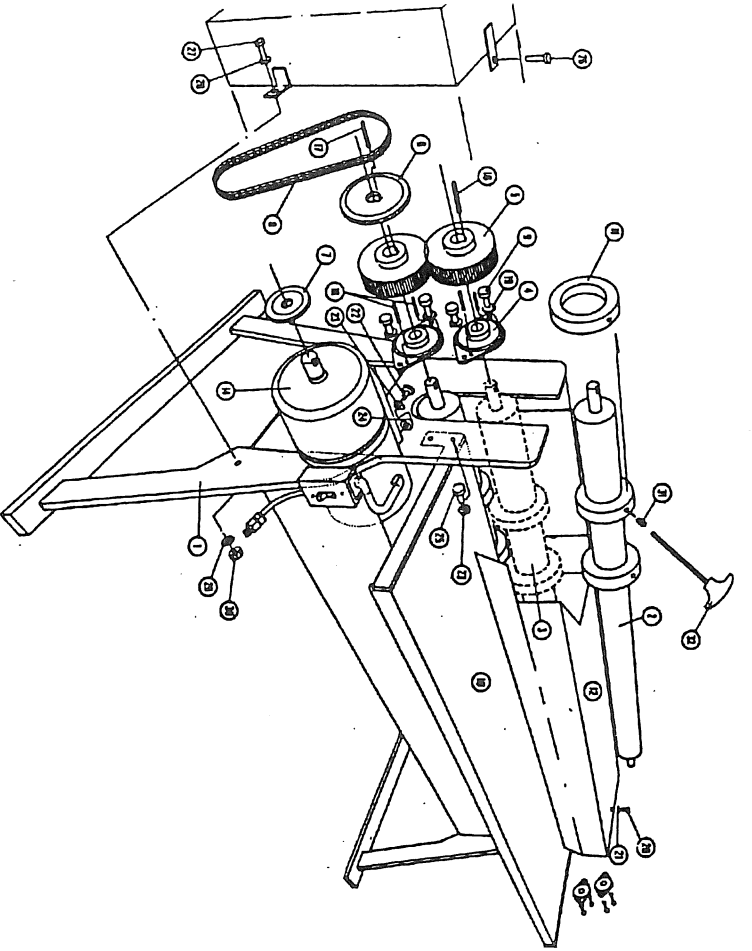


**READ ME NOW**  
**IMPORTANT INFORMATION**



**PARTS LIST**

#	Part #	Qty	Description	#	Part #	Qty	Description
1	MS48-01	1	Main Frame	17	MS48-17	1	Key
2	MS48-02	1	Top Arbor 3" Diameter	18	MS48-18	8	Bearing Pin (N/S)
3	MS48-03	1	Bottom Arbor 3" Diameter	19	MS48-19	8	Lock Washer 7/16" I.D.
4	MS48-04	4	Arbor Shaft Bearing	20	MS48-20	2	Boit 1/4-UNC x 1/2 Lg
5	MS48-05	2	Spur Gear	21	MS48-21	2	Lock Washer 1/4 I.D.
6	MS48-06	1	Driven Sprocket	22	MS48-22	6	Boit 3/8 UNC x 1-1/2 Lg
7	MS48-07	1	Drive Sprocket	23	MS48-23	10	Lock Washer 3/8" I.D.
8	MS48-08	1	Roller Chain	24	MS48-24	6	Nut 3/8 - UNC
9	MS48-09	8	Hex Bolt 7/16-UNC x 3/4" Lg	25	MS48-25	4	Boit 3/8 UNC x 1-1/4 Lg
10	MS48-10	1	Table Assembly	26	MS48-26	3	Self-Tapping Screw 3/8"
11	MS48-11	4	Knife - 4-1/2 x 3 x 3/4	27	MS48-27	2	Boit 5/16 UNC x 1-1/2
12	MS48-12	1	Finger Guard	28	MS48-28	2	Flat Washer 9/16"
13	MS48-13	1	Chain Guard	29	MS48-29	2	Lock Washer 5/16"
14	MS48-14	1	Electric Gear Motor	30	MS48-30	2	Nut 5/16 UNC
15	MS48-15	1	Sheet Guide	31	MS48-31	12	Brass Set Screw 3/8-16x5/8
16	MS48-16	1	Key	32	MS48-32	1	Allen Key 3/16"

Specifications subject to change without notice.

