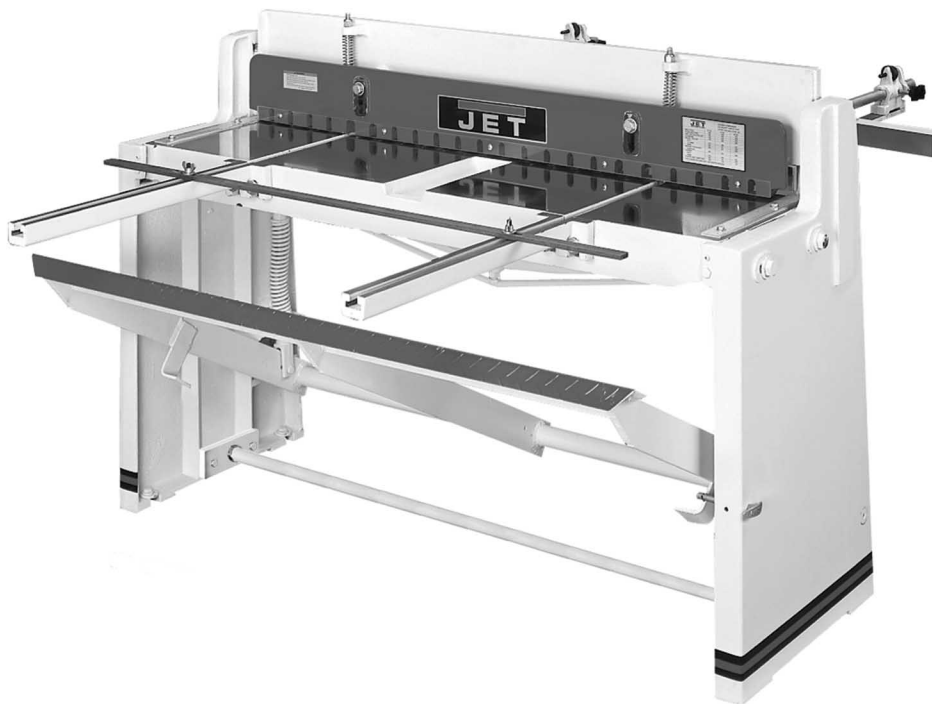


JET[®]

WMH TOOL GROUP

Operating Instructions and Parts Manual Foot Shear

Models FS-1636N, FS-1652N



WMH TOOL GROUP

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WMH Tool Group warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can provide quick service or information.

In most cases, a WMH Tool Group Service Center can assist in authorizing repair work, obtaining parts, or perform routine or major maintenance repair on your JET product.

For the name of an Authorized Service Center in your area, please call 1-800-274-6848, or visit our web site at www.wmhtoolgroup.com

More Information

Remember, WMH Tool Group is consistently adding new products to the line. For complete, up-to-date product information, check with your local WMH Tool Group distributor, or visit our web site at www.wmhtoolgroup.com

WMH Tool Group Warranty

WMH Tool Group makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 1 YEAR LIMITED WARRANTY ON ALL PRODUCTS UNLESS SPECIFIED OTHERWISE. This Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, repair or alterations outside our facilities, or to a lack of maintenance.

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To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an Authorized Service Center designated by our office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will either repair or replace the product at our discretion, or refund the purchase price if we cannot readily and quickly provide a repair or replacement. We will return the repaired product or replacement at WMH Tool Group's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of WMH Tool Group's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights; you may also have other rights, which vary from state to state.

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WARNING

For your own safety, read the owner's manual before operating the foot shear.

This foot shear is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a foot shear, do not use until proper training and knowledge has been obtained.

