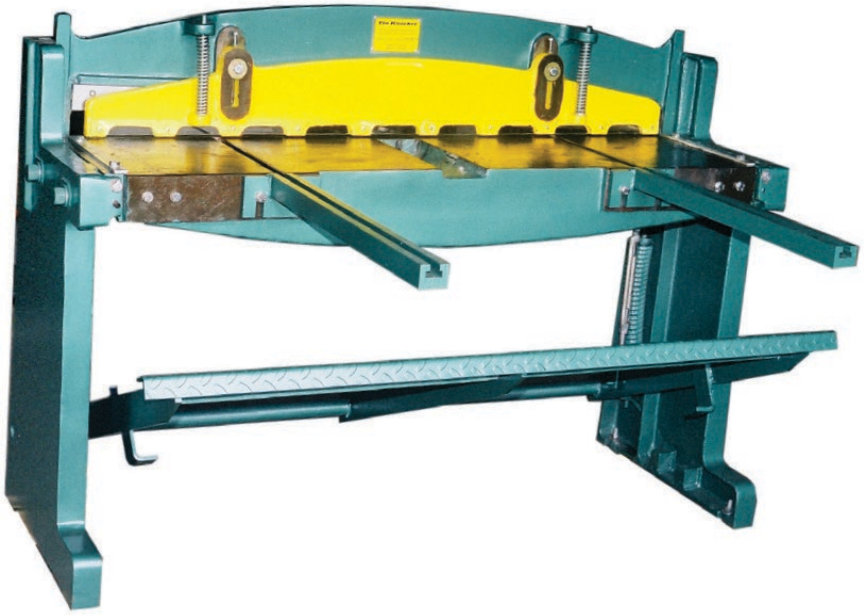
TIN KNOCKER

TK 1652 FOOT SHEAR

INSTRUCTIONS & PARTS DIAGRAMS



TAAG INDUSTRIES CORP.
1550 SIMPSON WAY, ESCONDIDO, CA 92029
Tel: (800) 640-0746 Fax: (760) 727-9948
Website: www.tinknocker.com Email: info@taagind.com

TIN KNOCKER
SAFETY RULES
TK 1652 FOOT SHEAR

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush – not your hands.

2. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual as well as the warnings and instructions mounted on the machine.

3. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.

4. Report all injuries or illness, regardless of severity, to your supervisor.

5. Do not place speed above safety.

6. Never use this machine for anything other than its intended purpose. Use the proper tool and equipment for the task.

7. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.

8. Do not override the safety features of the equipment. Do not remove guarding.

9. Do not operate the machine in excess of its rated capacity. (52" x 16ga.)

10. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.

WARRANTY

All new machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. TAAG Machinery Co. at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. TAAG Machinery Co. will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must deliver to TAAG Machinery Co., at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to TAAG Machinery Co. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

NOTE: 1. This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Following the procedures described within can easily do readjustment. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you. Call us at: (800) 640-0746.

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OPERATING INSTRUCTIONS FOR 1652 SHEAR

BEFORE OPERATING-

1. This shear has been tested to capacity at the factory and at our warehouse. Do not exceed rated capacity on nameplate. Test cut to capacity to see if the shear is still in adjustment.
2. If out of adjustment, remove from skids and place on level foundation. Back off all leg-to-bed bolts and loosen adjusting screws. Bed must rest squarely on right and left hand leg ledges at all form corners when bolts are loose. If necessary, shim legs at the floor, to level bed on ledges. LAG SHEAR SECURELY TO THE FLOOR.
3. To adjust blade for cutting, (after setting up or changing blades), first make sure leg-to-bed bolts are snug tight. CAUTION: Move bed toward crosshead blade by means of adjusting screws, screw

moves bed “out”, increasing clearance between upper and lower blade – moved bed “in”, decreasing clearance. Position lower blade within a few thousandths of the upper blade, being careful the lower blade does not overlap the upper. Place a sheet of heavy paper (approx. .005”) the full length of cut, between the blades and slowly depress the treadle. If shear does not cut paper, move bed blade in toward upper blade as necessary, by carefully readjusting screws at either or both sides. If shear cuts paper on ends but not I center, it will be necessary to turn crosshead ties rod adjusting nut clockwise until paper cuts full length of blade. If shear cuts I center but not on ends, reverse direction of turn on crosshead tie rod adjusting nut. NOTE: This adjustment is carefully made at the factory and should not be necessary on a new shear.

