

**Before Operating Your Tools,
Please Read This Instruction Carefully**



Precision Foot Shear

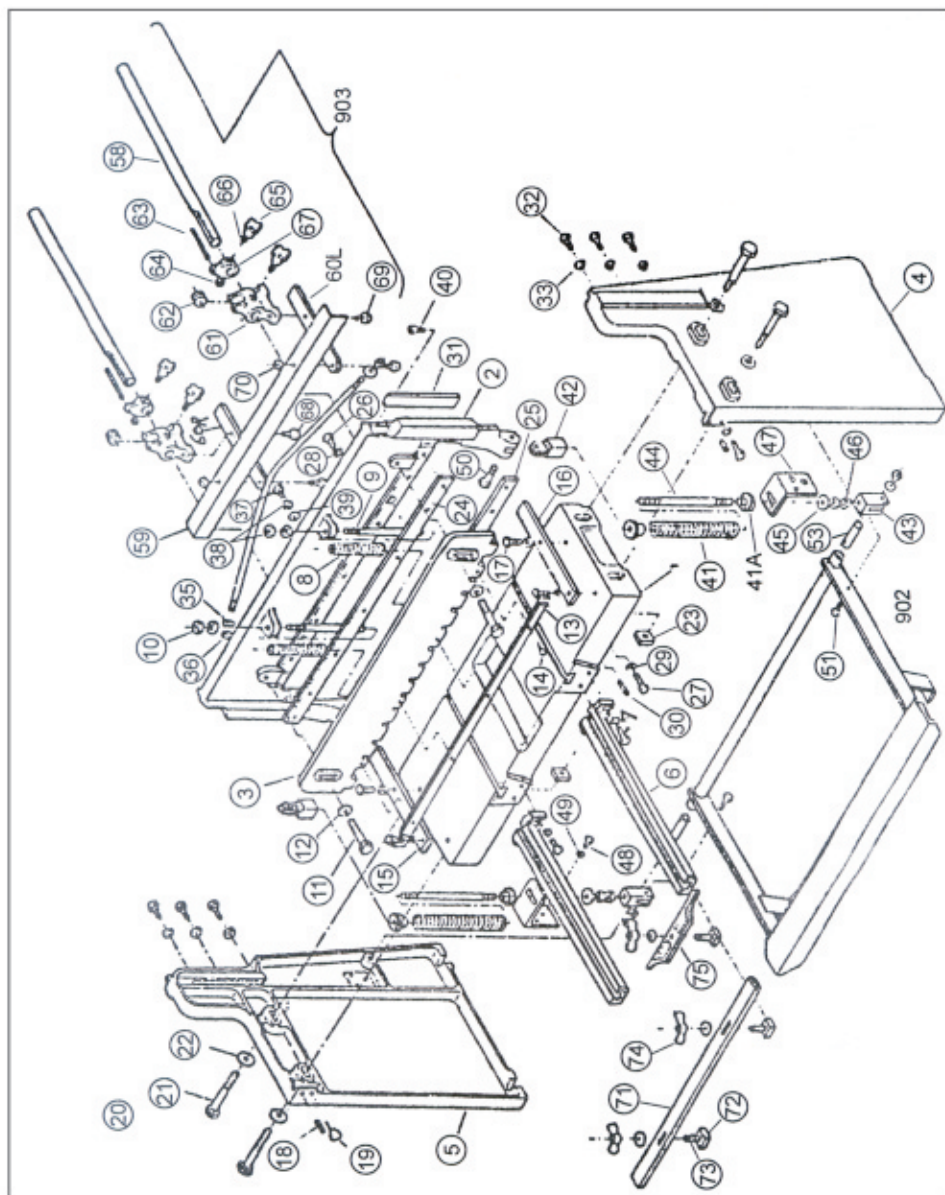
**ITEM NO.61-251-128
MODEL NO . #FS52**

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PARTS LIST

PART#	DESCRIPTION	PART#	DESCRIPTION
1	Table	38	Nut.adjscREW
2	Cutter Bar	39	Washer,adj. Screw
3	Holddown	40	Set Screw. Back Gauge Rod
4	R.h. Side Panel	41	Spring. Foot Pedal
5	L.h. Side Panel	41-A	Cap. Spring
6	Front Arm Ext	42	Swivel. Top
7	Screw. Front Arm Ext	43	Seivel. Bottom
8	Spring. Holddown	44	Stud.spring
9	Stud.holddown Spring	45	Washer.spring
10	Nut,holddown Stud	46	Nut.spring Stud
11	Screw.holddown	47	Brkt Spring Mtg
12	Washer. Holddown Screw	48	Screw.spring Mtg.brkt.
13	Finger Guard	49	Waser.screw Spring Brkt
14	Screw.finger Guard	50	Screw.top Swivel
15	Scale.l.h.table	51	Screw.bottom Swivel
16	Scale.r..table	54	Split Pin Pedal Bar
17	Screw.table Scale	58	Rod,rack Gauge
18	Set Screw.table Adj	59	Stop.back Gauge
19	Screw. Table Lock	60R	Ext Bar, Back Gauge
20	Washer. Table Lock Screw	60L	Ext Bar.back Gauge
21	Bolt.table	61	Adj.block.back Gauge
22	Washer.table Bolt	62	Adj.dial.back Gauge
23	Nut.table	63	Adj.screw.back Gauge
24	Knife.upper	64	Nut.adjscRE
25	Knife.lower	65	Knob.lock
26	Screw.upper Knife	66	Stud,knob
27	Screw.lower Knife	67	Adj.brkt.
28	Washer.upper Knife	68	Screw.ext Bar
29	Washer.lower Knife	69	Swivel Bolt
30	Set Screw.lower Knife Adj.	70	Nut.swivel Bolt
31	Shim.c'bar	71	Stopfront Material
32	Screw C'bar Shim	72	"t"nut
33	Nut.c'bar Shim Screw Lock	73	Stud"t"nut
34	Straightener Rod,c'bar	74	Wing Nut "t"nut
35	Washer.strightener Rod	75	Bevelgauge
36	Nut.straightener Rob	902	Pedallassembly
37	Adj.screw.straightener Rod	903	Back Gauge Assembly