1. **KEEP GUARDS IN PLACE** and in working order.
2. **KEEP ALL BODY PARTS AWAY FROM MOVING PARTS.** Avoid placing any part of your body near belts, cutters, gears, etc.
3. **DO NOT EXCEED 16 GAUGE RATED CAPACITY** on this shear.
4. **KEEP THE WORK AREA CLEAN.** Cluttered areas and work benches invite accidents.
5. **KEEP CHILDREN AWAY.** All visitors should be kept a safe distance from the work area.
6. **MAKE THE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
7. **DON'T FORCE THE MACHINE.** It will do the job better and safer at the rate for which it was designed.
8. **USE THE RIGHT MACHINE.** Don't force a machine or attachment to do a job for which it was not designed.
9. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
10. **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
13. **NEVER STAND ON A MACHINE.** Serious injury could occur if the machine tipped.
14. **CHECK DAMAGED PARTS.** Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
15. **SHEET METAL STOCK HAS SHARP EDGES.** To prevent cuts, use caution when handling.
16. **KEEP HANDS AND FINGERS** clear of the area in front and rear of the shearing blades.
17. **DO NOT USE THE MACHINE** for any purpose other than for which it was designed
18. **FAILURE TO COMPLY** with all of these warnings may cause serious injury.
19. **SOME DUST CREATED BY** power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint
 - crystalline silica from bricks and cement and other masonry products
 - arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles
20. **DO NOT OPERATE TOOL** while under the influence of drugs, alcohol or any medication.

Specifications:

FS-1636N

FS-1652N

Stock Number.....	754636.....	754652
Capacity (mild steel)	16 gauge.....	16 gauge
Shearing Length Capacity.....	36".....	52"
Back Gauge Capacity	25.5".....	25.5"
Front Gauge Capacity.....	28".....	28"
Overall Dimensions (LxWxH).....	46 1/2" x 21 1/4" x 41 1/2".....	62 1/2" x 21 1/4" x 41 1/2"
Net Weight (lbs.).....	824.....	1014

Uncrating and Clean-Up

1. Remove the crate from around the machine.
2. Carefully clean all rust protected surfaces with a mild solvent or kerosene and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline. These will damage painted surfaces.
3. Coat all machined surfaces with a light coat of oil to inhibit rust.
4. Remove the bolts holding the machine to the skid.
5. Carefully move the machine to a level foundation. Machine location must allow access to all sides.

Assembly Note: Prior to shipment the foot shear is adjusted at the factory for proper operation. If the machine does not operate properly or the stand does not sit squarely on the floor, proceed to setup.

Stop Assembly

The (#) in the text refers to the breakdown.

1. Attach the two front arm extensions #6 to the bed with four hex cap screws and washers.
2. Attach the stop #71 to the front extension arms with T-nuts #72.
3. Attach the rear stop #59 to the adjusting block assembly #61.
4. Insert the rod #58 through the adjusting block assembly and into the cutter bar. Tighten in place with knobs #65.

Setup

1. Loosen four bolts #21. Loosen adjusting screws #18 & 19. The bed must rest squarely on the right and left hand side panels at all four corners while screws are loose. Shim legs at floor if necessary. Tighten hardware.
2. Use set screw #18 and hex cap screw #19, to adjust the lower blade towards or away

from the upper blade. The distance between the upper and lower blades should be 0.002-0.005". **Do not** let the blades overlap.

3. Place a heavy sheet of paper (~0.005") in the cutting position, along the entire length of the bed, and slowly press the foot lever.
4. If the shear does not cut the paper move the lower blade towards the upper blade.
5. If the shear cuts the paper on the ends, but not the center, turn the tie-rod adjusting screw #37, clockwise until the paper is cut the entire length.
6. If the shear cuts the paper in the center, but not the ends, turn the tie-rod adjusting screw #37, counter-clockwise until the paper is cut the entire length.
7. Make sure the scales #15 and #16 on top of the bed are square to the blade, and also show the correct distance from the blade.
8. Make test cuts to verify the scales are correct.

Blade Care

The 2-way upper blade can be removed and flipped 180°, for a sharp edge before having to sharpen the blade.

Wipe the blade lightly with oil. Lubricate all pivot points on the machine daily.

