

MS-25-5 INSTRUCTION MANUAL



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SAFETY

1. DO NOT PLACE HANDS OR FINGERS UNDER HOLDDOWN ASSEMBLY OR NEAR BLADE AREA.
2. **NEVER** PLACE ANY PART OF YOUR BODY UNDER THE BLADE AREA.
3. **NEVER** ALLOW ANYONE TO SUPPORT MATERIAL BEING CUT FROM THE REAR POSITION OF THE MACHINE.
4. DO **NOT** STACK MATERIAL TO BE CUT, DESIGN IS FOR **SINGLE** LAYER ONLY.
5. KEEP FLOORS DRY AND FREE OF CLUTTER, MAINTAIN GOOD FOOTING, AND DO NOT OVERREACH.
6. DO **NOT** USE MACHINE AS A WORK TABLE, MATERIAL MAY SLIP INTO CUTTING PATH AND CAUSE SERIOUS DAMAGE AND INJURY.
7. **ALWAYS** OPERATE AND FEED THIS MACHINE FROM THE **FRONT** AREA ONLY.
8. CHECK MACHINE BEFORE EVERY USE FOR DAMAGE OR LOOSE MATERIAL BETWEEN BLADES.
9. **ALWAYS WEAR SAFETY GLASSES OR AN APPROVED EYE PROTECTION DEVICE WHEN OPERATING THIS MACHINE.**

SAFETY PRECAUTIONS

1. SOME CONTROL PANELS, TRANSFORMERS & JUNCTION BOXES HAVE HIGH VOLTAGE TERMINALS. THESE SHOULD NOT BE TOUCHED OR A SEVERE SHOCK MAY BE SUSTAINED.
2. CABLES, CORDS OR ELECTRIC WIRE WHOSE INSULATION IS DAMAGED CAN PRODUCE CURRENT LEAKS AND ELECTRIC SHOCK.. BEFORE USING, CHECK THEIR CONDITION.
3. DO NOT GO NEAR HYDRAULIC LEAKS, STOP MACHINE, DISCONNECT POWER, AND CONTACT MAINTENANCE, SYSTEM IS UNDER HIGH PRESSURE AND COULD CAUSE SEVERE INJURY. DECOMPRESS HYDRAULIC SYSTEM BEFORE SERVICING.

“WARNING”

**ELECTRICAL INSTALLATION
MUST BE PERFORMED BY
A LICENSED ELECTRICIAN**

CUTTING PROCEDURE

FIRST CHECK THAT THE MACHINE IS CLEAR OF ALL DEBRIS AND CLUTTER AROUND THE MACHINE.

AFTER YOU ARE SURE NO MATERIAL OR OTHER OBJECTS ARE IN YOUR WAY OF WORKING, PROCEED TO ADJUST YOUR BACK GAGES SO YOUR CUT WILL BE ACCURATE AND STRAIGHT.

YOU CAN NOW TURN THE MACHINE ON BY TURNING ON THE ELECTRICAL SWITCH LOCATED ON THE FRONT OF THE PANEL.

ALIGN YOUR PIECE OF METAL WITH THE ALIGNMENT GUIDE LOCATED ON THE LEFT HAND SIDE OF THE WORK TABLE.

WHEN YOU HAVE THE PIECE OF METAL PROPERLY POSITIONED SIMPLY PRESS THE FOOT PEDAL (MAKING SURE AT NO TIME YOUR FINGERS OR ANY PART OF YOUR BODY COMES NEAR THE BLADE.) AFTER THE PIECE IS CUT SIMPLY TAKE YOUR FOOT OFF THE FOOT PEDAL, AND THE BLADE WILL AUTOMATICLY RETUN TO THE STARTING POSITION LEAVING YOUR HANDS FREE TO WORK.



