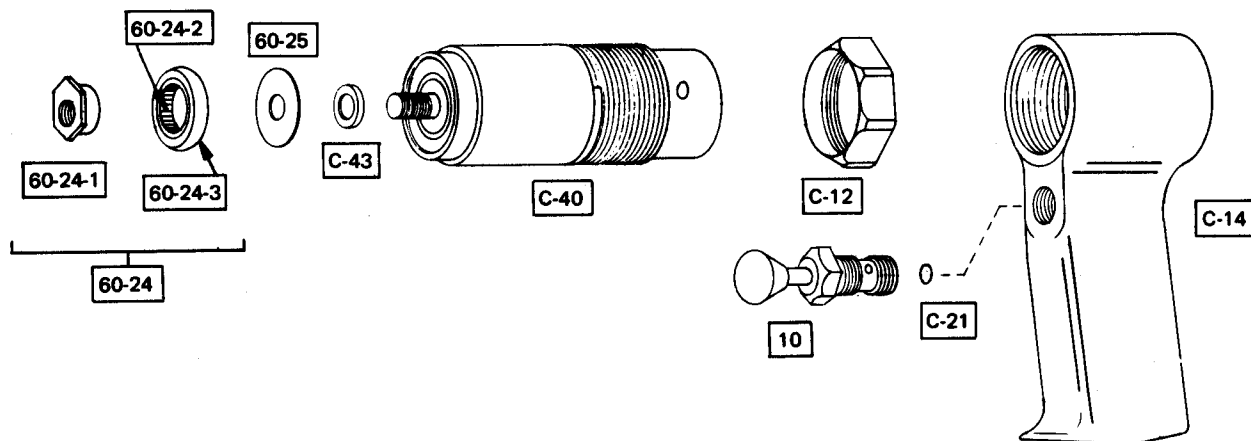




# KETT Pneumatic Shear Model P-300 PARTS LIST

253-28



## Operating instructions

The Model P-300 Pneumatic Shear is recommended for CR sheet steel up to 18 gage. Secure work piece. To start cut, place side knives of shear slightly on the top side of the edge of the work piece to steady the tool and ready it for the cut. Depress the trigger and guide shear into the work. Do not force it. Avoid double thicknesses of material which exceed the 18 gage recommended capacity.

For cutting within perimeter of work piece drill a 1/2" diameter starting hole and follow instructions above.

## Loss of power or erratic action

If resistance to tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication; thickness of material; sharpness of cutting blades; air pressure.

Check for low air pressure or air line restrictions, also reduced compressor output or excessive drain on air lines.

Dirt and gum deposits in tool may cause loss of power and may be removed by flushing tool with a gum solvent oil.

For maximum efficiency, 100 psi of clean, dry air should be supplied at the tool during operation. Use of one horsepower or larger compressor connected to an air tank of at least 40 gallons capacity is recommended.

Pipe and fittings between compressor and air hose outlets should be 1/2" pipe size (5/8" ID). Air hose should be at least 3/8" ID.

