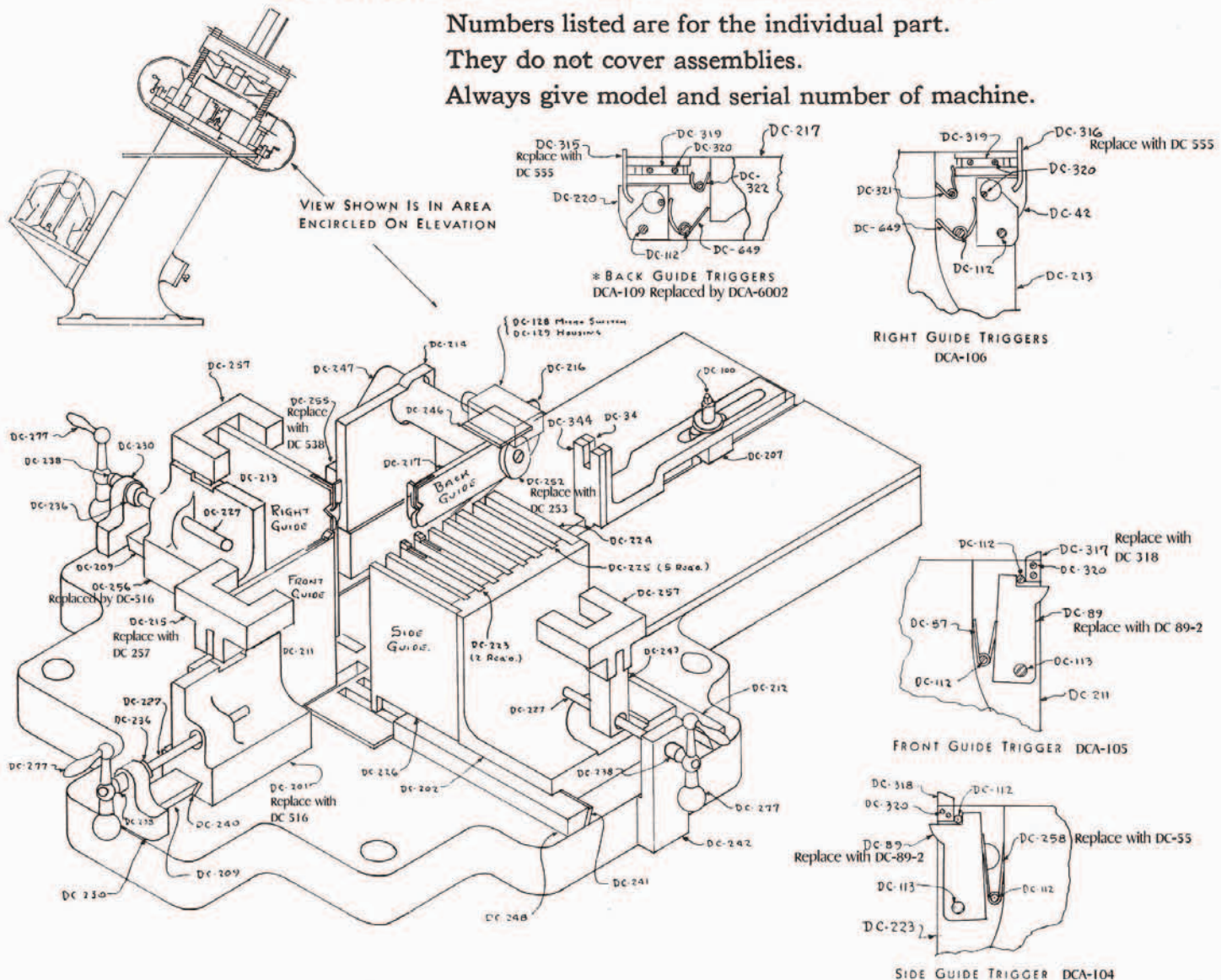
Always give model
and serial number
of machine.

IMPORTANT: Numbers shown are for **Style "B" Machine** For Comparable View of Style "C" Machine See Page 15.

Numbers listed are for the individual part.

