



THROATLESS SHEAR

Model 38413

ASSEMBLY AND OPERATING INSTRUCTIONS



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Read this material before using this product.

Failure to do so can result in serious injury.

SAVE THIS MANUAL.

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For technical questions or replacement parts, please call 1-800-444-3353.

Revised 09i

Thank you for choosing a Harbor Freight Tools product! For future reference, please complete the owner's record below:

Model: _____ **Purchase Date:** _____

Save the receipt and these instructions. It is important that you read the entire instruction sheet to become familiar with this product before you begin using it.

Technical Specifications:

Designed to allow you to turn the workpiece at any angle for straight, curved, and irregular cuts. Will cut mild steel, aluminum, stainless steel or lighter material.

- 18" handle for good leverage
- Blades: Alloy tool steel, 4" length
- Dimensions: 8-1/4" x 13-1/2" x 27-1/4"
- Base Size: 5-1/8" x 3-7/8" with three mounting holes (3/8" diameter)
- Tool Weight: 16.4 lbs.

Warning:

Common sense and caution are factors which cannot be built into any product. These factors must be supplied by the operator. Please remember:

1. Prevent body contact with grounded surfaces such as pipes, radiators, etc.
2. Stay alert. Never operate equipment or use tools if you are tired.
3. Do not use this product if under the influence of alcohol or drugs. Read warning labels on prescriptions to determine if your judgement or reflexes might be impaired.
4. Do not wear loose clothing or jewelry as they can be caught in moving parts.
5. Nonskid footwear is recommended.
6. Wear restrictive hair covering to contain long hair.
7. Use eye and ear protection. Always wear ANSI approved safety glasses when using equipment or tools.
8. Keep proper footing and balance at all times.

Work Area

To avoid risk of personal injury, equipment damage, fire and shock, make sure your work area is:

1. Free of damp, wet or rainy conditions.
2. Free of flammable gasses or liquids.
3. Free of children. Children should never handle tools or operate equipment.

4. Make sure your work area is well lighted.
5. Clean and uncluttered work spaces contribute to safe and productive work conditions.

Before Operating

1. Check for damaged parts. Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function.
2. Check for alignment and binding of all moving parts, broken parts or mounting fixtures and any other condition that may affect proper operation. Any part that is damaged should be properly repaired or replaced by a qualified technician.

Operation

1. Never force the tool or attachment to do the work of a larger industrial tool. It is designed to do the job better and more safely at the rate for which it was intended.
2. Never use the blades if they are dull, worn, or chipped. Blades must be sharpened, repaired or replaced before using.
3. Check to make sure all bolts are secure but not overtightened. Check for blade clearance. Make sure clearance is suitable for the workpiece.
4. While being used, the lower blade must be secured with the Clamp. When not being used, the Clamp (10) can be loosened.
5. Minor assembly of the Throatless Shear is required. Assemble the Handle (6) over the exposed shaft of the Geared Handle (4) and tighten Bolt (5).

Using the Throatless Shear

1. Adjust the clearance between the Upper Blade (14) and Lower Blade (8). To decrease the clearance, turn the Adjusting Bolts (15) clockwise. To increase clearance, turn the bolts counterclockwise. The clearance can be adjusted to between 1/4 and 1/10 of the thickness of the workpiece.
2. To gain power and control of the workpiece, start all cuts at the heel of the blades. Circular and irregular cuts are made by turning the workpiece while following through with the downward stroke of the blade.
3. When a cut has been finished, push the workpiece forward while raising the handle to lift the blade above the workpiece. Start the next cut at the heel of the blade.
4. Always keep the material being cut flat on the bed of the shear.