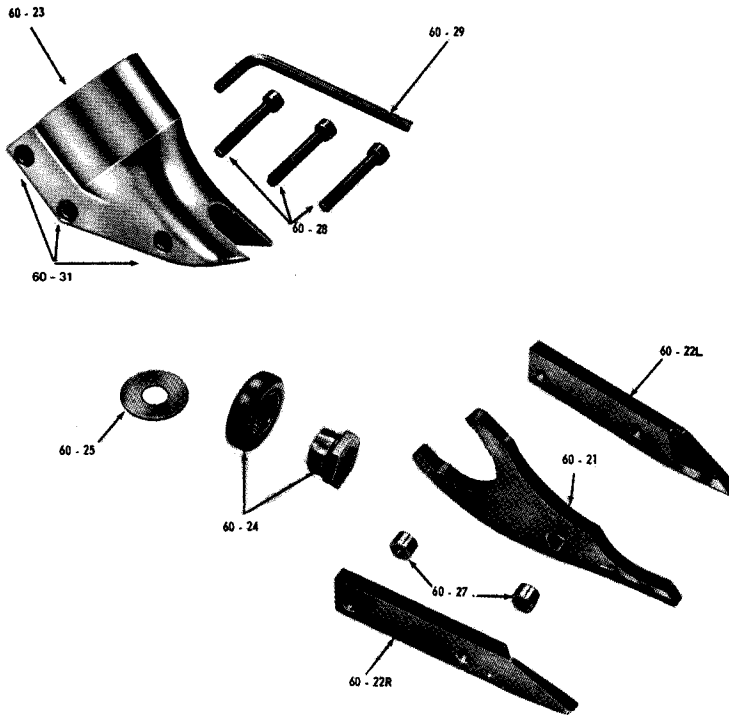
## Lubrication

Daily before using, pour a liberal quantity of gum solvent oil into air inlet and run tool to allow dirt and gum accumulations to be flushed out the exhaust.

Part Number	Description
60-24	Eccentric Bearing Assembly (Incl. Hex. Eccentric, Outer Ring and Needle Bearing)
60-24-1	Eccentric Bushing (Hex Head)
60-24-2	Eccentric Needle Bearing
60-24-3	Eccentric Outer Ring
60-25	Thin Washer, Large
C-12	Lock Nut
C-14	Handle
C-21	"O" Ring
C-40	Motor Unit Complete
C-43	Washer
10	Trigger Valve
253-28	Pneumatic Power Unit
C-40-R	Replacement C-40 Motor with trade in of your defective motor

**WARRANTY DOES NOT  
APPLY IF UNIT IS NOT  
PROPERLY LUBRICATED**

# INSTRUCTIONS FOR DISASSEMBLY AND ASSEMBLY OF SHEAR HEAD NO. 60-20



Part No.	Description
60-21	Center Blade
60-22L	Side Knife, Left
60-22R	Side Knife, Right
60-23	Shear Housing
60-24	Eccentric Bearing Assembly (Incl. Hex, Eccentric, Outer Ring and Needle Bearing)
60-25	Thin Washer, Large
60-27	Spacer Bushing (2)
60-28	Cap Screw (3)
60-29	Allen Wrench
60-31	Knurled Insert (3)

## TO ASSEMBLE NO. 60-20 SHEAR HEAD AND ADAPT TO POWER UNIT:

1. Place the left side knife (60-22L) into position in the shear housing (60-23).
2. Insert center cap screw (60-28) through housing and blade just far enough to slip spacer bushing (60-27) over cap screw.
3. Place right side knife (60-22R) into position and push center cap screw through right side knife. Start cap screw into insert just enough to hold blades in place. **DO NOT TIGHTEN.**
4. Insert spacer bushing (60-27) into hole in center blade (60-21) and lubricate with a good grade of bearing grease.
5. Install center blade (60-21) into shear housing (60-23) by tapping blade gently forward using a drift to line up hole in center blade with forward holes in housing.
6. Insert and tighten forward cap screw (60-28) making sure spacer bushing (60-27) in center blade stays in position. Apply good grade of bearing grease to clevis in center blade. **WHEN SHEAR HEAD IS PROPERLY ASSEMBLED THE CENTER BLADE WILL PIVOT FREELY IN HEAD.**
7. Insert rear cap screw (60-28) into shear housing (60-23) but do not completely tighten.

## TO REMOVE NO. 60-20 SHEAR HEAD FROM POWER UNIT AND DISMANTLE:

1. Loosen both rear cap screws (60-28) three complete turns.
2. Remove shear head assembly (60-20) from motor by pulling head firmly forward. Slight twisting action may be required.
3. Remove three cap screws (60-28) completely from shear housing (60-23). Be careful not to lose rear spacer bushing (60-27) when removing rear cap screw.
4. Remove center blade (60-21) from shear housing (60-23) by tapping blade gently rearward. Be careful not to lose spacer bushing (60-27) from hole in center blade.
5. Side Knives (60-22L and 60-22R) will now drop out of shear housing.

## TO INSTALL SHEAR HEAD ASSEMBLY (60-20) ONTO POWER UNIT.

1. Make sure rear cap screw and center cap screw (60-28) are loosened three complete turns.
2. Place shear head onto unit and tighten cap screws (60-28) snugly to lock head assembly in place. It may be necessary to gently tap the shear head assembly into place if it does not readily slip onto the power unit.

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