

INSTRUCTIONS
FOR
ADJUSTING PEXTO FOOT SHEARS

1. This shear has been tested to maximum capacity at factory. Do not exceed rated capacity shown on nameplate.
2. To set up Shear, remove from skids and place on a level foundation. NOTE: When Bed is level, it rests evenly on tile Leg Ledges at all four corners. If necessary, shim legs away from floor until Bed does rest evenly on the Leg Ledges.
3. Always keep Blades sharp. Wipe the Upper Blade with an oily rag frequently to help to keep the edges sharp.
4. Lubrication should be maintained between Cross head and Hold down Bearing surfaces and also between Cross head and Leg Bearing surfaces. Oil holes are provided in the Treadle to permit lubrication to the Hinge Pin.
5. Front, Back, Side and Bevel Gauges are provided for use as desired. Side and Back Gauges are graduated and adjustment is provided to keep graduations aligned with the Blade cutting edges.
6. Two leverage holes are provided on the 137, 142, and 152 Shears in each Treadle Lever Arm for the lower Connecting Link Pins. The Treadle as shipped will give ample leverage for cutting soft steel within the rated capacity of the machine, but greater leverage can be obtained for cutting maximum capacity stock by moving the lower Connecting Link Pins to the holes nearest the Hinge Pins.
7. It is advisable to have an extra pair of Blades available for use when the original Blades are removed to be sharpened. Always send the Blades for regrinding to the factory where necessary special machines for regrinding Blades are used.
8. To adjust Shear after Blades have been changed, back off the 4 Bolts that secure the Bed to the Legs a half turn. Bed adjusting screws move Bed to position Lower Blade in relation to upper Blade.
9. Place a sheet of heavy paper between the Blades for the full length and depress Treadle slowly. If Shear does not cut paper the full length, move Bed inward by turning Bed Adjusting Screws equally on each end a quarter turn at a time. If Shear cuts paper on ends but not in center, turn Cross head Adjustment Nut, in center of Tie-Rod, clockwise 1/8 turn at a time. If Shear cuts paper in center but not on ends, reverse direction of turn on Cross head Adjustment Nut. NOTE: This adjustment is always made at the factory and should not be necessary on a new Shear.
10. After adjusting for proper Blade clearance, tighten Bed to Leg Bolts securely before cutting stock.
11. When ordering replacement parts from the factory, be sure to give Machine Number, Serial Letter and Part Name.



