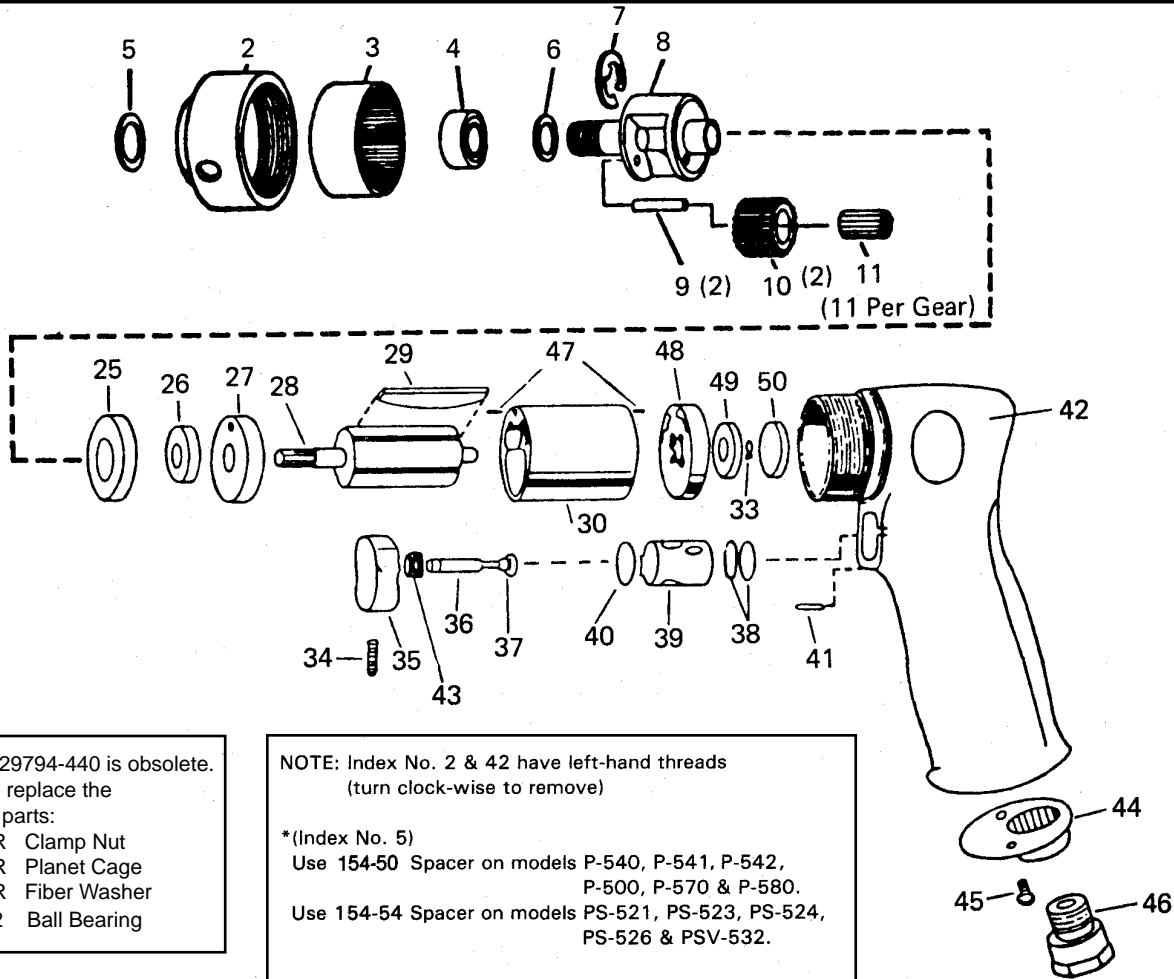




# PARTS LIST FOR PNEUMATIC POWER UNITS

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**\*\*Part #729794-440 is obsolete.**  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)**

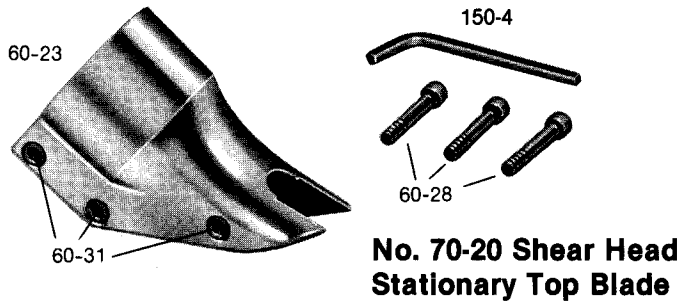
**\*(Index No. 5)**  
Use 154-50 Spacer on models P-540, P-541, P-542, P-500, P-570 & P-580.  
Use 154-54 Spacer on models PS-521, PS-523, PS-524, PS-526 & PSV-532.