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PARTS LIST FOR STYLE "B" and STYLE "C" MACHINES

Style "B"		Style "C"	Style "B"		Style "C"
DC-1	Column	DC-550	DC-14	Thrust Block	DC-501
DC-2	Cam Shaft Bushing (rear)	DC-2	DC-17	Feed Roller Pin	DC-17
DC-3	Cam Shaft Bushing (front)	DC-3	DC-19	Feed Lever Stud	DC-19
DC-4	Thrust Brg. Adj. Shaft	DC-4	DC-20	Feed Lever Stud Washer	DC-20
DC-5	Plunger Housing	DC-5	DC-25	Blank Feeder	DC-546
DC-6	Plunger Housing Cap	DC-6	†DC-27	Extension Guide	DC-602
DC-7	Plunger Housing Gib	DC-7	DC-28	Extension Guide Face	DC-512
DC-8	Plunger	DC-597	DC-32	Feed Grip Stud	DC-32
DC-9	Plunger Roller	DC-9	DC-33	Cam Shaft Brg. Cap.	DC-33
DC-10	Plunger Roller Pin	DC-10	DC-34	Feed Rod Head	DC-505
DC-12	Plunger Cam	DC-500	DC-41	Chuck Jaw Clamping Screw	DC-41
DC-13	Plunger Head	DC-504	DC-42	Blank Catch—Right Guide	DC-42

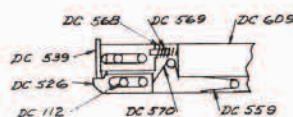
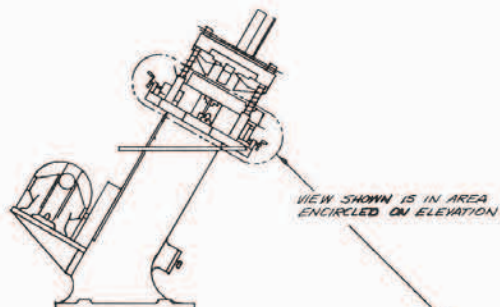
†Superseded by DC-602—Serial B-437

IMPORTANT: Numbers shown are for **Style "C" Machine** For Comparable View of Style "B" Machine See Page 14.

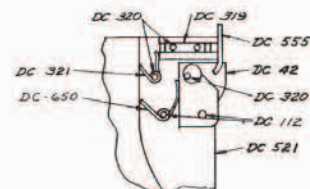
Numbers listed are for the individual part.

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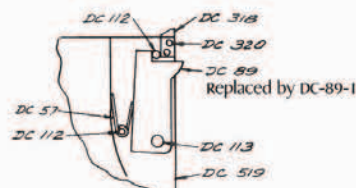
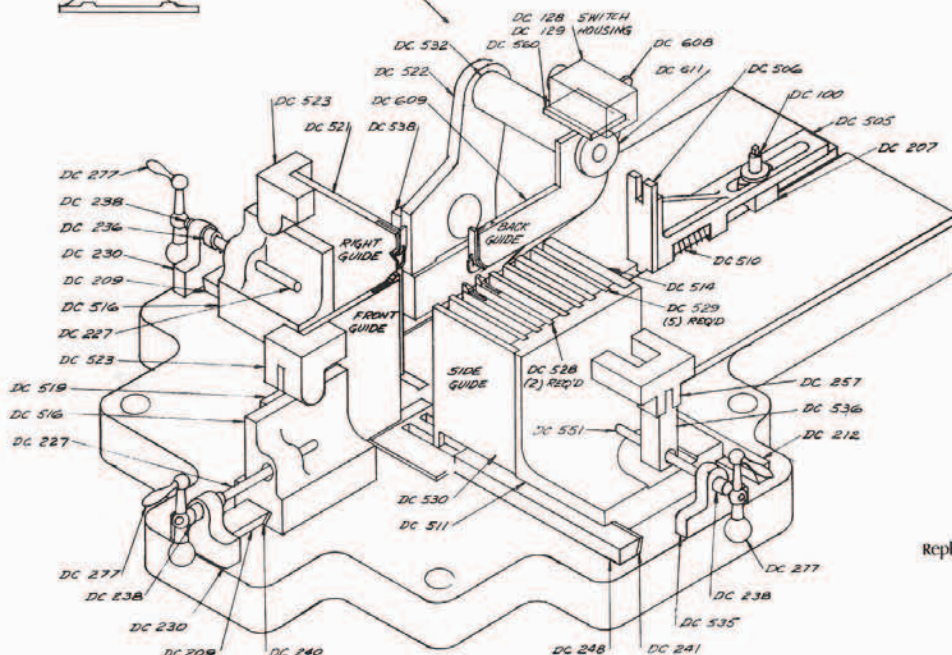
Always give model and serial number of machine.



