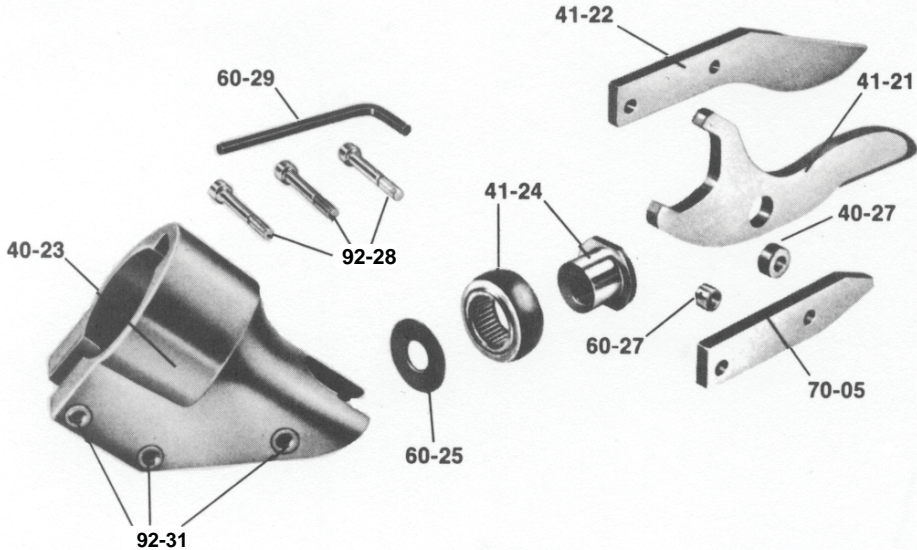




# INSTRUCTIONS FOR THE CARE OF THE KETT 41-20 SHEAR HEAD

**CAUTION**  
**Disconnect Power Unit**  
**Before Servicing Tool**



**PARTS LIST**

41-21	Center Blade
40-23	Shear Housing
41-24	Eccentric Bearing Assembly
40-27	Spacer Bushing
92-28	Cap Screw (3)
92-31	Knurled Insert (3)
41-22	Side Knife
70-05	Side Spacer
60-25	Thin Washer, Large
60-27	Spacer Bushing
60-29	(150-4) Allen Wrench

40-61 **Not Shown**  
 Adapter (1 3/8"-20 LH thread) fits  
 253-58 power unit on KD-441 power  
 shear.

**DISASSEMBLY:** To remove the shear head from the motor loosen three cap screws (92-28). 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 (92-28) from shear housing (40-23). Be careful not to lose rear spacer bushing (60-27) when removing the middle cap screw. Remove center blade (41-21) from shear housing by tapping blade gently rearward. Be careful not to lose spacer bushing (40-27) from hole in center blade. Side knife (41-22) and side spacer (70-05) will now drop out of the shear housing.

To remove eccentric bearing assembly (41-24) from shaft use an appropriate wrench to loosen eccentric nut by turning counter clockwise.

**ASSEMBLY:** To install eccentric bearing assembly (41-24) onto shaft, make sure the large thin washer (60-25) is first inserted over the shaft. Screw eccentric bearing assembly on to shaft and tighten with appropriate wrench. Lubricate bearing with a good grade of bearing grease.

To install cutter blades into shear housing (40-23) place the side knife (41-22) and side side spacer

