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Item #20643

ROTARY METAL SHEAR

INSTRUCTIONS



The **EASTWOOD ROTARY METAL SHEAR** is the perfect addition to any fabricators work bench. It is precision designed and manufactured to allow for quick and easy trimming of sheet metal pieces and the rotary design allows for both straight and curved cuts. Hardened, round, cutting dies produce clean, burr-free cuts in aluminum, steel and other mild metals.

CONTENTS

- (1) Assembled Rotary Shear
- (1) 9" Ratcheting Handle

SPECIFICATIONS

Maximum Material Cutting Thickness: 14 Gauge Aluminum, 16 Gauge Mild Steel

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 used with the safety alert symbol, 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 this manual before using.
- Save for future reference.



WARNING INJURY HAZARD!

- This tool has EXTREMELY SHARP cutting dies which can quickly cause severe injury or loss of fingers! Keep fingers and hands away from moving parts when operating.
- Wear thick, well fitting work gloves to prevent cuts from handling sharp metal.
- Frequently inspect cutting dies. If cracks or chips develop, discontinue tool use immediately.
- Always remove the handle from the tool when not cutting. The weight of the handle left in the up position can cause the upper die to suddenly and unexpectedly rotate with great force resulting in severe injury or loss of fingers.



SET UP

⚠ CAUTION

Always keep the handle removed from the tool when not cutting. The weight of the handle can cause the upper die to suddenly and unexpectedly rotate.

Place the Shear on a clean, level surface at a comfortable working height. Mount securely to the work surface using 2 suitable lag screws or bolts (not included) through the two holes in the steel base (FIG 1).

CUT LAYOUT

For best accuracy it is recommended that you coat the cut area with layout fluid or a marker and then scribe your cut line rather than using a marker (FIG 2). The width of the scribe line will be much smaller and will provide a precise guide when compared to the wide marker line.

OPERATION

⚠ CAUTION

The cutting dies are extremely sharp! Use extreme care when operating to avoid severe cuts or loss of fingers!

1. Install ratcheting handle so that the upper die rotates when you pull the handle towards yourself.
2. Apply moderate pressure to push the metal into the cutting dies as you pull the handle towards you (FIG 3).
3. To ratchet the handle simply rotate the handle away from you. The handle has an internal ratcheting mechanism that will re-engage automatically.
4. To make a curved cut, rotate the metal while it is fed into the dies.
NOTE: The Rotary Metal Shear creates its trim, the unwanted cut piece, on the right. When cutting a curve make sure the unwanted portion is to the right of the upper die (FIG 4).