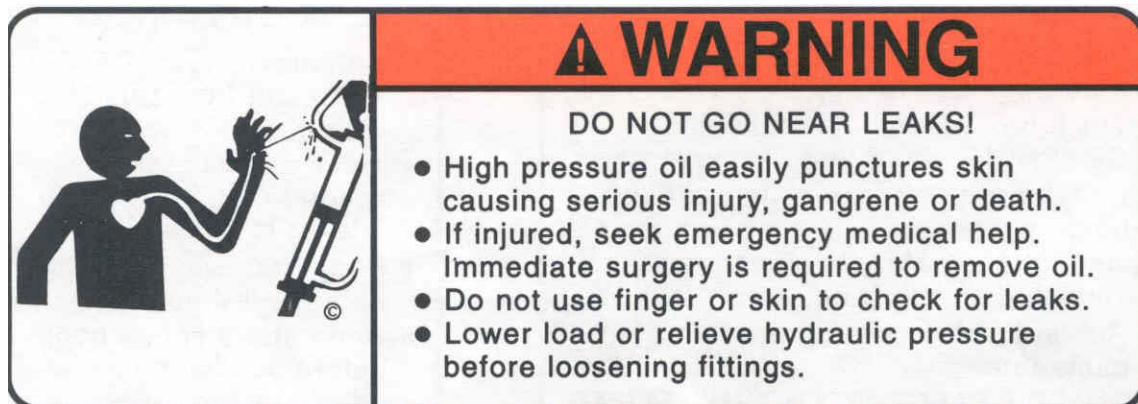
SPECIFICATIONS

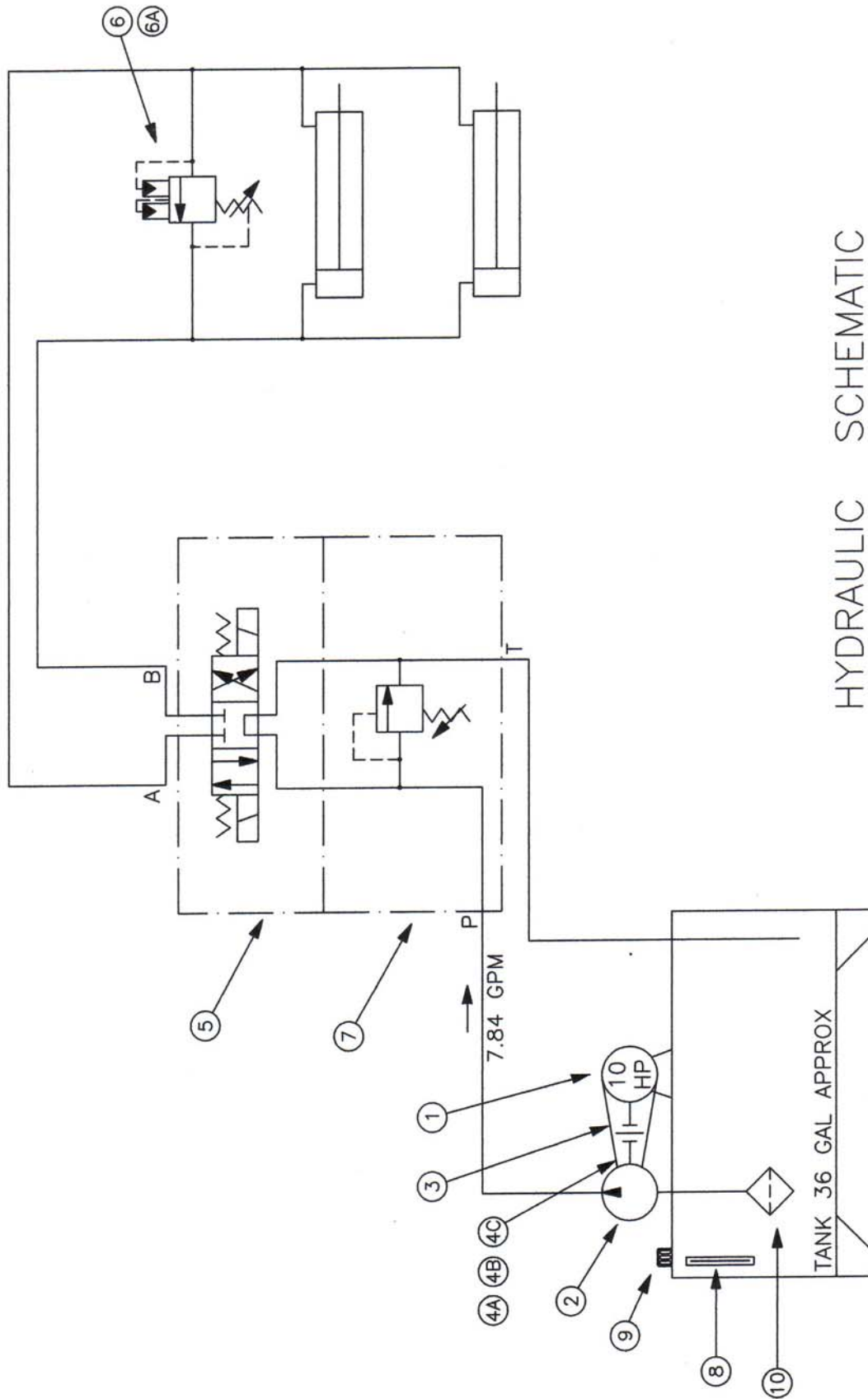
CUTTING CAPACITY	1/4 IN. (0.250) MILD STEEL
CUTTING LENGTH	60.375 IN.
RAKE ANGLE	0.250 PER FT.
STROKES PER MINUTE	18 MINIMUM
NUMBER OF HOLD-DOWN CYL.	10
MOTOR	10 H.P. 1760 R.P.M.
TABLE DEPTH TO BLADE	24.875 IN.
TABLE WORKING HEIGHT	35.500 IN.
FOOTPRINT	37 IN. WIDE x 83 IN. LONG
WEIGHT APPROX.	6,200 POUNDS
HYDRAULIC FLUID	160 LITERS / 42 US GAL. AW 68 OR EQUIVALENT

