Safety guidelines

- Think safely when handling sheet metal, sheet metal is extremely sharp. You can be severely injured if you are not careful.

These injuries can include minor cuts to major cuts requiring stitches. This can also be injuries that can be debilitating to your lively hood. We do recommend wearing cut resistant gloves while handling to prevent cuts. There are also Kevlar sleeves to prevent cuts to your arms, **we do not supply this.**

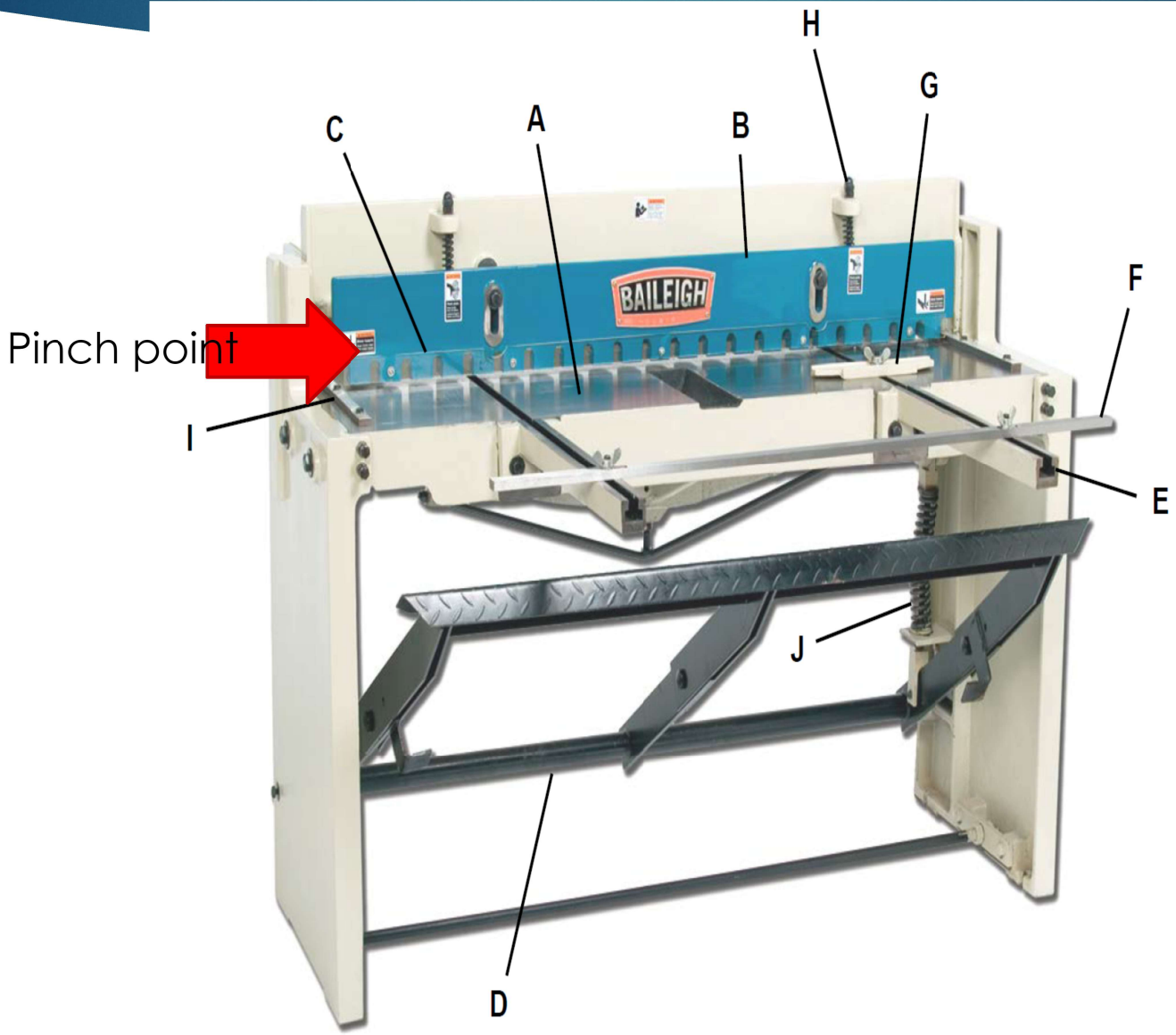
- Be aware of the pinch points that exist on the equipment. This could be the shear hold down clamp, shear blade, safety shield. If it moves it can & will pinch or sever.
- On the brake the pinch points are the clamping bars & the bending plate.
- On the slip roll the pinch points are the rollers, sleeve to frame & the actual crank arm

