

# FOOT SHEAR

**Model: Q01-5216B (Q01-1.6x1320B)**

**Model: Q01-9818B (Q01-1.2x2500B)**



## OPERATION MANUAL

## **1. PRIOR TO INSTALLATION AND OPERATION**

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

## **2. CAUTIONS**

- 2.1 Read and understand the entire owner's manual before attempting assembly or operation.
- 2.2 Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
- 2.3 Replace the warning labels if they become obscured or removed.
- 2.4 This foot shear is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a foot shear, do not use until proper training and knowledge have been obtained.
- 2.5 Do not use this foot shear for other than its intended use. If used for other purposes, we disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
- 2.6 Always wear approved safety glasses or face shield while using this foot shear. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
- 2.7 Before operating the foot shear, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended.
- 2.8 Wear ear protectors (plugs or muffs) if noise reaches unsafe levels.
- 2.9 Do not operate this machine while tired or under the influence of drugs, alcohol or any medication
- 2.10 Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
- 2.11 Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- 2.12 Provide for adequate space surrounding work area and non-glare, overhead lighting.
- 2.13 Keep the floor around the machine clean and free of scrap material, oil and grease.
- 2.14 Keep visitors a safe distance from the work area. Keep children away.
- 2.15 Make your workshop child proof with padlocks, master switches or by removing starter keys.
- 2.16 Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
- 2.17 Maintain a balanced stance at all times so that you do not fall into the blade or other moving parts. Do not overreach or use excessive force to perform any machine operation.
- 2.18 Use recommended accessories; improper accessories may be hazardous.
- 2.19 Maintain tools with care. Keep blades sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
- 2.20 Do not stand on the machine. Serious injury could occur if the machine tips over.

- 2.21 Remove loose items and unnecessary work pieces from the area before operating the machine.
- 2.22 Keep hold-down clearance to table as small as possible while allowing just enough room to feed stock.
- 2.23 Do not cut rods with the foot shear.
- 2.24 Sheet metal stock has sharp edges; use caution when handling to prevent cuts.
- 2.25 Keep hands and fingers clear of the blade and hold-down area. Do not place hands or fingers between material and table when operating.
- 2.26 Do not exceed rated capacity of the foot shear.
- 2.27 Do not exceed front gauge capacity – material must not be so long that it interferes in any way with safe operation of the foot pedal.
- 2.28 The knives are sharp. Take extra care in operating. Keep hands away from the reach of blade.

**3.RECEIVING AND UNPACKING**

On receiving your machine, examine if the outer 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 and your supplier. Some parts and 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.

**4. 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 directions. Insert metal shims between floor and the shear mounting surface to adjust the level. Tighten all of the bolts after those being adjusted.

**5. CAPACITY:**

|                                    |                              |                              |
|------------------------------------|------------------------------|------------------------------|
| Item No.                           | 172015                       | 172016                       |
| Model                              | Q01-5216B<br>(Q01-1.6x1320B) | Q01-9818B<br>(Q01-1.2x2500B) |
| Max shearing thickness- Mild steel | 1.6mm                        | 1.2 mm                       |
| Max shearing Length                | 1320 mm                      | 2500 mm                      |
| Back gauge range                   | 0-800 mm                     | 0-800 mm                     |
| Packing size                       | 180x60x120 cm                | 300x60x120 cm                |
| N.W./G.W.                          | 410 /570 kg                  | 740/940 kg                   |

**6. OPERATION INSTRUCTIONS**

**6.1 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” shim gauge and adjust table lock screws. Then, tighten all screws.

## **6.2 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.

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.