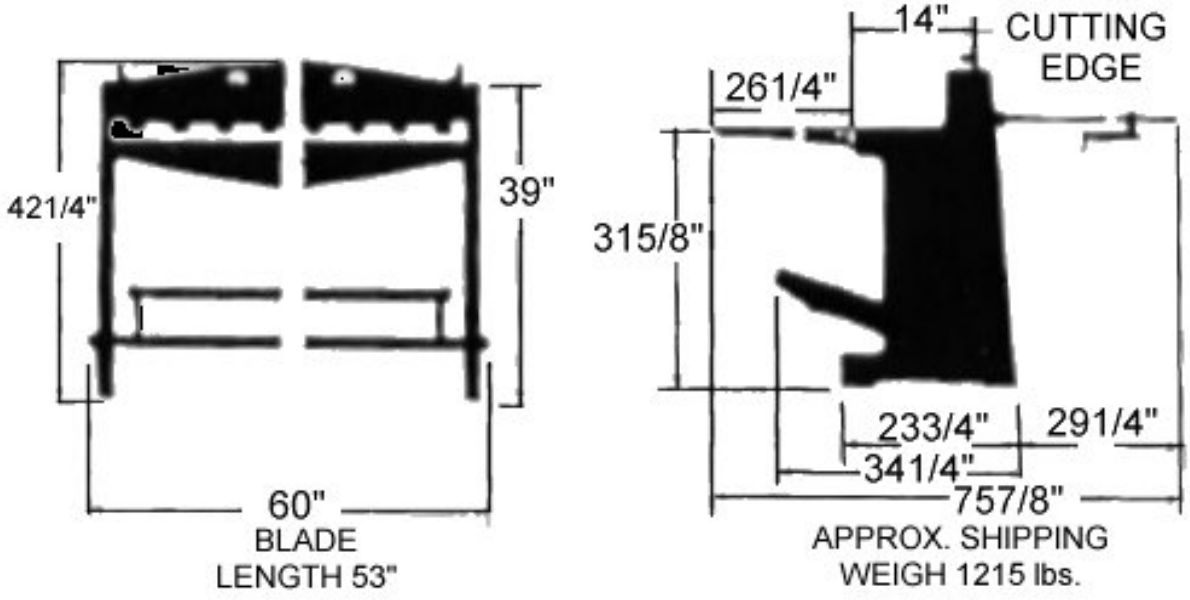
4. When blades are properly adjusted, tighten leg-to-bed bolts securely before cutting stock.
5. Always keep blades sharp. Wiping blades occasionally with oil will increase blade life.
6. Lubrication should be maintained between crosshead and leg bearing surfaces. Lubricate all points (X) daily.
7. Front, back and side gauges are provided for use as required. Side and back gauges are graduated in sixteenths and adjustment is provided to keep graduations aligned with blade cutting edges.
8. Crosshead adjustment – use gib screws to adjust gib setting. This setting should hold crosshead snugly against ways in legs, yet not bind the crosshead movement. This adjustment should not be necessary in new shear.
9. It is suggested that an extra pair of blades be available for use when blades are removed for sharpening. Blades should be returned to factory for regrinding.
10. Two leverage holes are provided 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.
11. To adjust shear after blades have been changed, back off the leg-to bed bolts and following instructions #3 above. CAUTION: Use heavy gloves when handling shear blades.
12. When ordering replacement parts from the factory, be sure to give machine number, serial letter and part name.
13. Hold down adjustment – set hold down to engage sheet before blades.

