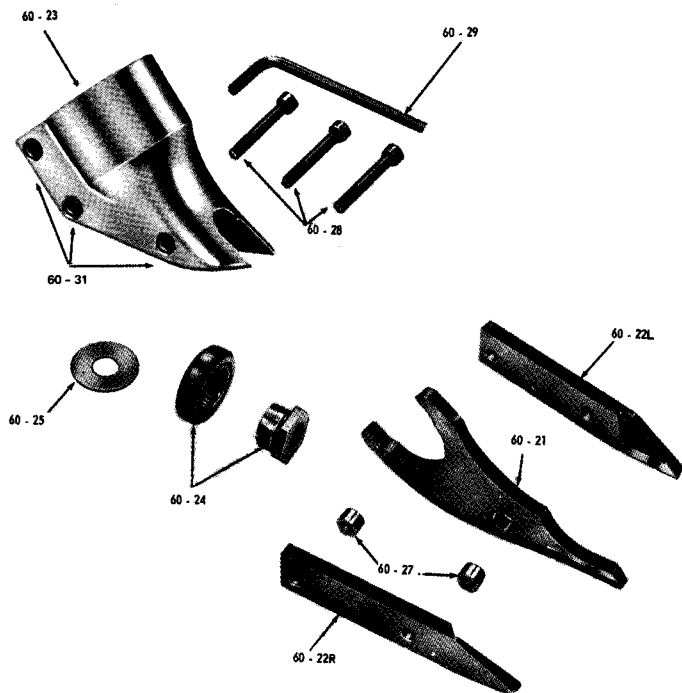




INSTRUCTIONS FOR THE CARE OF THE KETT NO. 60-20 SHEAR HEAD



ADJUSTMENT

To adjust the curl of waste material, the left side knife (60-22L) has elongated holes. Adjustment may be necessary after changing blades or material being cut. Loosen cap screws (60-28) and tap side knife (60-22L) either forward or backward so that curl of waste does not hit shear housing (60-23) or work material while cutting.

DISASSEMBLY

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.

ASSEMBLY

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 install shear head assembly (60-20) onto power unit:

