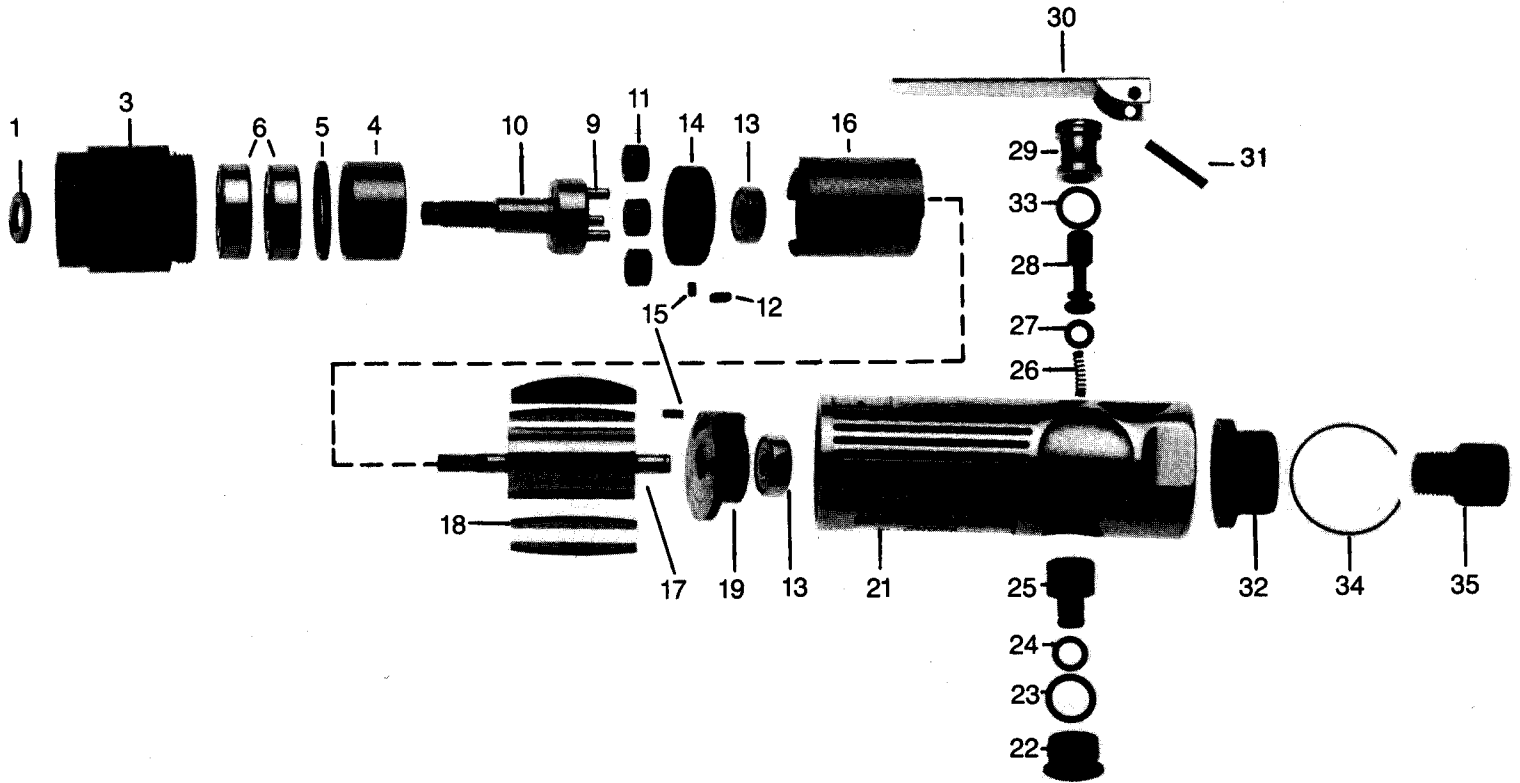




STRAIGHT PNEUMATIC MOTOR
PARTS LIST



253-56 POWER UNIT
S/N 101 & HIGHER

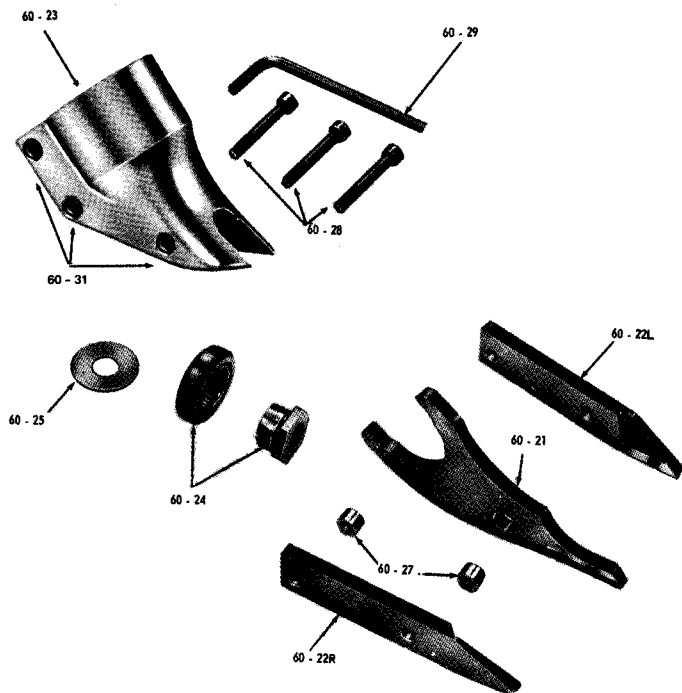
*Use 154-47 Spacer on model PN-1000 Nibbler

