



Established 1930

Distributors of new & used workshop Equipment

S602

SG-41

1320 x 1.2mm guillotine

INSTRUCTION & PARTS MANUAL

22-8-11

## **1. PRIOR TO INSTALLATION AND OPERATION**

Read the following instructions carefully and thoroughly will ensure your machine in perfect functions and avoid possible dangers.

## **2. RECEIVING AND UNPACKING**

On receiving your machine, examine if the outer packing is in good condition. Then, remove the cover to inspect whether there is any damage or loss caused during transportation. If any is found, please immediately notify the transportation and your supplier. Some parts and accessories are knocked down and in bulk packing to save transportation space. You must check those parts and accessories in extra care. Then, assemble them on to the machine according to the illustrations.

## **3. INSTALLATION**

Be sure to install your shear on a solid level floor. The work area should be well lighted to prevent any wrong or danger in operation.

Fix the machine on to the floor with anchor bolts to prevent from vibration place an precision level on the table surface to level the machine in all directions. Insert metal shims between floor and the shear mounting surface to adjust the level. Tighten all of the bolts after those being adjusted.

## **4. CAUTIONS**

The knife are sharp. Take extra care in operating. Keep hands away from the reach of blade.

Wear safety glasses or goggles to protect your eyes. Wear protective type foot shear. Keep the work area clear and to avoid slipping or tripping.

Never take away the protective guard. Keep hold down the clearance to the minimum gap required to feed material.

Never use shear to cut rod or material exceeding its designed capacity.

Never attempt to shear any material less than a 1/2" cut across the full length of the table under full capacity.

## 5. OPERATION INSTRUCTIONS

5.1 The chart below is a material conversion comparison to show equivalent capacities of material other than mild steel.

	Model 37"	Model 52"
MILD STEEL GAUGE	1.0mm	1.5mm
ALUMINUM	1.8mm	2.5mm
BRASS YELLOW		
.SOFT	1.2mm	1.8mm
.1/2HARD	1.1mm	1.6mm
.HARD	1.1mm	1.6mm
BRONZE PHOSPHOR		
.ANNEALED	1.1mm	1.6mm
COPPER		
.SOFT	1.2mm	1.8mm
HARD	1.1mm	1.6mm
PLASTIC ABS COMPOUND	1.8mm	2.5mm

## 5.2 BACK GAUGE ADJUSTMENT

On adjusting back gauge, loosen adjustment knobs, slide angle. remove. rod forward or backward for scales to read zero on pointers. Lock bracket again and do further a adjustment with wheel.

Tighten socket screws to lock rods in place.

## 5.3 BLADE CLEARANCE ADJUSTMENT

To adjust blade clearance, loosen front screws and table lock screws, and loosen table bolts on both sides.

Use a 0.002" shim gauge and adjust table lock screws. Then, tighten all serews.(See Figure 1).

## 5.4 CUTTER HEAD ADJUSTMENT

If cutter head is bowed after use, you can adjust the bow bolt. check for looseness of mounting bolt. Re-tighten all bolts.(See Figure 2).

To adjust the blade up or down. Drop pin on treadle and loosen nut. Adjust yoke up or down. Reassemble them.

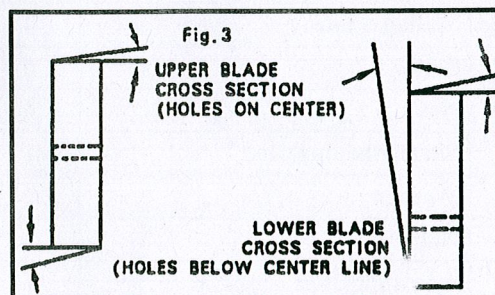
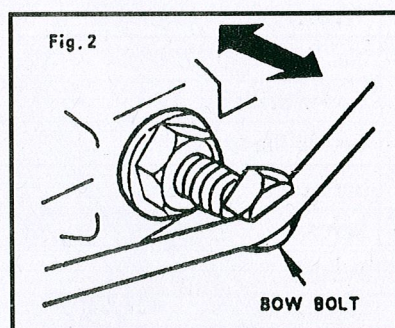
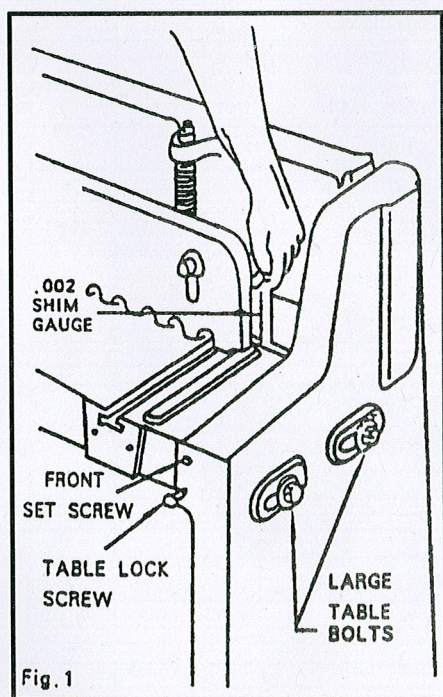
Loose lock screws may cause shake of blade in operation.

