



Changing Shear Blades in the Kett Double-Cut Shear

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Changing Shear Blades in the Kett Double-Cut Shear

These instructions may be used for any current or discontinued double-cut shear model. Double-cut shears have two stationary side knives and a moveable center cutting blade.

DISASSEMBLY:



[fig.#1]

To remove the shear head from the motor loosen three cap screws (see fig. #1). 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.

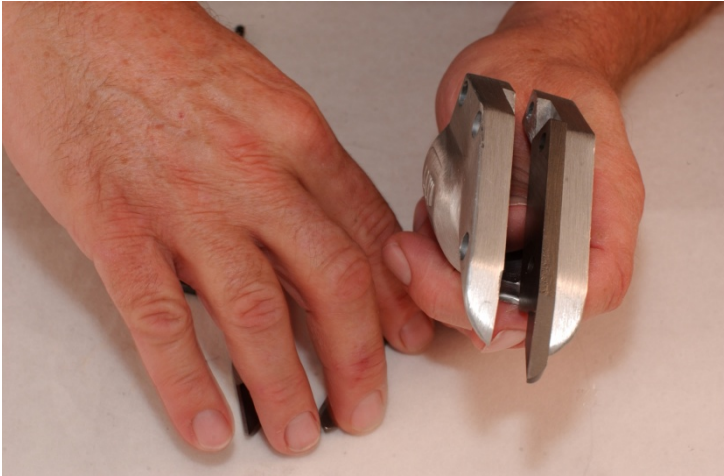


[fig. #2]

To remove cutter blades from shear head remove three cap screws from shear housing. Be careful not to lose rear spacer bushing when removing the middle cap screw.

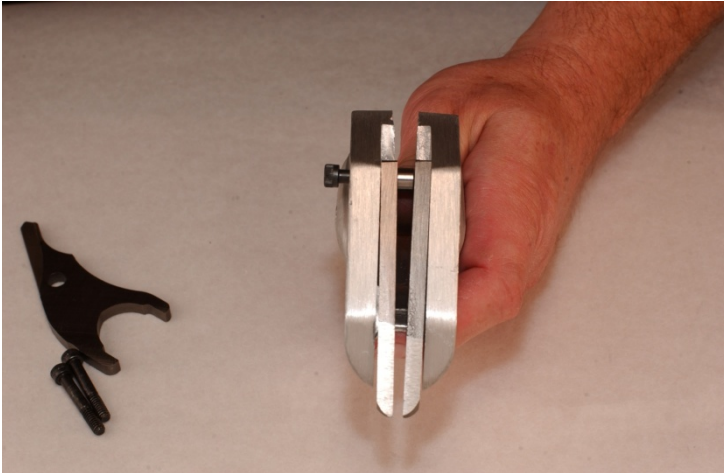
Remove center blade from shear housing by tapping blade gently rearward. Be careful not to lose spacer bushing from hole in center blade. Side knives will now drop out of the shear housing (see fig. #2 for the parts of the shear head).

ASSEMBLY:



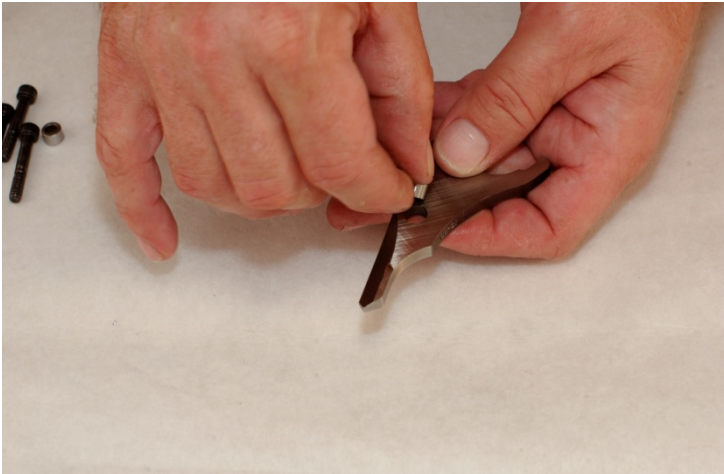
[fig. #3]

To install cutter blades into shear housing place the side knives into position in the shear housing.



