



Click Here To View  
Item at

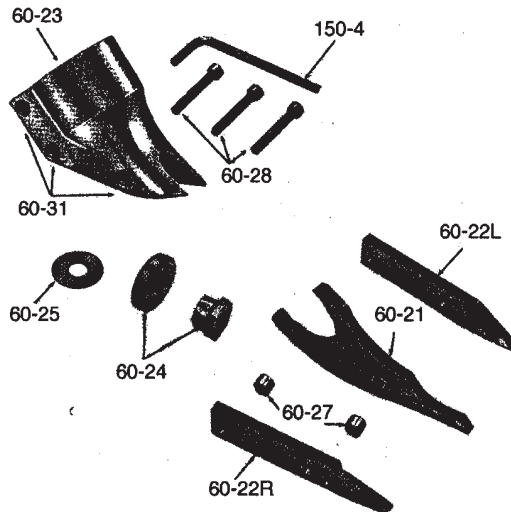
[www.GapPower.com](http://www.GapPower.com)

*Sales • Rentals  
Parts & Service*





# Instructions for the Care of the KETT 60-20 Shear Head



**CAUTION**  
Disconnect power Unit Before Servicing Tool

## PARTS LIST

60-21	Center Blade
60-23	Shear Housing
60-24	Eccentric Bearing Assembly
60-27	Spacer Bushing
60-28	Cap Screw (3)
60-31	Knurled Insert (3)
60-22L	Side Knife, Left
60-22R	Side Knife, Right
60-25	Thin Washer, Large
60-27	Spacer Bushing
150-4	Allen Wrench

**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 the shear head from the motor loosen three cap screws (60-28). Remove shear head from motor by pulling head firmly forward. Slight tapping with a mallet may be required if head does not slide off easily.

To remove cutter blades from shear head, remove three cap screws (60-28) completely from shear housing (60-23). Be careful not to lose rear spacer bushing (60-27) when removing middle cap screw. Remove center blade (60-21) from shear housing by tapping blade gently rearward. Be careful not to lose spacer bushing (60-27) from hole in center blade. Side knives (60-22L and 60-22R) will now drop out of the shear housing.

To remove eccentric bearing assembly (60-24) from shaft use an appropriate wrench to loosen eccentric nut by turning counter clockwise.

**ASSEMBLY:** To install eccentric bearing assembly (60-24) onto shaft make sure the large thin washer (60-25) is first inserted over the shaft. Screw 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) place the side knives (60-22L and 60-22R) into position in the shear housing (60-23). Insert center cap screw (60-28) through the side knives (60-22L and 60-22R) with rear spacer bushing (60-27) between them and start cap screw into thread just enough to hold blades in place. DO NOT TIGHTEN. Insert spacer bushing (60-27) into hole in center blade (60-21) and lubricate with Molybdenum Disulfide grease (264-3) or equivalent. Install center blade into shear housing by tapping blade gently forward, using a drift to line up hole in center blade with forward holes in housing. Insert and tighten forward cap screw (60-28) making sure spacer bushing (60-27) in center blade stays in position. Apply Molybdenum Disulfide grease (264-2) or equivalent to clevis or yoke in center blade where it rides on the eccentric bearing assembly. Insert rear cap screw (60-28) into shear housing, but do not completely tighten.

To install shear head assembly onto drive motor, make sure all cap screws (60-28) are loosened about three or four complete turns. Spread shear housing (60-23) slightly using a drift near the rear cap screw (60-28). Place shear head onto unit, tap left side knife rearward as far as it will go, and tighten cap screws very tightly to lock head assembly in place. It may be necessary to gently tap the shear head into place, if it does not readily slip onto the nose of 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 OTHER THAN THOSE REGULARLY SUPPLIED BY US. USE ONLY KETT REPLACEMENT BLADES EMBOSSED WITH PART NUMBERS 60-21, 60-22L OR 60-22R.**