

**MODEL JG SERIES
BENCH METAL MANUAL SHEAR**

MS-20 MS-24 MS-28 MS-32

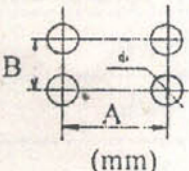


OPERATION MANUAL

1. USAGE

The manual shear of JG series can mainly be used to shear all the stocks of mild steel: flat steel, square steel and rod steel . It can be used to shear non-ferrous metal or plate and bar. The machine is easy to operate and carry, light in weight, small in size and takes the advantage of no power consumption . It is an ideal tool for energy-saving.

2. MAIN TECHNICAL SPECIFICATION

Technical desc.		Model	MS-20	MS-24	MS-28	MS-32
Item						
Max. processing capacities	Flat steel		30x8	35x12	40x12	40x14
	Square steel		18x18	20x20	24x24	28x28
	Rod steel		φ 4~20	φ 4~24	φ 4~28	φ 4~32
Meast (cm)			40x23x36	44x26x41	46x28x43	51x28x43
Net weight (kg)			14	23	34	48
Dimension after installation			244x90x13	270x94x13	310x104x13	380x12x13

3. INSTALLATION AND CAUTION

3.1 Installation

3.1.1 Please check whether the part of this machine are fully equipped and not damaged according to the parts list figure.

3.1.2 This machine should be mounted on hard ground or specific stand (not supplied).

3.1.3 Please leave plenty room around the machine for your easy operating ,in order to avoid injury.

3.1.4 Please remove the anti-rust grease on processing surfaces and some parts included with kerosene.

3.2. Caution

3.2.1 Please read this manual before operation and make yourself understand its structure and principle completely.

3.2.2 Please don't operate the material width or thickness than table list max. range.

3.2.3 Keep proper footing and your body balance. Force should be applied swiftly and steady.

3.2.4 Always be sure that the edge of the moving blade is sharp condition. Sharpen and replace the edge any time it is found to be blunt.

3.2.5. Use a proper auxiliary bar according to the sizes of the stocks to be processed. The recommended length of the bar is 1000–1500mm.

3.2.6. Please don't touch the blade during operation.

3.2.7 Be sure to leave the machine properly and paint a coat of anti-rust oil on the surface of the blade.

4. OPERATION AND MAINTENANCE

This machine is pre-adjusted before out of factory. When you want to shear , please raise handle (#8,#25), insert the workpiece between fixed blade (#2) and locomotive blade (#3), then ,lower the handle (#8,#25) to shear

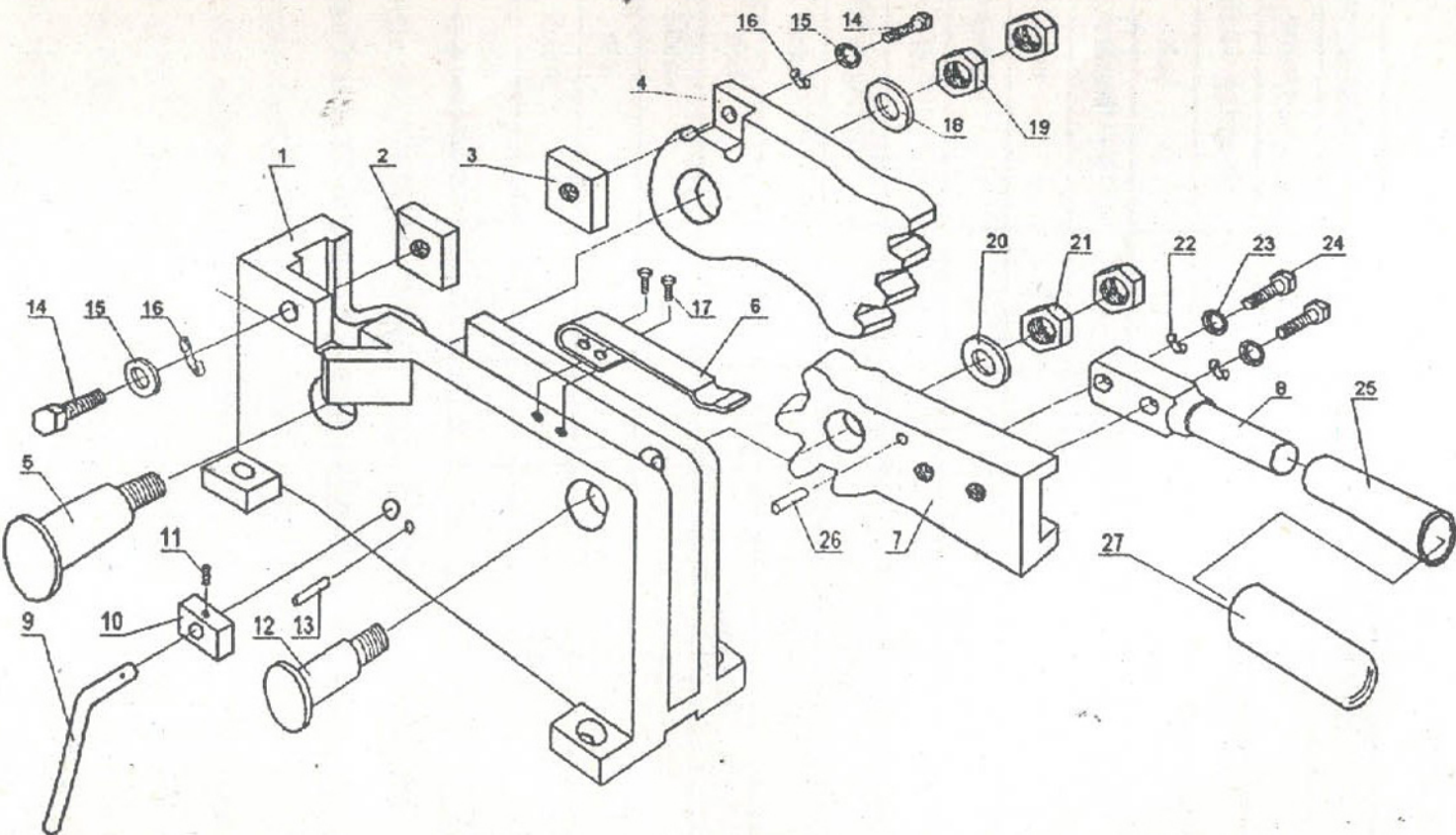
When you shear sheet metal, you must raise and forthcome the handle (#8,#25), the driver (#7) and the movable body (#4) will disengage . And you can turn the handle (#9) to raise the movable blade body (#4), you may lower the driver (#7),you will find their teeth had changed . Andthen,you can shear the thin plate or small bar.

