

WE MAKE THE CUT™



Kett Tool Company Pneumatic Tools

Safety, Operation, & Maintenance

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Safety Rules

Keep Work Area Clean

Cluttered areas and benches invite accidents.

Keep Children Away

All visitors should be kept a safe distance from the work area.

Store Idle Tools

When not in use, tools should be stored in a dry, high, or locked-up place - out of reach of children.

Do Not Force Tool

It will do the job better and safer at the rate for which it was designed.

Use The Right Tool

Do not force a small tool to do the job of a heavy-duty tool.

Wear Proper Apparel

No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.

Use Safety Glasses

Use safety glasses when operating a tool. A face or dust mask should be worn if the cutting operation is dusty. If the cutting operation creates silica dust, you should operate outdoors and use a respirator designed to protect you from silica dust.

Secure Your Work Piece

Use clamps or a vise to hold your work piece. It is safer than using your hand and it frees both hands to safely operate the tool.

Do Not Overreach

Keep proper footing and balance at all times.

Maintain Tools With Care

Keep your tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing blades.

Disconnect Tools

When not in use, before service, or when changing blades; always disconnect the tool from its power source.

Remove Adjusting Keys and Wrenches

Form the habit of checking to ensure that keys and adjusting wrenches are removed from the tool before turning it on.

Avoid Accidental Starting

Do not carry a tool that is connected to its power source with a finger on the trigger. The tool should be used only for the purpose for which it is designed.

Read Operating Instructions Carefully

Operating Instructions

Panel Saws

Please read carefully all safety rules and operating instructions.

Be sure the work piece is securely held unless it will remain secure due to its own weight or bulk. Grasp the tool with both hands, one around the handle where the trigger switch is located, the other around the neck or sleeve which holds the cutting head in position. Before starting the motor, place the shoe of the foot at the edge of the material to be cut.



Make certain the saw guard is set to to depress to the desired depth. Be sure the shoe is flat or level and ready to make full contact with the surface to be cut. The scribed line to be cut should appear in the vee type gunsight on the saw guard.

Squeeze the trigger switch and set the blade in motion. Slowly push the saw forward until the blade makes contact and starts to cut. Gradually increase pressure until blade is cutting at full capacity at a uniform speed with the feel of being forced or slowing to a stall. Keep the blade perpendicular to the cut and feed at a constant speed. Do not jerk or suddenly thrust the tool in the cut and do not rock the tool from side-to-side so as to bind the blade in the cut. When the blade starts cutting, it is more desirable to “crowd” the rate of feed to attain efficient cutting speed rather than to hold back and permit the blade to “dwell” in the cut.

Shut off the power the moment the saw has completed the cut through the sheet. If the cut is to be ended within the boundary of the sheet, bring the saw up to the end of the cut, hold firmly, shut off the power, and let it coast to a full stop. Then lift the saw from the cut. **NEVER BACK UP THE SAW IN THE CUT WITH THE POWER ON AND THE BLADE IN MOTION.** This is the most frequent cause of broken blades and can result in more serious damage to the tool.

For plunge cutting, that is, starting a cut within the perimeter or boundaries of a sheet, see the explicitly detailed instructions in the operation and service manual.

Where conditions permit, blade life can be extended and cutting efficiency improved through the use of a lubricant such as a grease stick, wax, or tallow, or even cutting oil. It is recommended to practice cutting with your Kett Tool saw on scrap material until a knack of using the tool is acquired.

Double Cut Shears

Please read carefully all safety rules and operating instructions.

The model P-500 and P-2060 shears are recommended for cold-rolled sheet steel up to 18 gauge, the P-542 and P-2042 shears are recommended for cold-rolled sheet steel up to 16 gauge, and the P-540 and P-2040 shears are recommended for



cold-rolled sheet steel up to 14 gauge. Secure the work piece. To start the 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 the tool. Avoid double thicknesses of material which exceed the recommended capacity of the tool. For cutting within the perimeter of the workpiece, drill a ½” diameter starting hole and follow instructions above. If resistance to the tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication, thickness of material, and/or the sharpness of cutting blades.

Scissor Shears

Please read carefully all safety rules and operating instructions.

