

FOOT SHEAR

MODEL:Q01-5216 (Q01-1.5x1320)52”

MODEL:Q01-1.0x1000 (37”)



OPERATION MANUAL

1. PRIOR TO INSTALLATION AND OPERATION

Read the following instruction carefully and thoroughly will ensure your machine in perfect function and avoid possible dangers.

2. RECEIVING AND UNPACKING

On receiving your machine, examine if the other packing is in good condition, Then, remove the cover to inspect whether there is any damage or loss caused during transportation, If any is found, please immediately notify the transportation any your supplier, Some parts and the accessories are knocked down and in bulk packing to save transportation space. You must check those parts and accessories in extra care. Then, assemble them on to the machine according to the illustrations.

3. 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 on to the floor with anchor bolts to prevent from vibration. Place a precision level on the table surface to level the machine in all direction. Insert metal shims between floor and the shear mounting surface to adjust the level. Tighten all of the bolts after those being adjusted.

4. CAUTIONS

The knives are 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 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 rod or material exceeding its designed capacity.

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

5. OPERATION INSTRUCTION

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

	Model 37"	Model 52"
MILD STEEL GAUGE	1.0mm	1.5mm
ALUMINUM	1.8mm	2.5mm
BRASS YELLOW		
SOFT	1.2mm	1.8mm
1/2HARD	1.1mm	1.6mm
HARD	1.1mm	1.6mm
BRONZE PHOSPHOR		
ANNEALED	1.1mm	1.6mm
COPPER		
SOFT	1.2mm	1.8mm
HARD	1.1mm	1.6mm
PLASTIC ABS COMPOUND	1.8mm	2.5mm

5.2 BACK GAUGE ADJUSTMENT

On adjusting back gauge, loosen adjustment knobs, slide angle. Remove rod forward or backward for scales to read zero on pointers. Lock bracket again and do further an adjustment with wheel.

Tighten socket screws to lock rods in place.

5.3 BLADE CLEARANCE ADJUSTMENT

To adjust blade clearance, loosen front screws and table lock screws, and loosen table bolts on both sides.

Use a 0.002" slim gauge and adjust table lock screws. Then, tighten all screws. (See Figure 1).

5.4 CUTTER HEAD ADJUSTMENT

If cutter head is bowed after use. You can adjust the bow bolt. Check for looseness of mounting bolt. Re-tighten all bolts. (See Figure 2).

To adjust the blade up or down. Drop pin on treadle and loosen nut. Adjust yoke up or down. Reassemble them.

Loose lock screws may cause shake of blade in operation.

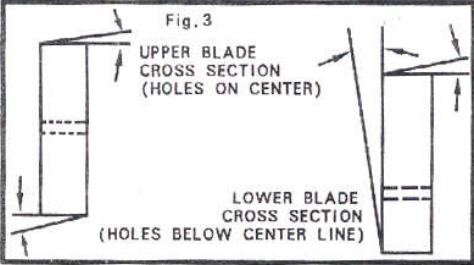
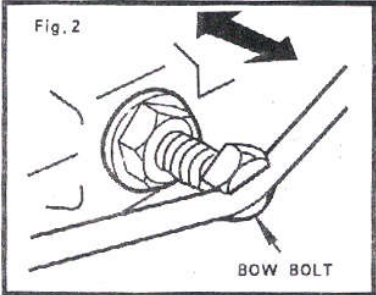
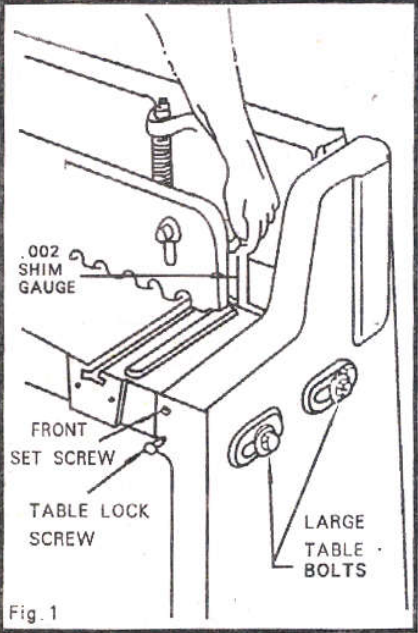
Check and sure they are rightly against shims. But be careful not to dimple them.

5.5 TO SHARPEN THE BLADE

The upper blade has two cutting edges what are ground with a 2 edges relief. Reverse to expose the new cutting edge as soon one edge is dull. It can be sharpened on a surface grinder by grinder by grinding machine both wide sides of the blade.

The lower blade has one cutting edge with a 2 edges relief and a 1 face relief. It

can be re-sharpened on a surface grinder by grinding the wide side of the blade having the 1 relief. (See Figure 3).



ITEM#	Description	Qty	Item#	Description	Qty
1	Work Table	1	39	Washer	1
2	Frame	1	40	Screw	2
3	Pressing plate	1	41	Spring	2
4	Right Stand	1	42	Washer	2
5	Left Stand	1	43	Upper Connecting Block	2
6	Connecting Rod	2	44	Lower Connecting Block	2
7	Screw	4	45	Bolt	2
8	Spring	2	46	Washer	2
29	Bolt	2	47	Nut	2
10	Nut	2	48	Connecting Plate	2
11	Screw	2	49	Bolt	4
12	Washer	2	50	Washer	4
13	Protecting Board	1	51	Upper Pin	2
14	Screw	3	52	Lower Pin	2
15	Workpiece Stop	2	53	Small Shaft	2
16	Gauge	2	54	Foot Stand Frame	1
17	Screw	4	55	Lid	2
18	Bolt	2	56	Pin	2
19	Bolt	2	57	Screw	2
20	Bolt	2	58	Workpiece stop	1
21	Bolt	2	59	Right Fixing Plate	1
22	Washer	4	60	Left Fixing Plate	1
23	Nut	4	61	Find Adjustment Stand	2
24	Upper Blade	1	62	Adjust Nut	2
25	Lower Blade	1	63	Bolt Shaft	2
26	Screw	8	64	Bolt	2
27	Screw	9	65	Small Screw	2
28	Washer	8	66	Large Screw	1
29	Washer	9	67	Large Screw	1
30	Screw	4	68	Bolt	2
31	Sliding Plate	2	69	Gauge Shaft	2
32	Screw	6	70	Nut	1
33	Nut	6	71	Workpiece Pushing Plate	1
34	Surengthening Rod	1	72	Washer	3
35	Washer	2	73	T-style Bolt	3
36	Nut	2	74	Wing Nut	3
37	Adjusting Bolt	1	75	Small Workpiece Pushing Plate	1
38	Washer	2	76	Pin	2

7 ASSEMBLY DRAWING

