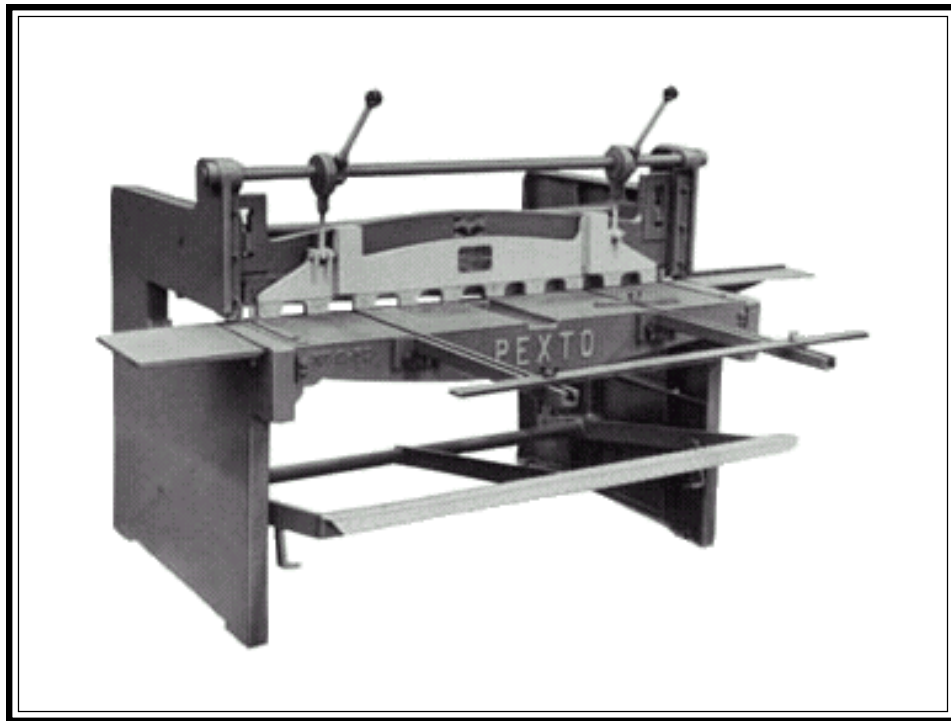


PEXTO

NO. G52 FOOT GAP SHEAR

OPERATING INSTRUCTIONS AND PARTS IDENTIFICATION



ROPER WHITNEY

2833 HUFFMAN BLVD., ROCKFORD, ILLINOIS 61103-3990 * 815/962-3011 * FAX 815/962-2227

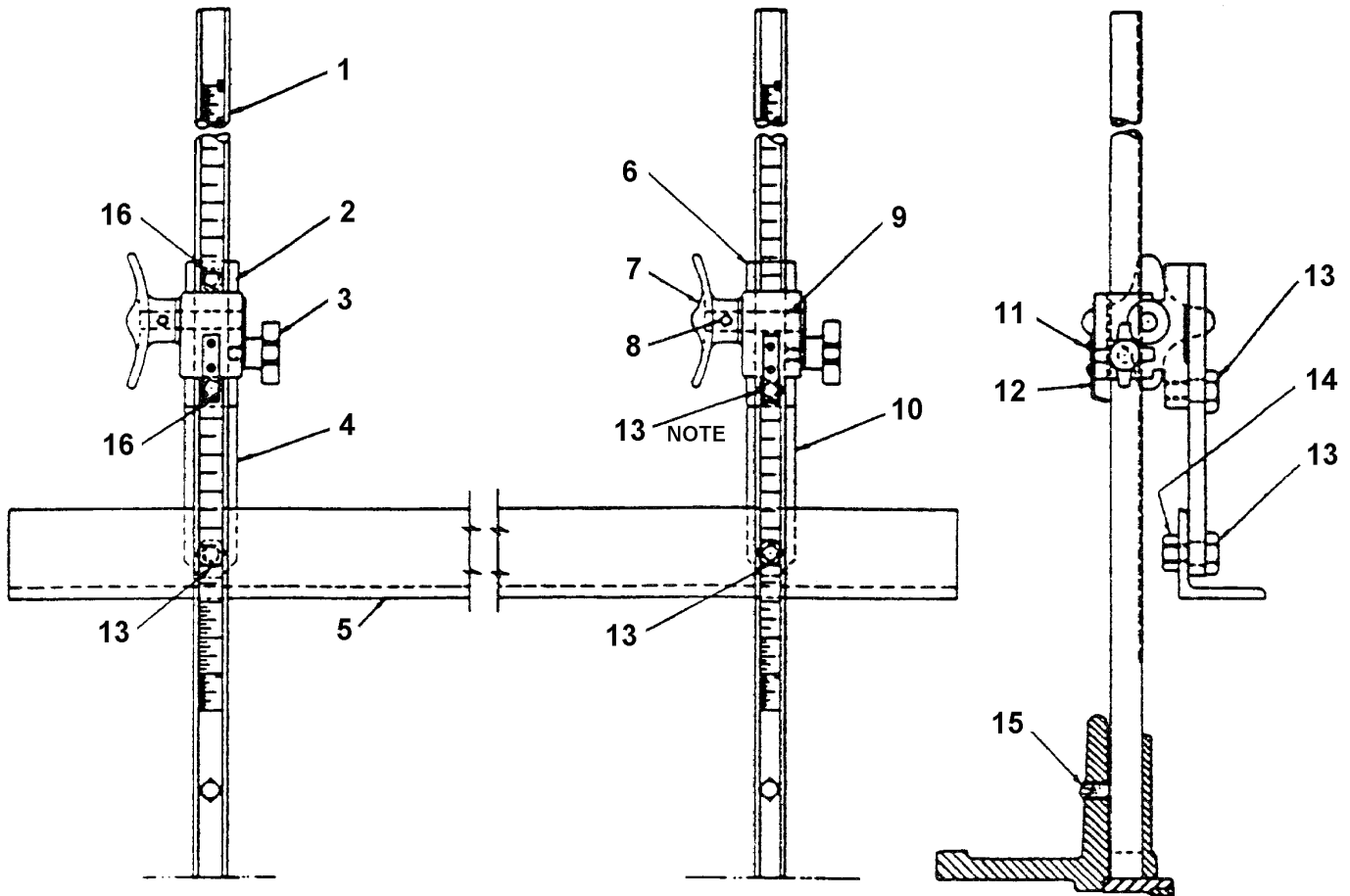
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Rev. 8/9/01

INSTRUCTIONS FOR ADJUSTING NO. G52 PEXTO FOOT SHEAR

1. This shear has been tested to maximum capacity at factory. Do not exceed 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 the 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 Crosshead and Holddown Bearing surfaces and also between Crosshead 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. 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.
7. 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.
8. 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 Crosshead 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 Crosshead Adjustment Nut. NOTE: This adjustment is always made at the factory and should not be necessary on a new Shear.
9. After adjusting for proper Blade clearance, tighten Bed to Leg bolts securely before cutting stock.
10. When ordering replacement parts from the factory, be sure to give Model, Letter and Serial Number shown on Machine Nameplate.

