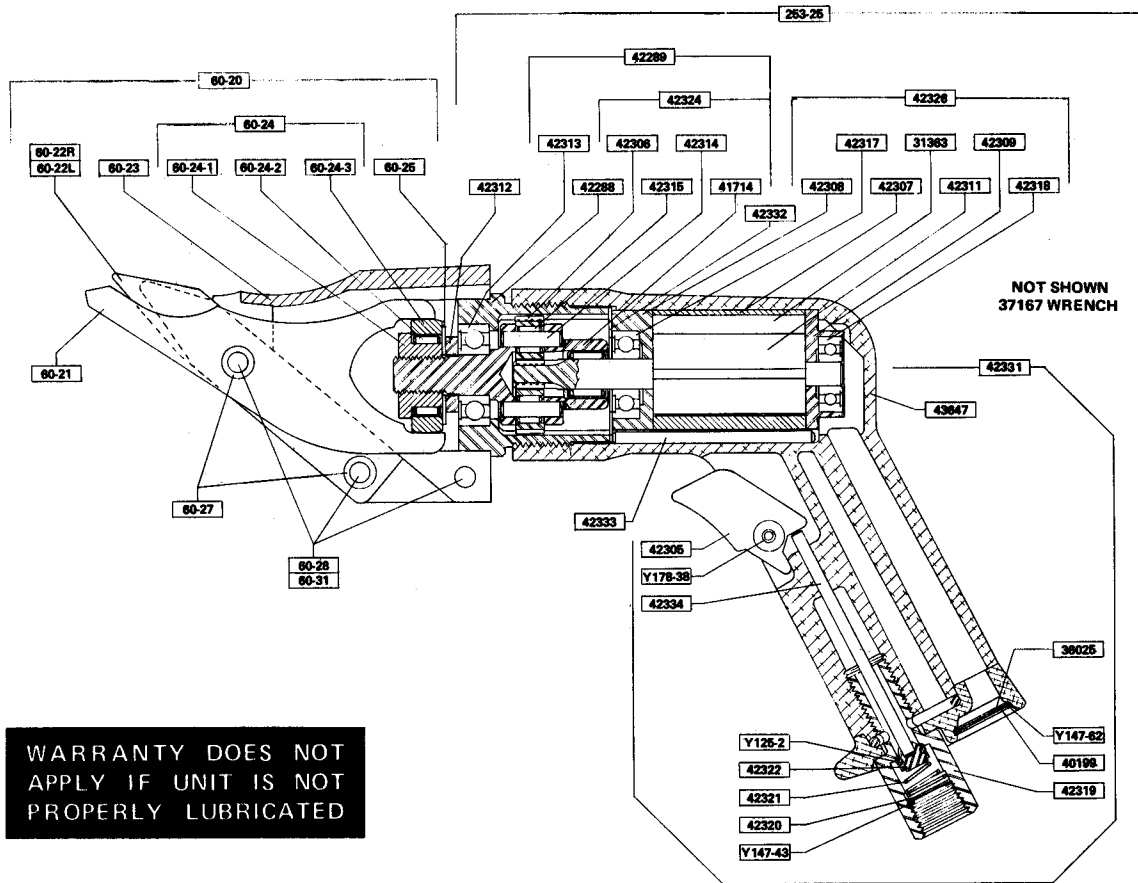




KETT/WPB Pneumatic Shear Model P-200 PARTS LIST

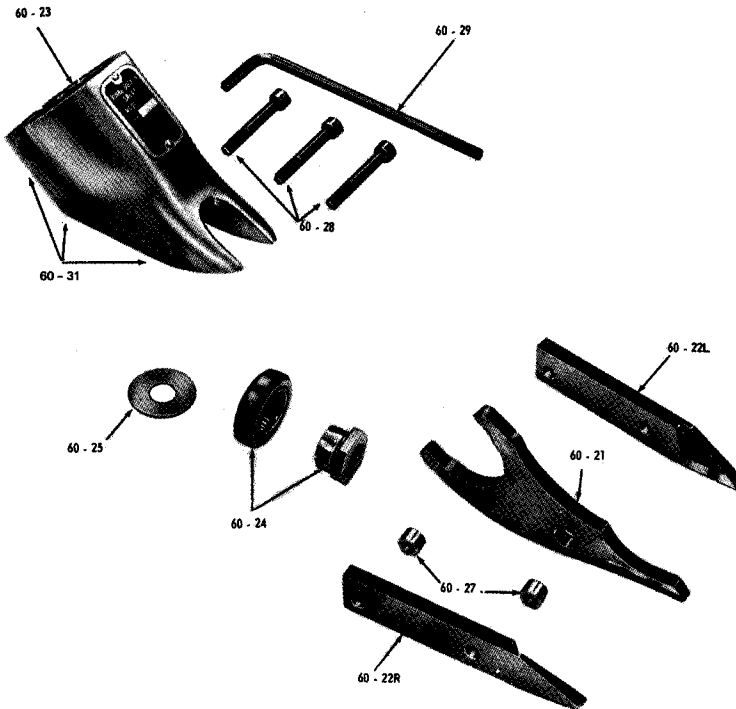


WARRANTY DOES NOT APPLY IF UNIT IS NOT PROPERLY LUBRICATED

When ordering repair parts use model number, part number and description of part.

Part Number	Description	Part Number	Description
60-20	Shear Head with 60-24 Eccentric Bearing Assembly	42289	Gearing Assembly
60-21	Center Blade	42305	Trigger
60-22L	Side Knife, Left	42306	Gear (2)
60-22R	Side Knife, Right	42307	Cylinder
60-23	Shear Housing	42308	End Plate
60-24	Eccentric Bearing Assembly	42309	End Plate
60-24-1	Eccentric Bushing (Hex Head)	42311	Rotor
60-24-2	Eccentric Needle Bearing	42312	Spacer
60-24-3	Eccentric Outer Ring	42313	Bearing
60-25	Thin Washer, Large	42314	Shaft (2)
60-27	Spacer Bushing (2)	42315	Bearing (2)
60-28	Cap Screw (3)	42317	Bearing
60-29	Allen Wrench	42318	Bearing
60-31	Knurled Insert (3)	42319	Adapter
Y125-2	"O" Ring	42320	Screen
Y147-43	Retaining Ring	42321	Spring
Y147-62	Retaining Ring	42322	Valve Body
Y178-38	Roll Pin	42324	Spindle Assembly
31363	Blade (4 to a set)	42326	Motor Assembly
36025	Screen	42332	Spacer
37167	Wrench	42333	Locating Pin
40199	Screen (Coarse)	42334	Valve Pin
41714	Spindle	42331	Housing & Valve Assembly
42288	Ring Gear	43647	Housing

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



ASSEMBLY

To install eccentric bearing assembly (60-24) onto shaft:

1. Make sure small thick washer (52680-01) and large thin washer (60-25) are inserted over shaft. Small thick washer (52680-01) must be put on shaft first.
2. Turn eccentric bearing assembly onto shaft and tighten with appropriate wrench. Lubricate bearing with a good grade of bearing grease.

To install cutter blades into shear housing (60-23):

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 thread 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.
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 drive motor:

1. Make sure rear cap screw and center cap screw (60-28) are loosened about three or four 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 drive motor.

DISASSEMBLY

To remove shear head assembly (60-20) from drive motor:

1. Loosen both rearward cap screws (60-28) three or four complete turns.
2. Remove shear head assembly (60-20) from motor by pulling head firmly forward. Slight twisting action may be required if head does not remove easily.

To remove cutter blades from shear head assembly (60-20):

1. 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.**
2. 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.**
3. Side knives (60-22L and 60-22R) will now drop out of shear housing.

To remove eccentric bearing assembly (60-24) from shaft:

1. Hold output shaft with wrench to prevent it from turning when removing eccentric nut. Flat areas are provided on the end of the shaft for this purpose.
2. Use an appropriate wrench to loosen eccentric nut by turning counter clockwise.

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.

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