



Double End Frame Mechanical Squaring Shears

Parts List

Model _____
Serial No. _____

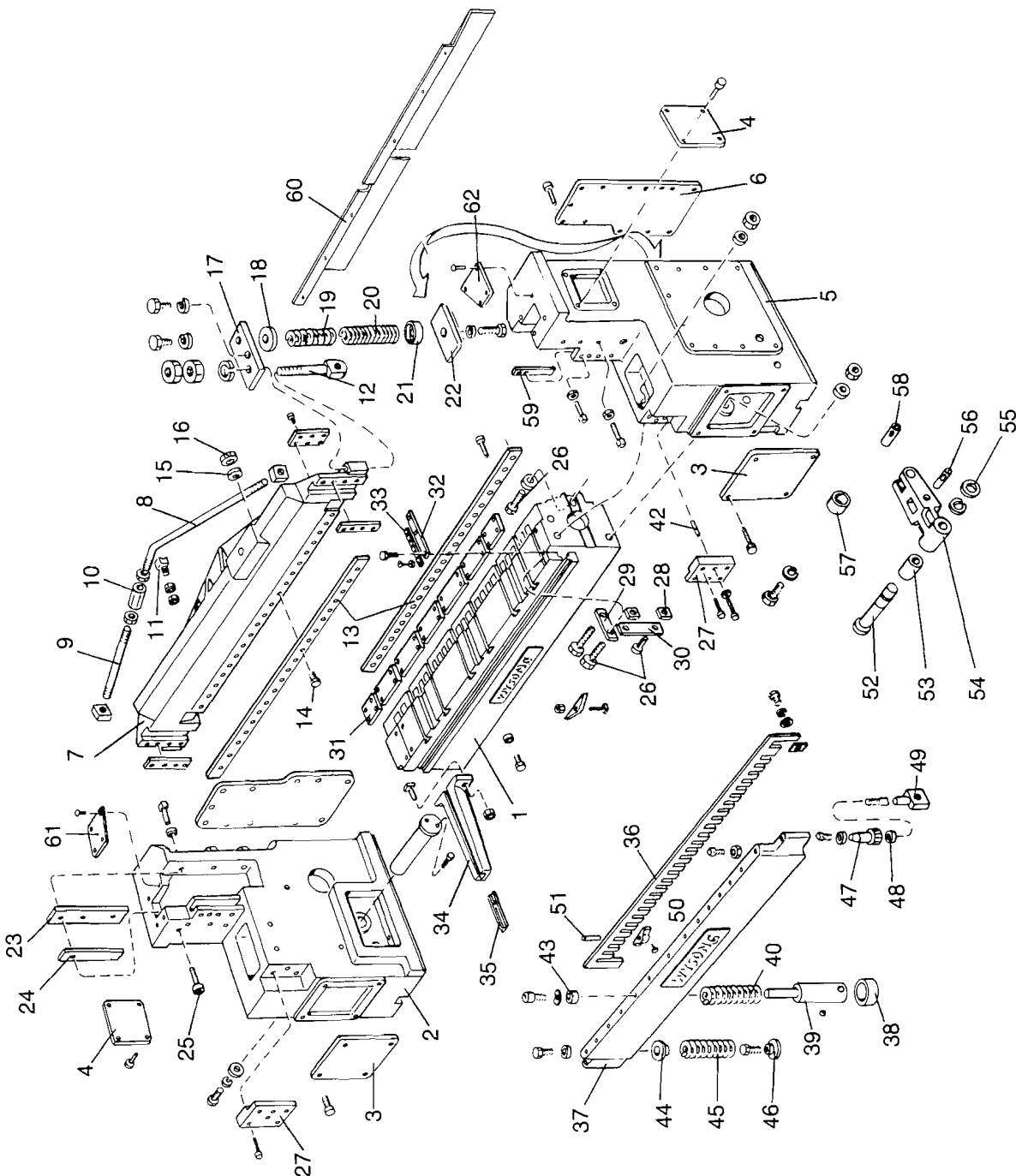
WHEN ORDERING REPLACEMENT PARTS, PLEASE REFER TO YOUR
SHEAR BY MODEL NUMBER AND SERIAL NUMBER..

