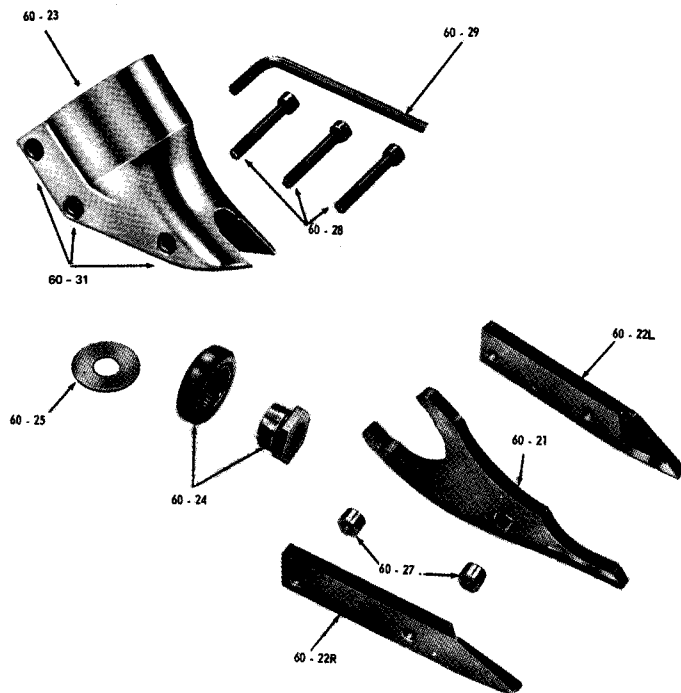




## INSTRUCTIONS FOR THE CARE OF THE KETT NO. 60-20 SHEAR HEAD



### 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.**