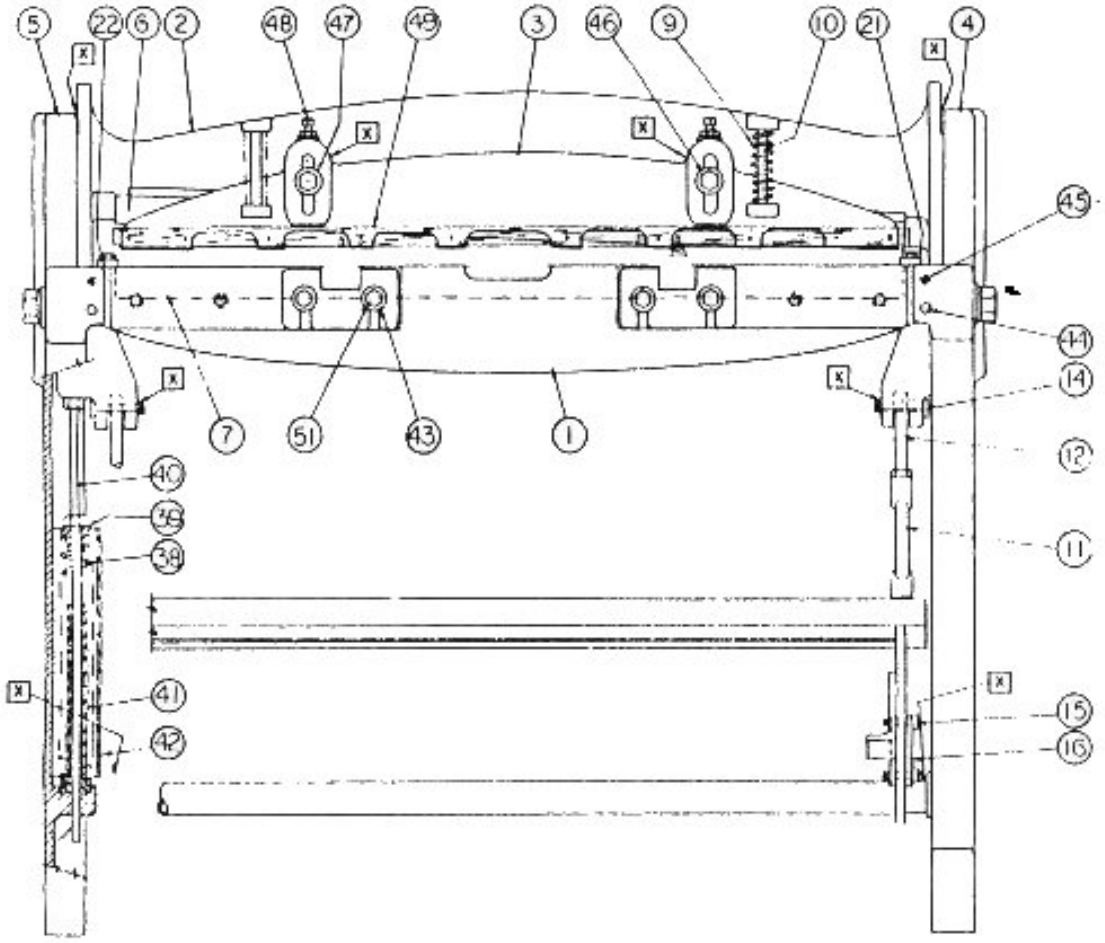
SPECIFICATIONS

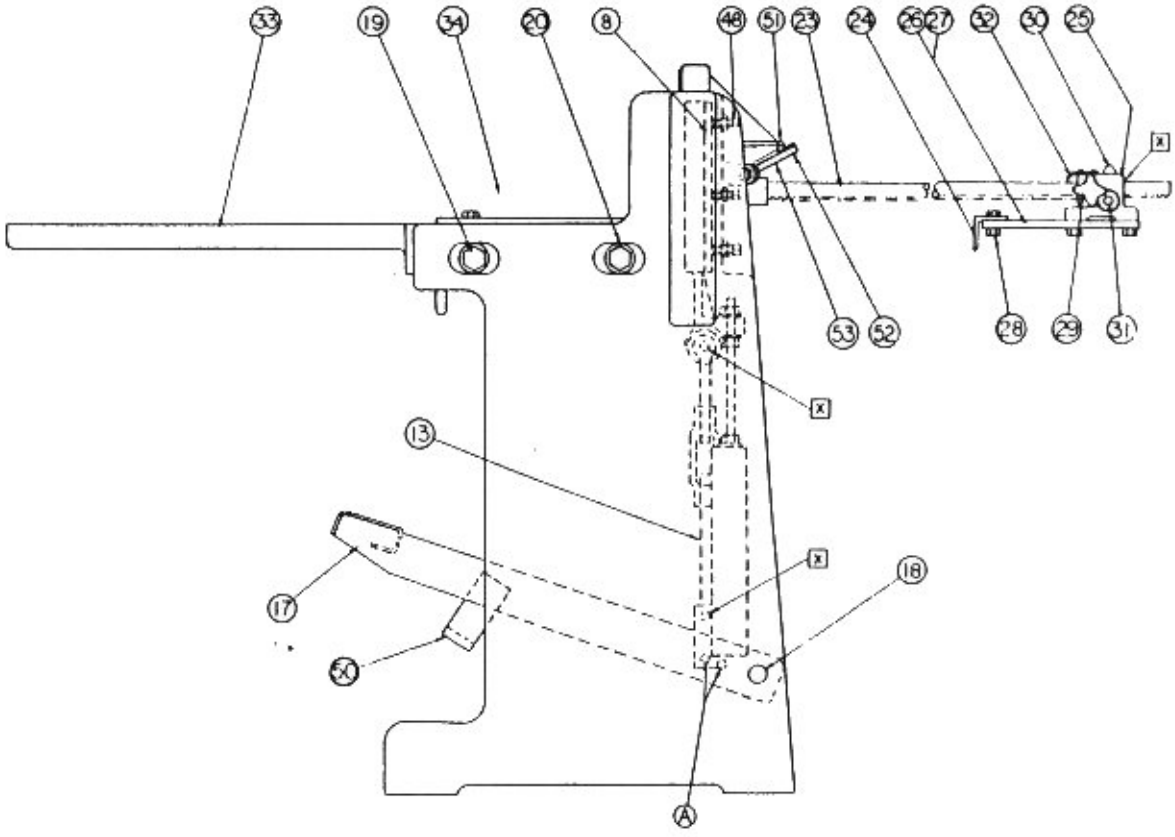
Dimensions: 60”L x 34”W x 42” H
Floor space: 60” x 72”
Weight: 1070 lbs.
Ship weight aux: 1215 lbs.