**DO NOT OPERATE
WITHOUT
EYE PROTECTION**

FEATURES

1. EQUIPPED WITH A FULLY-INTEGRATED HYDRAULIC UNIT.
LOW WORKING PRESSURE OF 2,332 P.S.I.
2. PRESSURE RELIEF VALVE TO PREVENT OVERLOADING.
3. ELECTRIC SOLENOID HYDRAULIC VALVING FOR
INSTANTANEOUS RESPONSE.
4. FOOT SWITCH, IF RELEASED ANYWHERE IN THE STROKE
THE CROSSHEAD RETURNS TO THE UP POSITION.
5. CLEAN HYDRAULIC OIL IS ASSURED BY A RENEWABLE
CARTRIDGE TYPE FILTER





HYDRAULIC SCHEMATIC

MS-25-5 METAL SHEAR

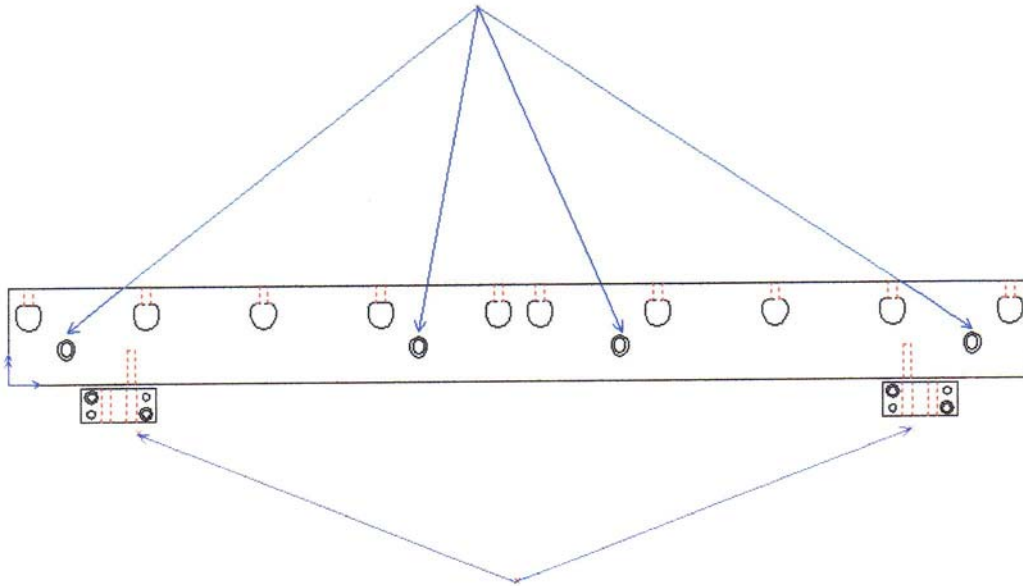
SEPTEMBER 07 2007

PART NUMBER	DESCRIPTION	QTY	ITEM #
10 HP	MOTOR 1760 RPM 254TC	1	1
122470	PUMP 1.03 3/4 SHAFT L/S	1	2
163709	BELL HOUSING	1	3
173572	MOTOR COUPLING 1 3/8	1	4A
173567	PUMP COUPLING 3/4	1	4B
173612	INSERT	1	4C
157869	RUN VALVE DSG-3C60-N-03-A1-3090	1	5
124576	SUBPLATE C/W RELIEF SAE 10	1	7
153629	LEVEL GAUGE 3.00 IN.	1	8
153630	BREATHER CAP	1	9
141679	SUCTION STRAINER 1.00 NPT 10.8 GPM	1	10
136854	SEQUENCE VALVE 15.8 GPM	1	6
129837	BODY (SEQUENCE VALVE) SAE 8	1	6A

2 CYLINDERS 3.0 BORE 4.5 STROKE 1.5 ROD

BLADE ADJUSTMENT

FIRST, LOOSEN THE 4 SCREWS HOLDING THE BLADE HOLDER SECURE



SECOND, SIMPLY TIGHTEN OR LOOSEN ADJUSTMENT BLOCKS.

THE BOLTS ON THE INSIDE PULL THE BLADE HOLDER. THE BOLTS ON THE OUTSIDE PUSH.

AFTER ADJUSTMENT TIGHTEN THE 4 SCREWS TO MAINTAIN GAP ALL SHEARS LEAVE R K MACHINERY SET AT 0.002.

ALL MACHINES ARE TESTED AT THIS SETTING AND WE RECOMMEND THIS GAP ON ALL MATERIAL UP TO 0.25 MILD STEEL.

THE ADJUSTMENT IS CHECKED BY PUTTING A FEELER GAUGE BETWEEN THE TWO BLADES.

TO LOWER THE TOP BLADE, PRESS ON THE FOOT PEDAL. WHEN THE BLADE GOES DOWN TURN THE POWER SWITCH OFF. THIS WILL KEEP YOUR BLADE DOWN UNTIL YOU ARE READY TO START UP.

WHEN CUTTING STAINLESS STEEL, USE A SPRAY LUBRICANT ON THE BLADES TO REDUCE RESIDUE FOR A CLEANER CUT AND LONGER BLADE LIFE.

ALWAYS SHUT POWER SUPPLY OFF AND LOCK THE LEVER BEFORE WORKING ON OR NEAR BLADE.

WARRANTY AND LIMITATION OF LIABILITY

WARRANTY

FOR A PERIOD OF ONE YEAR FROM DATE OF PURCHASE R. K. MACHINERY WILL REPLACE THROUGH IT'S DISTRIBUTOR, FREE OF CHARGE, ANY PART FOUND UPON EXAMINATION BY R. K. MACHINERY TO BE DEFECTIVE IN MATERIALS OR WORKMANSHIP.

