Eastwood® DO THE JOB RIGHT.®

Item #13743

PNEUMATIC METAL SHEAR

INSTRUCTIONS

The **EASTWOOD PNEUMATIC METAL SHEAR** is a heavy-duty, metal working tool capable of many years of reliable service. It features a high-performance, high-torque, ball bearing motor design with a hardened planetary gear reduction for quick and efficient operation and long life. Easily cuts stainless steel, steel and aluminum. Equipped with a 360° positionable cutting head for hard to access projects.

CONTENTS

- **(1)** Pneumatic Metal Shear
- **(1)** 4mm Hex Key
- **(1)** 1/4" NPT Male Quick Disconnect Fitting
- **(1)** #13743A Replacement Blade Set

SPECIFICATIONS

Maximum Material Thickness:

Mild Steel, Aluminum and Copper: 18 Ga (0.050" [1.2mm])

Stainless Steel: 20 Ga (0.036") [0.91mm]

Air Consumption:	4 CFM @ 90 PSI [113 L/min @ 6.2bar]
Maximum Operating Pressure:	90 PSI [6.2bar]
Strokes Per Minute:	2,500
Inlet Thread Size:	1/4" FNPT
Motor Construction:	4 Vane, Ball Bearing Air Motor with Planetary Gear Set

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

⚠ DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

⚠ WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

⚠ CAUTION

CAUTION indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

⚠ NOTICE

NOTICE is used to address practices not related to personal injury.

⚠ READ INSTRUCTIONS

- Thoroughly read and understand these product instructions before using this tool.
- Keep these product instructions for future reference.

⚠ WARNING EYE INJURY HAZARD!

- Rapidly reciprocating Blades will eject metal chips at high velocity. Always wear ANSI approved eye protection when operating this tool.

⚠ WARNING HEARING DAMAGE HAZARD!

- The Eastwood Pneumatic Metal Shear emits high sound levels while operating. Use ANSI approved ear protection when operating this tool.

⚠ CAUTION BURST HAZARD!

- Do not exceed 90 psi (6.2 bar) of tool inlet pressure. Permanent tool damage and/or bursting could occur and cause personal injury.

⚠ CAUTION INJURY HAZARD!

- This tool has high-speed cutting surfaces which can quickly cause severe injury. Keep fingers and hands away from moving parts when operating.
- Handling sharp metal can cause severe cuts. Wear thick, well-fitting work gloves.
- Do not force tool or exert excessive force on Blades while cutting as the tool body can suddenly kick back or twist causing severe hand or wrist injury.
- Always disconnect tool from air supply when changing Blades to prevent accidental tool starting and potential severe injury.
- Always make sure the workpiece being cut is securely clamped or anchored to avoid sudden movements which could result in injury.
- Frequently inspect Cutting Blades and tool condition. If cracks or chips develop, discontinue tool use immediately and replace damaged Blade Set. USE ONLY an Eastwood #13474 Pneumatic Metal Shear Replacement Blade Set. Severe injury can result in the event of a Cutting Blade failure.

⚠ CAUTION VIBRATION INJURY HAZARD!

- This tool will vibrate during use! Repeated exposure to vibration may cause physical injury. Wear thick, well-fitting work gloves when operating. Discontinue use immediately and seek medical attention if numbness or tingling is present.

SET-UP & CONNECTION

- Be sure that the air supply to the tool is clean and dry. Moisture in the supply line will quickly damage the motor and valves.
- A minimum 3/8" I.D. air line should be used for optimal performance.
- Thread the included 1/4" Male Quick-Disconnect Fitting into the air inlet of the tool using a quality thread sealing tape (not included).

OPERATION

⚠ WARNING EYE INJURY HAZARD!

Rapidly reciprocating Blades will eject sharp metal chips out of the front at high velocity. Always wear ANSI approved eye protection when operating this tool.

⚠ NOTICE

DO NOT attempt to exceed 18 Gauge (0.050") [1.2mm] mild steel, aluminum and copper or 20 Gauge Maximum (0.036") [0.91mm] for stainless steel.