WYSONG AND MILES COMPANY
4820 U.S. NORTH
POST OFFICE BOX 21168
GREENSBORO, NORTH CAROLINA
27420-1168
FAX: (336) 621-8360
TELEPHONE: (336) 621-3960

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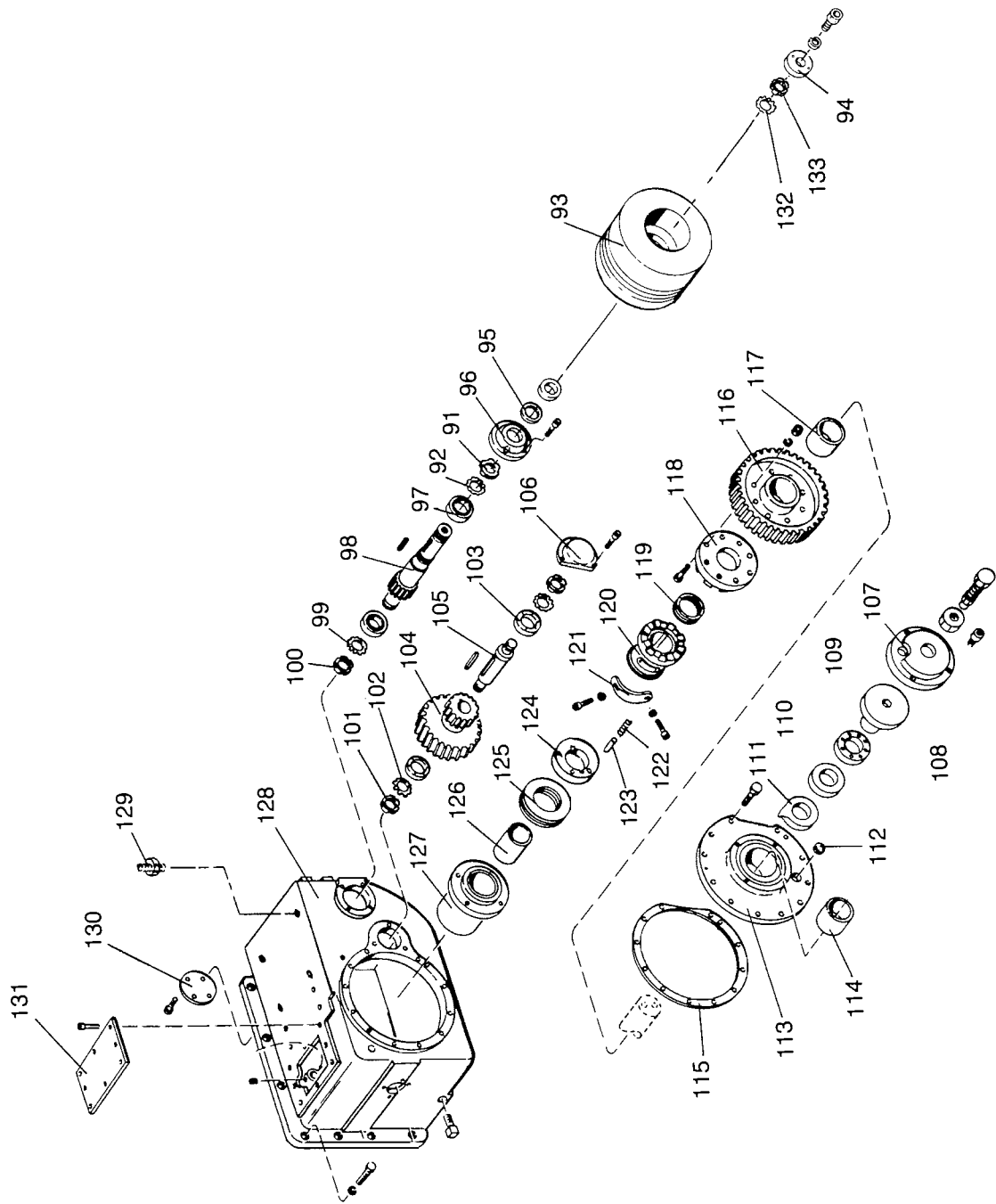
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TABLE, END HOUSING AND KNIFE BAR ASSEMBLY



