

# TIN KNOCKER

## TK 1652 FOOT SHEAR

### INSTRUCTIONS & PARTS DIAGRAMS



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**TIN KNOCKER  
SAFETY RULES  
TK 1652 FOOT SHEAR**

1. Keep the work area well lighted, clean, neat, and orderly to avoid accidents. Do not use compressed air for cleaning debris or grit from yourself or the machine. Remove debris and grit from machine with a rake or brush – not your hands.
2. Machine to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operator's Manual as well as the warnings and instructions mounted on the machine.
3. Notify your supervisor whenever you feel there is a hazard involving the equipment or the performance of your job.
4. Report all injuries or illness, regardless of severity, to your supervisor.
5. Do not place speed above safety.
6. Never use this machine for anything other than its intended purpose. Use the proper tool and equipment for the task.
7. Do not remove, paint over, alter, or deface any machine-mounted warning and instruction plates and signs.
8. Do not override the safety features of the equipment. Do not remove guarding.
9. Do not operate the machine in excess of its rated capacity. (52" x 16ga.)
10. Beware of protruding machine elements or assemblies. Avoid any pinch-points created by the movement of the machine's components.

## **WARRANTY**

All new SME machines are sold with a one-year limited warranty, on factory defective parts. The warranty is limited to the original user. SME at its option, will repair, replace or refund the purchase price of any part, tool or machine that fails during the warranty period. SME will pay normal shipping charges for replacement parts. After 90 days from date of purchase, all express or overnight delivery charges are the responsibility of the customer. Purchaser must contact SME, at the address below, any written claim, with proof of original purchase. Replacement parts will be invoiced to purchaser and credit issued when the failed part is delivered to SME. Removal, reinstallation or replacement parts shall be at purchasers' / user's expense. Failure due to improper use of the machine voids the warranty.

**NOTE:** This machine has been tested and adjusted prior to shipment, but can and often does require readjustment due to vibration and bouncing during transport. Readjustment can easily be done by following the procedures described within. These are procedures with which you, as a user, should be familiar, as you will use them repeatedly over the life use of the machine. If you have difficulty in performing these procedures, we are here to support you.

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## OPERATING INSTRUCTIONS FOR 1652 SHEAR

