



## **INSTRUCTION – REPLACING SHEAR BLADES**

1. Fasten lower blade to base and ensure blade is flush
2. Finger-tighten blade support bolts - confirm blade is completely flush with table
3. Tighten jam nuts
4. Raise lever to the open position
5. Add upper blade
6. Add far left and far right bolts
7. Insert heavy copper (or other soft, non-shearable material) to far left
8. Slowly bring down blade until there is pressure on the copper material (note: make sure the blades do not cut into one another)
9. Tighten far left bolt
10. Finger-tighten right-hand bolt until snug
11. Slowly bring blade down until there is pressure on the copper material
12. Tighten far right bolt
13. Thread all upper blade fasteners to tightly secure the upper blade
14. Slowly bring down upper blade to meet with lower blade and make sure that they do not cut into one another
15. Test shearing precision by shearing a piece of paper
16. If results are less than ideal, begin trouble-shooting – shim as necessary – never sharpen wide edge of blade