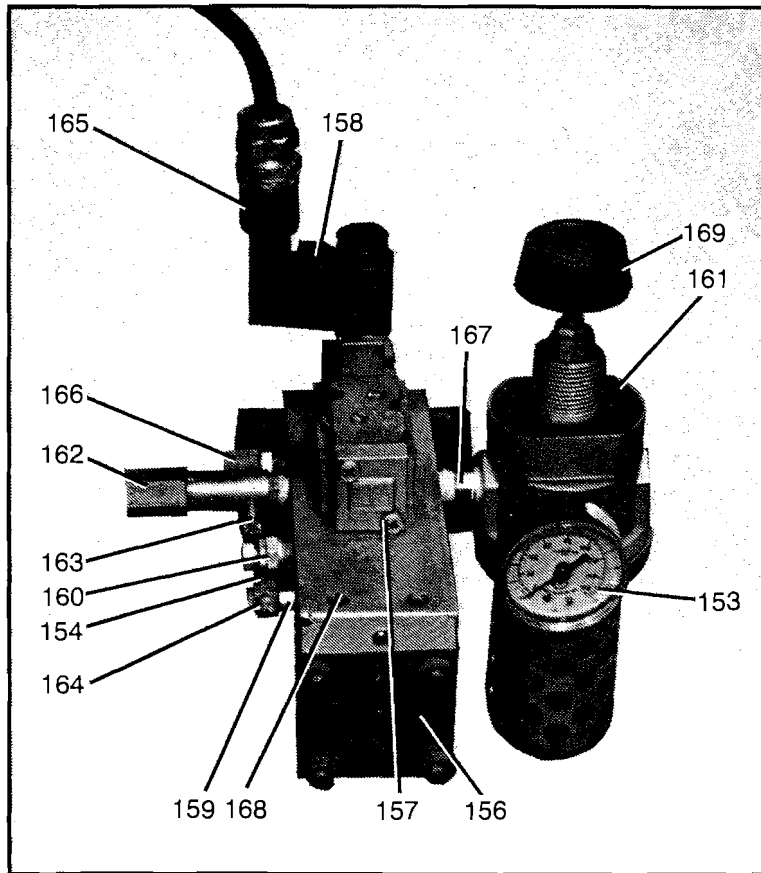
Table, End Housing and Knife Bar Assembly

Item	Description	Item	Description
1	Bed	52	Pin, Holddown Lever
2	Frame, Shear Double L.H.	53	Bearing, Bronze
3	Front Cover	54	Lever, Holddown R.H.
4	Side Cover		Lever, Holddown R.H.
5	Frame, Shear Double R.H.	55	Washer, Lever Pin
6	Cover, End Frame Rear	56	Pin, Cam Roller
7	Ram	57	Roller, Cam
8	Tension Rod	58	Pin, Cam Roller
9	Tension Rod	59	Gib, Holddown Bar
10	Turnbuckle, Tension Rod	60	Plate, Ram
11	Stud, Tension Rod	61	Plate, Oil Pump Adapter, L.H.
12	Eyebolts	62	Plate, Oil Pump Adapter, R.H.
13	Blade		
14	Blade Bolts		
15	Washer, Flat		
16	Nut, Heavy S.F.		
17	Bar, Spring Compression		
18	Seat, Ram Counterbalance Top Spring		
19	Spring		
20	Spring		
21	Seat, Ram Counterbalance Bottom Spring		
22	Seat, Lower Base Spring		
23	Gib, Ram Rear L.H.		
24	Assembly, Knifebar Take Up Gib		
25	Stud		
26	Screw, Hex Hd Cap		
27	Lug, Table Adjusting		
28	Washer, Table Bolt		
29	Plate, Table Bolt Locking		
30	Lock, Table Bolt		
31	Plate		
32	Side Gauge		
33	Scale, Inch-Metric		
34	Extension Table, 48" Range		
35	Disappearing Stop		
36	Finger Guard		
37	Holddown		
38	Holddown Foot		
39	Holddown Pin		
40	Spring, Compression		
41	Spacer, Finger Guard (Not Shown)		
42	Pin, Dowel		
43	Washer, Flat		
44	Seat, Holddown Counterbalance Top Spring		
45	Spring, Compression		
46	Seat, Holddown Counterbalance Lower Spring		
47	Nut, Holddown Locking		
48	Washer, Pull Rod		
49	Rod, Holddown Pull		
50	Guide, Finger Guard		
51	Pin, Finger Guard Guide		



