

# KAKA Industrial®

## Unpacking

The MINI ROTARY METAL SHEAR is shipped from the manufacturer in a carefully packed Carton box. Thoroughly inspect the product upon opening the package.

After unpacking the unit, carefully inspect for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Shipping damage claims must be filed with the carrier and are the responsibility of the user.

## Specifications

The KAKA MINI ROTARY METAL SHEAR is the perfect addition to any fabricator's work bench. It is precision designed and manufactured to allow for quick and easy trimming of sheet metal pieces and the rotary design allows for both straight and curved cuts. Hardened, round, cutting dies produce clean, burr-free cuts in aluminum, steel and other mild metals.



Stock No. ....172503  
 Model.....MMS-1  
 Max. Capacity.....22 Ga. (0.8 mm)  
 Packing size.....13"x4"x5" (32X10X13 cm)  
 N.W./G.W.....3/4 lbs (1.5/2 kg)

## Important

Blades are coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild

solvents, such as mineral spirits, and a soft cloth. Avoid getting cleaning solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil.

**▲ WARNING**  
*Never use highly volatile solvents.  
 Non-flammable solvents are recommended to avoid possible fire hazard.*

## SAVE THESE INSTRUCTIONS

Thank you for purchasing our MMS-1 MINI ROTARY METAL SHEAR machine. Before attempting to operate your new tool please read these instructions thoroughly. You will need these instructions for the safety warnings, precautions, assembly, operation, maintenance procedures, parts list and diagrams. Keep your invoice number with these instructions. Write the invoice number on the inside of front cover. Keep the instructions and invoice in a safe, dry place for future reference.

## General Safety Information

**▲ CAUTION**  
*Always follow proper operating procedures as defined in this manual even if you are familiar with use of this or similar tools.  
 Remember that being careless for even a fraction of a second can result in severe personal injury.*

## SAFETY RULES

1. Wear proper apparel. Do not wear loose

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clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.

2. Wear protective hair covering to contain long hair.
3. Wear safety shoes with non-slip soles.
4. Wear safety glasses complying with United States ANSI Z87.1.  
Everyday glasses have only impact resistant lenses. They are NOT safety glasses.
5. Be alert and think clearly. Never operate tools when tired, intoxicated or when taking medications that cause drowsiness.
6. Keep work area clean. Cluttered work areas invite accidents.
7. Work area should be properly lit.
8. Keep visitors at a safe distance from work area.
9. Keep children out of workplace. Make workshop childproof. Use padlocks to prevent any unintentional use of tools.
10. Assemble only according to these instructions. Improper assembly can create hazards.
11. When tools are not in use, store them in a dry, secure place out of the reach of children. Inspect the tools prior to storage and before reuse.
12. Maintain product labels and nameplates. These carry important safety information.

## ▲ WARNING

*The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be used by the operator.*

## KNOW HOW TO USE TOOL

1. Use right tool for job. Do not force tool or attachment to do a job for which it was not designed.
2. Keep hands out of path of shear blades.
3. The Max. shearing thickness of this machine is 22 Ga. (0.8mm). Exceeding capacity may be dangerous to operator and damage may occur to the machine.
4. Bolt machine to floor or sturdy stand that is bolted to floor to prevent sliding or tipping of machine.

## ▲ WARNING

1. *This tool has EXTREMELY SHARP cutting dies which can quickly cause severe injury or loss of fingers! Keep fingers and hands away from moving parts when operating.*
2. *Wear thick, well fitting work gloves to prevent cuts from handling sharp metal.*
3. *Frequently inspect cutting dies. If cracks or chips develop, discontinue tool use immediately.*
4. *Always place the handle in the down position. The weight of the handle left in the up position can cause the upper die to suddenly and unexpectedly rotate with great force resulting in severe injury or loss of fingers.*

## Assembly

### ▲ CAUTION

*Always keep the handle in the lowest possible position when not cutting. The weight of the handle can cause the upper die to suddenly and unexpectedly rotate.*

Place the Shear on a clean, level surface at a comfortable working height. Mount securely to

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the work surface using 2 suitable lag screws or bolts (not included) through the two holes in the steel base #18 (Figure 1).

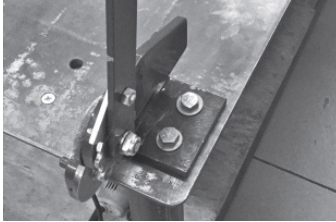


Figure 1

## Cut Layout

For best accuracy it is recommended that you coat the cut area with layout fluid or a marker and then scribe your cut line rather than using a marker (Figure 2). The width of the scribe line will be much smaller and will provide a precise guide when compared to the wide marker line.



Figure 2

## Operation

**⚠ CAUTION**  
*The cutting dies are extremely sharp! Use extreme care when operating to avoid severe cuts or loss of fingers!*

1. Apply moderate pressure to push the metal into the cutting dies #11 & #19 as you pull the handle #2 towards you (Figure 3).
2. To ratchet the handle simply rotate the handle #2 away from you. Gravity will

reengage the pawl #3 on the upper cutting die #19 when you pull it towards you to cut.