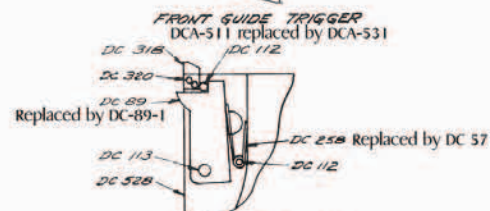
* BACK GUIDE TRIGGER
DCA-520 Replaced by DCA-6002



RIGHT GUIDE TRIGGER
DCA-512 replaced by DCA-529



Replaced by DC-89-1



FRONT GUIDE TRIGGER
DCA-511 replaced by DCA-531

SIDE GUIDE TRIGGER
DCA-510 replaced by DCA-533

Style "B"		Style "C"	Style "B"		Style "C"
⁽¹⁾ DC-43	Swivel Plate	DC-540	DC-65	Jogging Deck	DC-603
⁽²⁾ DC-44	Chuck Plate	DC-541	DC-67	Corner Post	DC-543
DC-45	Chuck Jaw (side and right)	DC-45	DC-68	Corner Post Spring	DC-68
DC-46	Chuck Jaw (front and back)	DC-612	DC-69	Adjusting Nut Chain	DC-69
DC-47	Anchor Post (for chuck slides)	DC-46	DC-70	Adjusting Sprocket Nut	DC-70
DC-49	Swivel Clamp	DC-613	DC-71	Spanner Wrench	DC-71
DC-51	Adjusting Screw Collar	DC-47	DC-72	Spanner Wrench Stud	DC-72
DC-53	Chuck Jaw Cap	DC-49	DC-73	Chuck Jaw Stanchion	DC-607
DC-54	Plunger Spring Bracket	DC-51		(feed side)	
DC-57	Paper Catch Spring	DC-53	DC-74	Chuck Jaw Stanchion (front)	DC-606
DC-58	Plunger Spring Stud		DC-75	Gear Guard	DC-75
DC-61	Feed Staff Cap	DC-57	DC-76	Column Cover Plate	DC-76
⁽³⁾ DC-64	Roller Chain Cover	DC-58	DC-77	Motot Shelf	DC-77
		DC-515	DC-78	Motor Pinion	DC-78
		DC-542	DC-79	Gear	DC-79

⁽¹⁾ Superseded by DC-540 Serial B388

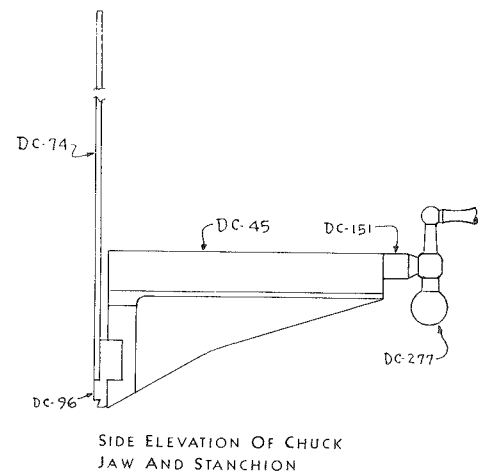
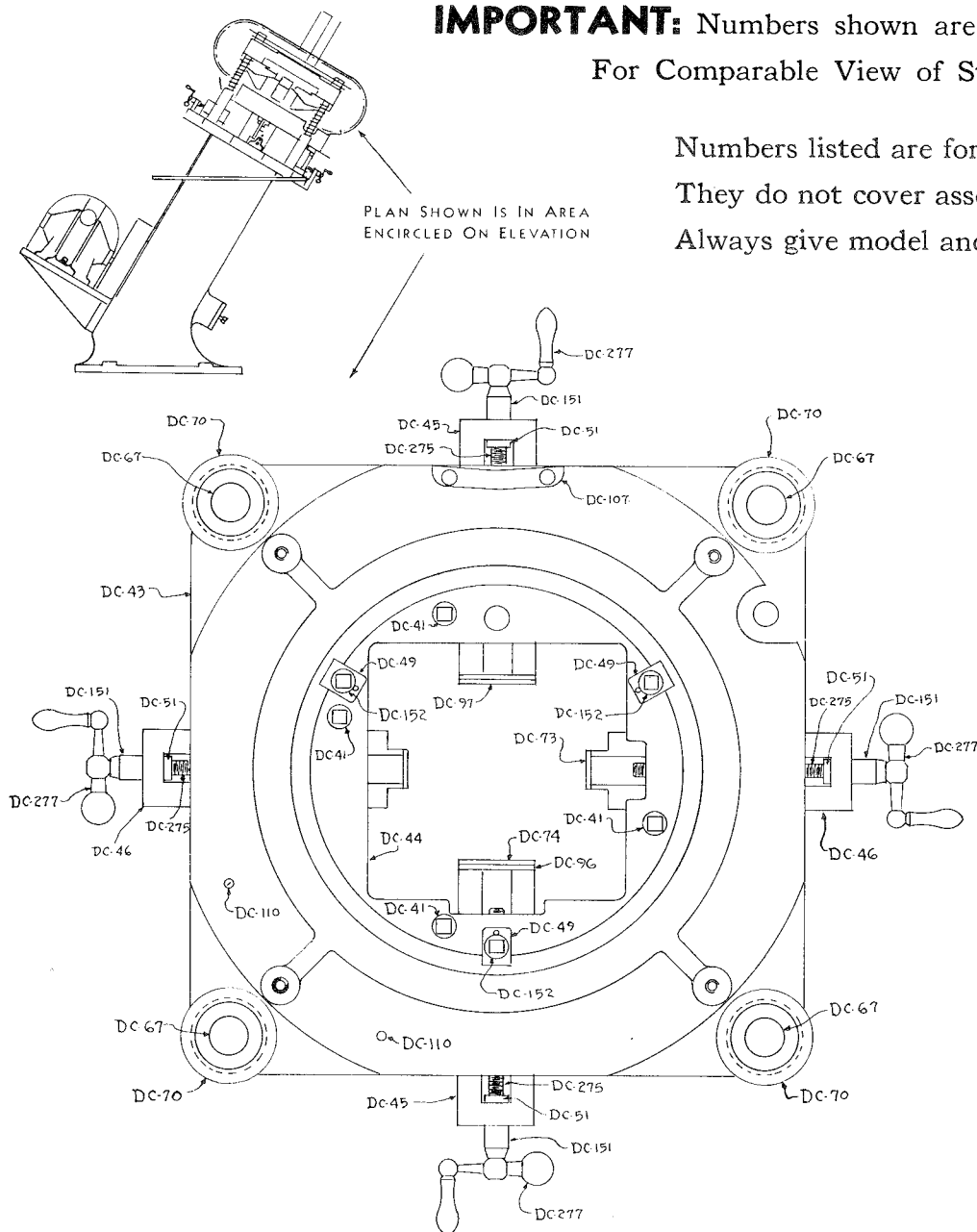
⁽²⁾ Superseded by DC-541 Serial B388