- Place the cutting blades against work piece and depress trigger to actuate cutting.
- Always maintain a firm grip while operating tool, do not force but allow the reciprocating action of the Cutting Blade to do the work.
- Be sure that the workpiece is clamped down or held securely to minimize the danger of injury while operating tool.

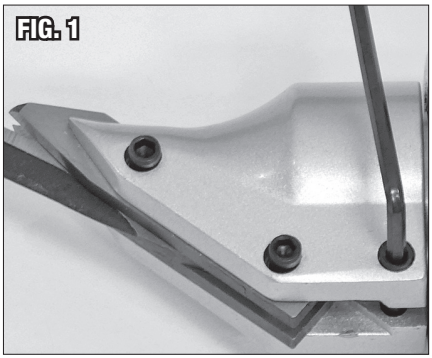
POSITIONING CUTTING HEAD

⚠ WARNING INJURY HAZARD!

This Metal Shears can quickly start up when handling while connected to an air supply causing serious personal injury. Always disconnect the tool from the air supply before changing Cutting Blades or performing maintenance.

The Cutting Head may be rotated 360° in relation to the Handle of the Shear Body to accommodate cutting in difficult to reach areas. To do so:

- Using the included 4 mm Hex Key, loosen (but do not remove) the three socket head cap screws on the Cutting Head adequately to release clamping pressure **(FIG 1).**
- Rotate the Cutting Head about the axis of the Shear Body to the desired position then re-tighten the three screws.



MAINTENANCE

- Add several drops of air tool oil before each use by dropping directly into the air inlet.
- Add a few drops of light machine oil to the Blades.
- If tool is to be unused for an extended period, add 10 drops of air tool oil directly to the air inlet and store the tool, air inlet up.
- Frequently, with the air supply disconnected, inspect Cutting Blade condition and tightness.

BLADE REPLACEMENT

⚠ WARNING INJURY HAZARD!

This Metal Shears can quickly start up when handling while connected to an air supply causing serious personal injury. Always disconnect the tool from the air supply before changing Cutting Blades or performing maintenance.

⚠ NOTICE

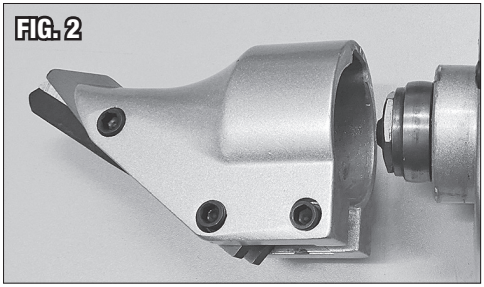
Blade replacement requires a high level of dexterity and patience to achieve installation and alignment. Refer to photos for positioning.

BLADE REMOVAL

1. Using the included 4mm Hex Key, loosen but do not remove the three Socket Head Screws in the Cutting Head **(FIG 1)**.
2. Pull the Cutting Head from the Shears **(FIG 2)**.
3. Using the included 4mm Hex Key, loosen and remove the two forward socket head cap screws.
4. Remove Blades & Bushing/Spacers.

⚠ NOTICE

Carefully note the position of the Blades and Bushing/ Spacers for proper position during reassembly! (Fig 3).



BLADE INSTALLATION

1. Set the Cutting Head on a firm surface with the slot facing upward.
2. Set the two Fixed Blades into the machined lands of the Cutting Head **(FIG 4)**.
3. Place one of the two Bushing/Spacers between the rearmost holes of the blades and insert one of the Socket Head Screws through the Cutting Head, Left Blade, Spacer/Bushing and Right Blade **(FIG 4)**.
4. Partially thread the Socket Head Screw into the opposite side of the Cutting Head. DO NOT TIGHTEN.
5. Set a Bushing/Spacer into the center pivot hole of the Center Moving Blade making sure it is flush on both sides **(FIG 5)**.
6. Pass the Center Moving Blade through the round opening of the Cutting Head and set in place with the "notch" under the Bushing/Spacer **(FIG 6)**.
7. Pass the Socket Head Screw through the Cutting Head, Left Blade, Center Moving Blade and Right Blade **(FIG 6)**.
8. Partially thread the Socket Head Screw into the opposite side of the Cutting Head. DO NOT TIGHTEN.

