



Installing Module- Sheer Shear tightening

We are using a prybar to tighten the blade assembly while loosening and tightening bolts to make this happen.

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Step 1 — Shear tightening



- Take a solid helper bar and push down on the blade spacer assembly by wedging the bar in between the upper and lower blades

Step 2



- Tighten the upper blade holder plate bolts down so that the metal is firm against one another but still able to move. Do this on the side of the ironworker opposite of the table

Step 3



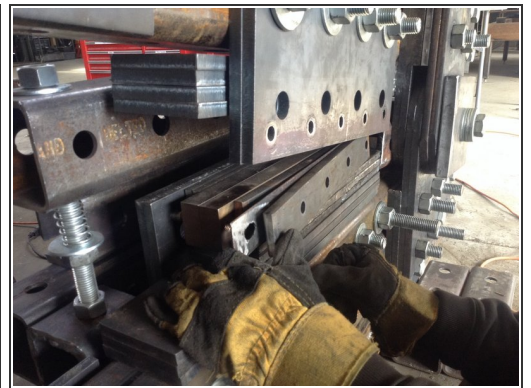
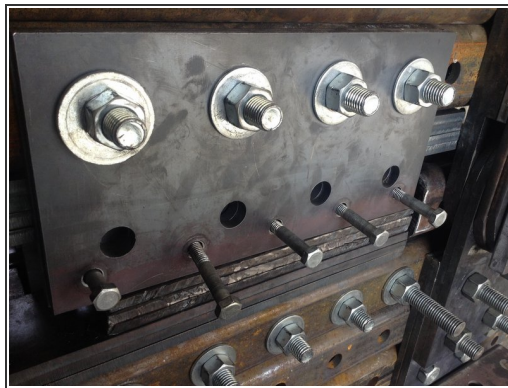
- Repeat the same for the lower blade holder bolts

Step 4



- Cut Out a blade spacer plate as necessary

Step 5



- take off the blade to insert blade spacers as needed.

Step 6



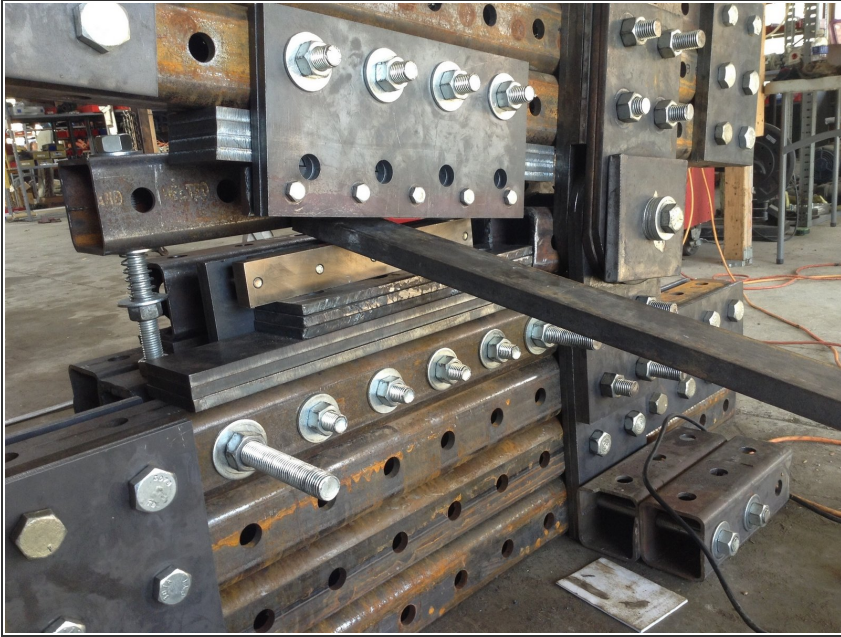
- Take a blade you need to take off the entire blade mounting plate.