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

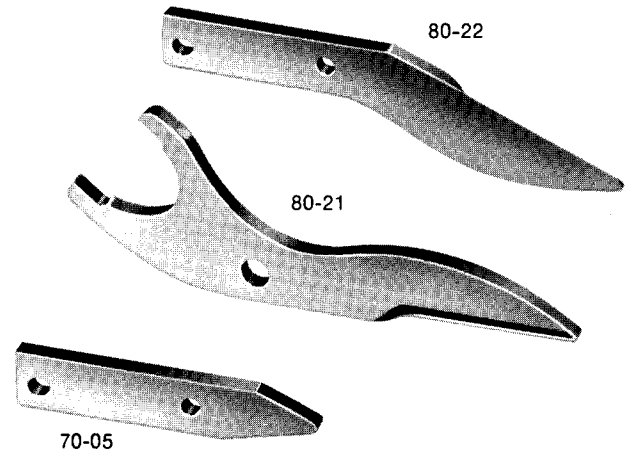
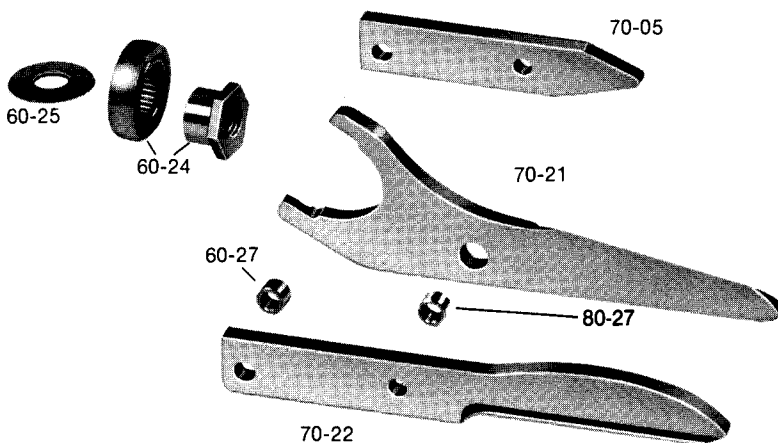


# Instructions for the Care of the Kett Scissor Shears Head

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



**No. 80-20 Shear Head  
Stationary Bottom Blade**



## DISASSEMBLY

To remove shear head from motor loosen three cap screws (60-28). Remove shear head from motor by pulling head firmly forward. Slight twisting action may be required if head does not slide off easily.

To remove cutter blades from shear head remove three cap screws (60-28) completely from shear housing (60-23). Be careful not to lose rear spacer bushing (60-27) when removing middle cap screw. Remove center scissor blade from shear housing by tapping blade gently rearward. Be careful not to lose spacer bushing (80-27) from hole in center blade. Side knife and side spacer (70-05) will now drop out of the shear housing.

To remove eccentric bearing assembly (60-24) from shaft use an appropriate wrench to loosen eccentric nut by turning counter clockwise.

## ASSEMBLY

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

To install cutter blades into shear housing (60-23) place the side knife and side spacer into position in the shear housing (60-23). Insert center cap screw (60-28) through side knife and side spacer 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 (80-27) into hole in center scissor blade and lubricate with a good grade of bearing grease. Install center scissor 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 (60-28) making sure spacer bushing (60-27) in center blade

60-23	Shearing Housing
60-24	Eccentric Bearing Assembly
60-25	Thin Washer, Large
60-27	Spacer Bushing
60-28	Cap Screw (3)
150-4	Allen Wrench
60-31	Knurled Insert (3)
70-05	Side Spacer
70-21	Center Scissor Blade
70-22	Side Knife
80-21	Center Scissor Blade
80-22	Side Knife
80-27	Spacer Bushing

stays in position. Apply good grade of bearing grease to clevis or yoke in center blade where it rides on the eccentric bearing assembly. Insert rear cap screw (60-28) into shear housing but do not completely tighten.

To install shear head assembly onto drive motor make sure all cap screws (60-28) are loosened about three or four complete turns. Place shear head onto unit and tighten cap screws snugly to lock head assembly in place. 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.

## SPECIAL SIDE KNIVES

For cutting woven wood or other rigid slat type materials side knives are available that do not have the wiping action of the standard Scissor Shears. These are: 75-22 Side Knife transforming the 70-20 Shear Head into the 75-20 Shear Head and the 85-22 Side Knife transforming the 80-20 Shear Head into the 85-20 Shear Head.