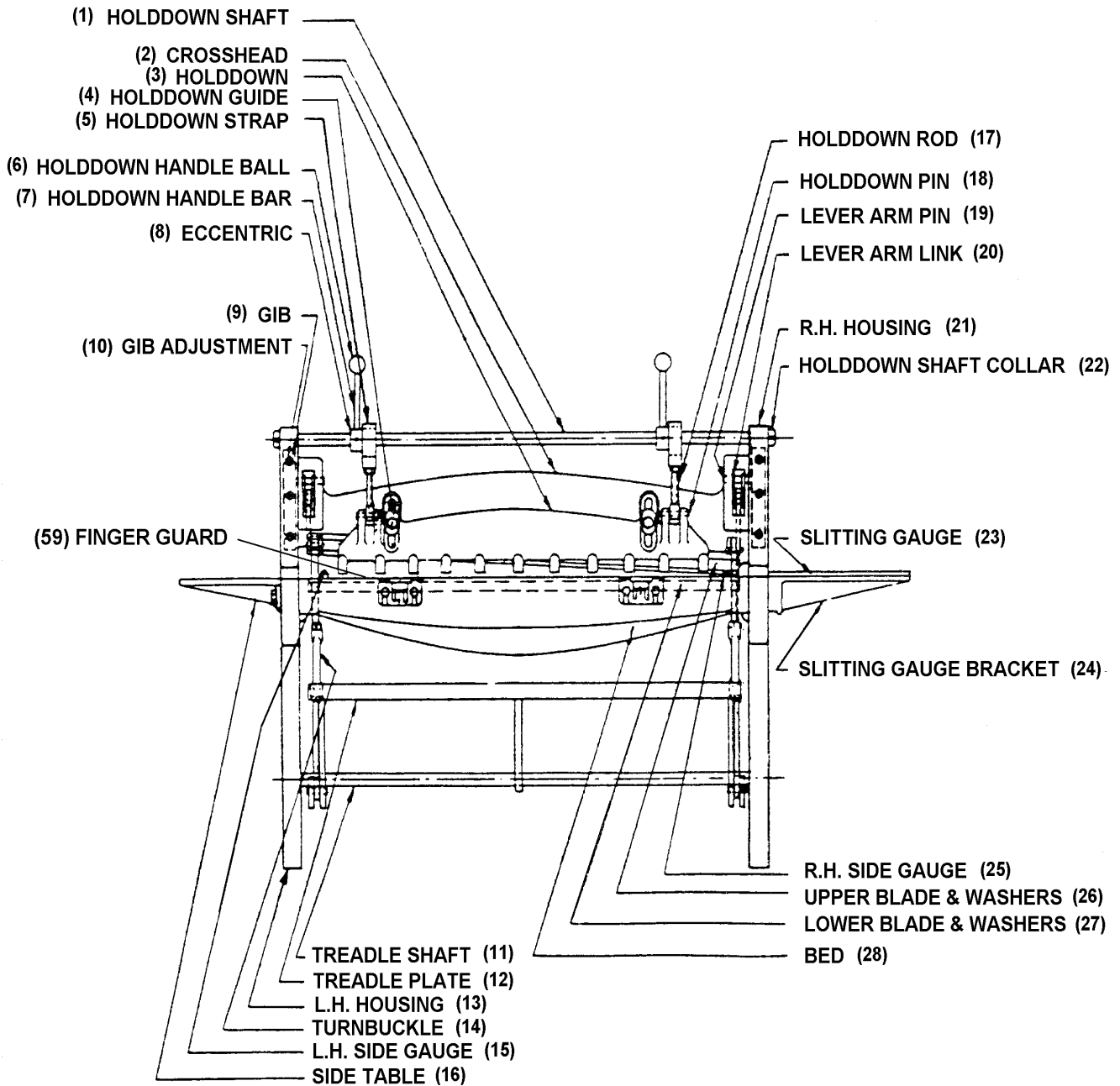
PEXTO NO. 3 BACKGAUGE IDENTIFICATION CHART



NOTE: R.H. Link (10) is assembled to R.H. Gauge Holder (6) with one pivot stud (13) to provide for angular setting of backgauge.