Step 7



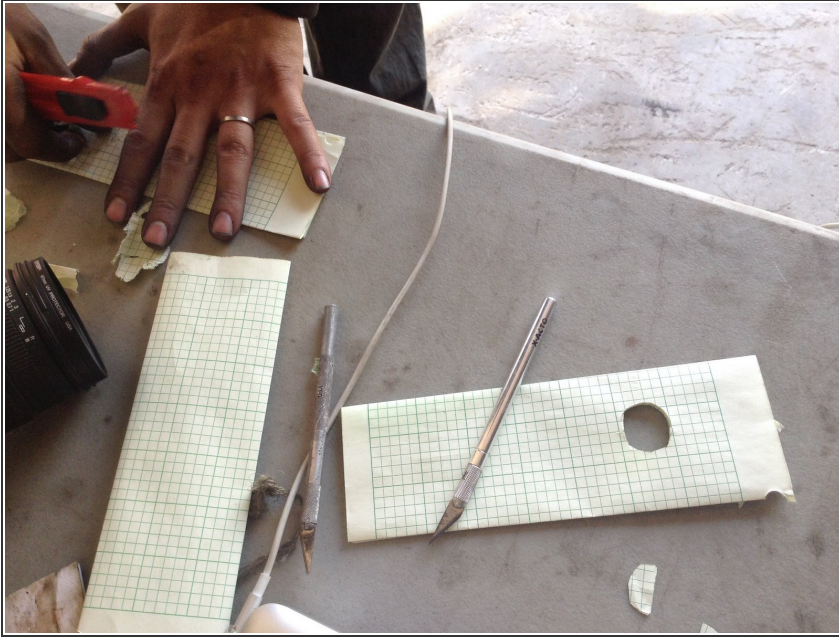
- Mount the spacer plate in the blade assembly. Mount blade assembly back on the ironworker.

Step 8



- Place a spacer between the top blade and the bottom blade so that the spacer presses down on the blade to tension it into position.

Step 9



- To finalize the spacing between the blades use paper as the final spacer adjustment. Do this for the top blade where access to blade mounting is easier

Step 10



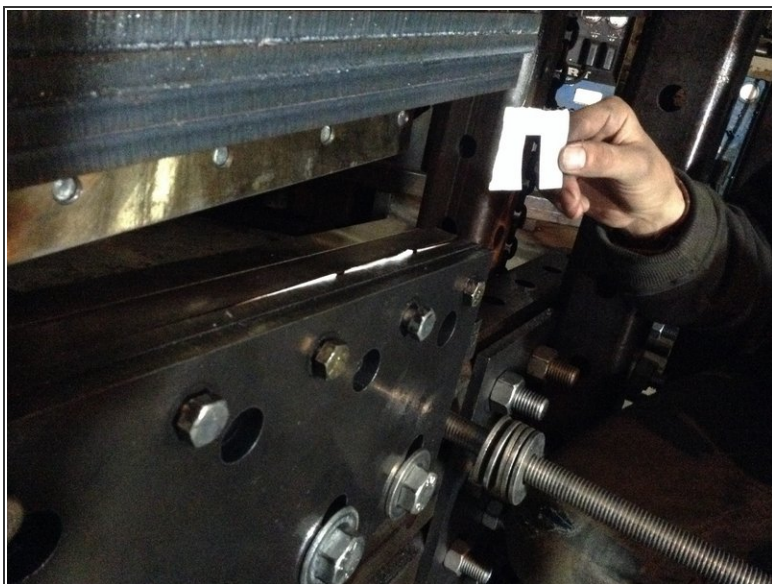
- Insert The paper spacer under the blade mount plate

Step 11



- Test blade gap - 2-4 sheets thicknesses (printer paper). And you are ready to cut up to 1"x8" steel.

Step 12



- If blade gap varies more than 2 thousandths of an inch throughout, use spacers - sheets of paper, where each sheet is about 2 thousandths wide.