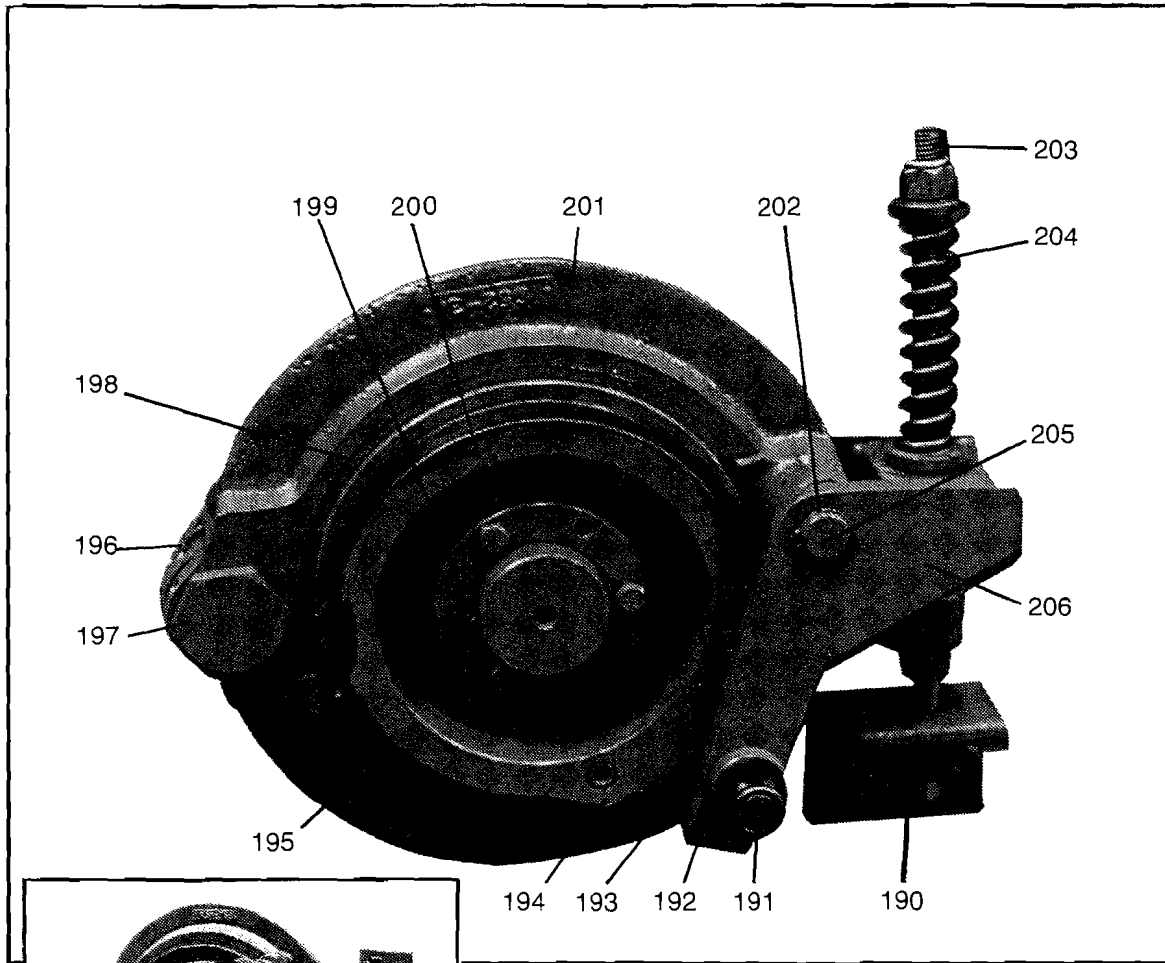
Gear Case Assembly

Item	Description
91	Locknut, Bearing
92	Lockwasher, Bearing
93	Flywheel
94	Retainer, Flywheel
95	Seal, Oil
96	Cap, Bearing Pinion Shaft
97	Bearing, SKF
98	Shaft, Pinion
99	Lockwasher, Bearing
100	Locknut, Bearing
101	Locknut, Bearing
102	Lockwasher, Bearing
103	Bearing, SKF
104	Gear, Intermediate
105	Shaft, Intermediate
106	Cap, Intermediate Shaft Bearing
107	Cover, Housing Indicator
108	Screw, Thrust Bearing Adjusting ($\frac{3}{8}$ " x $\frac{1}{2}$ " Shears)
109	Block, Thrust ($\frac{3}{8}$ " x $\frac{1}{2}$ " Shears)
110	Bearing, Thrust ($\frac{3}{8}$ " x $\frac{1}{2}$ " Shears)
111	Indicator, Topp Center ($\frac{3}{8}$ " x $\frac{1}{2}$ " Shears)
112	Gauge, Oil Level ($\frac{3}{8}$ " x $\frac{1}{2}$ " Shears)
113	Cover, Gear Case
114	Bushing, Bronze
