



Peddinghaus

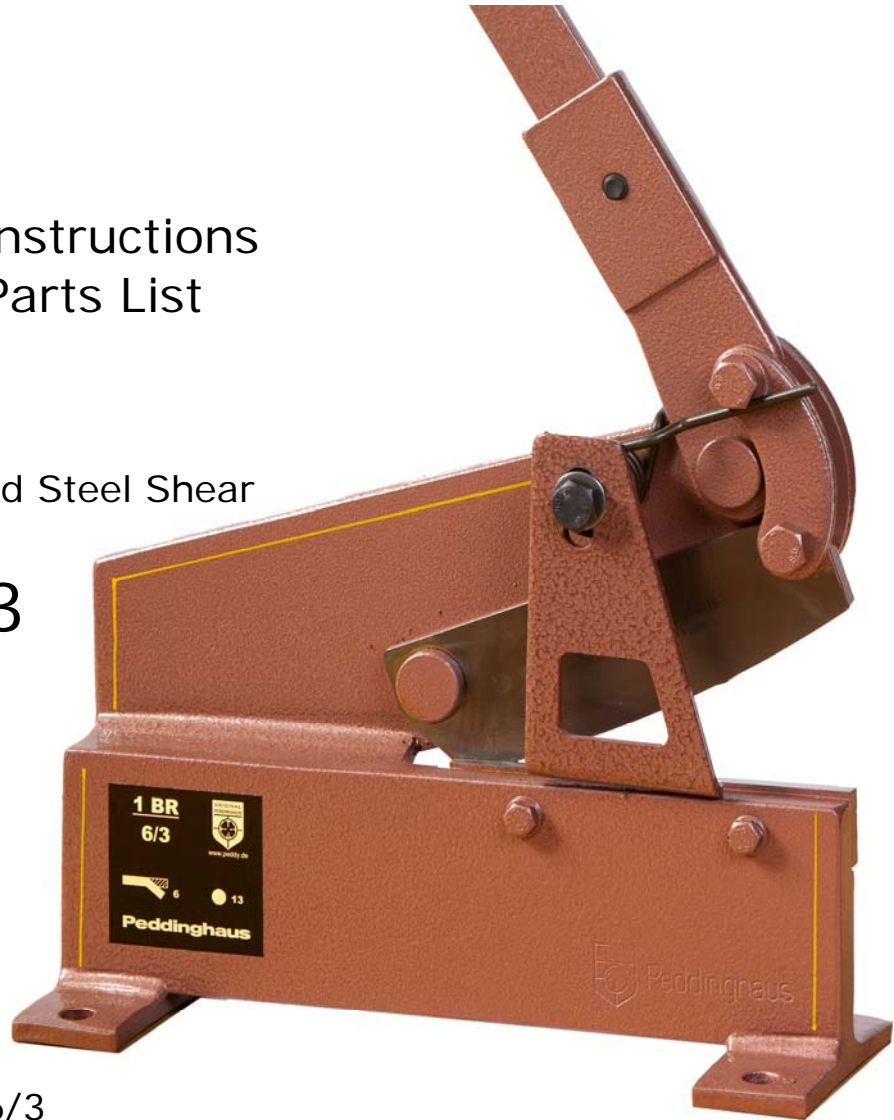
Peddinghaus Anlagen & Maschinen GmbH

Operating Instructions and Spare Parts List

for

Plate and Round Steel Shear

1 BR 6/3



Product – No.
20129 – 1 BR 6/3

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Description

Plate and round steel shear 1 BR 6 / 3

- rugged machine frame
- blades of high grade tool steel, hardened and ground
- ergonomic cutting geometry
- infinitely adjustable hold-down
- hand lever with safety spring
- The operator has a clear view over the full blade length enabling work to be performed on layouted plate.