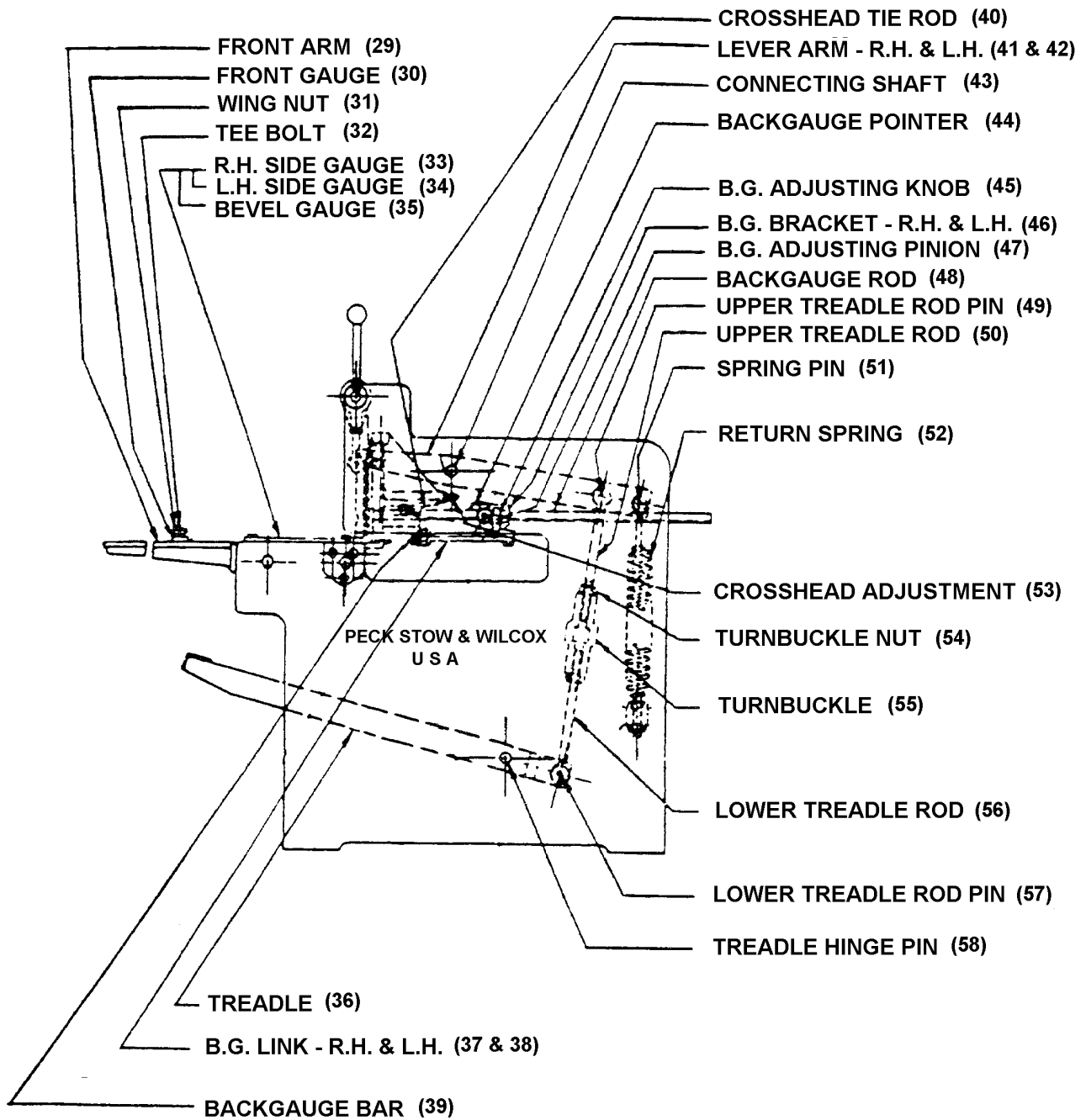
1. 762030044	GAUGE ROD	9. 762380050	PINION
2. 762200043	L.H. BACKGAUGE HOLDER	10. 762240045	R.H. LINK
3. 600356311	HAND KNOB	11. 615012024	8-32 X 1/4 BH SCREW
4. 762240046	L.H. LINK	12. 762420048	POINTER
5. 762420047	BACKGAUGE BAR	13. 762160051	PIVOT STUD
6. 762200043	R.H. BACKGAUGE HOLDER	14. 649023007	1/2-13 HEX NUT
7. 762550049	HANDWHEEL	15. 621012275	1/2-13 X 1 1/2 SCREW
8. 621012084	1/4-20 X 3/8 ALLEN SET SCREW	16. 601012273	1/2-13 X 1 1/4 SCREW

NO. G52 PARTS IDENTIFICATION CHART



Please refer to the Parts Identification List on page 6 for part numbers.

NO. G52 PARTS IDENTIFICATION CHART



WARNING: Before operating, machine must be bolted to work bench. If floor stand has been provided, machine must be bolted to floor stand with bolts provided. Stand must be securely lagged to floor.

