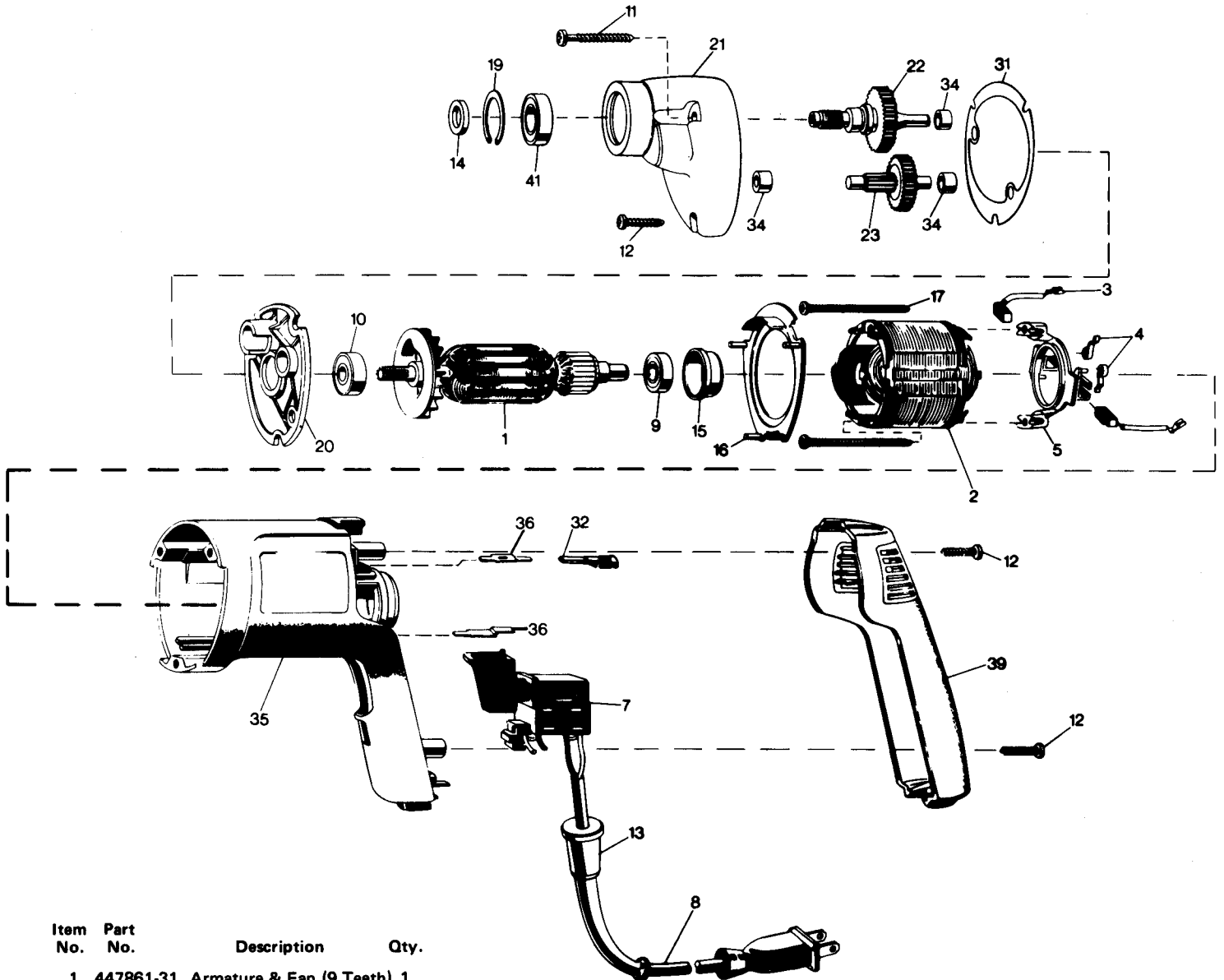




# Model K-200 Electric Shear PARTS LIST



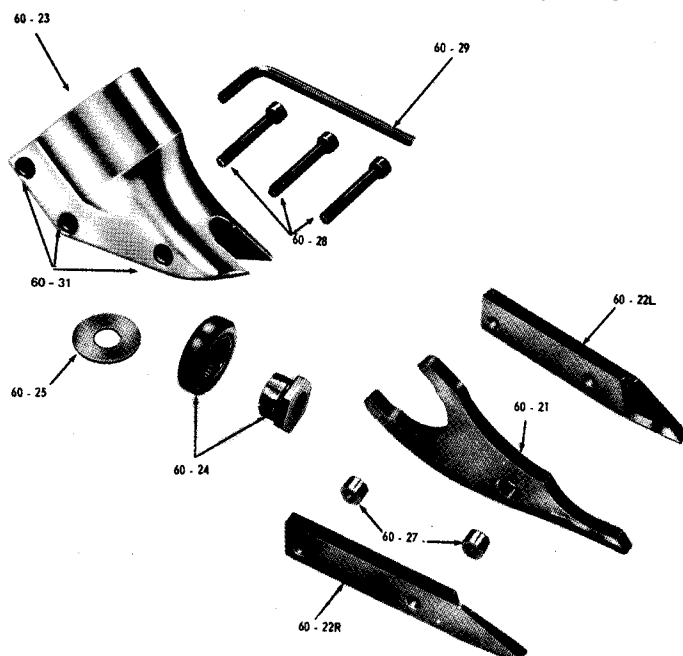
Item No.	Part No.	Description	Qty.
1	447861-31	Armature & Fan (9 Teeth)	1
2	449762-71	Field (Incl. 17)	1
3	445861-01	Brush	2
4	445860	Brush Spring	2
5	445884	Brush Holder	1
7	447869	Switch	1
8	448557-98	Cord & Plug (18-2 SJ)	1
Ø 9	400285	Ball Bearing	1
Ø 10	400285	Ball Bearing	1
11	95048	8-16 x 1-1/2" Thread Forming Screw	2
12	978114	8-16 x 13/16" Thread-Forming Screw	3
13	24288	Cord Protector	1
14	132809	Spacer	1
15	445217	Sleeve	1
16	447866	Fan Baffle	1
17	448269	6-19 x 2-1/4" Thread-Forming Screw	2
19	87692	Retaining Ring	1
20	448658-02	Gear Case Cover (Incl. 10, 34)	1
21	132697-03	Gear Case (Incl. 34, 41, 19)	1

Item No.	Part No.	Description	Qty.
22	445352	Spindle & Gear (37 Teeth) (3/8-24 Thd.)	1
23	132323-03	Int. Gear & Pinion (44/15 Teeth)	1
31	133954-01	Gasket	1
32	449192	Terminal	2
34	131557	Sleeve Bearing	3
35	447838-03	Field Case (Incl. 36)	1
36	445881	Contact Strip (Field Terminal-Short)	2
39	447867-01	Handle Cover	1
Ø 41	49423-02	Ball Bearing	1

Ø NOTES:

- 9 Press Bearing flush with end of shaft; seal faces Commutator
- 10 Press Bearing to bottom of bore; seal faces Gear
- 41 Seal faces Gear

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



## 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 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.

## ASSEMBLY

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

1. Make sure small thick washer (132809) and large thin washer (60-25) are inserted over shaft. Small thick washer (132809) 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. Lubricate outside diameter of spacer bushing (60-27) with a good grade of bearing grease then insert spacer bushing (60-27) into hole in center blade (60-21).
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.

**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.**