⁽³⁾ Superseded by DC-542 Serial B388

* See CDA-6005-Retro (Back Guide Assy. Retrofit)

IMPORTANT: Numbers shown are for **Style "B" Machine**
For Comparable View of Style "C" Machine See Page 17.

Numbers listed are for the individual part.
They do not cover assemblies.
Always give model and serial number of machine.



Style "B"		Style "C"	Style "B"		Style "C"
DC-81	Feed Lever Stud Bushing	DC-81	DC-109	Oiler Stud Ring	DC-109
DC-88	Housing Gib Stud	DC-88	DC-110	Spanner Wrench Locking Pin	DC-110
DC-89	Blank Catch (front)	DC-89	DC-111	Table Stud	DC-111
^④ DC-94	Chuck Swivel Adjusting Screw	DC-580	DC-112	Trigger Pin	DC-112
^⑤ DC-95	Swivel Adjusting Screw Knob	DCA152	DC-113	Trigger Pin	DC-113
DC-96	Stanchion Swivel (Side)	DC-96	DC-115	Adjusting Screw Pin	DC-115
DC-97	Stanchion Swivel (Right)	DC-97	DC-123	Spanner Wrench Washer	DC-123
DC-98	Swivel Head Stop Pin	DC-98	DC-124	Adjusting Sprocket Nut	DC-124
DC-99	Corner Post Washer	DC-99		Washer	
DC-100	Feed Rod Head Lock Nut	DC-100	DC-126	Chuck Jaw Cap	DC-126
DC-106	Jogging Deck Spacer		DC-127	Ram Spring	DC-127
DC-107	Roller Chain Shoe	DC-581	DC-128	Micro Switch	DC-128
DC-108	Oiler Stud	DC-108	DC-129	Switch Housing	DC-129

