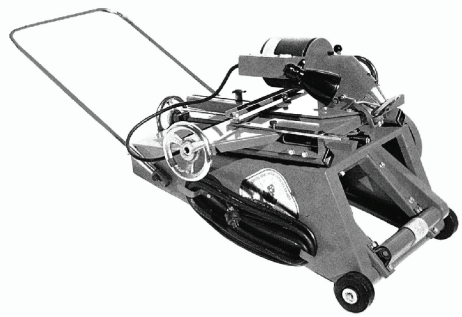
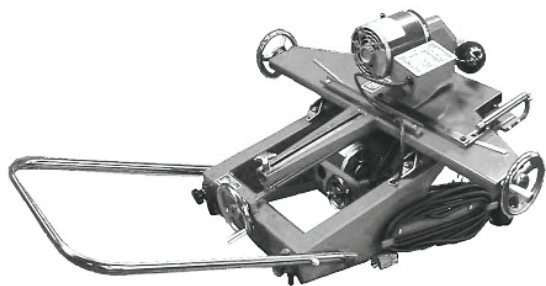


## SAFETY INSTRUCTIONS



400B PORTA-TRUER



405 PORTA-TRUER

### Owner's Responsibility

To maintain machine and user safety, the responsibility of the owner is to read and follow these instructions:

- Follow all installation instructions.
- Make sure installation conforms to all applicable Local, State, and Federal Codes, Rules, and Regulations; such as State and Federal OSHA Regulations and Electrical Codes.
- Carefully check the unit for correct initial function.
- Read and follow the safety instructions. Keep them readily available for machine operators.
- Make certain all operators are properly trained, know how to safely and correctly operate the unit, and are properly supervised.
- Allow unit operation only with all parts in place and operating safely.
- Carefully inspect the unit on a regular basis and perform all maintenance as required.
- Service and maintain the unit only with authorized or approved replacement parts.
- Keep all instructions permanently with the unit and all decals/labels/notices on the unit clean and visible.
- Do not override safety features.

### ⚠ NOTICE ⚠

Read entire manual before assembling, installing, operating, or servicing this equipment

### Operator Protective Equipment

Personal protective equipment helps make tire servicing safer. However, equipment does not take the place of safe operating practices. Always wear durable work clothing during tire service activity. Loose fitting clothing should be avoided. Tight fitting leather gloves are recommended to protect operator's hands when handling worn tires and wheels. Sturdy leather work shoes with steel toes and oil resistant soles should be used by tire service personnel to help prevent injury in typical shop activities. Eye protection is essential during tire service activity. Safety glasses with sideshields, goggles, or face shields are acceptable. Back belts provide support during lifting activities and are also helpful in providing operator protection. Consideration should also be given to the use of hearing protection if tire service activity is performed in an enclosed area, or if noise levels are high

### FAILURE TO READ AND FOLLOW ALL WARNINGS AND INSTRUCTIONS IN THIS MANUAL CAN LEAD TO SERIOUS PERSONAL INJURY OR DEATH TO OPERATOR OR BYSTANDER.

THE OWNER IS RESPONSIBLE FOR MAINTAINING THE OPERATION INSTRUCTIONS AND DECALS FOR OPERATOR REFERENCE.  
FOR ADDITIONAL COPIES, CONTACT TSISSG

## Warranty Statement & Return Policy

Warranty & Workmanship you can depend on.

TSISSG products are designed and developed by experts in their respective industries. Our passion for designing and testing is second only to our drive for creating industry innovations and real world solutions which our customers can depend upon. With over 25 years of manufacturing experience we maintain the ability to provide competitive prices while employing and manufacturing in the USA. We are the manufacturer of virtually all our products so taking pride in workmanship and standing behind each and every product is not just our claim but our uncompromising responsibility.

TSISSG products are warranted to be free from defective workmanship for a period of (90 days) from the date of original purchase to original owner. Repair labor is warranted for (90 days) from date of original purchase. Bushings, bearings and normal wear and tear are not covered under warranty. Blades for the tire cutters are not covered under the warranty. Careless handling, negligence, misuse, abuse, mutilation, improper operation, making unauthorized repairs, additions, and or alterations automatically cancels this guarantee and relieves TSISSG of any obligation. Any warranty parts need to be returned, prepaid, to the plant listed on the RGA for credit. Any warranty parts shipped from the plant will be shipped at the customer's expense. Material or product returned to the wrong plant will be refused. Any warranty work needed on a machine must be brought to the manufacturing plant in Monticello, MN or authorized by TSISSG.

