



**PEPETOOLS, INC.**  
**USER INSTRUCTIONS FOR BENCH SHEARS**  
**NO. 196.60, 196.80**

Safety is always a concern when using any tool especially if the tool involves any type of cutting. Bench shears are included in this group of dangerous tools. The user must always be cautious and extremely careful when using this tool. Keep fingers away from the cutting blades. This is especially true if trying to cut small pieces that will require the user to hold the piece to be cut close to the blades. The shear must also be bolted down to a sturdy work bench.

The Pepetools shears are designed to cut sheet metal stock up to 1.6mm (14 GA) mild steel. The shears are also equipped with a port, located on the side of the frame, for cutting round stock up to 2.6mm (10GA) of mild steel.

Prepare the sheet metal to be cut by marking a visible line that can be easily viewed when presented in the jaws or cutting blades. Make sure that the marked line is at the back edge of the cutting blade. This position should be where the top and bottom edges of the cutting blades meet when the handle is pulled down. Pepetools shears are equipped with a brace that will assist in keeping the metal from moving when shearing but it will also be necessary for the user to hold the metal to keep it from moving while shearing. Newer models have a material locking bar that will keep the metal from moving when cutting. To shear, simply pull the handle down. The handle is spring loaded to return it to the open blade position.

**REMEMBER THAT SAFETY FIRST PAYS!**

**Shimming of the Pepetools Guillotine and Bench Shears**

On rare occasions and possibly after many uses, blades of the guillotine or shears may have to be shimmed. Shimming will have to be done if the metal being cut folds rather than having a clean cut. The following is the proper method to perform this task.

On either machine, whether guillotine or shear, loosen and remove the holding screws on the lower blades. Carefully, remove the blade and remove all shimming material that may have been there at the factory. Replace the blade and the mounting screws but do not tighten. Cut some shim material to fit between the mounting screws approximately 1/2" wide. Thickness of the material will determine how much shim is required. The following are the sizes recommended to perform this task. .004" (.102mm), .007" (.178mm), .010" (.254mm). Shim material can be obtained at most automotive stores. Since the exact amount of shim is unknown, select a middle shim thickness and place it between the screws on the lower cutting blade. Apply a small amount of grease to hold the shim from slipping out of place. Retighten the mounting screws and perform a cutting test. If the metal still folds, more shim is required. If the blades hit each other and will not close in order to be able to cut, reduce the thickness of the shim. Always keep a light film of oil on the blades to prevent rust.