STORAGE

⚠ CAUTION

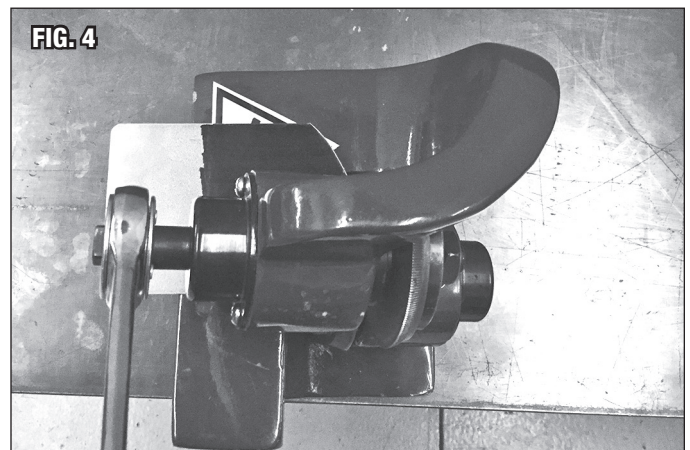
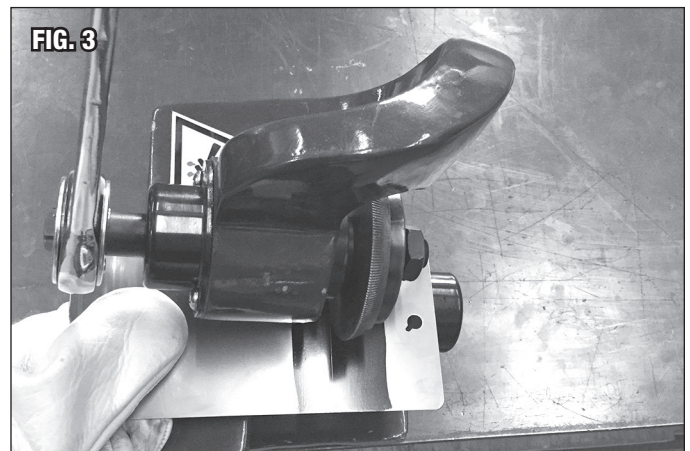
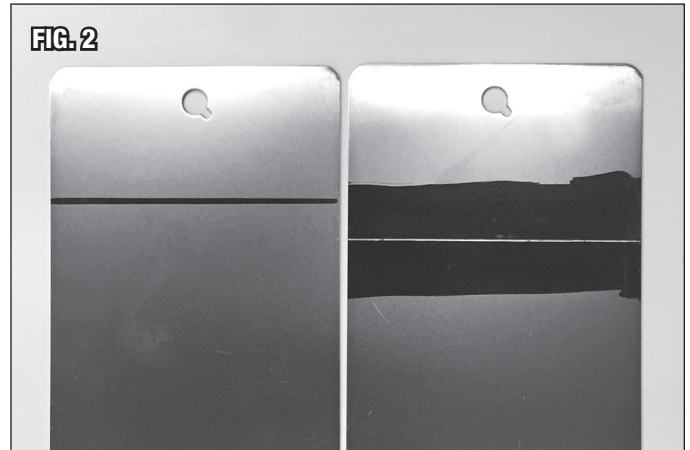
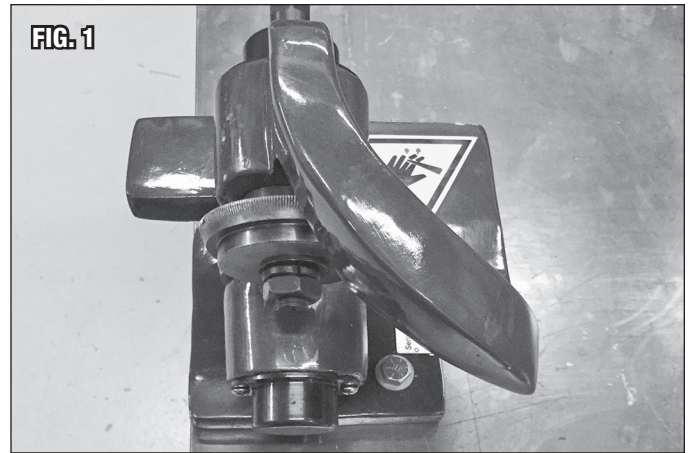
The cutting dies are extremely sharp! Use extreme care when operating to avoid severe cuts or loss of fingers!

- Remove handle to ensure that it cannot engage the upper cutting die in storage.
- Apply a thin film of light oil or rust-preventive coating to all bare steel areas.
- Store in a clean, dust-free, dry, dampness free area preferably covered with plastic sheeting.

MAINTENANCE

NOTE: Maintenance should be performed before each use.

- Check tightness of all hardware.
- Check operation for binding. Lubricate Pivot Points and Dies periodically with a medium bodied lubricating oil.



TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Rotary Metal Shear Does Not Cut	Incorrect Handle Orientation	Ensure that the Upper Die is turning as you pull the handle towards you. If it is not, remove handle and re-install in the opposite orientation.
	Tool Body Has Flexed and Cutting Dies are on Top of One Another	Remove the Hex Nut fastening the Upper Cutting Die, remove Die and re-install in the correct configuration. Cutting edges should be beside one another.
	Upper Die is Spinning Freely	Moderate pressure is required to feed the metal into the Dies.

ADDITIONAL AVAILABLE ITEMS

- #12012 Mig 175
- #14042 Versa Bend Sheet Metal Brake
- #13603 Auto body Sheet Metal Kit 20 Gauge Aluminized Steel
- #11797 Throatless Shear
- #20198 8" Bench Shear

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/20643manual

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