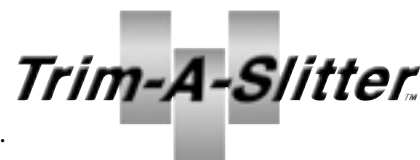


# Assembly, Operation, Maintenance, Lubrication and Parts List



## I. Assembly.

- A. Loosen crank handle set screw with T-Wrench. Align set screw with flat of shaft and tighten snugly in place. Check periodically that set screw is tight on flat of shaft.

## II. Operation.

### A. Slitting.

1. Loosen set screws and slide upper knife into cutting position by aligning the edge of knife with desired mark on the tape rule scale; tighten set screw securely. Next, slide the lower knife (carefully) against the upper knife and tighten set screw securely in place. Repeat this procedure with the other knives if more than one cut is to be made. If no other cuts are to be made, slide knives at least 3 inches apart to avoid marring or cutting material.
2. Place one edge of material against the rollers of the fixed guide on the feed shelf. Slide the adjustable guide up against the opposite edge of material and hand tighten both knobs (do not pinch material between guides as improper slitting may occur).
3. Push material into knives and rotate handle counterclockwise, material will now be pulled through the slitter by the knives as it is slit.
  - a. For maximum performance during slitting operation, ensure material is flat, level and supported with the feed shelf and the output side of the tool.
  - b. When cutting close to one edge of wider material it may be necessary to lightly hold the material down on the feed shelf surface to prevent the material from buckling upward and therefore not running true between the guides.
  - c. With harder or thicker materials, or if material twisting occurs, a better cut may sometimes be obtained by horizontally separating the upper and lower knives a few thousandths of an inch from one another.

### B. Rib Forming/Stiffening

Material may be rib formed, stiffened and/or made more decorative by setting the knives about 1/8 inch apart. Use 2 knives an 1/8 inch apart for a single rib, or use 3 knives spaced an 1/8 inch apart for a double rib.

## III. Maintenance & Lubrication

- A. Maintain a light film of protective oil on shafts, rollers, set screws and gears, and when not in use, knives. Be sure to always clean knives before use.
- B. To clean knives. Warning: Knives are extremely sharp and can cause serious injury to user. Ensure hands, fingers or loose clothing are never in contact with tool while in operation. Spread knives apart 3 to 4 inches to prevent catching of cloth while cleaning. Hold a dry cloth to knife face and edge and slowly rotate shaft until clean. For stubborn dirt, use kitchen cleanser on cloth or steel wool. Use fine emery cloth if needed being careful not to leave scratches in knife edge.
- C. Knives can be re sharpened using a surface grinder or blanchard mill. The sides should be ground just enough to bring back a clean sharp edge. Do not grind on the O.D. face of the knife.
- D. Check that the fixed guide is square to the arbor shafts before use. To square the fixed guide, use a 3/4" piece of plywood or similar flat material approx. 6" x 18". Slide knives to ends of shaft away from fixed guide. Prop piece up against shafts. Place 1 end of square against piece and 1 against the rollers of the fixed guide. To adjust, loosen both hex head screws on fixed guide, position rollers along square and re-tighten.

## IV. Knife Configuration

- A. Standard configuration of 4 knives will permit:

From the factory	1 slit	2 simultaneous slits	1 single rib form
2 simultaneous single ribs	1 simultaneous slit & rib	1 double rib (facing up)	1 double rib (facing down)

- B. Extra slitting knives can be added, or removed as needed. Each slit/rib requires 2 knives. Exact number of knives may vary depending on your particular requirements (see section V on reverse side).

Continued on Back

## V. Adding/Removing Knives or Dies

**Step 1.** Remove feed shelf - remove Allen head shoulder screws and square nuts which hold feed shelf to brackets - 1 screw & nut each side.

**Step 2.** Remove carrying handle and cover - remove Phillips head screw, one from each end of carrying handle.

**Step 3.** Remove end plate - slide upward from bearing block end.

**Step 4.** Free retaining rods - remove two nuts and washer from each retaining rod at the bearing block.

**Step 5.** Loosen and slide knives to left of center on shafts.

**Step 6.** Place shims/supports between shafts and base just left of center. (This avoids possible shaft and base deflection).

**Step 7.** Remove bearing block - remove 4 screws from bottom (see note at right). Tap gently and evenly from inside center of bearing block to ensure block slides off shafts evenly.

**Step 8.** Place additional knives on shafts, move knives from one shaft to another, etc.

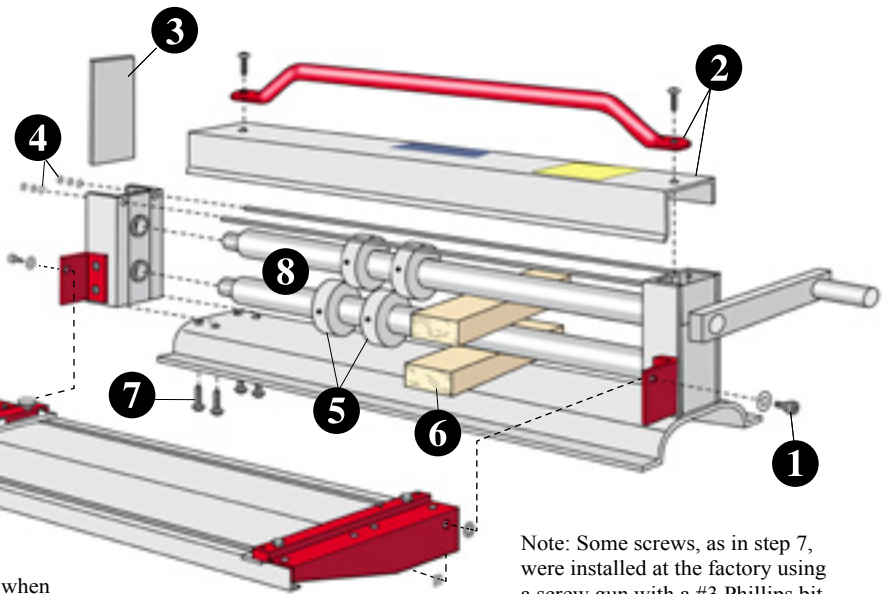
### REASSEMBLY

1. Slide bearing block & rods back into position.

2. Replace four screws holding bearing block to base and tighten. Shafts should fit snug against bronze bearings on both ends to prevent shafts from shifting laterally (side to side). Remove shims.

