



SWENSON SHEAR

EST. 1959



SHEAR MANUAL

Thank you for purchasing our Swenson Shear

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SHEAR MANUAL



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SAFE OPERATION INSTRUCTIONS

- *WARNING: CARELESS OR IMPROPER OPERATION OF THIS SHEAR MAY RESULT IN SERIOUS INJURY.
- *OPERATOR MUST READ AND UNDERSTAND THESE INSTRUCTIONS PRIOR TO OPERATION OF THIS SHEAR.

PACKING CHECKLIST

The following items will be found in the shipping box:

1. Shear (top blade should be locked in place with clevis pin and clip. Please do not remove clevis pin before removing the shear from the shipping box)
2. Packing slip and instruction manual

**If you are missing any parts, please contact Swenson Shear immediately.*

ASSEMBLY INSTRUCTIONS

1. Bolt handle to either pair of mounting holes (high position for ground operation, low position for table top operation).
2. Clamping Table Operation: Use vice grip pliers to secure flat portion of panel to clamping tab so panel will not move during shearing.



GENERAL DESCRIPTION OF DEVICE:

The Swenson Shear is a hand-operated, pivot-style shear designed to cut a variety of materials. *We recommend not cutting material thicker than 24 gauge mild steel or equivalent. Cutting thicker panels may increase wearing of the blades.*

PREPARATION FOR OPERATION

- *Place shear on flat and firm surface.*
- *Cycle the shear 20-30 times before the first job. Cycling the shear will allow the shear to set and will aid in eliminating burred edges.*
- Top blade of *shear must always be stowed in closed position* using supplied clevis pin and clip. Prior to removal of clevis pin, hold one hand on shear handle to control the raising of the blade.
- Remove clip from locking clevis pin and remove pin from hole.
- Lift top blade of shear to full upright position.
- Store clevis pin and clip for safe keeping in hole above blade lock hole at handle end of top blade.
- Check surrounding area to be sure there are no electrical cords in the vicinity of the shear operation. Electric shock may occur if cord is severed by shear.



OPERATION OF SHEAR

1. Operator must *always* stand at rear of shear facing machine from the handle end. Shear blade should *never* be lowered without an operator holding the handle at the end of the shear.
2. Material that is to be cut should be oriented in the shear *without* operator placing hands or fingers *near or under* the top shear blade.
3. In some cases, shear operation may require the assistance of a person working to the side of the shear to hold the material in place while operator shears the material.

NOTE - OPERATOR ASSISTANT INSTRUCTION: NEVER HOLD MATERIAL WITH HANDS AND FINGERS LESS THAN TWO FEET FROM THE CUTTING SURFACE.

4. If cut width leaves less than 24 inches of material for assistant operator to hold, material must be sheared without person holding material or material must be clamped to a pre-alignment jig or other device.
5. Shear Operator must hold both hands on the top blade handle with both feet flat on the ground for operation. Shearing motion is a quick, continuous downward motion of the blade with *operator paying close attention to cut progress and to any possible obstacles in cut path.*
6. Operator should *NEVER JUMP UP TO GRAB SHEAR HANDLE.* Operator must be tall enough while standing flat footed in front of the shear to reach handle with both hands.
7. *DO NOT JUMP UP TO ADD WEIGHT TO TOP BLADE DURING SHEARING MOTION!* If material offers resistance sufficient to keep operator from moving blade down through material smoothly with both feet on the ground, stop shearing operations immediately and investigate the material in question.
8. Shearing material thicker than 24 gauge may increase the wearing of the blades.

POST-SHEAR OPERATION:

When shearing operation is complete, carefully lower top blade and latch blades carefully to frame with supplied clevis pin and clip.

MAINTENANCE:

1. Apply light oil, such as WD40, to top and bottom blade cutting surfaces periodically prior to operation.
2. Periodically check the grease on the heel pad of the shear. Clean off dirt as necessary and grease with any heavy-duty grease.

BLADE REPLACEMENT:

Tools Required:

3/16" Allen Wrench

9/16" wrench

1. Open shear fully.
2. Loosen and remove fasteners on blades and pull blades off.
3. Place new blades on top and bottom and tighten fasteners.
4. See Blade Realignment Procedure on the next page.



BLADE ALIGNMENT PROCEDURE

After changing blades, it may be necessary to align the top blade with the bottom blade in order to achieve the best cut possible. This is done using the adjusting screws that move the pivot bolt to the front or rear. Simply loosen the lock nuts and move the pivot bolt either direction. Be sure to retighten the lock nuts when adjustment is complete. You want to make sure that the profile on the top and bottom blades align on the first rib.



WARRANTY

Swenson Shears are warrantied to be free from material or manufacturing defects for a period of 2 years from the date of purchase excluding blades and springs.

PRE-ALIGNMENT JIG ASSEMBLY INSTRUCTIONS

Contents of Pre-Alignment Jig Package:

- 2 Powder coated leg pieces
- 2 Clevis pins with clips
- Wood screws
- *2x4 Wood pieces not included

Step One: Place the 2x4 wood pieces on the floor and screw in the jig legs using the screws supplied. The distance between the $\frac{3}{8}$ " holes in the ends of the jig pieces **must be 38 inches**. This will insure that the holes in the shear frame and jig align in order to be attached with the clevis pins supplied.

Step Two: Attach the jig to the shear frame using the clevis pins supplied.

Step Three: Place a short piece of sacrifice panel matching the blade profile across the 2x4 pieces and perpendicular to the cutting blade. The edge of the panel should be about half way across the width of the cutting blade. Cut a sample piece square using the shear if you are not using a factory shear edge. Use a carpenter square to confirm position of the panel relative to the cutting blade. With panel perpendicular to cutting blade, screw panel to both 2x4 pieces to lock in place.

*The jig can now be removed or installed quickly by simply pulling the clevis pins out of the mounting holes.