Check and sure they are rightly against shims. But be careful not to dimple them.

## 5.5 TO SHARPEN THE BLADE

The upper blade has two cutting edges which are ground with a 2 edges relief. Reverse to expose the new cutting edge as soon one edge is dull. It can be sharpened on a surface grinder by grinding machine both wide sides of the blade.

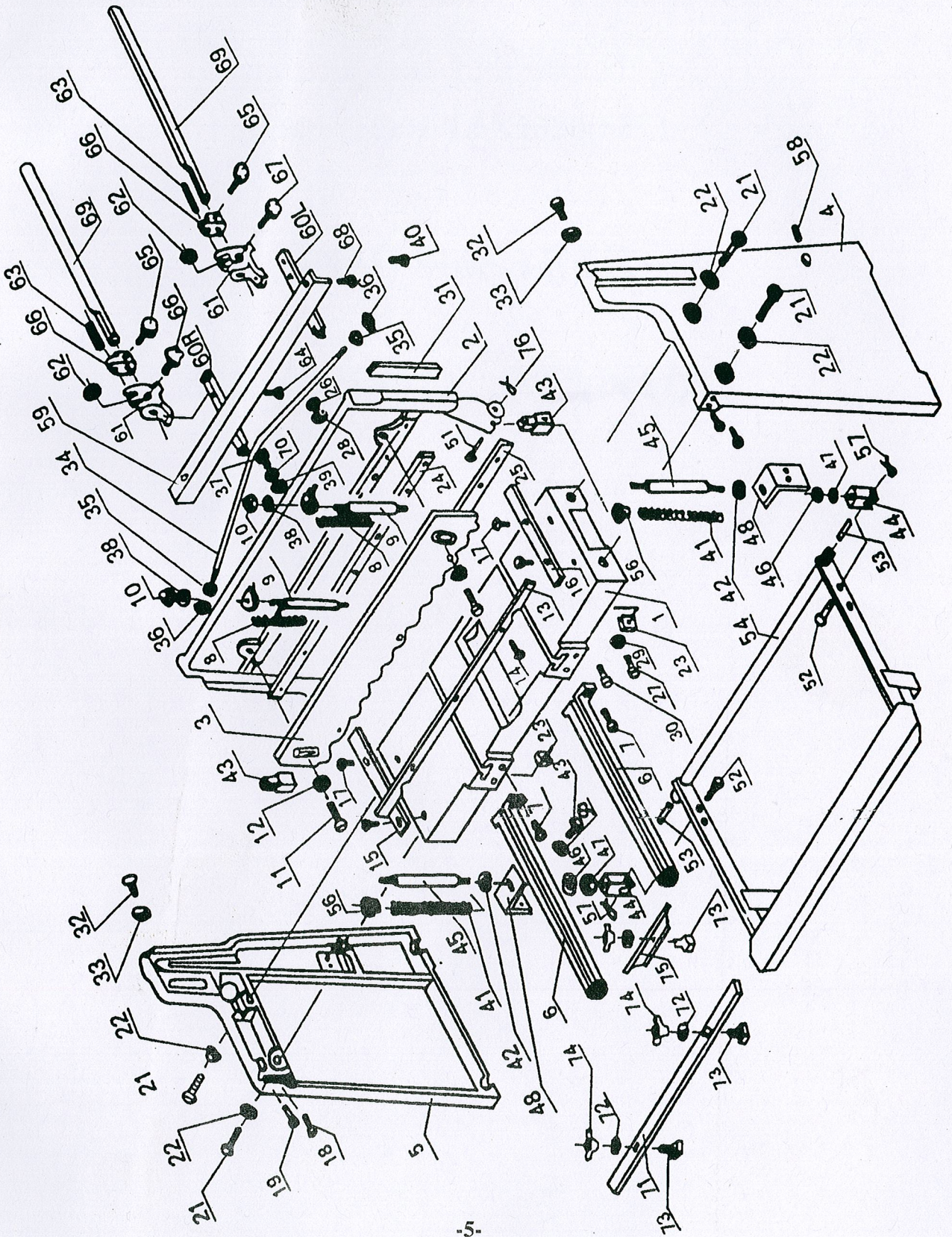
The lower blade has one cutting edge with a 2 edge relief and a 1 face relief. It can be re-sharpened on a surface grinder by grinding the wide side of the blade having the 1 relief.(See Figure 3).