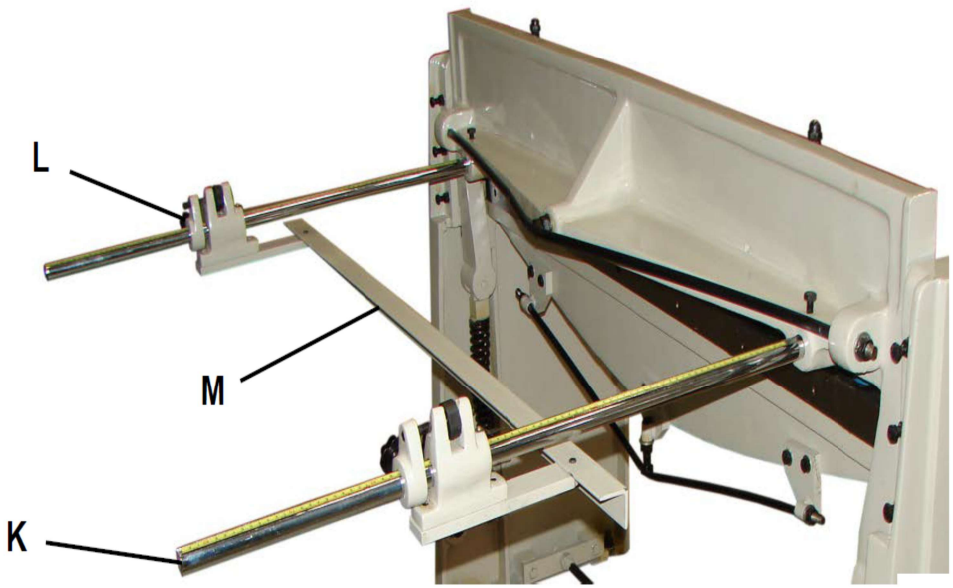
General guidelines

- Do not exceed the capacity of the equipment.
- Do not try to cut hardened material.
- Keep the machinery covered when not in use. This will allow our equipment to last much longer.
- If the material was cut on the plasma cutter, ensure that the surfaces are smooth.
- Do not modify the equipment in any way. You can make custom clamps for the brake but don't modify the factory clamps.
- Do not make any cheaters for the brake handle.

Sheet Metal shear

- The sheet metal shear that we have is foot operated & powered. It is actually called a foot stomp shear. On the thicker materials, you may have to stomp harder to get through the material. But do no exceed the maximum capacity.
- Remember to keep your hands clear of any parts on the shear that will move.


Pinch point
H
G
C
A
B
F
BAILEIGH
I
E
J
D



Back Side

Item	Description	Function
A	Table	Machined surface for loading material
B	Hold down	Spring loaded bar to secure material
C	Safety shield	Clear plastic guard attached to hold down
D	Foot pedal	Used to lower the top blade for shearing
E	Front arm extensions	Provides material support at load end
F	Front Stop	Adjustable with T-slot
G	Miter guide	Use for angled cuts of smaller material
H	Hold down adjusting springs	Allows hold down to adjust to various heights
I	Graduated side guide	Keeps material square to the shear blade
J	Blade return spring	Dual springs to raise top blade to up position
K	Blade return spring	Used to support micro-adjust and back stop
L	Micro-adjuster	Use to accurately set back stop position
M	Back gauge stop	Set and use for repeat shearing

Capacities

TECHNICAL SPECIFICATIONS

Maximum Shear Length	52” (1321mm)
Maximum Material Thickness	16 ga. (1.52mm) mild steel* 20 ga. (.912mm) stainless steel**
Minimum Material Thickness	24 ga. (0.607mm)
Front Gate Length	20” (508mm)
Back Gate Length	33” (838mm)
Blade Angle	1° / 40ft (12.19 m)
Power Requirements	Manual
Shipping Dimensions (L x W x H)	66” x 30” x 46” (1676 x 762 x 1168mm)
Shipping Weight	1199 lbs. (544 kg)
Based on a material tensile strength of **100000 PSI – stainless steel	*65000 PSI – mild steel

Material Equivalency Chart

	16 Ga.	18 Ga.	20 Ga.
Mild Steel	.060" (1.52mm)	.048" (1.22mm)	.036" (.91mm)
Stainless Steel	—	—	.031" (.78mm)
Cold Rolled Steel	.048" (1.22mm)	.035" (.89mm)	.030" (.76mm)
Aluminum	.100" (2.54mm)	.090" (2.28mm)	.063" (1.60mm)
Soft Brass	.072" (1.83mm)	.064" (1.63mm)	.051" (1.29mm)
Half Hard Brass	.064" (1.62mm)	.051" (1.29mm)	.036" (.91mm)
Hard Brass	.054" (1.37mm)	.051" (1.29mm)	.036" (.91mm)
Bronze, Annealed	.064" (1.62mm)	.051" (1.29mm)	.040" (1.02mm)
Soft Copper	.072" (1.83mm)	.064" (1.62mm)	.051" (1.29mm)
Hard Copper	.064" (1.62mm)	.051" (1.29mm)	.040" (1.02mm)