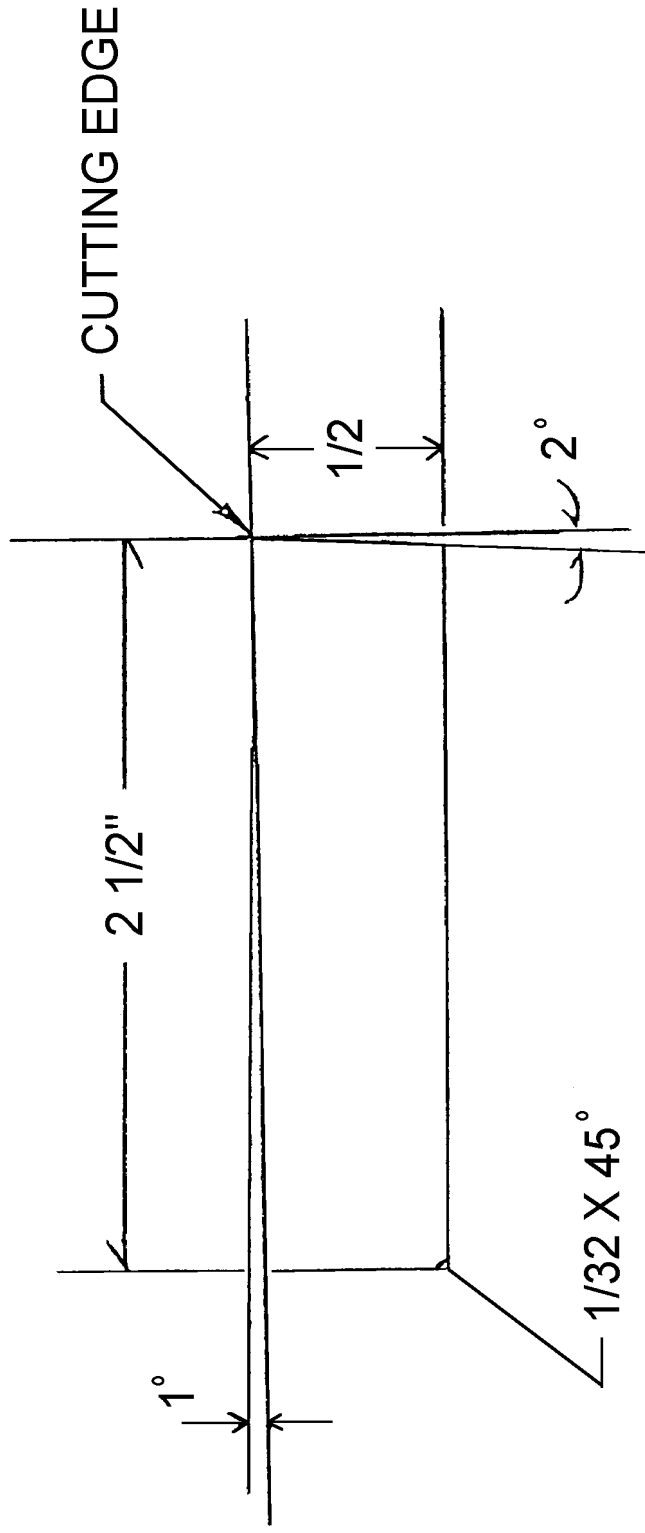
G52 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO.	PART NAME	QTY.
1	762680013	Holddown Shaft	1
2	762610001	Crosshead	1
3	762010007	Holddown	1
4	762450023	Holddown Guide	2
5	762240024	Holddown Strap	2
6	600356310	Holddown Handle Ball	2
7	762460026	Holddown Handle Bar	2
8	762210025	Eccentric	2
9	762400027	Gib	2
10	633012099	Gib Adjustment Screw 1/4 x 2" Sq. Hd.	
11	462680003	Treadle Shaft	1
12	462060002	Treadle Plate	1
13	762140006	L. H. Housing	1
14	600000124	Turnbuckle	2
15	762420032	L. H. Side Gauge	1
16	762090037	Side Table	1
17	762030022	Holddown Rod	2
18	762160021	Holddown Pin	2
19	762160029	Lever Arm Pin	2
20	762240030	Lever Arm Link	4
21	762140005	R. H. Housing	1
22	762260020	Holddown Shaft Collar	2
23	762420039	Slitting Gauge	1
24	762200038	Slitting Gauge Bracket	1
25	762420031	R. H. Side Gauge	1
26	350700195	Upper Blade	1
27	350700195	Lower Blade	1
28	762090004	Bed	1
29	762030035	Front Arm	2
30	762420033	Front Gauge	1
31	673023007	Wing Nut	3
32	762160036	Tee Bolt	3
33	762420031	R. H. Side Gauge	1
34	762420032	L. H. Side Gauge	1
35	762420034	Bevel Gauge	1
36	762810008	Treadle	1
37	762240045	R. H. Backgauge Link	1
38	762240046	L. H. Backgauge Link	1
39	762420047	Backgauge Bar	1
40	762030002	Crosshead Tie Rod	1
41	762030011	R. H. Lever Arm	1
42	762030012	L. H. Lever Arm	1

G52 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO.	PART NAME	QTY.
43	762680014	Connecting Shaft	1
44	762420048	Backgauge Pointer	2
45	600356311	Backgauge Adjusting Knob	2
46	762200043	R. H. & L. H. Backgauge Brackets	2
47	762380050	Backgauge Adjusting Pinion	2
48	762030044	Backgauge Rod	2
49	762160017	Upper Treadle Rod Pin	2
50	762030015	Upper Treadle Rod	2
51	600063473	Spring Pin	2
52	662184545	Return Spring	2
53	762650003	Crosshead Adjustment	1
54	643023012	Turnbuckle Nut	
55	600000124	Turnbuckle	2
56	762030016	Lower Treadle Rod	2
57	762160018	Lower Treadle Rod Pin	2
58	762160019	Treadle Hinge Pin	2
59	762440040	Finger Guard	1

FOR SHARPENING MODEL G52 BLADE



CUTTING EDGE AND THICKNESS

PARALLEL WITHIN .001 IN ANY 12"

PARALLEL WITHIN .003 OVERALL LENGTH