Kett Tool P-580 and P-2080 scissor shears are recommended for woven wood slat type shades; carpeting; carpet underlay or padding; linoleum; vinyl and rubber flooring tile; soft, pliable plastic sheeting up to ¼” thickness; and many other similar sheet-like materials. Kett Tool P-541 and P-2041 heavy-duty scissor shears are recommended for cold-rolled mild steel up to 24 gauge, wire mesh up to 18 gauge, steel siding and other light gauge metals, vinyl, rubber, and metal studs.



The shear head can be rotated a full 360 degrees on the power unit making it possible to position it to cut in close quarters. This feature also serves to set the oscillating blade to a preferred position either to the top or to the bottom of the shear unit.

Secure the workpiece. To start the cut, place knives of the shear slightly on the side of the workpiece to steady the tool and ready the tool for the cut. Depress the trigger and guide the shear into the work. Simply depress the trigger to adjust the speed to suit the material being cut. Do not force the tool in the cut.

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

Profile Shears

Please read carefully all safety rules and operating instructions.

The Kett Tool P-546L profile shear is recommended for cold-rolled mild steel up to 18 gauge, spiral pipe, metal studs, and corrugated metal.



Secure the workpiece. To start the cut, place knives of the shear slightly on the side of the workpiece to steady the tool and ready the tool for the cut. Depress the trigger and guide the shear into the work. Simply

depress the trigger to adjust the speed to suit the material being cut. Do not force the tool in the cut.

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

Fiber Cement Shears

Please read carefully all safety rules and operating instructions.

The Kett Tool P-593 and P-2093 fiber cement shears can safely cut up to ½" thick fiber cement. They cut cleanly with minimal airborne dust.



The Kett Tool P-595 and P-2095 fiber cement shears can safely cut up to ⅝" thick fiber cement. They also cut cleanly with minimal airborne dust.

In 2016, OSHA updated its rules for controlling exposure to respirable silica dust. Kett Tool Company is here to help its customers work safely and efficiently with this standard.

Although the standard primarily affects installers and contractors, any building professional can rely on Kett Tool Company as a resource for accurate information about the OSHA silica dust standard as it relates to the use of Kett Tool Fiber Cement Shears.

Kett Tool Company has always promoted best practices and provided solutions to help you meet OSHA standards – and we'll continue to do so as part of our commitment to you.

About the Standard

OSHA sets exposure limits for dust, chemicals and other materials that employees may be exposed to at work or on a jobsite. These exposure limits cover dust from all types of materials, including: stone, brick, concrete, drywall, wood, and wood composites.

OSHA requires employers to take specific actions to protect workers on construction sites based on the amount of silica dust they are exposed to. The OSHA Permissible Exposure Limit (PEL) for respirable crystalline silica dust is 50 µg/m³ (micrograms per cubic meter) as a time weighted average over an 8-hour period.

How It's Measured

Respirable crystalline silica exposure is measured using an air sampling device that is placed in the work area or worn by an employee. An industrial hygienist (IH)** will generally oversee the sample collection. The samples are collected and sent to a qualified lab for analysis and the IH will review the results and make recommendations.

Who Is Affected?

This OSHA standard affects all activities that generate silica dust on a jobsite. Trades that use stone, concrete and other materials that are difficult to replace must also comply with the standard, as the change affects work practices that use these materials.

OSHA has compiled a list of work practices that, if fully and properly implemented, are deemed to be compliant with the PEL. This list of work practices is known as "Table 1". Employers can either use the control methods laid out in Table 1 of the construction standard, or they can measure workers' exposure to silica and

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independently decide which dust controls work best to limit exposures to the PEL in their workplaces.

The OSHA standard can be viewed at <https://www.osha.gov/silica-crystalline>.

Secure the workpiece. To start the cut using your Kett Tool fiber cement shears, place the knives of the shear slightly on the side of the workpiece to steady the tool and ready the tool for the cut. Depress the trigger and guide the shear into the work. Simply depress the trigger to adjust the speed to suit the material being cut. Do not force the tool in the cut.

If resistance to the tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication, thickness of material, and/or the sharpness of the cutting blades. The blades can be sharpened.

Power Nibblers

Please read carefully all safety rules and operating instructions.

