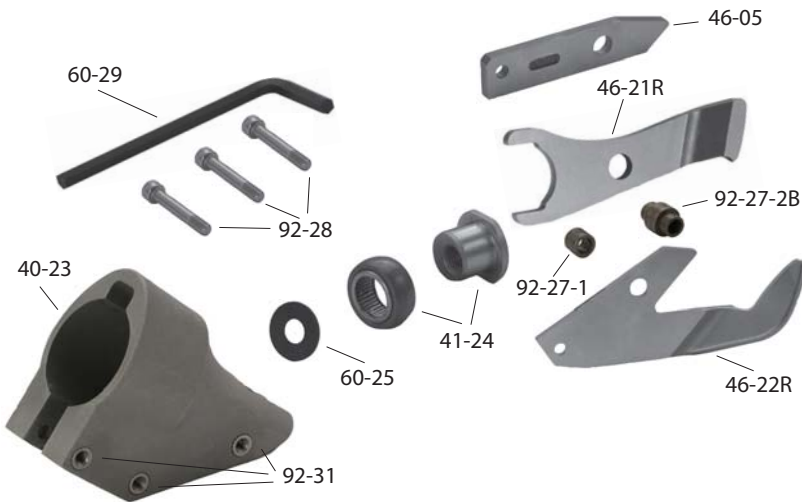




INSTRUCTIONS FOR THE CARE OF THE KETT 46-20R SHEAR HEAD

CAUTION
Disconnect Power Unit
Before Servicing Tool



PARTS LIST

46-21R	Center Blade
42-23	Shear Housing
41-24	Eccentric Bearing Assembly
92-27-2B	Spacer Bushing
92-28	Cap Screw (3)
92-31	Knurled Insert (3)
46-22R	Side Knife, Left
60-25	Thin Washer, Large
92-27-1	Spacer Bushing
60-29	(150-4) Allen Wrench

DISASSEMBLY: To remove the shear head from the motor loosen three cap screws (92-28). Remove shear head from motor by pulling head firmly forward. Slight tapping with a mallet may be required if head does not slide off easily.

To remove cutter blades from shear head remove three cap screws (92-28) from shear housing (42-23). Be careful not to lose rear spacer bushing (92-27-1) when removing the middle cap screw. Remove center blade (46-21) from shear housing by tapping blade gently rearward. Be careful not to lose spacer bushing (92-27-2B) from hole in center blade. Side knife (46-22R) will now drop out of the shear housing.

To remove eccentric bearing assembly (41-24) from shaft use an appropriate wrench to loosen eccentric nut by turning counter clockwise.

ASSEMBLY: To install eccentric bearing assembly (41-24) onto shaft, make sure the large thin washer (60-25) is first inserted over the shaft. Screw eccentric bearing assembly on to shaft and tighten with appropriate wrench. Lubricate bearing with a good grade of bearing grease.

To install cutter blades into shear housing (42-23) place the side knife (46-22R) into position in the

shear housing (42-23). Insert center cap screw (92-28) through the side knife (46-22R) with rear spacer bushing (92-27-1) between them and start cap screw into thread just enough to hold blades in place. **DO NOT TIGHTEN.** Insert spacer bushing (92-27-2B) into hole in center blade (46-21) and lubricate with Molybdenum Disulfide grease (264-2) or equivalent. Install center blade into shear housing by tapping blade gently forward using a drift to line up hole in center blade with forward holes in housing. Insert and tighten forward cap screw (92-28) making sure spacer bushing (92-27-2B) in center blade stays in position. Apply Molybdenum Disulfide grease (264-2) or equivalent to clevis or yoke in center blade where it rides on the eccentric bearing assembly. Insert rear cap screw (92-28) into shear housing, but do not completely tighten.

To install shear head assembly onto drive motor make sure all cap screws (92-28) are loosened about three or four complete turns. Spread shear housing (41-23) slightly using a spreader (drift) near the rear cap screw (92-28). Place shear head onto unit, tap left side knife rearward as far as it will go, and tighten cap screws to 40-45 inch pounds. It may be necessary to gently tap the shear head into place if it does not readily slip onto the nose of the power unit.

WARNING: THE KETT TOOL CO. CANNOT ASSUME RESPONSIBILITY FOR DAMAGE TO OR MALFUNCTION OF A KETT SHEAR HEAD USED IN COMBINATION WITH ANY DRILL OTHER THAN THOSE REGULARLY SUPPLIED BY US.