Spring Tension

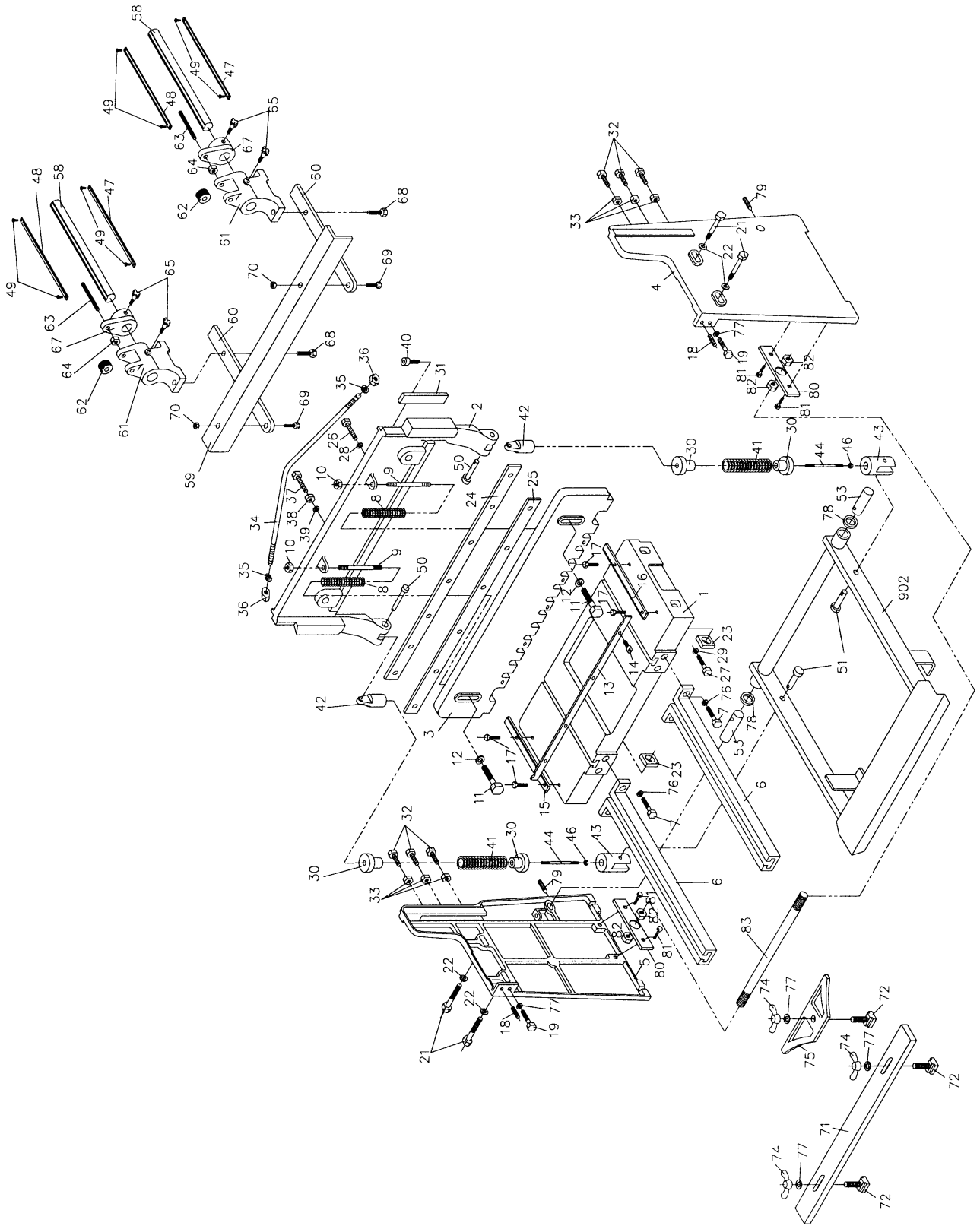
The spring return can be adjusted on the foot lever by tightening #46 hex nuts.

The spring return can be adjusted on the hold down #3 by tightening #10 hex nuts.

Gib Adjustment

There are three hex cap screws #32 that can be adjusted for play in the shim #31. Adjust for smooth travel.