Maintenance

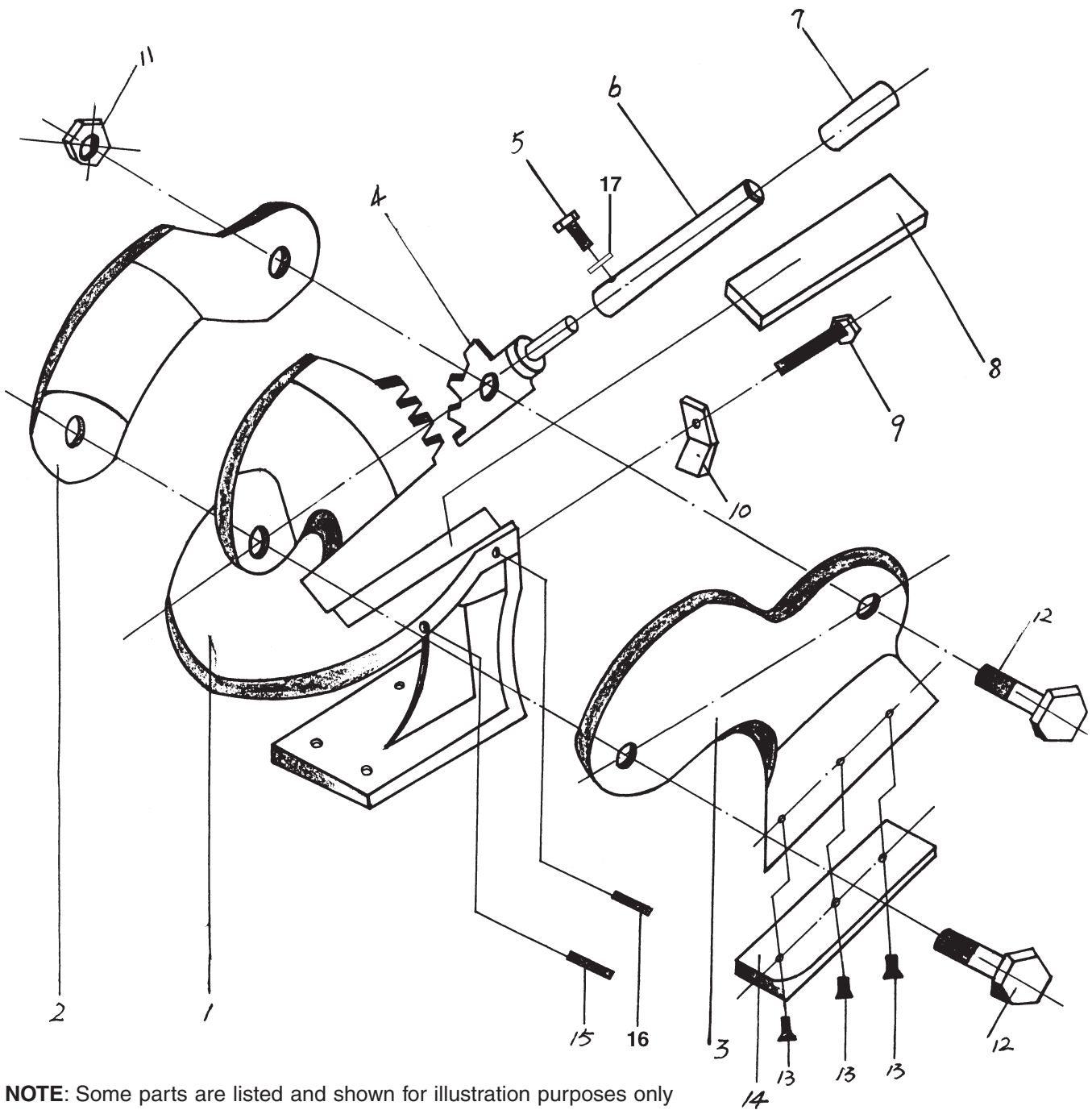
1. Periodically use a good graphite oil to lubricate blade edges and gears on the Geared Handle (4).
2. **To Replace the Blades (8, 14):**
 - a. Open jaws completely. Be sure to use caution when replacing the blade; if the handle is bumped the blades may move, causing personal injury.
 - b. Remove all three Bolts (13), replace Upper Blade (14), and secure Blade with Bolts (13).
 - c. Loosen Bolt (9), replace Lower Blade (8), and loosen Adjusting Bolts (15,16).
 - d. Adjust the Lower Blade (8) to the proper clearance for the workpiece to be cut, by using the Adjusting Bolts (15,16).
 - e. After the Lower Blade (8) is properly adjusted, tighten Bolt (9) to secure it in place.

Parts List

Part	Description	Q'ty
1	Base	1
2	Right Stand	1
3	Blade Stand	1
4	Geared Handle	1
5	Bolt M8x16	1
6	Handle	1
7	Handle Bushing	1
8	Lower Blade	1
9	Bolt M8x30	1

Part	Description	Q'ty
10	Clamp	1
11	Nut M12	1
12	Bolt M12	2
13	Bolt M5x8	3
14	Upper Blade	1
15	Adjusting Bolts M5x35	1
16	Adjusting Bolt M5x20	1
17	Spring Washer	1
18	Screw Driver	1

Assembly Diagram



NOTE: Some parts are listed and shown for illustration purposes only and are not available individually as replacement parts.

PLEASE READ THE FOLLOWING CAREFULLY

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