Shearing Length: 52”
Capacity: 16 Ga. Mild Steel
Back Gauge: 25” with Engraved Rule

TK1652 SHEAR




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Parts For 1652 Foot Shear

Fine No.	Part No.	Description	No. REQ"D.
1	SHEAR001	BED	1
2	SHEAR002	CROSSHEAD	1
3	SHEAR003	HOLD DOWN	1
4	SHEAR004	R.H. LEG	1
5	SHEAR005	L.H. LEG	1
6	SHEAR006	UPPER BLADE	1
7	SHEAR007	LOWER BLADE	1
8	SHEAR008	GIB	2
9	SHEAR009	HOLD DOWN SPRING	2
10	SHEAR010	HOLD DOWN STUD	2
11	SHEAR011	TURNBUCKLES	2
12	SHEAR012	UPPER TREADLE ROD	2
13	SHEAR013	LOWER TREADLE ROD	2
14	SHEAR014	CROSSHEAD PIN	2
15	SHEAR015	CONNECTING LINK PIN	4
16	SHEAR016	CONNECTING LINK	4
17	SHEAR017	TREADLE ASSEMBLY	1
18	SHEAR018	TREADLE HINGE PIN	2
19	SHEAR019	BED TO LEG BOLTS	4
20	SHEAR020	WASHERS	4
21	SHEAR021	R.H. SIDE GAUGE	1
22	SHEAR022	L.H. SIDE GAUGE	1
23	SHEAR023	BACK GA. ARM	2
24	SHEAR024	BACK GAUGE BAR	1
25	SHEAR025	BACK GAUGE HOLDER	2
26	SHEAR026	R.H. LINK	1
27	SHEAR027	L.H. LINK	1
28	SHEAR028	PIVOT STUD	3
29	SHEAR029	HAND KNOB	2
30	SHEAR030	HAND WHEEL	2
31	SHEAR031	PINION	2
32	SHEAR032	POINTER	2
33	SHEAR033	FRONT ARM	2
34	SHEAR034	BEVEL GAUGE	1
38	SHEAR038	TREADLE SPRING	2
39	SHEAR039	SPRING COLLAR	4
40	SHEAR040	SPRING ROD	2
41	SHEAR041	SPRING GUIDE	2
42	SHEAR042	SPRING COVER	2
43	SHEAR043	WASHER	16

44	SHEAR044	“BED OUT” ADJ. SCREW	2
45	SHEAR045	“BED IN” ADJ. SCREW	2
46	SHEAR046	R.H. HOLD DOWN TO CROSSHEAD BOLT	1
47	SHEAR047	L.H. HOLD DOWN TO CROSSHEAD BOLT	1
48	SHEAR048	GIB & HOEDOWN Adj. SCREW	1
49	SHEAR049	FINGER GUARD	1
50	SHEAR050	TREADLE STOP	1
51	SHEAR051	FRONT ARM BOLTS	1
52	SHEAR052	ADJ. SCREW	1
53	SHEAR053	TIE ROD	1
54	SHEAR054	Back Gauge Kit	