FIG. 4

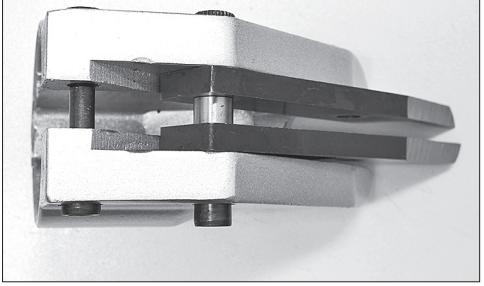
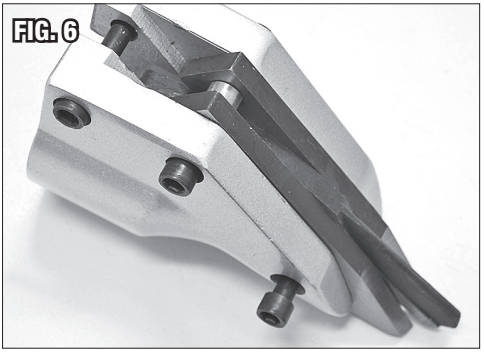


FIG. 5

FIG. 6



9. Check for proper alignment and Center Blade movement. Add some light machine oil to all contact and pivoting points of the Center Blade and also to the Eccentric Bearing at the front of the Shear.
10. Re-install the Head Assembly to the Main Shears Body.
    NOTE: The Body may need to be rotated from side to side to allow the eccentric bearing to align within the arms of the Center Blade.
11. Tighten all three Socket Head Screws securely.
12. The Metal Shear is, once again, ready for use.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Tool Does Not Respond to Trigger Depression	Insufficient volume of air (CFM) to operate tool	Verify sufficient air supply to tool. (4 CFM @ 90 PSI [113 L/min @ 6.2bar] minimum requirement).
	Moisture or other contamination in air supply	Check for moisture in air line and tool air inlet.
Tool Performance is Slow or Sluggish	Insufficient volume of air (CFM) to operate tool	Verify sufficient air supply to tool. (4 CFM @ 90 PSI [113 L/min @ 6.2bar] minimum requirement).
	Moisture or other contamination in air supply	Check for moisture in air line and tool air inlet.
	Air Motor is lacking lubrication	Stop use immediately and add air tool oil directly to air inlet.
Tool Vibrates Excessively During Use	Out of balance condition from damaged Cutting Blade	Stop use immediately, check for and replace cracked or broken Cutting Blade.
	Loose Clamping Screws	Tighten loose Clamping Screws.

TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Shear Fails to Cut Through Metal Fully	Metal too thick.	DO NOT attempt to exceed 18 gauge (0.050") [1.2mm] mild steel, aluminum and copper or 20 gauge maximum (0.036") [0.91mm] for stainless steel.
	Cutting Blades worn	Replace Cutting Blade set with Eastwood #13743A.
Air Flows Through Shear But Cutting Blade Does Not Move	A metal chip likely has become lodged in the Cutting Blade Assembly	Disconnect Shear from air supply and use a small screwdriver or punch to move the Cutting Blade. After moving the Blade, reconnect to air supply and depress paddle. Shear should function normally.
		If moving the Blade does not clear the chip, follow Blade Removal only to Step 3 then reassemble.

ADDITIONAL ITEMS

#13743A Eastwood Pneumatic Metal Shear Replacement Blade Set
#28038 Eastwood Sheet Metal Thickness Gauge
#21299 Tilman Cut Resistant Gloves
#21297 Tilman True fit Work Gloves
#20257 Eastwood Sheet Metal Layout Kit
#14752Z CRC Blue Layout Fluid

If you have any questions about the use of this product, please contact
The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com
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