AUTHORIZATION MUST FIRST BE OBTAINED BEFORE EXERCISING A WARRANTY CLAIM. TRANSPORTATION CHARGES ON PARTS OR COMPONENTS SUBMITTED FOR WARRANTY ARE THE RESPONSIBILITY OF THE PURCHASER, AND MUST BE ACCOMPANIED BY PROOF OF PURCHASE.

THIS WARRANTY DOES NOT APPLY TO FAILURES RESULTING FROM ABUSE, NORMAL WEAR AND TEAR, NEGLIGENT REPAIRS, ALTERATIONS OR MODIFICATIONS MADE TO THE PRODUCT WITHOUT EXPRESS WRITTEN CONSENT FROM R. K. MACHINERY.

ELECTRIC MOTORS ARE COVERED BY THE ORIGINAL MANUFACTURERS WARRANTY AND SHOULD BE RETURNED BY THE PURCHASER TO THEIR AUTHORIZED SERVICE CENTER FOR REPAIR.

R. K. MACHINERY IS NOT RESPONSIBLE FOR LABOR COSTS RELATED TO CHANGING PARTS OR COMPONENTS.

LIMITATION OF LIABILITY

R. K. MACHINERY AND IT'S DISTRIBUTORS SHALL NEITHER BE LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL, SPECIAL OR PUNITIVE DAMAGES WHETHER BASED UPON LOSS OF USE, LOST PROFITS OR REVENUE, OR WORK STOPPAGE WHETHER OR NOT SUCH DAMAGE IS BASED ON CONTRACT, WARRANTY, NEGLIGENCE, OR OTHERWISE.