^④DC-94 Superseded by DC-580 Serial B388

^⑤DC-95 Superseded by DCA152 Serial B388

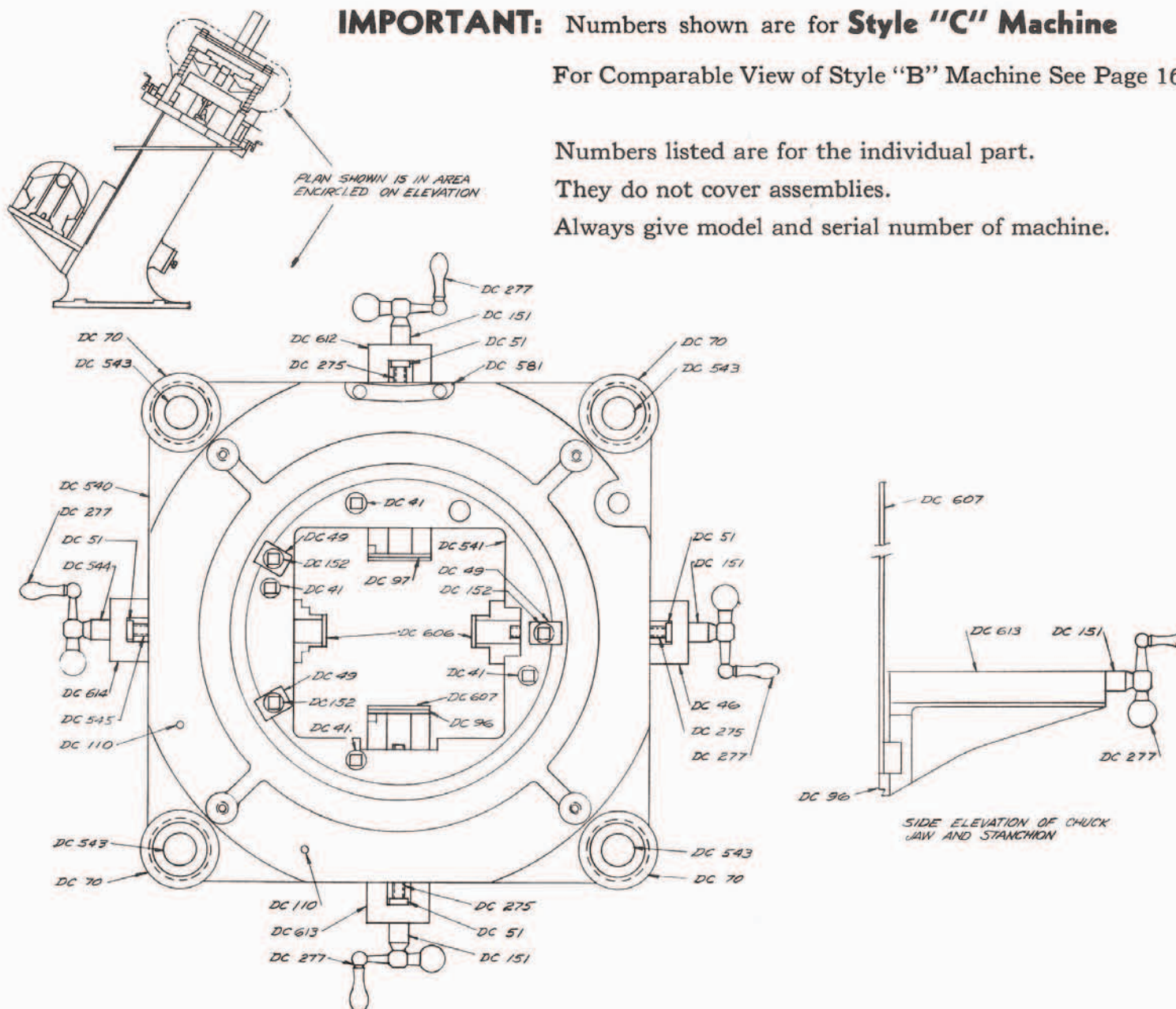
IMPORTANT: Numbers shown are for **Style "C" Machine**

For Comparable View of Style "B" Machine See Page 16.

Numbers listed are for the individual part.

They do not cover assemblies.

Always give model and serial number of machine.



Style "B"		Style "C"	Style "B"	Style "C"
DC-130	Rt. Angle Comb. G. H. Motor—A.C.	DC-130	DC-147	Arrow
DC-131	Starter—A.C.	DC-131	DC-150	Hand Hole Cover Plate
DC-132	Push Button	DC-132	DC-151	Collar on Chuck Jaw Screw
DC-134	Name Plate	DC-134	DC-152	Collar Screw
DC-136	"T" Wrench	DC-136	⑥DC-516	Front Guide Bracket
DC-137	18" x 24" Plywood Board	DC-137	DC-202	Angle Plate—Side Guide
DC-141	Thrust Bearing	DC-141	DC-203	Needle Bearing
DC-142	Pin-Adjusting Screw Collar	DC-142	⑦DC-204	Waste Chute (right)
DC-143	Eyebolt for Wrenches	DC-143	⑧DC-205	Waste Chute (side)
DC-144	.008 Shim—Plunger Housing	DC-144	DC-206	Lower Feeder Bracket
DC-145	.010 Shim—Plunger Housing	DC-145	DC-207	Upper Feeder Bracket