*Use 154-50 Spacer on models P-1060 & P-1080 Shears

Index No.	Part Number	Description	Req'd Tool	Index No.	Part Number	Description	Req'd Tool
1	154-*	Spacer	1	21	820020	Motor Housing	1
3	820002	Clamp Nut	1	22	820021	Retaining Screw	1
4	820003	Internal Gear	1	23	820022	"O" Ring	1
5	820004	Large Spacer	1	24	820023	"O" Ring	1
6	820005	Ball Bearing	2	25	820024	Air Regulator	1
9	820008	Planet Pin	3	26	820025	Spring	1
10	820009	Planet Spindle	1	27	820026	"O" Ring	1
11	820010	Planet Gear & Bushing	3	28	820027	Throttle Valve	1
12	820011	Key	1	29	820028	Valve	1
13	820012	Ball Bearing	2	30	820029	Throttle Leaver	1
14	820013	Front End Plate	1	31	820030	Lever Pin	1
15	820014	Pin	2	32	820031	Exhaust Deflector	1
16	820015	Cylinder	1	33	820032	"O" Ring	1
17	820016	Rotor	1	34	820033	Retaining Clip	1
18	820017	Rotor Blade	4	35	820034	Inlet Bushing	1
19	820018	Rear Plate	1				



INSTRUCTIONS FOR THE CARE OF THE KETT NO. 60-20 SHEAR HEAD



ADJUSTMENT

To adjust the curl of waste material, the left side knife (60-22L) has elongated holes. Adjustment may be necessary after changing blades or material being cut. Loosen cap screws (60-28) and tap side knife (60-22L) either forward or backward so that curl of waste does not hit shear housing (60-23) or work material while cutting.

DISASSEMBLY

To remove no. 60-20 shear head from power unit and dismantle:

1. Loosen both rear cap screws (60-28) three complete turns.
2. Remove shear head assembly (60-20) from motor by pulling head firmly forward. Slight twisting action may be required.
3. Remove three cap screws (60-28) completely from shear housing (60-23). Be careful not to lose rear spacer bushing (60-27) when removing rear cap screw.
4. Remove center blade (60-21) from shear housing (60-23) by tapping blade gently rearward. Be careful not to lose spacer bushing (60-27) from hole in center blade.
5. Side Knives (60-22L and 60-22R) will now drop out of shear housing.

ASSEMBLY

To assemble no. 60-20 shear head and adapt to power unit:

1. Place the left side knife (60-22L) into position in the shear housing (60-23).
2. Insert center cap screw (60-28) through housing and blade just far enough to slip spacer bushing (60-27) over cap screw.
3. Place right side knife (60-22R) into position and push center cap screw through right side knife. Start cap screw into insert just enough to hold blades in place. **DO NOT TIGHTEN.**
4. Insert spacer bushing (60-27) into hole in center blade (60-21) and lubricate with a good grade of bearing grease.
5. Install center blade (60-21) into shear housing (60-23) by tapping blade gently forward using a drift to line up hole in center blade with forward holes in housing.
6. Insert and tighten forward cap screw (60-28) making sure spacer bushing (60-27) in center blade stays in position. Apply good grade of bearing grease to clevis in center blade. **WHEN SHEAR HEAD IS PROPERLY ASSEMBLED THE CENTER BLADE WILL PIVOT FREELY IN HEAD.**
7. Insert rear cap screw (60-28) into shear housing (60-23) but do not completely tighten.

To install shear head assembly (60-20) onto power unit:

1. Make sure rear cap screw and center cap screw (60-28) are loosened three complete turns.
2. Place shear head onto unit and tighten cap screws (60-28) snugly to lock head assembly in place. It may be necessary to gently tap the shear head assembly into place if it does not readily slip onto the power unit.

WARNING: THE KETT TOOL CO. CANNOT ASSUME RESPONSIBILITY FOR DAMAGE TO OR MALFUNCTION OF A KETT SHEAR HEAD USED IN COMBINATION WITH ANY DRILL OR PARTS OTHER THAN THOSE REGULARLY SUPPLIED BY US. USE ONLY KETT REPLACEMENT BLADES EMBOSSED WITH PART NUMBERS 60-21, 60-22L OR 60-22R.

**NOTE: WHEN SHEAR HEAD IS PROPERLY ASSEMBLED
THE CENTER BLADE WILL MOVE FREELY IN HEAD.**