The Kett Tool PN-1020 Nibbler is recommended for cold-rolled sheet metal up to 18 gauge and most grades of



stainless steel up to 20 gauge. The Kett Tool PN-2020 Nibbler is recommended for cold-rolled sheet metal up to 14 gauge and most grades of stainless steel up to 18 gauge. Both nibblers cut flat or corrugated materials effectively. Secure the workpiece. To start the cut, place the die opening of the nibbler slightly onto the edge of the

workpiece to steady the tool and ready it for the cut. Depress the trigger switch on the drive motor and guide the nibbler into the work. Do not force the tool. Avoid double thickness of material which exceeds the 18 gauge recommended capacity. For cutting within the perimeter of the workpiece, drill a 9/16" diameter starting hole and follow the instructions above. If resistance to the tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication, chip clogging, thickness of material, and/or sharpness of the punch and die.

Maintenance

When servicing your Kett Tool pneumatic tool, use only identical replacement parts.

The tool may be cleaned and lubricated by the user but any other servicing should be performed by the manufacturer or any authorized representative or service provider.

Loss of Power or Erratic Action

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

Check for low air pressure or air line restrictions. It would also be advisable to check for reduced compressor output or excessive drain on the air lines.

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

For maximum efficiency, 90 PSI of clean, dry air should be supplied at the tool during operation. Use of a one horsepower or larger compressor connected to an air tank with a capacity of at least 40 gallons is recommended.

Pipe and fittings between the compressor and the air hose should be ½" pipe size (5/8" ID) The air hose should be at least 3/8" ID.

Lubrication

Lubricate the air motor daily with a good grade of air motor oil. Use a continuous airline oiler with filter.

Right Angle Saw Heads

Saw head gears should be lubricated after 25 to 30 hours of use.

Inject a light cup grease into the grease opening covered by screw plug 181-2 in the bottom of the geared right angle transmission head.



Tubes of grease are available directly from Kett Tool Company. Specify 264-3 tube grease for lubrication.

Adherence to these maintenance instructions will greatly increase the life of your saw so it will give you long and satisfactory service.

Shear Heads

Once every three months, depending upon usage, remove the Shear Head from the power unit following the instructions given on the service sheet under the heading "Disassembly - To remove the shear head assembly from the drive motor." Put a few drops of heavy oil on the Eccentric Bearing Assembly so that it saturates the needle bearing. Grease is even better if it



can be forced or pressed into the needle bearing.

Nibbler Head

When servicing, use only identical replacement parts. Once every three months, depending upon usage, remove the nibbler head from the power unit by loosening the clamping screw and pull the head with a twisting action. Lubricate the bearing surface of the eccentric nut with a good grade of bearing grease. Place the nibbler head back onto the motor unit. Tighten the clamping screw snugly to lock the head assembly in place.





All Angle Head

To lubricate the KU-5 360° All Angle Head, first separate the two halves of the head by removing the socket head swivel stud nut. With the two halves separated, fill the drive spindle side until level, with 264-3 Tube Grease.

Be sure to replace the copper shim between the two halves of the head. After the two halves are tightly clamped together, remove the excess grease. The tool is again ready for use.

Kett Tool Company: A Family of Pneumatic Tools

Power Unit	Cutting Head	Kett Tool
253-57 Pistol Grip 	60-20	P-500 18 gauge double cut shears
	42-20	P-542 16 gauge double cut shears
	40-20	P-540 14 gauge double cut shears
	80-20	P-580 scissor shears
	41-20	P-541 heavy-duty scissor shears
	46-20L	P-546L profile shears
	93-20	P-593 ½" fiber cement shears
	95-20	P-595 ⅝" fiber cement shears
	KS-21	PS-521 light-duty panel saw
	KS-23	PS-523 panel saw
	KS-26	PS-526 panel saw
	KS-44	PS-544 panel saw
	KSV-32	PSV-532 vacuum saw
	KSV-34	PSV-534 vacuum saw
253-58 Straight Handle 	60-20	P-2060 18 gauge double cut shears
	42-20	P-2042 16 gauge double cut shears
	40-20	P-2040 14 gauge double cut shears
	80-20	P-2080 scissor shears
	41-20	P-2041 heavy-duty scissor shears
	93-20	P-2093 ½" fiber cement shears
	95-20	P-2095 ⅝" fiber cement shears
	1020	PN-1020 18 gauge nibbler
	2020	PN-2020 14 gauge nibbler

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