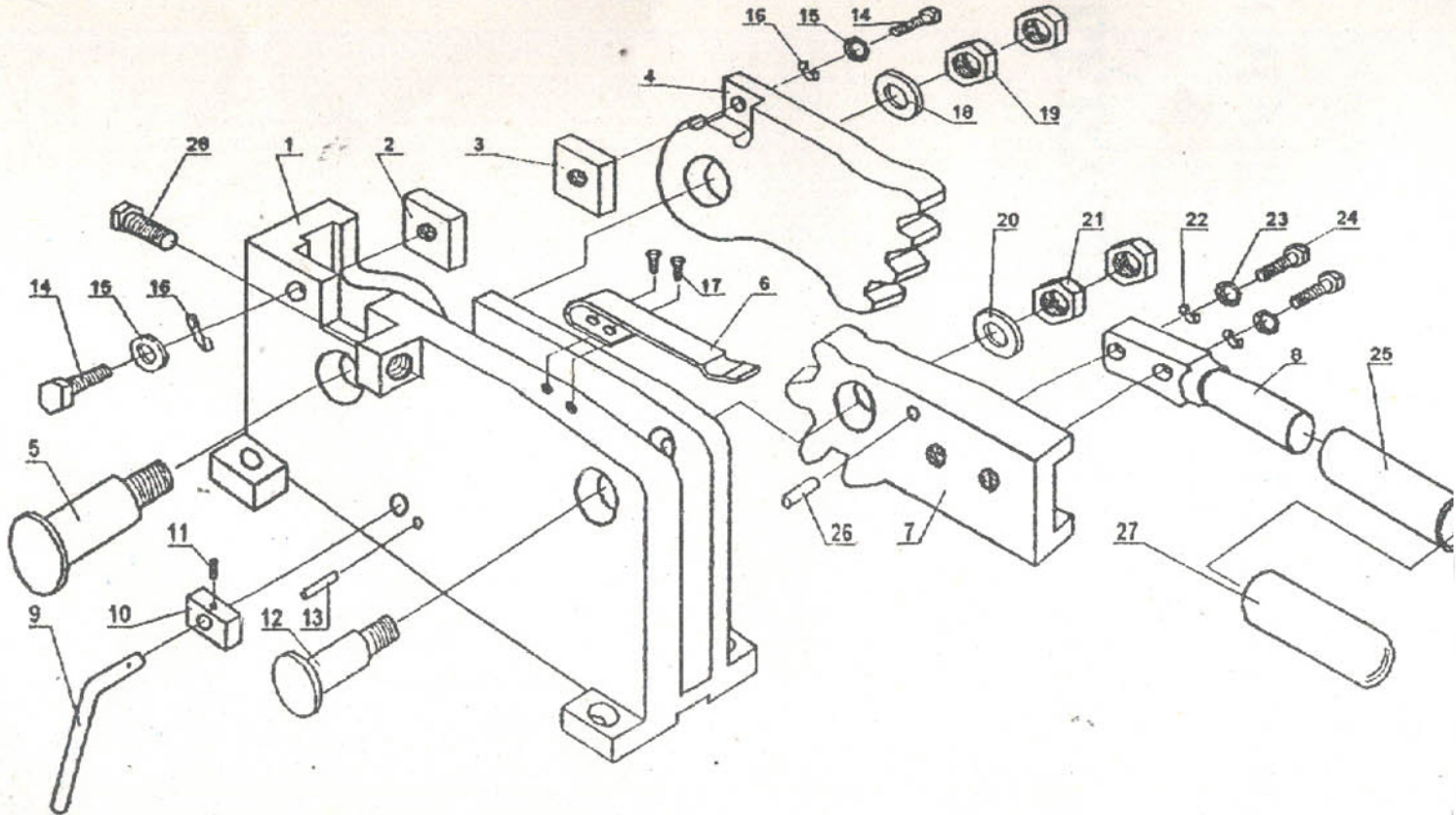
5. PARTS LIST

Part #	Description	Qty.	Part #	Description	Qty.
1	body	1	15	washer	2
2	fixed blade	1	16	spring washer	2
3	locomotive blade	1	17	bolt	2
4	movable blade body	1	18	washer	1
5	shaft	1	19	nut	2
6	locate spring	1	20	washer	1
7	driver	1	21	nut	2
8	handle	1	22	spring washer	2
9	handle - bar	1	23	washer	2
10	stir cake	1	24	bolt	2
11	screw	1	25	handle	1
12	shaft	1	26	pin	1
13	pin	1	27	sheath	1
14	bolt	2	28	bolt	1

Remark: The part #28 only within model MS-28 MS-32 machine.

6. ASSEMBLY DIAGRAM (MODEL MS-20 MS-24)





6. ASSEMBLY DIAGRAM (MODEL MS-28 MS-32)