Breakdown for FS-1636N & FS-1652N Foot Shear



Parts List for the FS-1636N & FS-1652N Foot Shear

Index No.	Part No.	Description	Size	Quantity
1	FS1636N-1	Table		1
	FS1652N-1	Table		1
2	FS1636N-2	Cutter Bar		1
	FS1652N-2	Cutter Bar		1
3	FS1636N-3	Hold Down		1
	FS1652N-3	Hold Down		1
4	FS1636N-4	R.H. Side Panel		1
5	FS1636N-5	L.H. Side Panel		1
6	FS1636N-6	Front Arm Extension		2
7	FS1636N-7	Screw	M12x45	4
8	FS1636N-8	Spring		2
9	FS1636N-9	Stud		2
10	FS1636N-10	Nut	M12	2
11	FS1636N-11	Screw	M12x80	2
12	FS1636N-12	Washer		2
13	FS1636N-13	Finger Guard		1
	FS1652N-13	Finger Guard		1
14	FS1636N-14	Screw	M6x12	4
15	FS1636N-15	Table Scale (L.H.)		1
16	FS1636N-16	Table Scale (R.H.)		1
17	FS1636N-17	Screw	M8x20	4
18	FS1636N-18	Set Screw	M10x45	2
19	FS1636N-19	Screw	M10x50	2
21	FS1636N-21	Bolt	M16x115	4
22	FS1636N-22	Washer	M16	4
23	FS1636N-23	Nut	M16	4
24	FS1636N-24	Upper Knife		1
	FS1652N-24	Upper Knife		1
25	FS1636N-25	Lower Knife		1
	FS1652N-25	Lower Knife		1
26	FS1636N-26	Screw	M10x40	7
27	FS1636N-27	Screw	M10x45	6
28	FS1636N-28	Washer		7
29	FS1636N-29	Washer		6
30	FS1636N-30	Spring Cap		4
31	FS1636N-31	Gib		2
32	FS1636N-32	Screw	M10x55	6
33	FS1636N-33	Nut	M10	6
34	FS1636N-34	Rod		1
	FS1652N-34	Rod		1
35	FS1636N-35	Washer	M16	2
36	FS1636N-36	Nut	M16	2
37	FS1636N-37	Screw	M16x80	1
38	FS1636N-38	Nut	M16	1
39	FS1636N-39	Washer	M16	1
40	FS1636N-40	Hex Socket Cap Screw	M10x30	2
41	FS1636N-41	Spring		2
42	FS1636N-42	Swivel Top		2
43	FS1636N-43	Swivel Bottom		2
44	FS1636N-44	Stud		2
46	FS1636N-46	Nut	M16	2
47	FS1636N-47	Scale (metric)		2
48	FS1636N-48	Scale (inches)		2
49	FS1636N-49	Screw	M4x8	4
50	FS1636N-50	Pin	Ø12x70	2
51	FS1636N-51	Pin	Ø12x45	2

53	FS1636N-53	Brake Pin		2
58	FS1636N-58	Rod		2
59	FS1636N-59	Stop		1
	FS1652N-59	Stop		1
60	FS1636N-60	Extension Bar		2
61	FS1636N-61	Adjusting Block		2
62	FS1636N-62	Adjusting Dial		2
63	FS1636N-63	Adjusting Screw		2
64	FS1636N-64	Nut	M10	2
65	FS1636N-65	Knob		4
67	FS1636N-67	Adjusting Bracket		2
68	FS1636N-68	Screw	M10x25	4
69	FS1636N-69	Bolt	M10x25	2
70	FS1636N-70	Nut	M10	2
71	FS1636N-71	Stop		1
	FS1652N-71	Stop		1
72	FS1636N-72	"T" Nut		3
74	FS1636N-74	Wing Nut	M10	3
75	FS1636N-75	Bevel Gauge		1
76	FS1636N-76	Washer		4
77	FS1636N-77	Washer	M10	5
78	FS1636N-78	Washer		2
79	FS1636N-79	Set Screw	M10x50	2
80	FS1636N-80	Plate		2
81	FS1636N-81	Screw	M12x35	4
82	FS1636N-82	Nut	M16	4
83	FS1636N-83	Connection Bar	Ø16x1081mm	1
	FS1652N-83	Connection Bar	Ø16x1463mm	1
902	FS1636N-902	Pedal Assembly		1
	FS1652N-902	Pedal Assembly		1
	FS1636N-ID	ID Label (not shown)		1
	FS1652N-ID	ID Label (not shown)		1
	FS1636N-W	Warning Label (not shown)		1
	FS1636N-J	JET Label (not shown)		1



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