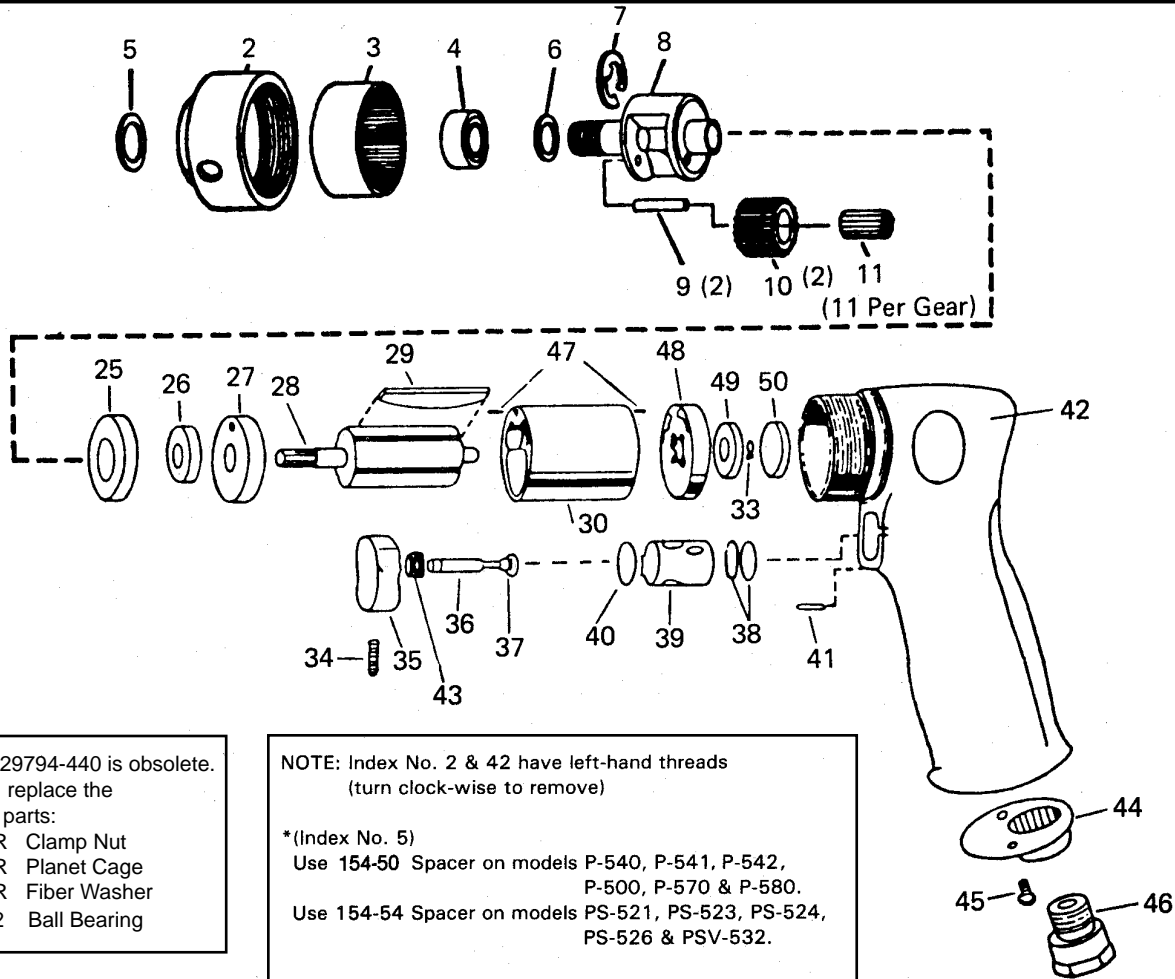




# PARTS LIST FOR PNEUMATIC POWER UNITS

253-38 (SERIAL NUMBER 2001 TO 9600)

253-57 (SERIAL NUMBER 9601 & HIGHER)



**\*\*Part #729794-440 is obsolete.**  
To repair, replace the following parts:  
729799-R Clamp Nut  
729794-R Planet Cage  
729797-R Fiber Washer  
49423-02 Ball Bearing

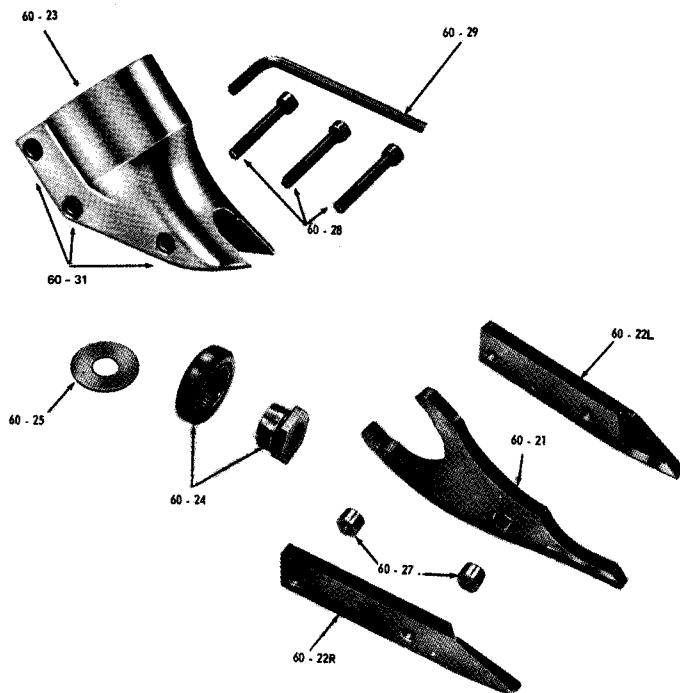
**NOTE: Index No. 2 & 42 have left-hand threads (turn clock-wise to remove)**

**\*(Index No. 5)**  
Use 154-50 Spacer on models P-540, P-541, P-542, P-500, P-570 & P-580.  
Use 154-54 Spacer on models PS-521, PS-523, PS-524, PS-526 & PSV-532.