⑥DC-201 Superseded by DC-516

⑦DC-204 Superseded by DC-337

⑧DC-205 Superseded by DC-338

Style "B"		Style "C"	Style "B"		Style "C"
DC-208	Indicator	DC-208	DC-252	Washer	DC-611
DC-209	Dovetail Guide	DC-209	¹¹ DC-253	Corner Post Washer	DC-124
DC-210	Tube—Back Guide Blade		*DC-254	Filler Post	
DC-211	Front Guide Plate	DC-519	¹² DC-516	Back Guide Bracket	DC-538
DC-212	Dovetail Bar—Side Guide	DC-212	¹² DC-538	Right Guide Bracket	DC-516
DC-213	Right Guide Plate	DC-521	DC-257	Waste Chute Hinge Support	DC-257
DC-214	Back Guide Plate	DC-522	DC-258	Blank Catch Spring—	DC-258
DC-257	Hinge Support	DC-523		Side Guide	
DC-216	Micro Switch Lever	DC-608	DC-261	Micro Switch Lever Spring	DC-559
DC-217	Back Guide Blade	DC-609	*DC-262	Micro Switch Safety Catch	
⁹ DC-218	Waste Chute (back)	DC-571		Lever Plunger	
¹⁰ DC-219	Waste Chute (front)	DC-572	*DC-263	Micro Switch Safety Catch	
DC-220	Blank Catch—Back Guide	DC-526		Lever Spring	
DC-221	Coil Spring—Waste Chute	DC-221	DC-264	Screw Boss—Chuck Swivel—	DC-264
DC-222	Frame—Top	DC-527		(tapped)	
DC-223	Center Plate—With Blank	DC-528	DC-266	Feed Lever	DC-502
	Catch Side Guide		DC-267	Spring Bar	DC-267
DC-224	End Plate—Extension Guide	DC-524	DC-268	Spring Bar Collar	DC-268
	Side Guide		DC-269	Spring Bar Pin	DC-269
DC-225	Center Plate—Side Guide	DC-529	DC-270	Thrust Stud	DC-270
DC-226	End Plate—Side Guide	DC-530	DC-271	Feed Pusher Bracket	DC-503
DC-227	Guide Adjusting Screw	DC-227	DC-272	Feed Lever Roller	DC-272
DC-228	Feed Staff Arm	DC-662	DC-273	Feed Staff	DC-507
DC-230	Adjusting Screw Post	DC-535	DC-274	Feeder Plate—Side Guide Side	DC-547
DC-233	Gib Lock Screw	DC-233	DC-275	Chuck Jaw Adjusting Screw	DC-275
DC-234	Gib Lock Screw Pin	DC-234	DC-276	Screw Boss—Chuck Swivel	DC-276
DC-235	Back Guide Needle Bearing		DC-277	"Balcrank" No. 0 Handle	DC-277
	Shaft		DC-278	Plunger Cam Set Screw	DC-278
DC-236	Adjusting Screw Collar	DC-236	DC-280	Locking Screw	DC-280
DC-237	Gib Lock Screw Plug	DC-237	DC-281	Stud	DC-281
DC-238	Extension Collar—Guide	DC-238	DC-282	Slot Cleaner	DC-282
	Adjusting Screw		DC-284	Guard	DC-284
*DC-239	Back Guide Adjusting Screw		DC-285	Stop Pin—Side Guide Dovetail	DC-285
	Post			Bar	
DC-240	Gib—Guide (Right, Front and	DC-240	DC-286	Stop Pin—Side Guide Angle	DC-511
	Back)			Plate	
DC-241	Gib—Side Guide	DC-241	DC-287	Feed Staff Arm Washer	DC-287
DC-242	Bracket—Side Guide	DC-535	DC-289	Extension Guide Spring	DC-289
	Adjusting Screw		DC-290	Extension Guide Face Screw	DC-290
DC-243	Screw Post—Waste Chute	DC-536	DC-291	Cam Shaft	DC-291
	Hinge		DC-292	Feed Cam	DC-900
DC-244	Spring Stud	DC-244	DC-293	Feed Cam Hub	DC-631
DC-245	Spring Stud	DC-554	DC-298	Feed Lever Spring	DC-298
DC-246	Micro Switch Plate	DC-560	DC-299	Conduit Clamp—	DC-299
DC-247	Micro Switch Safety Catch		DC-300	Spring Bar End	DC-300
	Lever		*DC-301	Support—Adjusting Screw	
DC-248	Dovetail Bar—Gib Side	DC-248		Post	
*DC-249	Back Guide Safety Roller		*DC-302	Bracket—Adjusting Screw	
*DC-250	Back Guide Safety Roller Pin			Post Support	
*DC-251	Back Guide Safety Roller		*DC-303	Adjusting Screw Post—	
	Bracket			Back Guide	