115	Gasket, No. 3 Gear Box Cover
116	Bull Gear
117	Bushing, Bronze
118	Clutch Drive Plate
119	Collar, Bull Gear Spacing
120	Clutch Driven Plate
121	Clutch Release Cam
122	Spring, Compression
123	Stud, Clutch Spring
124	Plate, Clutch Spring Retainer
125	Bearing, Andrews
126	Bearing, Bronze
127	Bearing, Eccentric Shaft
128	Housing, Gear
129	Stud-Moor Base
130	Cover, Gear Case Rear
131	Cover, Hand Hole
132	Lockwasher, Bearing
133	Locknut, Bearing



Electro-Pneumatic Assembly

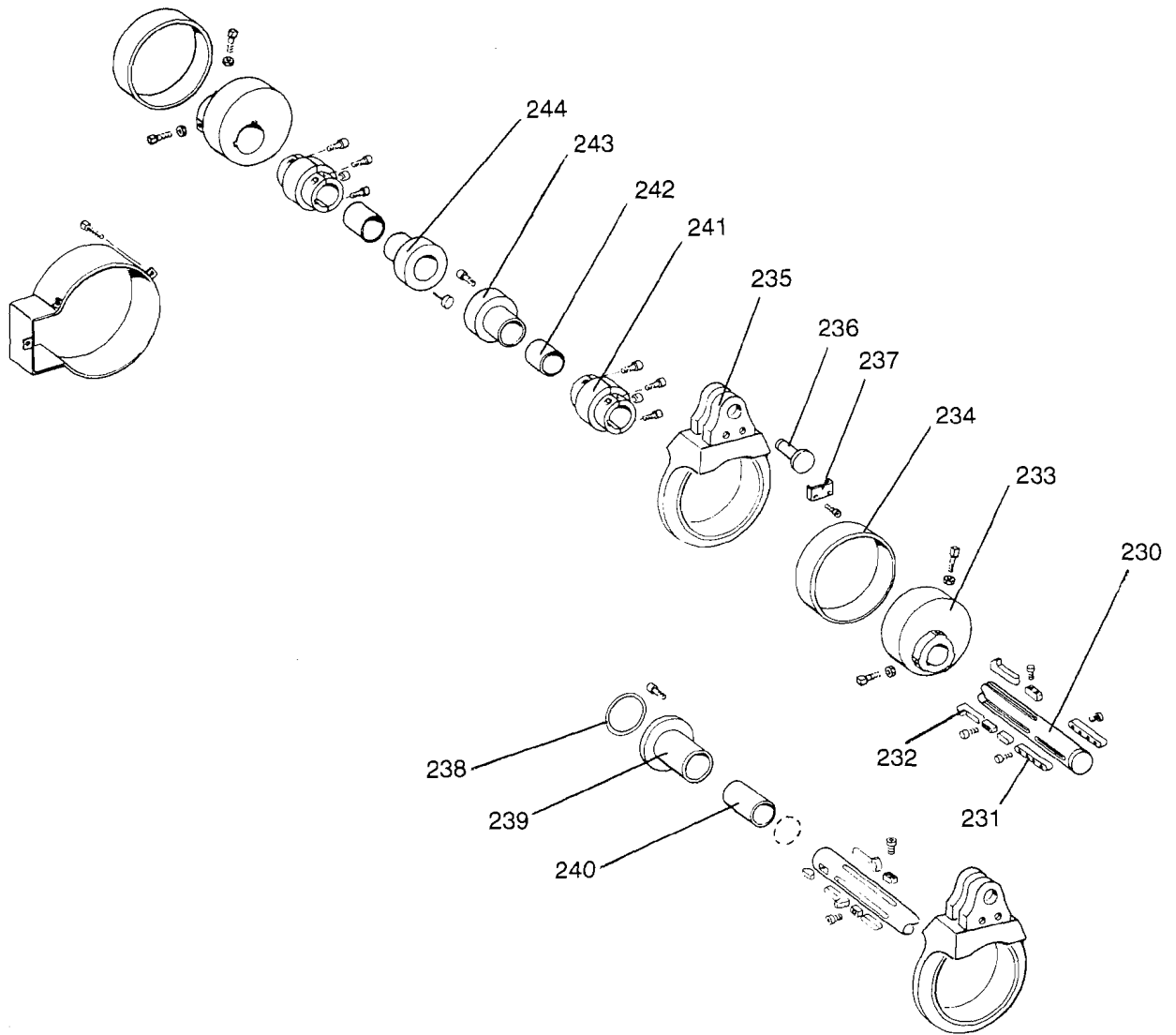
Item	Description
153	Gauge, Pressure
154	Tubing
155	Screw, Socket Head Cap (Not Shown)
156	Cylinder, Air
157	Valve, 3-Way
158	Coil, Ross Valve
159	Valve, Check
160	Valve, Relief
161	Regulator
162	Regulator
163	Connector
164	Elbow
165	Connector
166	Muffler
167	Fitting, Nipple Stainless Steel
168	Manifold
169	Cover, Air Regulator Knob