3. To make a curved cut, rotate the metal while it is fed into the dies.

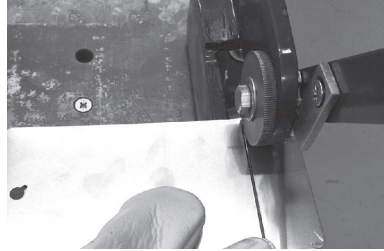


Figure 3

**NOTE:** *The mini rotary metal shear creates its trim, the unwanted cut piece, on the right. When cutting a curve make sure the unwanted portion is to the right of the upper die (Figure 4).*

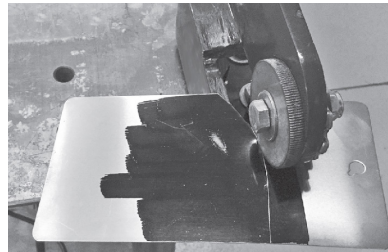


Figure 4

**NOTE:** *The Cutting Dies have been adjusted by the factory for optimal cutting performance. Do not attempt to adjust dies as improper overlap can cause reduced performance and Cutting Die failure.*

## Maintenance

1. Lower the Handle to ensure that it cannot engage the Upper Cutting Die in storage.
2. Apply a thin film of light oil or rust-preventive

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coating to all bare steel areas.

3. Store in a clean, dust-free, dry, dampness free area preferably covered with plastic sheeting.

4. Maintenance should be performed before each use.

5. Check tightness of all hardware.

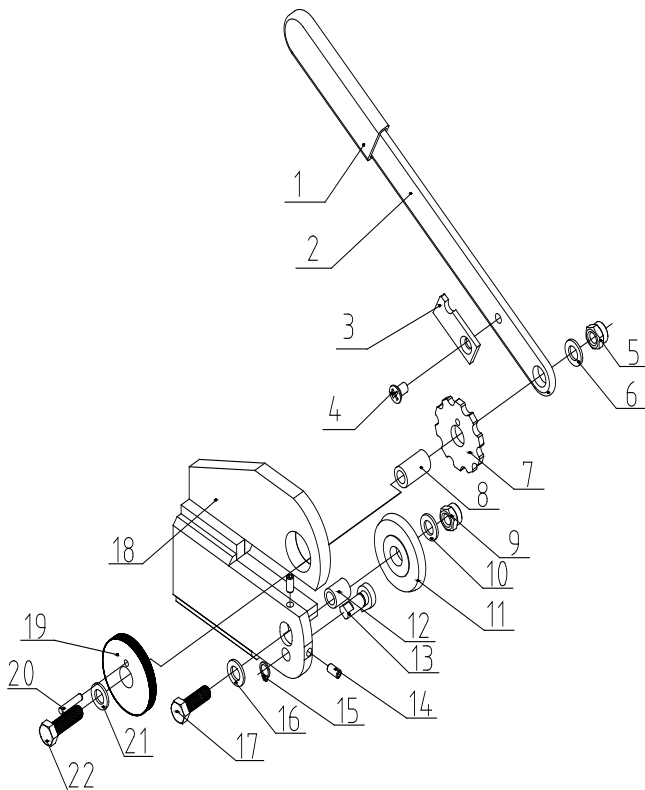
6. Check operation for binding. Lubricate Pivot Points and Dies periodically with a medium bodied lubricating oil.

## Troubleshooting Chart

Symptom	Possible Cause(s)	Corrective Action
Machine will not Cut	1.Ratcheting Pawl is not Engaging Upper Die	Ensure Pawl is engaged and turning the Upper Die as you pull the Handle towards you. If it does not, adjust screw tension on the Pawl so that it can freely drop into the Upper Die.
	2.Tool Body Has Flexed and Cutting Dies are on Top of One Another	Remove the Nut and Bolt fastening the Upper Cutting Die. Remove Die and reinstall in the correct orientation. Cutting edges should be beside one another.
	3.Upper Die is Spinning Freely	Moderate pressure is required to feed the metal into the Dies.

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## Drawing



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## Parts List

Ref.No.	Description	QTY
1	Handle Grip	1
2	Handle	1
3	Pawl	1
4	Screw M6x10	1
5	Hex Nut M8	1
6	Flat Washer	1
7	Gear	1
8	Sleeve	1
9	Hex Nut M8	1
10	Flat Washer	1
11	Lower cutting dies	1
12	Sleeve	1
13	Cam	1
14	Holding Screw	2
15	Ring	1
16	Flat Washer	1
17	Hex Bolts M8x25	1
18	Base	1
19	Upper cutting dies	1
20	Rod Pin 4x20	1
21	Flat Washer	1
22	Hex Bolts M8x35	1

# SERVICE RECORD

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Date	Maintenance performed	Repair components require

# NOTES

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Stock No: 172503  
Edition 1 09/2018  
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If you have any questions about the use of this product, please contact the nearest one to you as below:

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