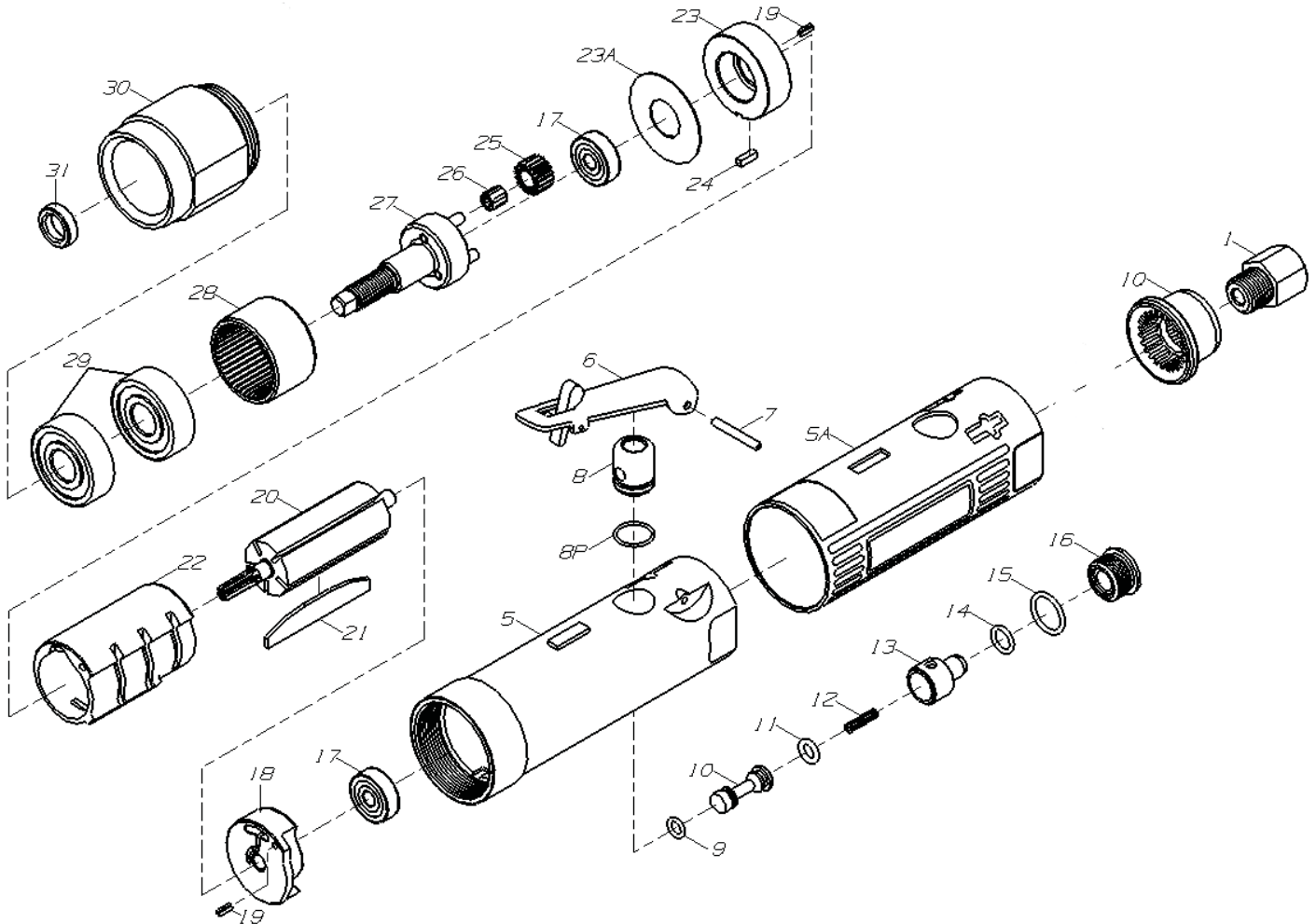
1. Make sure rear cap screw and center cap screw (60-28) are loosened three complete turns.
2. Place shear head onto unit and tighten cap screws (60-28) snugly to lock head assembly in place. It may be necessary to gently tap the shear head assembly into place if it does not readily slip onto the power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

WARNING: THE KETT TOOL CO. CANNOT ASSUME RESPONSIBILITY FOR DAMAGE TO OR MALFUNCTION OF A KETT SHEAR HEAD USED IN COMBINATION WITH ANY DRILL OR PARTS OTHER THAN THOSE REGULARLY SUPPLIED BY US. USE ONLY KETT REPLACEMENT BLADES EMBOSSED WITH PART NUMBERS 60-21, 60-22L OR 60-22R.

**NOTE: WHEN SHEAR HEAD IS PROPERLY ASSEMBLED
THE CENTER BLADE WILL MOVE FREELY IN HEAD.**



253-58 PNEUMATIC POWER UNIT PARTS LIST



ITEM NO.	PART NO.	DESCRIPTION	REQ'D TOOL	ITEM NO.	PART NO.	DESCRIPTION	REQ'D TOOL
1	103132	Inlet Bushing	1	17	0626-ZZ0A	Ball Bearing	2
1Q	103129	Exhaust Deflector	1	18	103116	Rear End Plate	1
5	303305	Motor Housing	1	19	P-0025-060	Pin	2
5A	103118-S	Housing Sleeve	1	20	303319	Rotor	1
6	103127	Lever	1	21	303115	Rotor Blades	5
7	P-0030-220	Lever Pin	1	22	303112	Cylinder	1
8	103126	Valve Bushing	1	23	303323	Front End Plate	1
8P	O-1100-120	O-Ring	1	23A	103322A	Washer	1
9	O-0500-150	O-Ring	1	24	303324	Key	1
10	103125	Throttle Valve	1	25	103323	Idler Gear	3
11	O-0500-200	O-Ring	1	26	K477TN	Needle Bearing	3
12	103123	Spring	1	27	303327	Idler Gear Plate	1
13	103122	Air Regulator	1	28	303328	Ring Gear	1
14	O-0700-180	O-Ring	1	29	6201-Z00A	Ball Bearing	2
15	O-1100-250	O-Ring	1	30	303330	Gear Cap	1
16	103119	Valve Screw	1	31	303331	Washer	1