Receiving and Unpacking

On receiving your machine, please examine if the outer packing is in good condition, then remove the cover to inspect whether there is any damage or loss caused during the transportation. If any is found, please immediately notify the transportation and your supplier. Some parts and accessories are knocked down and in bulk packing to save transportation space, please check those parts and accessories in extra care. List for parts and accessories in bulb pack as below:

Parts in bulk packing: Wrenches, Plastic handle covers(spare), Counterweight.

Installation

Be sure to install your shear on a solid level floor. The work area should be well lighted to prevent any wrong or danger in operation.

Fix the machine onto the floor with anchor bolts to prevent from vibration.

Place an precision level on the table surface to level the machine in all directions. Insety metal shims between floor and the shear mounting surface to adjust the level. Tighten all of the bolts after those being adjusted.

Cautions

The knife is sharp. Take extra care in operating. Keep hands away from the reach of blade.

Wear safety glasses or goggles to protect your eyes. Wear protective type foot shear. Keep the work area clear and clean to avoid slipping or tripping.

Never take away the protective guard. keep hold down the clearance to the minimum gap required to feed material.

Never use shear to cut or material exceeding its designed capacity.

Never attempt to shear any material less than a 1/2" cut across the full length the table under full capacity.

Operation Instructions

The chart below is a material conversion comparison to show equivalent capacities of material other than mild steel.

	16GA	18GA	20GA
Mild Steel Gause	.060	.048	.036
Stainless Steel			.031
Sae 1050 Cold Rolled	.048	.036	.030
Aluminum	.100	.090	.053
Brass Yellow			
Soft	.072	.064	.051
1/2"hard	.064	.051	.036
Hard	.064	.051	.036

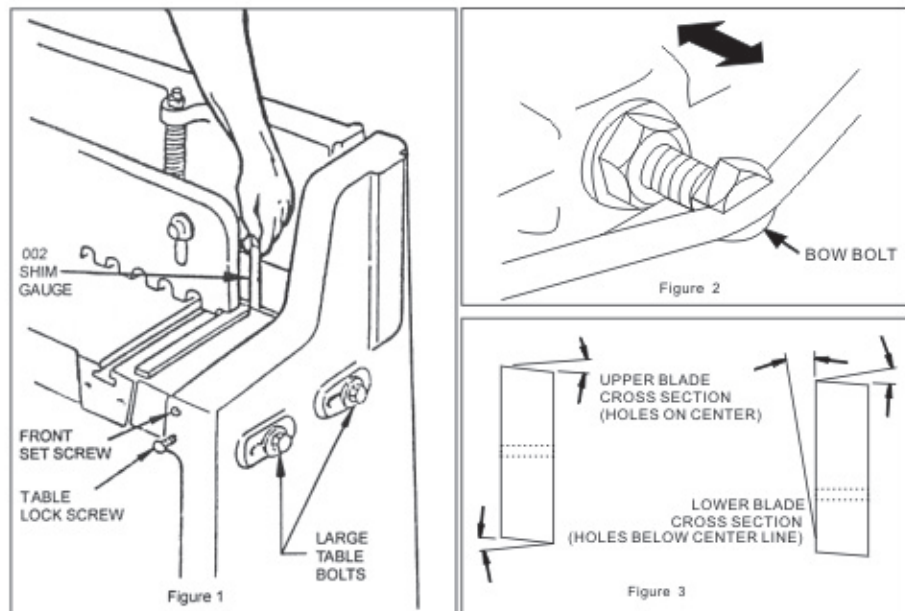
	16GA	18GA	20GA
Bronze, Phosphor			
Annealed	.060	.051	.040
Copper			
Soft	.072	.064	.051
HARD	.064	.051	.040
PLASTICABS COMPOUNDS	.200	.150	.120

◆ Back Gauge Adjustment

On adjusting Back Gauge, loosen adjustment knobs, slide angle against blade. Remove rod forward or backward for scales to read zero on pointers. Lock bracket again and do further adjustment with wienier wheel. Tighten socke screws to lock rods in place.

◆ Blade Clearance Adjustment

To adjust blade clearance, loosen Front Screws and Table Lock Screws and loosen Table Bolts on both side. Use a 0.002" shim gauge and adjust table in or out by use of Table Lock Screw. Then, tighten all screws. (See Figure 1)



◆ Cutter Head Adjustment

If cutter head is bowed after use. Adjust Bow Bolt. Check for looseness of mounting bolt. Retighten all Bolts. (See Figure2)
To adjust the end of blade up or down, drop pin on treadle and loosen jam nut. Adjust yoke up or down. Reassemble them.
Loose Lock Screws may cause shake of blade in operation. Check and assure they are rightly against shims. But be careful not to dimple them.

◆ To Sharpen the Blade

The upper blade has two cutting edges which are ground with a 2 degree edge relief. Reverse to expose the new cutting edge as soon as one edge is dull. it can be sharpened on a surface grinder by grinding both wide side of the blade.
The lower blade has one cutting edge with a 2 degree edge relief and a 1 degree face relief. It can be resharpened on a surface grinder by grinding the wide side of the blade having the 1 degree relief.(See Figure 3)

◆ PARTS DRAWING

See next page