### BEFORE OPERATING

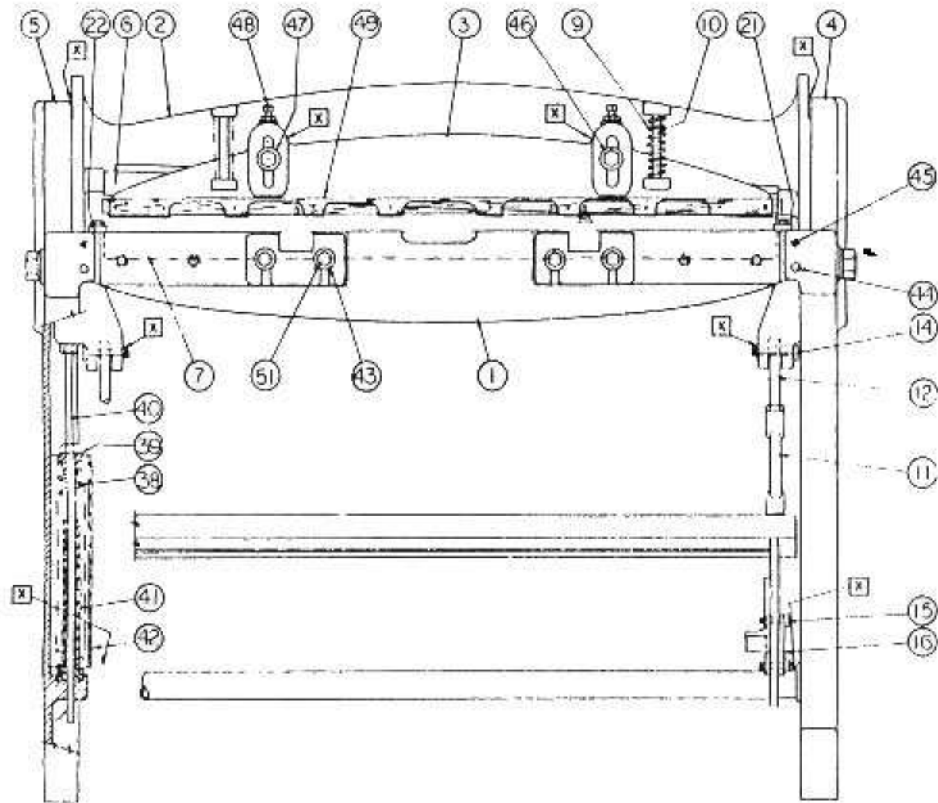
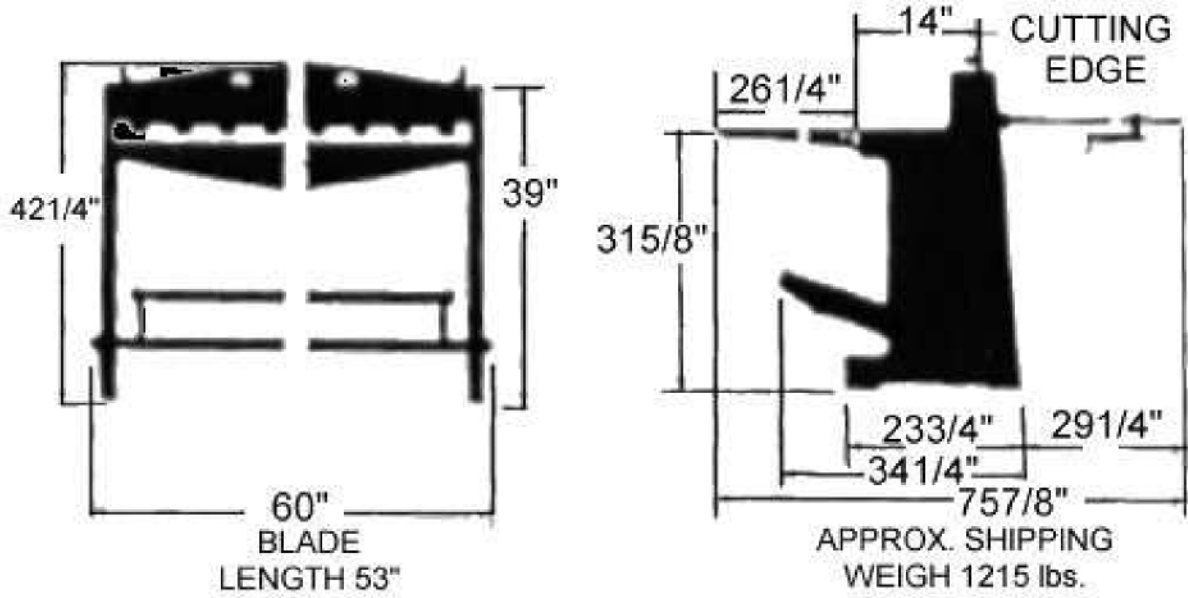
1. This shear has been tested to capacity at the factory and at our warehouse. Do not exceed rated capacity on nameplate. Test cut to capacity to see if the shear is still in adjustment.
2. If out of adjustment, remove from skids and place on level foundation. Back off all leg-to-bed bolts and loosen adjusting screws. Bed must rest squarely on right and left hand leg ledges at all form corners when bolts are loose. If necessary, shim legs at the floor, to level bed on ledges. LAG SHEAR SECURELY TO THE FLOOR.
3. To adjust blade for cutting, (after setting up or changing blades), first make sure leg-to-bed bolts are snug tight. CAUTION: Move bed toward crosshead blade by means of adjusting screws, screw moves bed "out", increasing clearance between upper and lower blade – moved bed "in", decreasing clearance. Position lower blade within a few thousandths of the upper blade, being careful the lower blade does not overlap the upper. Place a sheet of heavy paper (approx. .005") the full length of cut, between the blades and slowly depress the treadle. If shear does not cut paper, move bed blade in toward upper blade as necessary, by carefully readjusting screws at either or both sides. If shear cuts paper on ends but not I center, it will be necessary to turn crosshead tie rod adjusting nut clockwise until paper cuts full length of blade. If shear cuts I center but not on ends, reverse direction of turn on crosshead tie rod adjusting nut. NOTE: This adjustment is carefully made at the factory and should not be necessary on a new shear.