Technical Data

Model 1 BR 6 / 3		
plate	up to mm	6
rounds	up to mm	13
blade length	mm	180
net weight	kg	19
part no.		20129

Mounting the hand lever

Prior to using the shear the hand lever must be fitted to the lever shoe as follows:

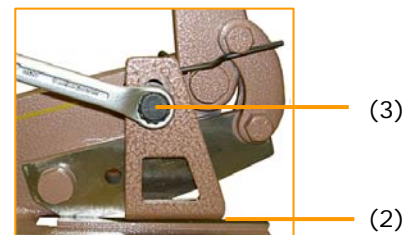
- By means of a size 19 open-jaw spanner or box spanner release the screw (1) and remove the screw.
- Insert the hand lever into the lever shoe guide.
- Fix the hand lever by means of the screw (1).



Cutting flat bar – adjusting the hold-down

Prior to shearing operations the hold-down must be set to the workpiece. There should be a gap (2) of approx. 1 to 2 mm between the upper edge of the material and the lower edge of the hold-down.

- Release the screw (3) by means of a size 19 open jaw spanner or box spanner.
- Push the hold-down upwards or downwards.



Shearing round bar

Round bar is cut in the opening of the round blade (4), to the left of the hold-down.



Changing the torsion spring

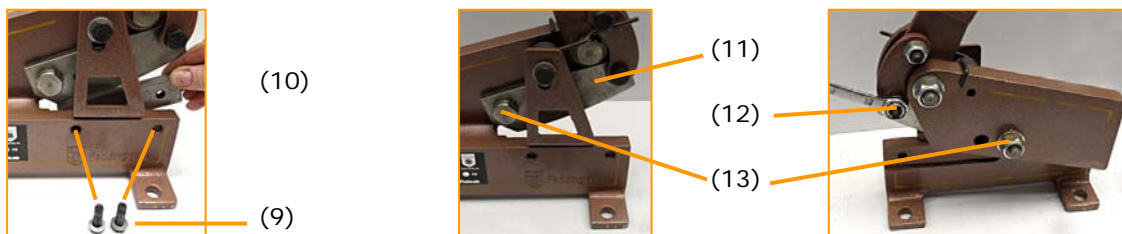


Operations:

- Use a pipe of approx. 15cm length as a lever to remove the torsion spring (5) from the guide of the screw (7).
- By means of a size 19 open-jaw spanner or box spanner release the screw (8) and remove the screw.
- Remove the hold-down (6).
- Remove the torsion spring (5) and replace with new spring.

Reassemble in reverse sequence.

Changing the plate shear blades



Dismantling the bottom blade:

- By means of a size 19 open-jaw spanner or box spanner release both fixing screws (9) and remove the screws.
- From the front side, remove the bottom blade (10) from its seat.

Dismantling the upper blade:

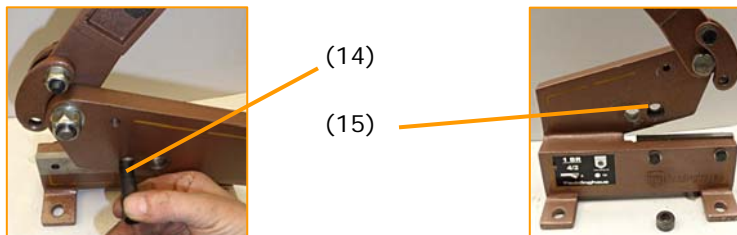
- By means of a size 19 open-jaw spanner or box spanner release and remove the screw (12).
- Release the bolt (13) by means of a size 24 open-jaw spanner or box spanner and beating slightly with a hammer knock the bolt out of its seat.
- Remove the upper blade (11).

Mount the new blades in reverse sequence.

Changing the round blade

- Remove torsion spring and hold-down, see chapter "Changing the torsion spring".
- Remove the upper blade, see chapter "Changing the plate shear blades".
- From the opposite side, knock the round blade out of its seat (15) by means of a 14mm bolt (14).

