

## # 89246 Throat-Less Metal Cutting Rotary Shear Instructions

**⚠ WARNING: CUTTING AND PINCHING HAZARD!** Keep fingers at a safe distance from wheels, or fingers could be cut or severely pinched.

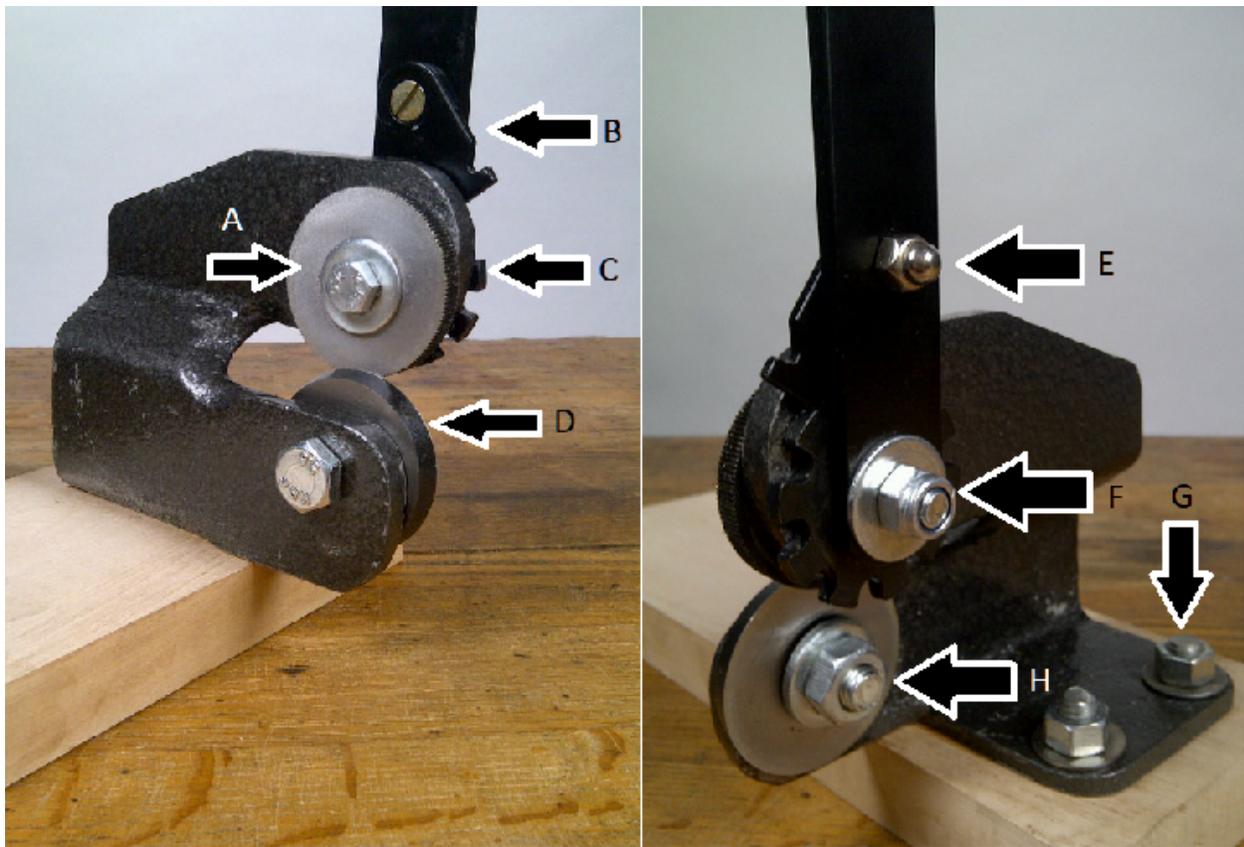
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### Preparing Your New Shear

Prior to use, clean off any oils that had been applied for rust protection while in transit.

Prior to use, the unit must be mounted to a bench or portable piece of sturdy wood or metal that can be affixed to a bench by means of a c-clamp by securing with bolts at the 2 locations located on the base.

### Getting to Know Your Shear



A: Driving Wheel connected to the handle. B: Reversible Pawl. C: Pawl Gear. D: Cutting Wheel. E: Pawl Adjusting Bolt. F: Driving Wheel Adjustment Bolt. G: Mounting Locations (2). H: Cutting Wheel Adjusting Bolt.

### **Operation Preparation:**

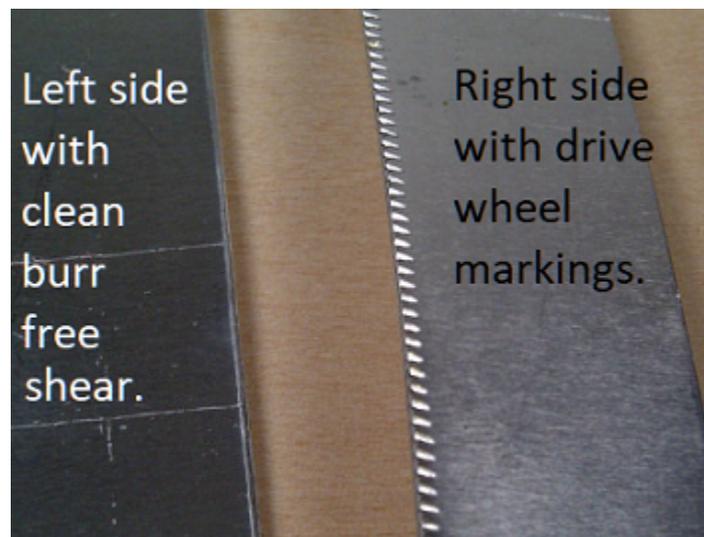
This shear is only to be used for shearing non-ferrous metal up to 1.5mm thickness. It will shear mild steel up to 1/16" when needed but not on a regular basis.

Adjust (E) so that Pawl (B) swings freely but not too loose.

Adjust (F) so that the assembly is allowed to raise up and down with just a little resistance. There is some up and down play that you will need to accommodate for different thickness of metal. This assembly will raise slightly when cutting metal in order of allowing the driving wheel (A) to grab onto the discard side of the sheet.

Adjust (H) so that the cutting wheel (D) is allowed to spin during the shearing process. Do not make it too loose or too snug.

The material fed through the left-side of the tool is what you will use in your project. The material cut from the right-side of the tool is the waste, this sheared off piece will have the indentation drawing marks left on it from the driving wheel as seen in this picture



### **The Shearing Process:**

1. Raise the handle and engage the pawl in one of the ratchet notches.
2. Place the sheet metal between the upper drive wheel and lower cutting wheel.

3. Pull the handle toward you with one hand as you feed and guide the sheet metal with the other into the cutting wheel to begin shearing.
4. Push the handle away from you to re-engage the pawl and repeat step 3 to keep advancing the metal.
5. The pawl can be swung up and around to the backside of the handle for reversing your cut (if needed) by then pushing away of the handle to the rear.

Left hand radius cuts are also possible with this rotary shear. By pulling the metal through while driving, you can turn your metal for cuts like this below.



If you plan on shearing really long piece of metal, keep in mind the room required behind your shear. As you practice with your new shear you will find new and better ways of taking advantage of all that this tool offers. Happy Shearing!

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