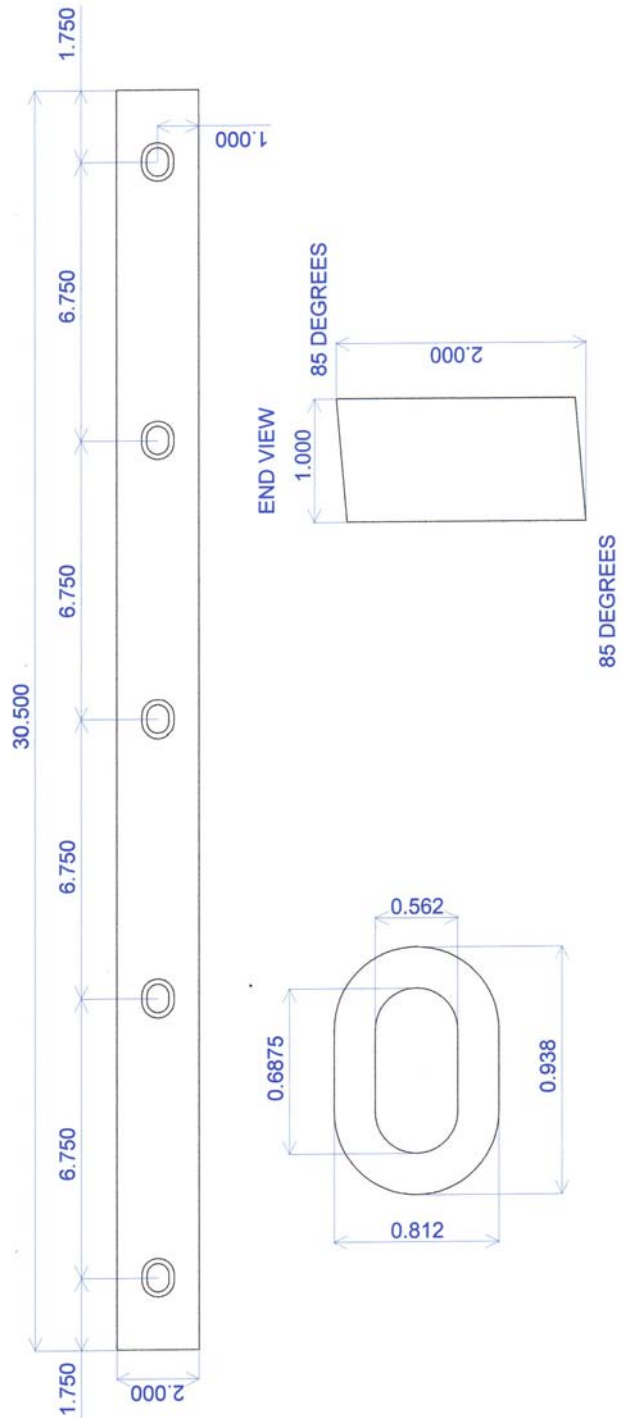
TOP BLADE

FOR BLADE REPLACEMENT E-MAIL US AT rkm@rkmachinery.ca

MS-25-5
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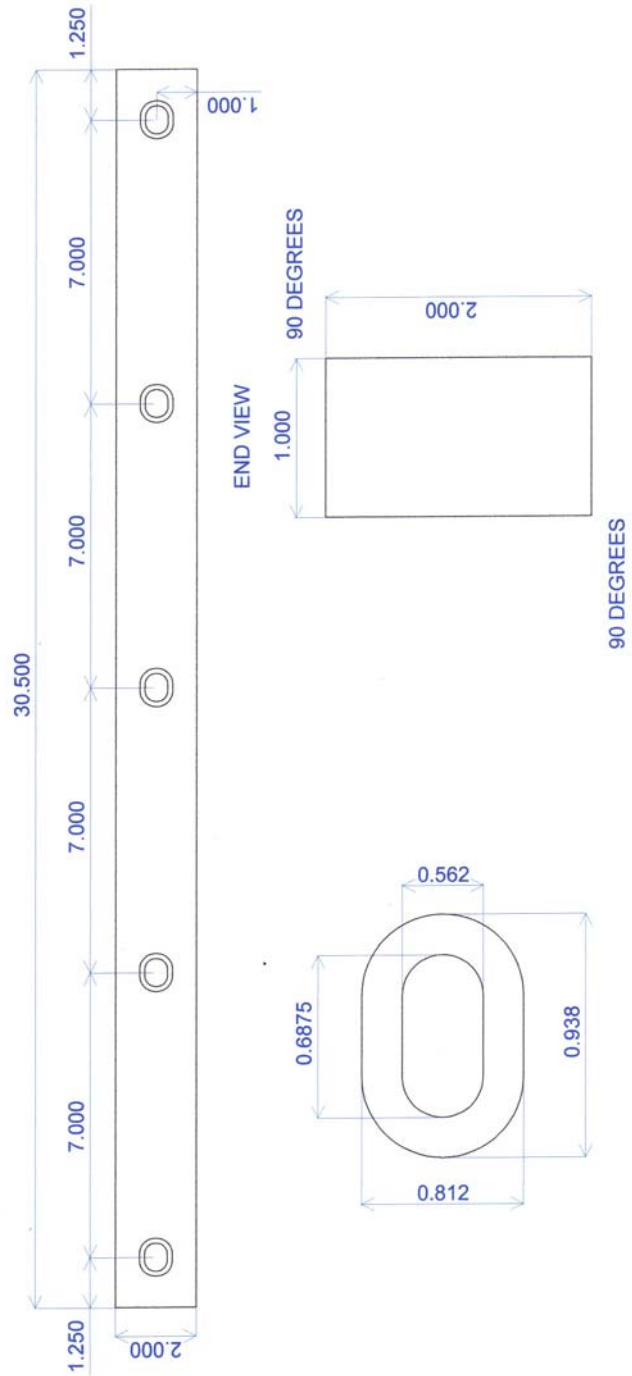
TOP BLADE
MATERIAL AISI D2 RC 56-58
FINISHED SIZE 1.000 x 2.000 x 30.500
2 PCS. REQ. 5 FT.