⁹DC-218 Superseded by DC-335

¹⁰DC-219 Superseded by DC-336

¹¹DC-253 Superseded by DC-124

DC-215 Superseded by DC-257

¹²DC-255 Superseded by DC-516

¹²DC-256 Superseded by DC-516

*Not Used after Serial B-406

†DC-255 Superseded by DC-538 or DC-516—Serial B-406

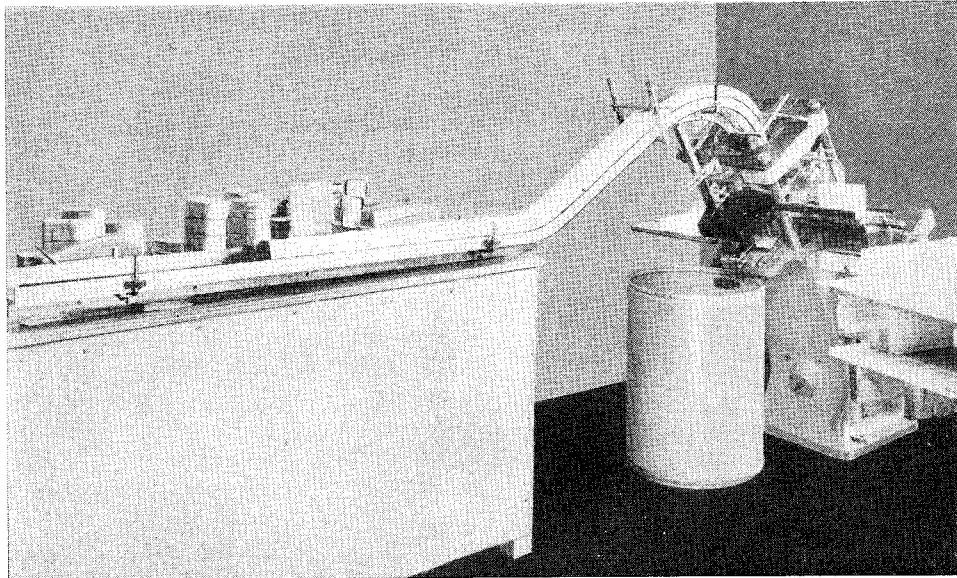


Style "B"		Style "C"	Style "B"		Style "C"
DC-304	Bushing—Spring Bar End	DC-304	‡DC-577	Thrust Washer	DC-577
DC-305	Cam Roller—Feed Lever	DC-305	‡DC-594	Jam Nut	DC-594
DC-306	Bearing—Cam Roller	DC-306		Spring Seat Ext. Guide	DC-601
DC-307	Stud—Cam Roller	DC-307		Washer—Feed Rod Head	DC-604
DC-308	Steel Insert Chuck Jaw	DC-308		Retainer Ring	DC-605
DC-315	Horizontal Upper Sliding Trigger Back Guide	DC-539			
DC-316	Horizontal Upper Sliding Trigger Right Guide	DC-555			
DC-317	Extension—Front Guide	DC-318			
DC-318	Extension—Side Guide	DC-318			
DC-319	Slide—Horizontal Trigger	DC-319	DCA-13	Chuck Jaw Assy.—Front	DCA-522
DC-320	Pin—Slide and Extension	DC-320	DCA-13	Chuck Jaw Assy.—Back	DCA-13
DC-321	Spring—Right Guide Trigger	DC-321	DCA-100	Side Guide Assy.	DCA-514
DC-322	Spring—Back Guide Trigger	DC-569	DCA-101	Front Guide Assy.	DCA-515
DC-649	Spring—Right Guide Trigger Back Guide Trigger	DC-650	DCA-105	Front Guide Plate Assy.	DCA-531
DC-325	Wedge—Chuck Jaw Swivel	DC-570	DCA-106	Right Guide Plate Assy.	DCA-529
DC-326	Set Screw—30° Cone Point	DC-325	DCA-109	Back Guide Blade Assy.	DCA-6002
*DC-327	Filler Post—Back Guide Adjusting Screw Post	DC-326	DCA-111	Chuck Jaw Assy.—Side	DCA-522
DC-330	Metal Bumper Plate	DC-506	DCA-112	Chuck Jaw Assy.—Right	DCA-521
DC-331	Metal Bumper Plate Guide Pins	DC-509	DCA-117	Motor Crank Assy.	DCA-117
DC-332	Metal Bumper Plate Limit Screw and Nuts	DC-508	DCA-122	Chuck Jaw & Insert—Back	DCA-122
DC-333	Metal Bumper Spring	DC-510	DCA-122	Chuck Jaw & Insert—Front	DCA-523
DC-334	Jogging Deck Brace	DC-334	DCA-124	Feed Rod Head Assy.	DCA-518
DC-335	Waste Chute—Rear	DC-571	DCA-104	Side Guide Blade ASSY.	DCA-533
DC-336	Waste Chute—Front	DC-572	DCA-121-A	Aluminum Arm Sub Assy.	
DC-337	Waste Chute—R. H.	DC-573	DCA-160	Back Guide Assy	DCA-519 use DCMA-6005
DC-338	Waste Chute—L. H.	DC-574			
DC-339	Jogging Deck Large		DCA-102	Right Guide Assy.	DCA-524
DC-420	Scale	DC-420			
DC-421	Pointer	DC-421			
‡DC-518	Spring Stud	DC-518			
	Back Guide Shaft	DC-532			
‡DC-533	Adj. Screw Bracket— Back Guide	DC-533			
‡DC-544	Adj. Screw Collar	DC-544			
	Center Plate—Side Guide	DC-552			
DC-553	Feed Staff Ext. Cap	DC-553			
	Spring Stud	DC-554			
‡DC-558	Back Guide Adj. Scr. Post	DC-558			
‡DC-561	Pivot Pin	DC-561			
	Pivot Pin	DC-563			
‡DC-565	Back Guide Gear Shaft	DC-565			
‡DC-567	Mitre Gear	DC-567			
	Trigger Guide Pin	DC-568			
‡DC-575	Spring Stud	DC-575			
	Extension Spring	DC-576			