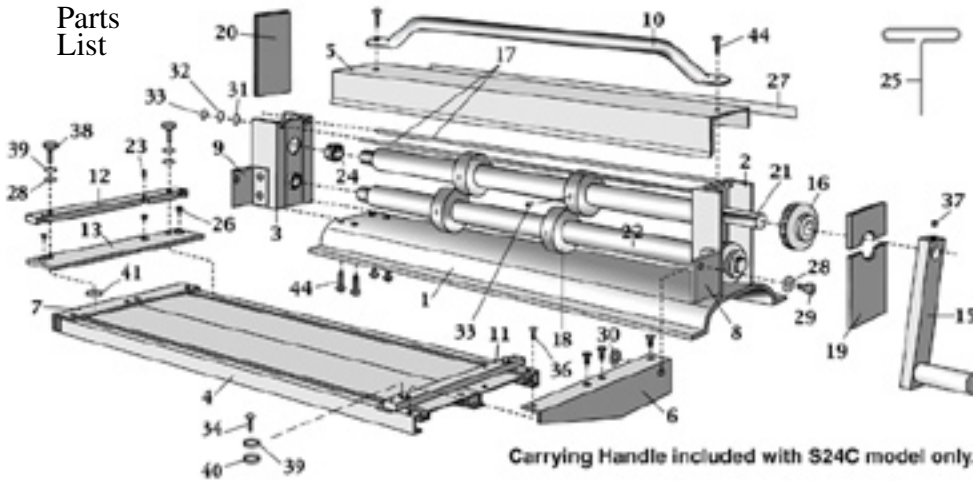
3. Reinstall washer and 1 nut to tie rod, tighten snugly. Nut is too tight when operating handle does not turn easily. Once properly tightened, install remaining nut.

4. Reverse assembly steps 3, 2 and 1. Note: After the shelf is installed, the fixed guide should be checked to be at 90 degrees with the shafts (see Maintenance & Lubrication, item D page 1).

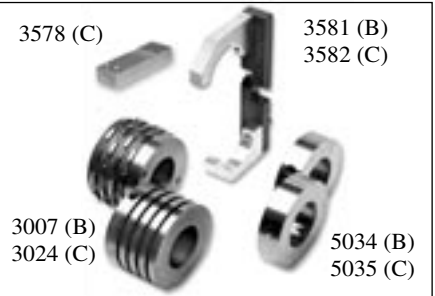


Note: Some screws, as in step 7, were installed at the factory using a screw gun with a #3 Phillips bit. When a gun is not available, use a large #3 Phillips screwdriver.

### Parts List



Carrying Handle included with S24C model only.



Add-On Slitter Power Packages		
Part No	HP	Rating
3521	1/3 HP	115v 60HZ
3522	1/3 HP	220v 50HZ
3533	Hi-Torque	220v 50HZ
3535	Hi-Torque	115v 60HZ

Add-On Slitter Knives for Multiple Slitting		
Part No	Model	Shaft Size
5034	B	1 1/2"
5035	C	2"

Add-On Accessories		Part No
Perforator Rollers B Model		3007
Booster Block C Model		3578
Perforator Rollers C Model		3024
Capacity Boosters C Model		3582

Model		S14B	S24B	S24C	S36C	S48C
Ref	z Description	Part No	Part No	Part No	Part No	Part No
1	Base, Main Slitter	5001	5002	5002	5003	5004
4	Shelf, Material Feed	5007	5008	5008	5009	5010
5	Cover, Top	5011	5012	5012	5013	5014
10	Carrying Handle, Top	N/A	5020	5020	N/A	N/A
17	Tie Rod	5029	5030	5030	5031	5032
18	Knife, Steel Slitting	5034	5034	5035	5035	5035
21	Arbor Shaft, Top	5038	5042	5046	5048	5050
22	Arbor Shaft, Bottom	5039	5043	5047	5049	5051

### Parts For All Models

Ref	Description	Part No
2	Bearing Block, Right	5005
3	Bearing Block, Left	5006
6	Shelf End Bracket, Right	5015
7	Shelf End Bracket, Left	5016
8	Shelf Pivot Bracket, Right	5017
9	Shelf Pivot Bracket, Left	5018
11	Guide Bar, Right	5023
12	Guide Bar, Left	5024
13-14	Nylon Wear Strips	3518
15	Crank Handle	3514
16	Gear, Spur Drive	5028

Ref	Description	Part No
19	End Cap, Right	5036
20	End Cap, Left	5037
23	Roll Pins, Steel	3517
24	Bearings, Oilite Bronze (2 ea.)	3516
25	T-Wrench 5/32"	5054
26	Roller Guides, Edge (6 ea.)	3515
27	Tape Rule	5059
33	Screw, 5/16-18x3/8" Gib (4 ea.)	3631
37	Screw, 5/16-18 Socket Set	2014
38	Screw, 5/16-18 Lock Knob	2015



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