## 6 PART LIST

Item#	Description	Qty	Item#	Description	Qty
1	Work Table	1	39	Washer	1
2	Frame	1	40	Screw	2
3	Pressing plate	1	41	Spring	2
4	Right Stand	1	42	Washer	2
5	Left Stand	1	43	Upper Connecting Block	2
6	Connecting Rod	2	44	Lower Connecting Block	2
7	Screw	4	45	Bolt	2
8	Spring	2	46	Washer	2
7	Bolt	2	47	Nut	2
10	Nut	2	48	Connecting Plate	2
11	Screw	2	49	Bolt	4
12	Washer	2	50	Washer	4
13	Protecting Board	1	51	Upper Pin	2
14	Screw	3	52	Lower Pin	2
15	Workpiece Stop	2	53	Small Shaft	2
16	Gauge	2	54	Foot Stand Frame	1
17	Screw	4	55	Lid	2
18	Bolt	2	56	Pin	2
19	Bolt	2	57	Screw	2
20	Bolt	2	58	Workpiece Stop	1
21	Bolt	2	59	Right Fixing Plate	1
22	Washer	4	60	Left Fixing Plate	1
23	Nut	4	61	Find Adjustment Stand	2
24	Upper Blade	1	62	Adjusting Nut	2
25	Lower Blade	1	63	Blot Shaft	2
26	Screw	8	64	Bolt	2
27	Screw	9	65	Small Screw	2
28	Washer	8	66	Large Screw	1
29	Washer	9	67	Large Screw	1
30	Screw	4	68	Bolt	2
31	Sliding Plate	2	69	Gauge Shaft	2
32	Screw	6	70	Nut	1
33	Nut	6	71	Workpiece Pushing Plate	1
34	Strengthening Rod	1	72	Washer	3
35	Washer	2	73	T-style Bolt	3
36	Nut	2	74	Wing NUT	3
37	Adjusting Bolt	1	75	Small Workpiece Pushing Plate	1
38	Washer	2	76	Pin	2

# 7 ASSEMBLY DRAWING



**SG - 41**

**MODEL Q01-1.0x1000(37")**

**MODEL Q01-1.5X1320(52")**

**FOOT SHEARER**

**OPERATION MANUAL**

# WARNING

## General Machinery Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



# WARNING

## Manual Guillotine Safety Instructions

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Machinery House  
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure all moving parts are locked down before any inspection, adjustment or maintenance is carried out. Place a block of timber between the blades to save blades from shearing hands or fingers.
- 2. Guillotine Condition.** Guillotine must be maintained for a proper working condition. Never operate a Guillotine that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis.
- 3. Blade Condition.** Never operate a Guillotine with a damaged or badly worn blades. Replace if required.
- 4. Hand Hazard.** Keep hands and fingers clear from moving parts. Serious injury can occur if hand or finger tips come between blades.
- 5. Personal Protection.** Gloves are recommended when handling the workpieces.
- 6. Authorized and trained personnel.** The machine must be operated by authorized and trained personnel. The shear is designed to be operated by a single user. Using the machine with more than one operator is forbidden, except for certain maintenance situations.
- 7. Work area hazards.** Keep the area around the Guillotine clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 8. Guards.** Do not operate Guillotine without the correct guards in place. Necessary guards protect you from injuries by the shear blades.
- 9. Material.** Material must NOT be hardened ceramic or glass-originated, non flat metals (at origin) e.g. rods, bars, tubes & pipes.
- 10. Blade gap adjustment.** Do NOT operate the machine without proper blade gap adjustment according to sheet thickness.
- 11. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 12. Backgauge Area.** Do not access the backgauge area, while the machine is working.
- 13. Squaring arm.** Do not use side squaring arm and front support arms for intermediate storage of workpieces.
- 14. Operation.** During the shearing process, the workpiece may slide or move unexpectedly. Therefore, the material must be handled carefully.
- 15. Level machine.** Level the machine on a flat concrete surface by using a spirit level.
- 16. Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.
- 17. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

# PLANT SAFETY PROGRAM

## **NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL**

### **Manual Guillotine**

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures  
This program is based upon the Australian Worksafe Standard for Plant(NOHSC:1010-1994)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies <small>(Recommended for Purchase / Buyer / User)</small>
B	CRUSHING	LOW	Secure & support work material on table.
C	CUTTING, STABBING, PUNCTURING	MEDIUM	Wear gloves to prevent cuts from sharp material offcuts.
D	SHEARING	MEDIUM	Hands should be kept clear of moving parts and blades. Ensure front blade guard is fitted securely. Do not adjust or clean machine while operating.
F	STRIKING	MEDIUM	Wear safety glasses. Stand clear of falling offcuts. Ensure material hold downs are correctly adjusted. Ensure guards are secured properly.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by:  
Safety officer:

Manager: 

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