3/8 and 1/2 Shears

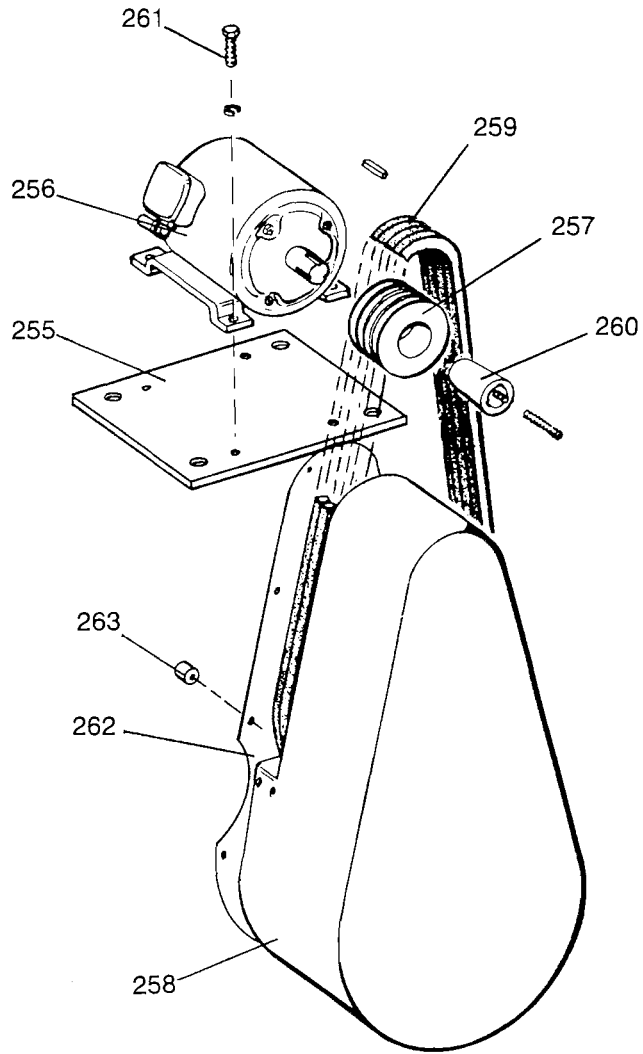
Brake Assembly

Item	Description
	Brake Cover (Not Shown)
190	Stop, Male Brake Shoe
191	Locknut
192	Spacer, Brake Arm
193	Bearing, Cam Follower
194	Brake Cam
195	Shoe, Male Brake
196	Washer, Brake Pivot Stud
197	Stud, Brake Pivot
198	Lining, Brake
199	Collar, Clamping Sleeve
200	Brake Drum
201	Shoe, Female Brake
202	Ring, Waldes External
203	Stud, Spring
204	Spring, Compression
205	Stud, Brake Arm Pivot
206	Brake Arm