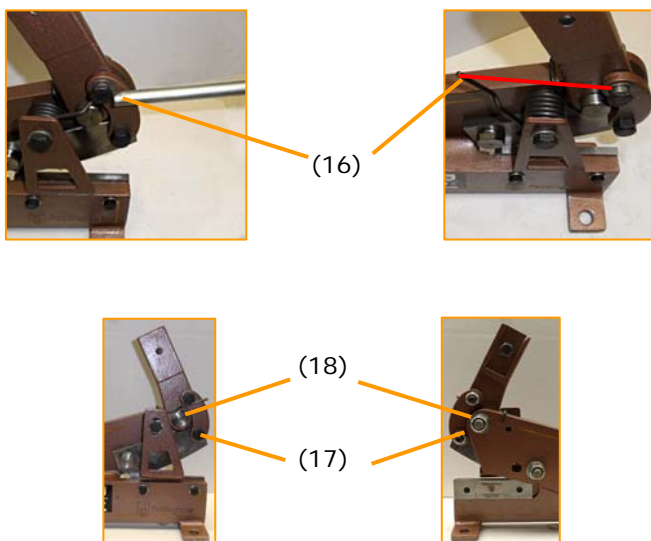
Mount the new blade in reverse sequence.



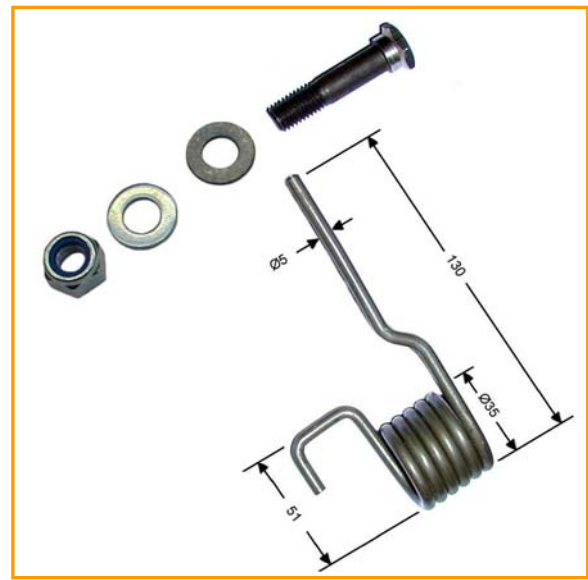
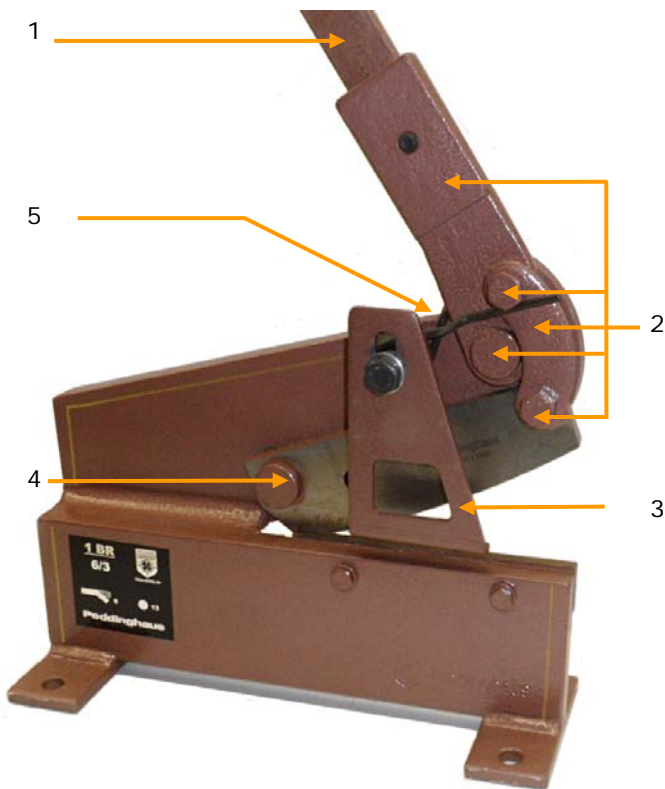
Changing the elements of the driving parts set

- Remove the torsion spring from the guide of the screw (16) using a pipe as lever.
- Release the screws (17) by means of a size 19 open-jaw spanner or box spanner and remove the screws.
- Release the bolt (18) by means of a size 24 open-jaw spanner or box spanner and beating slightly with a hammer knock the bolt (18) out of the bush.

Fit the new parts in reverse sequence.