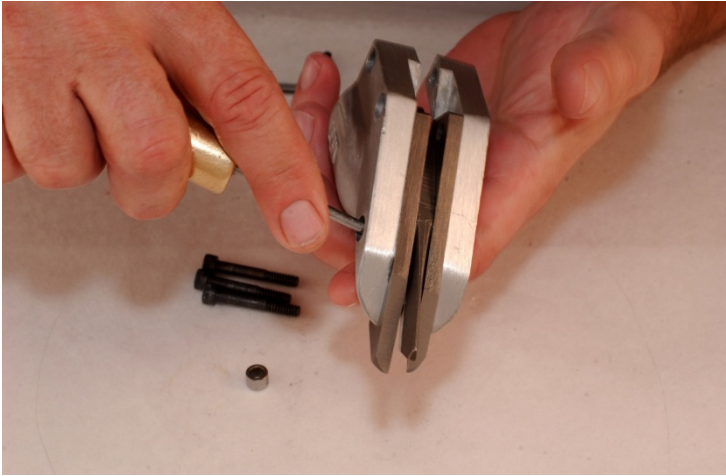
[fig. #4]

Insert center cap screw through the side knives with rear spacer bushing between them and start cap screw into thread just enough to hold blades in place. **DO NOT TIGHTEN** (see fig. #3 and #4).



[fig. #5]

Insert spacer bushing into hole in center blade and lubricate with Molybdenum Disulfide grease or equivalent (see fig. #5).



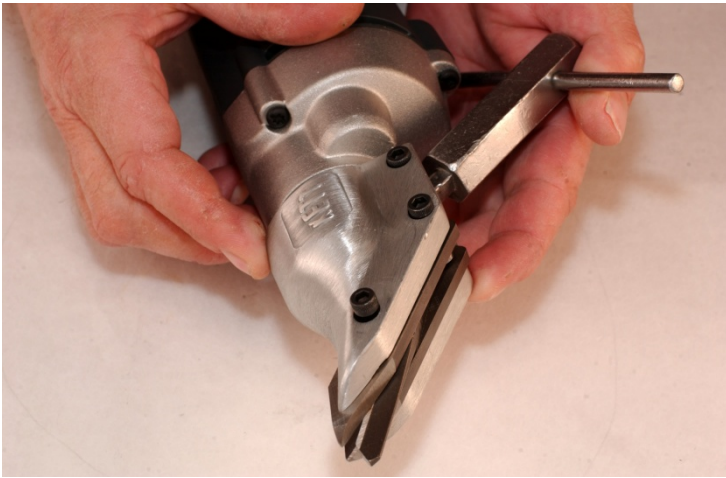
[fig. #6]

Install center blade between side knives by gently tapping it forward and use a drift to line up hole in center blade with front holes in housing. Insert and tighten forward cap screw making sure spacer bushing in center blade stays in position. Apply Molybdenum Disulfide grease or equivalent to clevis or yoke in center blade where it rides on the eccentric bearing assembly. Insert rear cap screw into shear housing and start it into the thread, but do not completely tighten (see fig. #6).



[fig. #7]

To install shear head assembly onto drive motor make sure all cap screws are loosened about three or four complete turns (see fig. #7).



[fig. #8]

Spread shear housing slightly using a spreader (drift) near the rear cap screw (see note #1). Place shear head onto unit and push it back as far as it goes. 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. Tap left side knife rearward as far as it will go, and tighten cap screws to 40 to 45 inch-pounds (see note #2).

IMPORTANT: Tighten the front cap screw first, middle cap screw second and rear cap screw last. (see fig. #8)

Notes:

1. If you do not have a spreader, a large screw driver may be used to slightly spread the shear housing.
2. Cap screws should be torque 40 to 45 inch-pounds. If you do not have a torque wrench, the standard 5/32" x 2-1/2" allen wrench may be used to fully tighten the cap screws. Do not use an extension bar.



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