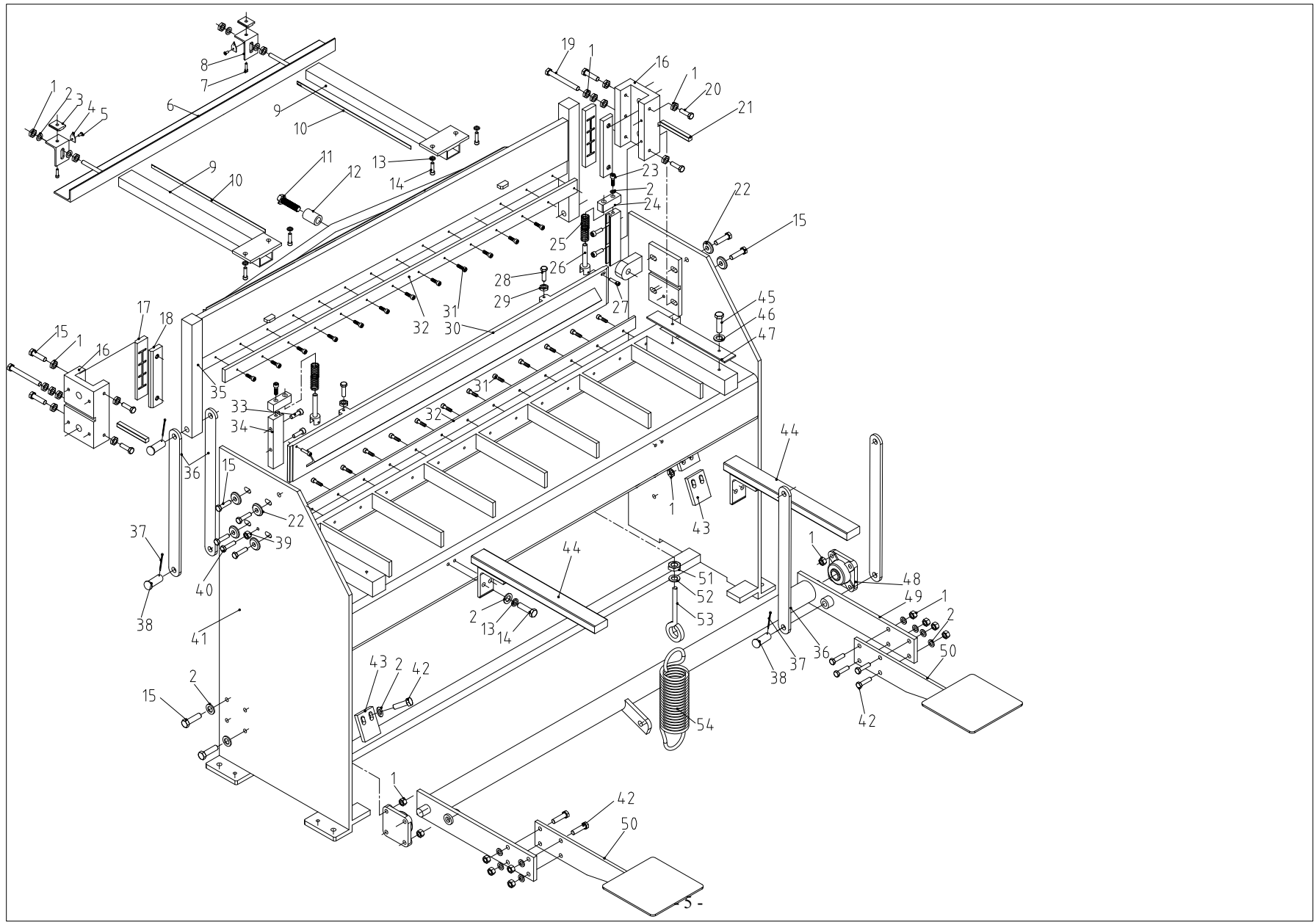
Check and sure they are rightly against shims. But be careful not to dimple them.

## **6.3 TO SHARPEN THE BLADE**

The upper blade has two cutting edges which 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 grinding machine both wide sides of the blade.

The lower blade has one cutting edge with a 2 edge 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.

## **7. DRAWING AND PART LIST**



| Part No. | Description            | Qty. | Part No. | Description      | Qty |
|----------|------------------------|------|----------|------------------|-----|
| 1        | Nut                    | 38   | 28       | Bolt             | 2   |
| 2        | Washer                 | 40   | 29       | Nut              | 2   |
| 3        | Washer                 | 2    | 30       | Cut-off bar      | 1   |
| 4        | Pointer                | 2    | 31       | Screw            | 28  |
| 5        | Clich bolt             | 2    | 32       | Blade            | 2   |
| 6        | Angle steel            | 1    | 33       | Screw            | 4   |
| 7        | Bolt                   | 2    | 34       | Guideway         | 2   |
| 8        | adjustment angle steel | 2    | 35       | Cutting beam     | 1   |
| 9        | Stopping square tube   | 2    | 36       | Connecting plate | 4   |
| 10       | Rear scale             | 2    | 37       | Cotter           | 4   |
| 11       | Adjusting bolt         | 1    | 38       | Pin              | 4   |
| 12       | Socket                 | 1    | 39       | Nut              | 2   |
| 13       | Spring Washer          | 8    | 40       | Bolt             | 2   |
| 14       | Bolt                   | 8    | 41       | Frame            | 1   |
| 15       | Bolt                   | 20   | 42       | Bolt             | 12  |
| 16       | Slide                  | 2    | 43       | Adjusting baffle | 2   |
| 17       | Rear sliding plate     | 2    | 44       | Support          | 2   |
| 18       | Front sliding plate    | 2    | 45       | Bolt             | 2   |
| 19       | bolt                   | 2    | 46       | Washer           | 2   |
| 20       | bolt                   | 4    | 47       | Guide plate      | 1   |
| 21       | Guide bar              | 2    | 48       | Bearing          | 2   |
| 22       | Washer                 | 8    | 49       | Stand for pedal  | 1   |
| 23       | Screw                  | 2    | 50       | Pedal            | 2   |
| 24       | Lock block             | 2    | 51       | Nut              | 1   |
| 25       | Pressure spring        | 2    | 52       | Washer           | 1   |
| 26       | Guide rod              | 2    | 53       | Hook for spring  | 1   |
| 27       | Screw                  | 2    | 54       | Spring           | 1   |

Note: This manual is only for your reference. Owing to continuous improvement of the machines, Changes may be made at any time without obligation on notice.