Return Policy:

**!!WARNING!!** Goods returned without RGA will be refused. All returns will be subject to a 15% handling charge, plus any additional charges for reconditioning and repackaging. A returned goods authorization (RGA) form must be obtained before returning any material or goods. All material or goods must be returned within 15 days of RGA date or RGA will be void.



TIRE SERVICE EQUIPMENT MFG. CO. INC.  
SAF-TEE SIPING & GROOVING INC.



1. Uncrate machine and remove any securing wires used for shipment.
2. Unwrap tool package which contains set of profile gouges and spanner wrench for installing blades.
3. Study picture above for nomenclature.
4. CAUTION: Do not true tires from a vehicle which has been parked. Have the vehicle driven at least 4 miles and immediately jack up wheels which are to be trued.
5. Jock up wheel so that the bottom of the tire to be trued clears the floor. The wheel should be high enough off the floor to place the center of the axle at the height of the top of the cutter blade; however, variation up to one inch above or below the specified elevations will not seriously impair the efficiency of the cutting.
6. For front wheel truing, turn the steering wheel to the extreme left limit for front left wheel (opposite for right front wheel) and lock in place.
7. Remove surface grit, imbedded stones and metal objects from tire as thoroughly as practical.
8. Determine the profile of the tread with the set of profile gouges furnished. These are marked in even numbers. If no one will fit exactly, the proper profile will be the odd number between the gouge that is too flat and the gouge that is too curved.
9. Before moving the PORTA-TRUER to the tire, see that the cutting blade is exactly centered in the truer (both top and bottom profile arms parallel), and then set the profile index pointer to the desired number. This is done by loosening the top hand knob and sliding forward or backward. Be certain to tighten hand knob in this position.
10. Locate PORTA-TRUER in line with the center of the tire, with the blade about 1/4" from the tire.

NOTE: The thumb screw (P-16 on the picture) is normally used in position No.2, where stamped on the pivot link; however, when truing dual tires, and in cases where the movement of the top motor may be restricted by springs, etc., move the thumb screw to rear position No. 1.

12. Turn on drive roller switch before contacting drive roller with the tire, and gently apply pressure with the small hand wheel until tire is turning uniformly. Since the drive roller is knurled, this will take very little pressure. If the drive roller is in contact with the tire when the switch is turned on, the snatching effect may move the PORTA-TRUER slightly so that it will have to be re-aligned.

13. Use the rear hand wheel to advance the blade until it nearly starts cutting. By observing how much the tread is out-of-round you can judge the depth of the cut necessary. In no case should a single cut be more than 1/8" in depth.

14. The blade motor switch is now pushed in the direction which truing is to be performed. You can start at the center rib or either outside rib. With the rear hand wheel, advance the blade until the proper cut is being made and traverse the blade slowly across the tread. This cut will be a perfect profile of the original tread in accordance with the setting of the index of the profile arm. During the traversing movement it is possible to override this profile by turning the rear hand wheel in or out to compensate for unusual rib conditions in the tread. Upon passing the outside rib, the motor is allowed to stop and is reversed with the switch in the return direction. The return traverse should be a very light cut sufficient only to remove the small feathers remaining from the first cut. It is possible that a beginner will prefer to repeat the above operation, taking lighter cuts until all the high spots in the tread have been removed, but after a few tires experience, they will get the feel of complete control, and can true the tire on one cutting pass and one return cleanup pass. The Amermac blade is specially hardened but will become dulled by the normal abrasive characteristic of tread rubber, and specially so by unseen imbedded objects in the tread. To insure a clean smooth job, the blade is sharpened continuously, by the automatic sharpener. For additional sharpening, use the manual sharpening arm located on the side of the cutter head.