‡Used on Style B Machines after Serial B-406

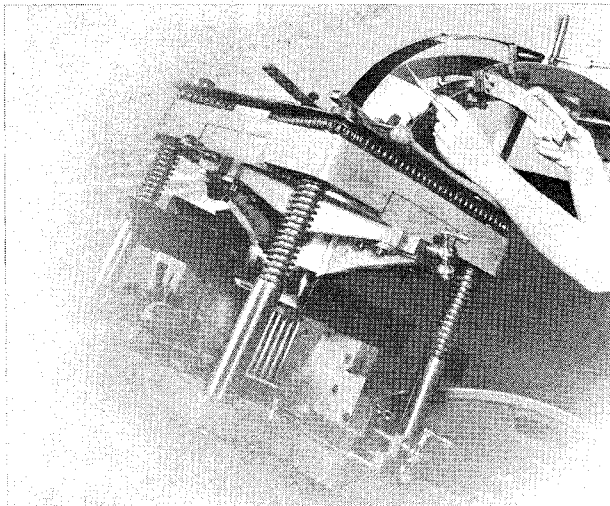
*Not used after Serial B-406

EXTENSION DELIVERY



Extension delivery delivers labels to inspection table

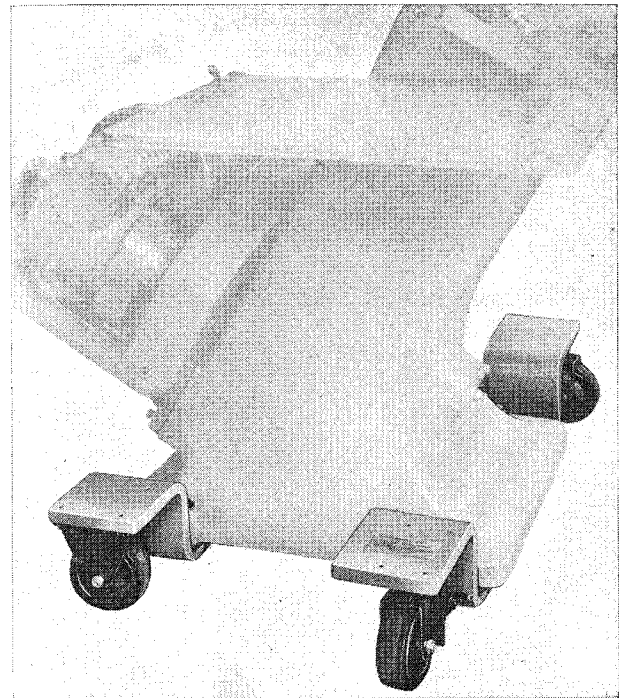
An Extension Delivery is available for all PMC Die Cutting Machines. Die Cut labels are delivered directly to an inspection table. The extension delivery is adjustable to accommodate the full range of sizes of labels that are die cut on the PMC Die Cutting Machine. The extension delivery can be attached to any PMC Die Cutting Machine, even after the machine has been put into service. Full instructions are included.



Labels may be checked for register

PORTABLE UNIT

The portable unit makes it possible to move the PMC Die Cutting Machine into and out of your production line as required. The unit is equipped with two rigid and two locking swivel casters.



Portable Unit for PMC Die Cutting Machine