BL-001 SG



BOTTOM BLADE

BL-002 SG
MS-25-5
BOTTOM BLADE
MATERIAL AISI D2 RC 56-58
FINISHED SIZE 1.000 x 2.000 x 30.500
2 PCS. REQ. 5 FT.
APR 02 2007



BUSHINGS

ON OUR LINKAGE SYSTEM & CYLINDER ASSEMBLY WE USE 16
SELF LUBRICATING BUSHINGS.

PART NO. GB24DU16 1.500 x 1.656 x 0.125

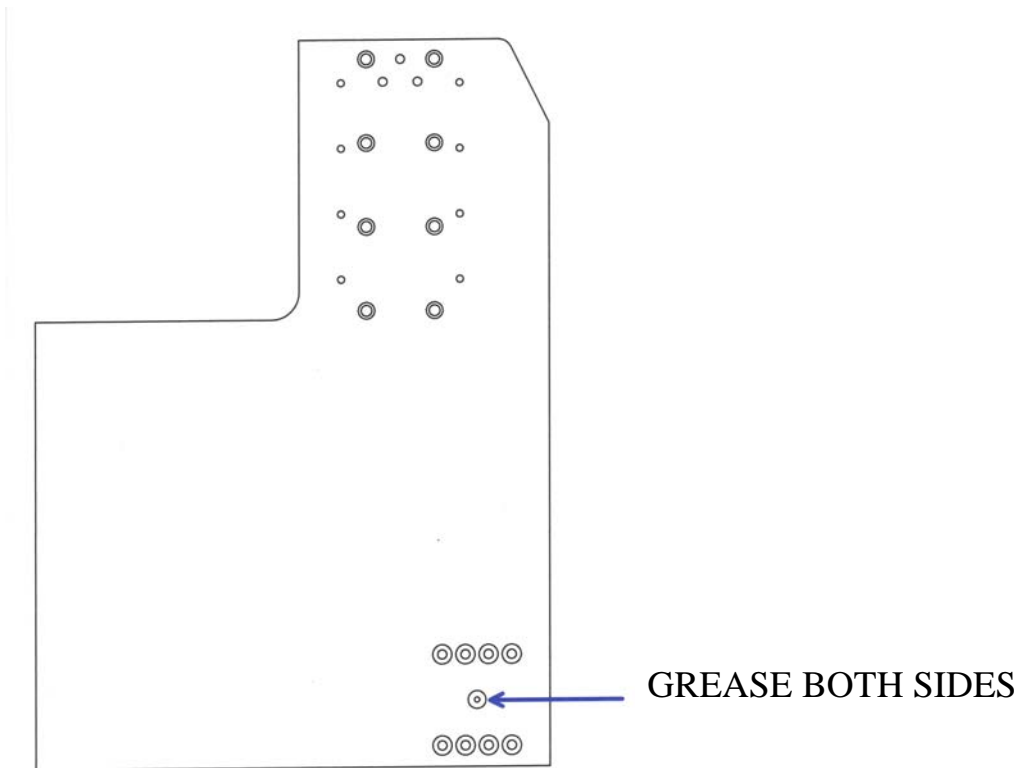
TO FIND YOUR LOCAL DISTRIBUTOR CONTACT GARLOCK BEARINGS
INC.

700 MID ATLANTIC PARKWAY,
P.O. BOX 189, THOROFARE, NEW JERSEY
08086

PHONE 1-800-222-0147
FAX 609-848-5115

GREASE ZERTS

THERE ARE **6 PLACES TO GREASE**



THERE ARE TWO GREASE ZERTS ON TOP OF THE RAM

THERE ARE ALSO GREASE ZERTS ON THE BACK OF THE RAM
SUPPORT

THESE 6 ZERTS SHOULD BE GREASED MONTHLY OR MORE
ACCORDING TO THE USAGE.

NOTES