**SPAR-Marathon**  
**ROOFING SUPPLIES**  
 A division of SPAR Roofing & Metal Supplies Limited

WESTON SERVICE CENTRE: 3689 Weston Road, Weston, Ontario, Canada M9J 1W4  
 PH: (416) 745-4111 • Ontario: (800) 367-2873 • FAX: (416) 745-6773  
 TORONTO SERVICE CENTRE: 1360 Bloor Street West, Toronto, Ontario, Canada M6H 1P2  
 PH: (416) 534-9421 • FAX: (416) 534-9373



**SPAR-Marathon**  
**ROOFING SUPPLIES**

**SUPER SLITTER - #48**

**OPERATING INSTRUCTIONS and SAFETY INFORMATION**

## PLACING THE MACHINE:

1. Install with motor mount facing operator.
2. Set the machine at the temporary or permanent location.
3. Remove the factory packing and rust protective spray.
4. A simple feeding table and receiving table will aid in increasing productions and more consistent sizing by eliminating exit material sag.
5. Receiving table should be castored for easy placement at Brake station.

## SETTING THE KNIVES

1. Adjust bottom knives by loosening their set screws and slide them to the desired width setting measure from the table feed gauge. Tighten set screws with T-handled allen wrench provided.
2. Move the top knives next to their matching bottom knives, leaving the proper side clearance for the thickness of material to be cut (as per the following chart):

### GAUGE CLEARANCE (inch)

30	0.0010
28	0.0010
26	0.0015
24	0.0020
22	0.0025
20	0.0030
18	0.0040
16	0.0050

3. Put a small amount of oil on the cutting edge of knives to increase their life and cutting performance.
4. Separate knives to allow material to pass through if not splitting, no need to be slid to one end.

## SLITTING

1. Start the electric motor.
2. Feed the material between the table side gauge and the sheet guide.  
Pass material from right to left with the motor facing operator.
3. Apply sufficient pressure on the feed sheet guide to keep material to the gauge while slitting.  
This guarantees good cutting and safer operation.

## KNIFE SHARPENING PROCEDURE

1. Knives may be re-sharpened with a tool post grinder or a surface grinder.
2. Knives must be mounted on a precision stub arbour for either method, and side faces must be ground at 90 degrees to bore to ensure parallelism.
3. **DO NOT GRIND OUTSIDE DIAMETER.**
4. For removal of blades for sharpening, see next section.

## REPLACING BLADES

1. Remove safety cover.
  2. Remove bearing and bolts, mount nuts, and pins on each end.
  3. **NOTE:** Care must be taken in marking bearings so that they can be re-assembled exactly in the original position with the bearing pin installed.
  4. Remove chain by locating link.
  5. Remove shafts.
  6. Install cutters on shafts.
- Replace bottom shaft first, then the top shaft and finally the remaining parts, in reverse order.

## SPECIFICATIONS:

Sheet capacity: 48" (1220mm) width  
Shafts: 3" (76mm) diameter  
Cutting speed: 40 ft per min (0.2 m/sec)

Cutting Capacities:	
Gauge	Max. # of Cuts
30	6
28	4
26	3
24	3
22	2
20	2
18	1
16	1

### **WARNING**

This machine can cause sever injury.  
Never allow fingers to come within 12 inches of the blade.  
**ALWAYS TURN POWER OFF WHEN ADJUSTING BLADES.**

# **WARNING!**

**Misuse of this equipment may result in injury or damage. SPAR-Marathon provides instructions for its safe use, and relies on the purchaser to ensure that these instructions are given to the personnel who will actually be using the equipment.**