INDEX NO.	PART NO.	DESCRIPTION	REQ'D TOOL	INDEX NO.	PART NO.	DESCRIPTION	REQ'D TOOL
2	729799-R	Clamp Nut (253-57)	1	29	729709	Rotor Blade	4
	729799-440	Clamp Nut (253-38)	1	30	729708	Cylinder	1
3	729798	Internal Gear	1	33	1012831	Retaining Ring	1
4	49423-02	Ball Bearing (253-57)	1	34	731928	Set Screw	1
	1008854	Ball Bearing (253-38)	1	35	731929	Trigger	1
5	154-*	Spacer	1	36	731926	Valve Stem	1
6	729797-R	Fiber Washer (253-57)	1	37	729591	O-ring	1
	729797	Fiber Washer (253-38)	1	38	729091	O-ring	2
7	729208	Ret. Ring (used only on 253-38)	1	39	731927	Valve Bushing	1
8	729794-R	Planet Cage (253-57)	1	40	729263	O-ring	1
	729794-440	Planet cage (253-38) obsolete**	1	41	731930	Pin	1
9	729796-440	Planet Pin	2	42	731923-440	Motor Housing	1
10	729795	Planet Gear (incl. 729808 Needle Rollers)	2	43	731925	Valve Spring	1
11	729808	Needle Rollers (see 729795 Planet Gear)	22	44	731922	Housing End Cap	1
25	1008212	Ball Bearing	1	45	731921	Screw	2
26	1001532	Ball Bearing	1	46	731920	Air Inlet	1
27	729793	Front Plate	1	47	729707	Dowel Pin	2
28	729792	Rotor	1	48	729791	Rear Plate	1
				49	729012	Ball Bearing	1
				50	729178	Bearing Seal	1



## INSTRUCTIONS FOR THE CARE OF THE KETT NO. 60-20 SHEAR HEAD



### ADJUSTMENT

To adjust the curl of waste material, the left side knife (60-22L) has elongated holes. Adjustment may be necessary after changing blades or material being cut. Loosen cap screws (60-28) and tap side knife (60-22L) either forward or backward so that curl of waste does not hit shear housing (60-23) or work material while cutting.

### DISASSEMBLY

To remove no. 60-20 shear head from power unit and dismantle:

1. Loosen both rear cap screws (60-28) three complete turns.
2. Remove shear head assembly (60-20) from motor by pulling head firmly forward. Slight twisting action may be required.
3. Remove three cap screws (60-28) completely from shear housing (60-23). Be careful not to lose rear spacer bushing (60-27) when removing rear cap screw.
4. Remove center blade (60-21) from shear housing (60-23) by tapping blade gently rearward. Be careful not to lose spacer bushing (60-27) from hole in center blade.
5. Side Knives (60-22L and 60-22R) will now drop out of shear housing.

### ASSEMBLY

To assemble no. 60-20 shear head and adapt to power unit:

1. Place the left side knife (60-22L) into position in the shear housing (60-23).
2. Insert center cap screw (60-28) through housing and blade just far enough to slip spacer bushing (60-27) over cap screw.
3. Place right side knife (60-22R) into position and push center cap screw through right side knife. Start cap screw into insert just enough to hold blades in place. **DO NOT TIGHTEN.**
4. Insert spacer bushing (60-27) into hole in center blade (60-21) and lubricate with a good grade of bearing grease.
5. Install center blade (60-21) into shear housing (60-23) by tapping blade gently forward using a drift to line up hole in center blade with forward holes in housing.
6. Insert and tighten forward cap screw (60-28) making sure spacer bushing (60-27) in center blade stays in position. Apply good grade of bearing grease to clevis in center blade. **WHEN SHEAR HEAD IS PROPERLY ASSEMBLED THE CENTER BLADE WILL PIVOT FREELY IN HEAD.**
7. Insert rear cap screw (60-28) into shear housing (60-23) but do not completely tighten.

To install shear head assembly (60-20) onto power unit:

1. Make sure rear cap screw and center cap screw (60-28) are loosened three complete turns.
2. Place shear head onto unit and tighten cap screws (60-28) snugly to lock head assembly in place. It may be necessary to gently tap the shear head assembly into place if it does not readily slip onto 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 OR PARTS OTHER THAN THOSE REGULARLY SUPPLIED BY US. USE ONLY KETT REPLACEMENT BLADES EMBOSSED WITH PART NUMBERS 60-21, 60-22L OR 60-22R.**

**NOTE: WHEN SHEAR HEAD IS PROPERLY ASSEMBLED  
THE CENTER BLADE WILL MOVE FREELY IN HEAD.**