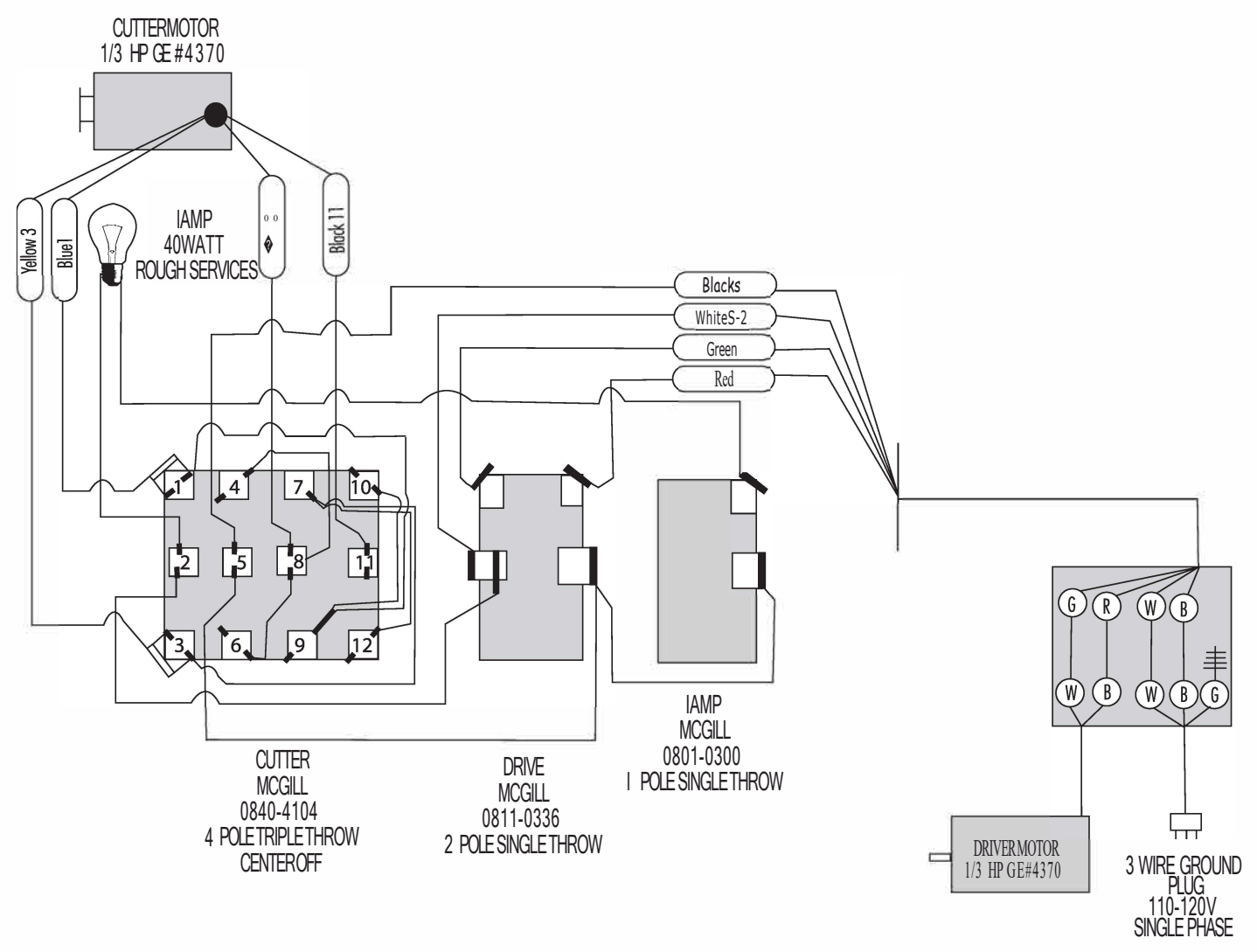
NOTE: After installing a new blade, which is not sharp, use the manual sharpening arm to sharpen the new blade.

15. When the truing is completed, cut off all switches, disengage drive roller, and slide PORTA-TRUER rearward about 3 inches. Then lift the machine with the handle and back off from the tire, or relocate to the adjacent dual tire.

NOTE: Your Amermac PORTA-TRUER, since it trues a tire rotating on its own wheel bearings, is the ultimate in extreme accuracy; however, a wheel carrying an absolute true tire can still be out of balance due to other factors such as rim, hub, or drum defects, and should be checked for correct balance by any good on-the-car balancer.

**NOTICE**  
TO CHANGE ROTATION ON CUTTER MOTOR  
EXCHANGE THE YELLOW AND BLUE WIRES

MODEL 711 after serial # P-429  
MODEL 400 B after serial #243-D



*\*FOR YOUR SAFE MACHINE SHOULD BE PLUGGED INTO A GROUNDED OUTLET*