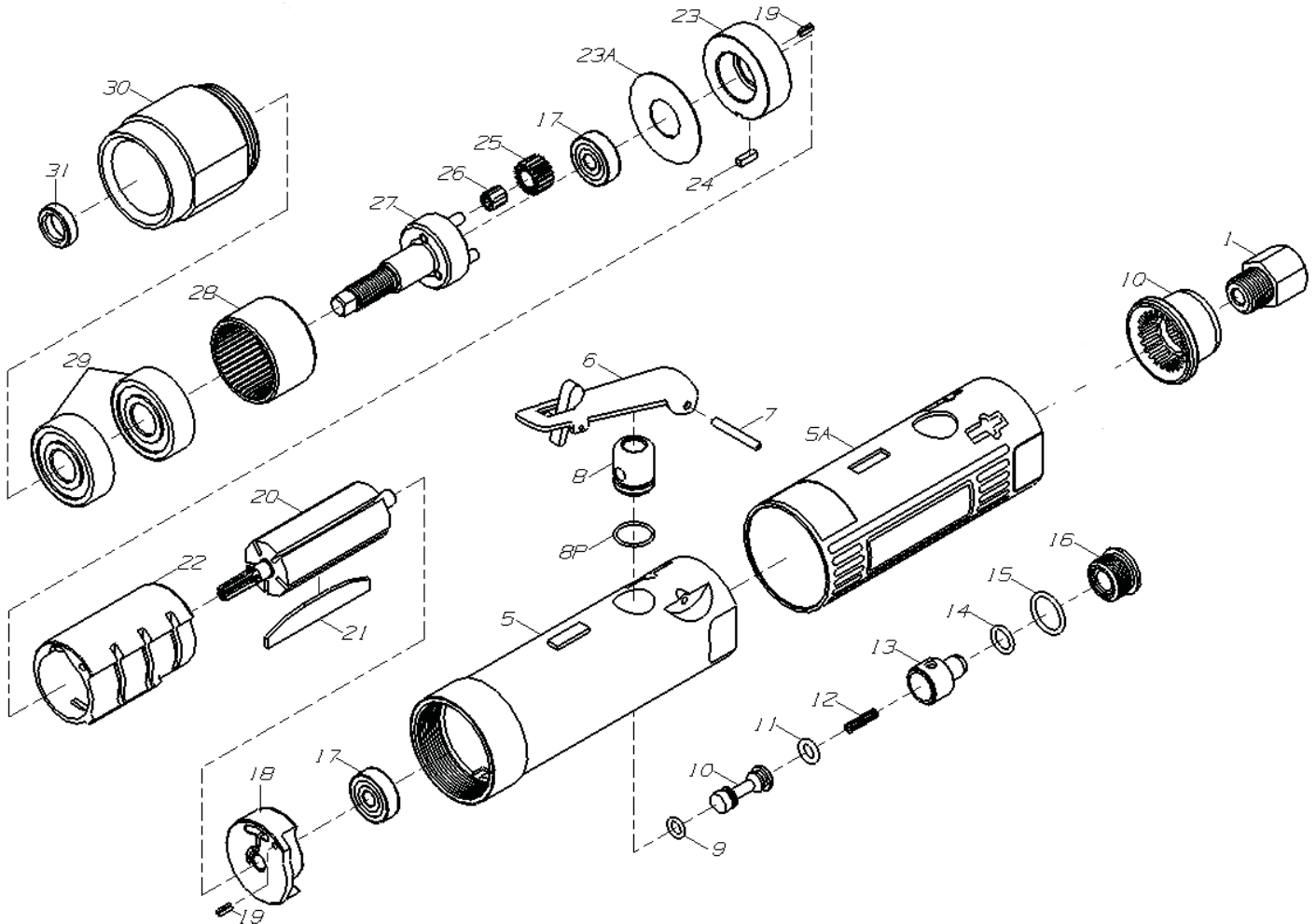
(70-05) into position in the shear housing (40-23). Insert center cap screw (92-28) through the 41-21 and 70-05 with rear spacer bushing (60-27) between them and start cap screw into thread just enough to hold blades in place. **DO NOT TIGHTEN.** Insert spacer bushing (40-27) into hole in center blade (41-21) and lubricate with Molybdenum Disulfide grease (264-2) 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 (92-28) making sure spacer bushing (40-27) 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 (92-28) into shear housing, but do not completely tighten.

To install shear head assembly onto drive motor make sure all cap screws (92-28) are loosened about three or four complete turns. Spread shear housing (40-23) slightly using a spreader (drift) near the rear cap screw (92-28). Place shear head onto unit, tap side knife rearward as far as it will go, and tighten cap screws to 40-45 inch pounds. 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.**



## 253-58 PNEUMATIC POWER UNIT PARTS LIST



ITEM NO.	PART NO.	DESCRIPTION	REQ'D TOOL	ITEM NO.	PART NO.	DESCRIPTION	REQ'D TOOL
1	103132	Inlet Bushing	1	17	0626-ZZ0A	Ball Bearing	2
1Q	103129	Exhaust Deflector	1	18	103116	Rear End Plate	1
5	303305	Motor Housing	1	19	P-0025-060	Pin	2
5A	103118-S	Housing Sleeve	1	20	303319	Rotor	1
6	103127	Lever	1	21	303115	Rotor Blades	5
7	P-0030-220	Lever Pin	1	22	303112	Cylinder	1
8	103126	Valve Bushing	1	23	303323	Front End Plate	1
8P	O-1100-120	O-Ring	1	23A	103322A	Washer	1
9	O-0500-150	O-Ring	1	24	303324	Key	1
10	103125	Throttle Valve	1	25	103323	Idler Gear	3
11	O-0500-200	O-Ring	1	26	K477TN	Needle Bearing	3
12	103123	Spring	1	27	303327	Idler Gear Plate	1
13	103122	Air Regulator	1	28	303328	Ring Gear	1
14	O-0700-180	O-Ring	1	29	6201-Z00A	Ball Bearing	2
15	O-1100-250	O-Ring	1	30	303330	Gear Cap	1
16	103119	Valve Screw	1	31	303331	Washer	1