4. When blades are properly adjusted, tighten leg-to-bed bolts securely before cutting stock.
5. Always keep blades sharp. Wiping blades occasionally with oil will increase blade life.
6. Lubrication should be maintained between crosshead and leg bearing surfaces. Lubricate all points (X) daily.
7. Front, back and side gauges are provided for use as required. Side and back gauges are graduated in sixteenths and adjustment is provided to keep graduations aligned with blade cutting edges.
8. Crosshead adjustment – use gib screws to adjust gib setting. This setting should hold crosshead snugly against ways in legs, yet not bind the crosshead movement. This adjustment should not be necessary in new shear.
9. It is suggested that an extra pair of blades be available for use when blades are removed for sharpening. Blades should be returned to factory for regrinding.
10. Two leverage holes are provided in each treadle lever arm for the lower connecting link pins. The treadle as shipped will give ample leverage for cutting soft steel within the rated capacity of the machine, but greater leverage can be obtained for cutting maximum capacity stock by moving the lower connecting link pins to the holes nearest the hinge pins.
11. To adjust shear after blades have been changed, back off the leg-to bed bolts and following instructions #3 above. CAUTION: Use heavy gloves when handling shear blades.
12. When ordering replacement parts from the factory, be sure to give machine number, serial letter and part name.
13. Hold down adjustment – set hold down to engage sheet before blades.

