



User article - Leading Notch Edge Adjustment



Version 2026.1

SCOTTSDALE
THE TRUSTED STEEL-FRAMING PARTNER

USER ARTICLE - LEADING NOTCH EDGE ADJUSTMENT

Problem/Question

Leading notch edge jamming on 7090G2/5140G2 panel machine.

Explanation

Manufactured items that have the notches punched at the leading end of an item get jammed as it exits through the cut-off die.

Possible resolution

Increase station 4 roller pressure.

Useful tip

The 5 series run 8x 2mm thick Belleville washers in station 1,2 and 3. 9x 1,75mm Belleville washers in station 4 and 5

The 7 series run 9x 1.75mm thick Belleville washers in all stations



Step 1

Release pressure on the M8 set screw by turning ant-clockwise 2 full revolutions.



Step 2

Loosen and remove the locking bolts to remove the jack block.



Step 3

Remove the top spacer.

**Step 4**

Remove the 9 Belville stack washers, taking note of the stack configuration (3 facing down – 3 facing up – 3 facing down).

**Step 5**

Using the coil stock 1.2mm(18g) cut a shim the size of the spacer.

**Step 6**

Insert the shim into the side block pocket then replace the Belville spring washers using the same stacking configuration as they were removed.

**Step 7**

Replace the spacer back on top of the stack.



Step 8

Place the jack block back in position and secure tightly.



Step 9

Tighten back down the M8 set screw till the set screw locks down on the jack block



Step 10

****Repeat the process on the other side of the station 4 roller****