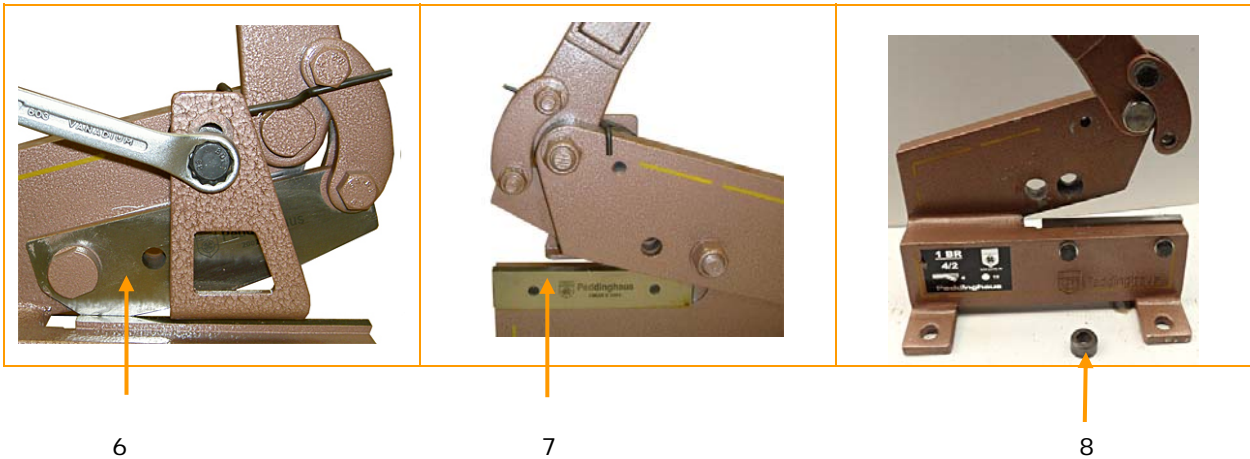
Spare parts



5 – torsion spring complete

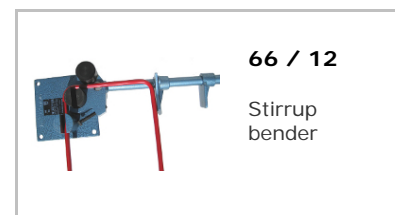
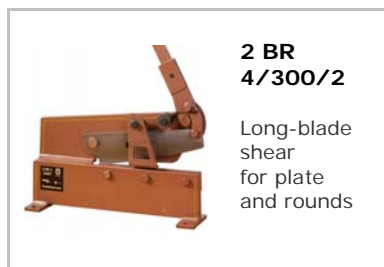
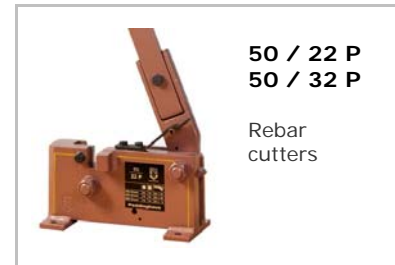
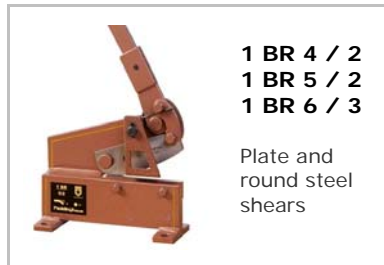
Item	Description	Part number	Quantity
1	hand operating lever	20129 152 10 00	1
2	driving parts, set	20129 152 50 00	1
	– lever shoe		1
	– pivot pin complete		1
	– hex. head screw complete		1
	– torsion spring screw complete		1
	– knife clamps		2
3	plate hold-down	20129 173 01 01	1
4	pivot pin complete	20129 152 02 00	1
5	torsion spring complete	20129 152 60 00	1
	– torsion spring screw complete		1


Shear blades



Item	Description	Part number	Quantity
6	upper blade	20029 5 1000	1
7	bottom blade	20029 5 1001	1
8	round blade	20055 5 1002	1


Peddinghaus Sales Program Hand lever shears, punching machines, rebar benders





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