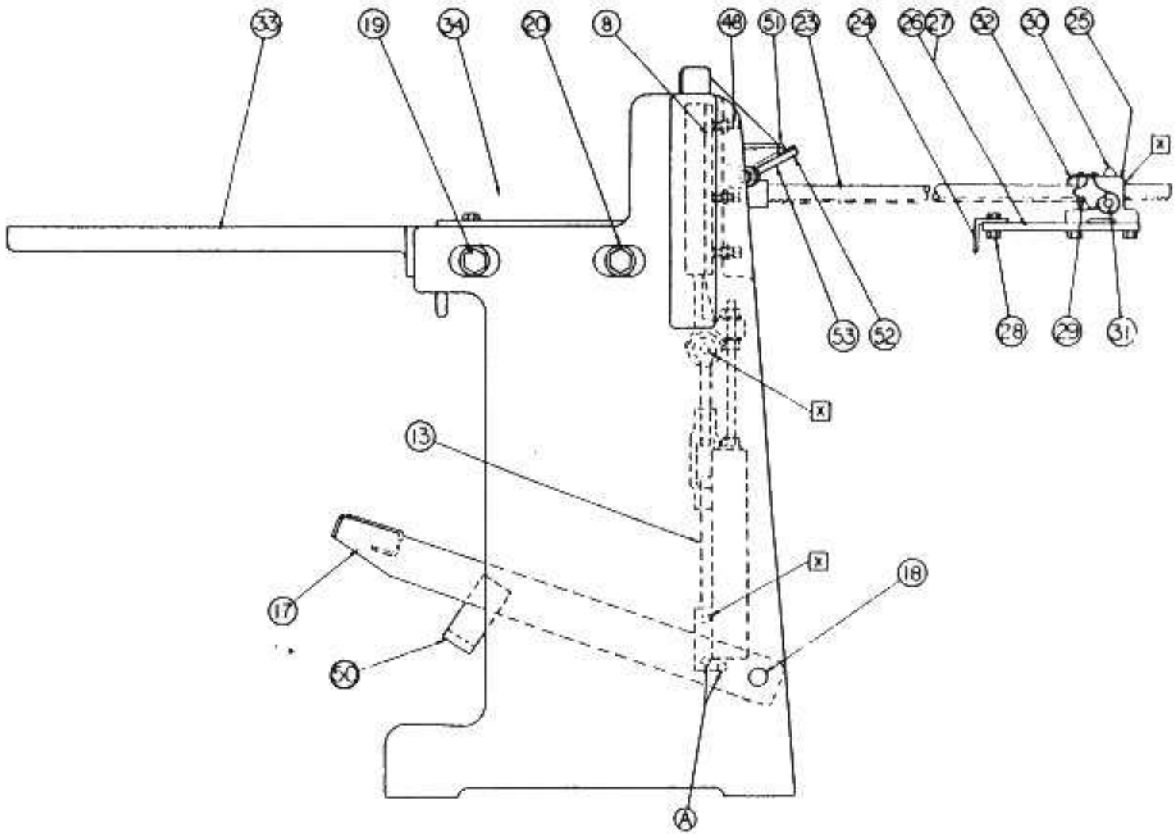
### **SPECIFICATIONS**

Dimensions: 60"L x 34"W x 42" H  
 Floor space: 60" x 72"  
 Weight: 1070 lbs.  
 Rule Ship weight aux: 1215 lbs.

Shearing Length: 52"  
 Capacity: 16 Ga. Mild Steel  
 Back Gauge: 25" with Engraved

### TK1652 SHEAR





<b>FIND NUMBER</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>	<b>PIECES PER UNIT</b>
1	TKSHEAR001	BED	1
2	TKSHEAR002	CROSSHEAD	1
3	TKSHEAR003	HOLD DOWN	1
4	TKSHEAR004	R.H. LEG	1
5	TKSHEAR005	L.H. LEG	1
6	TKSHEAR006	UPPER BLADE	1
7	TKSHEAR007	LOWER BLADE	1
8	TKSHEAR008	GIB	2
9	TKSHEAR009	HOLD DOWN SPRING	2
10	TKSHEAR010	HOLD DOWN STUD	2
11	TKSHEAR011	TURNBUCKLES	2
12	TKSHEAR012	UPPER TREADLE ROD	2
13	TKSHEAR013	LOWER TREADLE ROD	2
14	TKSHEAR014	CROSSHEAD PIN	2
15	TKSHEAR015	CONNECTING LINK PIN	4
16	TKSHEAR016	CONNECTING LINK	4
17	TKSHEAR017	TREADLE ASSEMBLY	1
18	TKSHEAR018	TREADLE HINGE PIN	2
19	TKSHEAR019	BED TO LEG BOLTS	4
20	TKSHEAR020	WASHERS	4
21	TKSHEAR021	R.H. SIDE GAUGE	1
22	TKSHEAR022	L.H. SIDE GAUGE	1
23	TKSHEAR023	BACK GA. ARM	2
24	TKSHEAR024	BACK GAUGE BAR	1
25	TKSHEAR025	BACK GAUGE HOLDER	2
26	TKSHEAR026	R.H. LINK	1
27	TKSHEAR027	L.H. LINK	1
28	TKSHEAR028	PIVOT STUD	3
29	TKSHEAR029	HAND KNOB	2
30	TKSHEAR030	HAND WHEEL	2
31	TKSHEAR031	PINION	2
32	TKSHEAR032	POINTER	2
33	TKSHEAR033	FRONT ARM	2
34	TKSHEAR034	BEVEL GAUGE	1
38	TKSHEAR038	TREADLE SPRING	2
39	TKSHEAR039	SPRING COLLAR	4
40	TKSHEAR040	SPRING ROD	2
41	TKSHEAR041	SPRING GUIDE	2
42	TKSHEAR042	SPRING COVER	2
43	TKSHEAR043	WASHER	16
44	TKSHEAR044	"BED OUT" ADJ. SCREW	2
45	TKSHEAR045	"BED IN" ADJ. SCREW	2
46	TKSHEAR046	R.H. HOLD DOWN TO CROSSHEAD BOLT	1
47	TKSHEAR047	L.H. HOLD DOWN TO CROSSHEAD BOLT	1
48	TKSHEAR048	GIB & HOEDOWN Adj. SCREW	1
49	TKSHEAR049	FINGER GUARD	1
50	TKSHEAR050	TREADLE STOP	1
51	TKSHEAR051	FRONT ARM BOLTS	1
52	TKSHEAR052	ADJ. SCREW	1
53	TKSHEAR053	TIE ROD	1