Eccentric Shaft Assembly

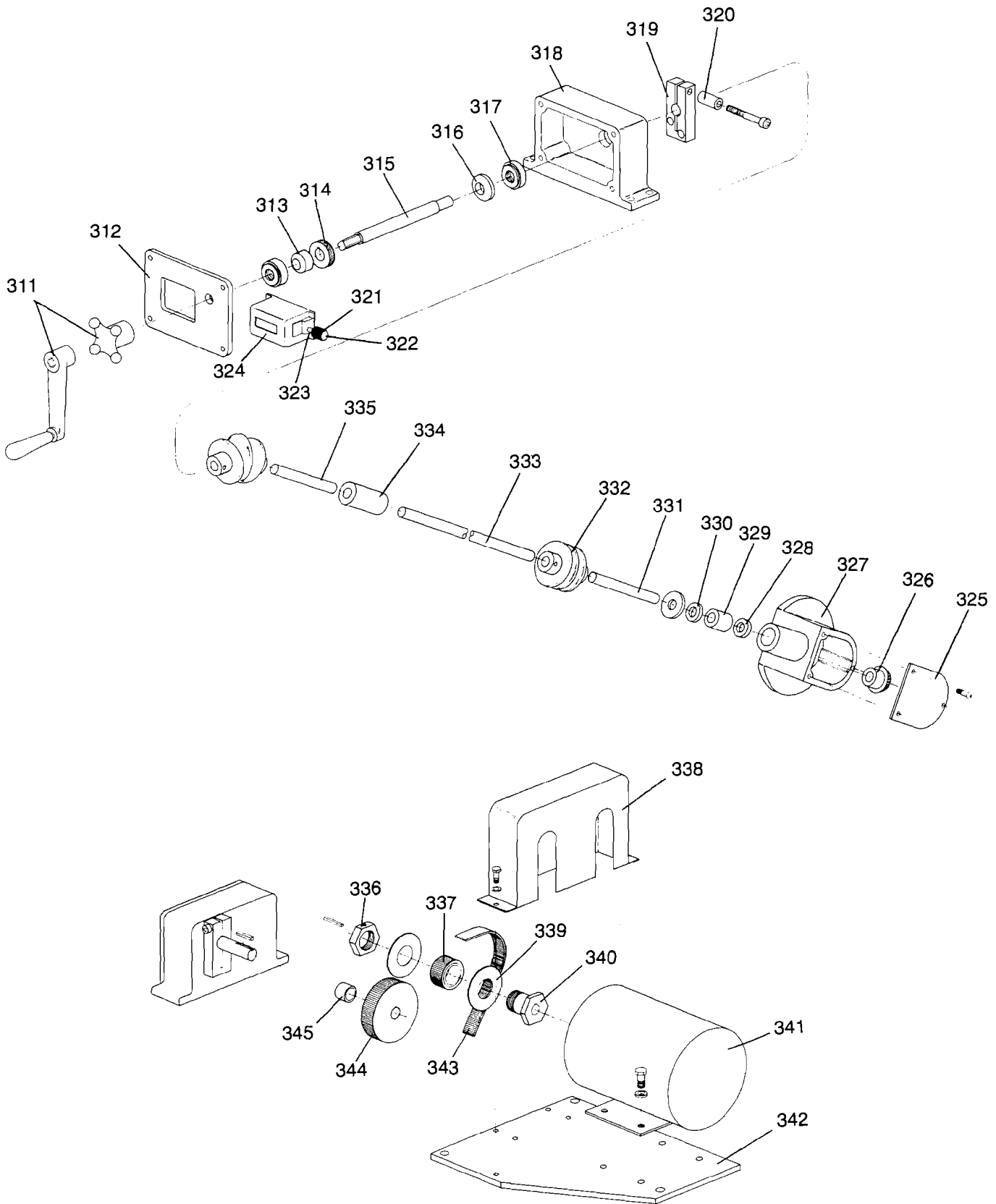
Item	Description
230	Eccentric Shaft
231	Keys, Clutch Driving
232	Eccentric Keys
233	Eccentric
234	Bushing, Bronze
235	Eccentric Strap
236	Pin, Connecting End
237	Plate, Keeper
238	Oil Seal
239	Bearing, Outside Eccentric Shaft L.H.
240	Bushing, Bronze
241	Cam, Holddown
242	Bushing, Bronze
243/244	Bearing, Eccentric Shaft Inside L.H.



Motor Assembly

Item	Description
255	Motor Base
256	Motor - 10 HP
257	Sheave, Woods
258	Belt Guard
259	V-Belt
260	Bushing
261	Stud, Motor Base
262	Plate, Guard Mounting
263	Spacer, Flywheel Guard

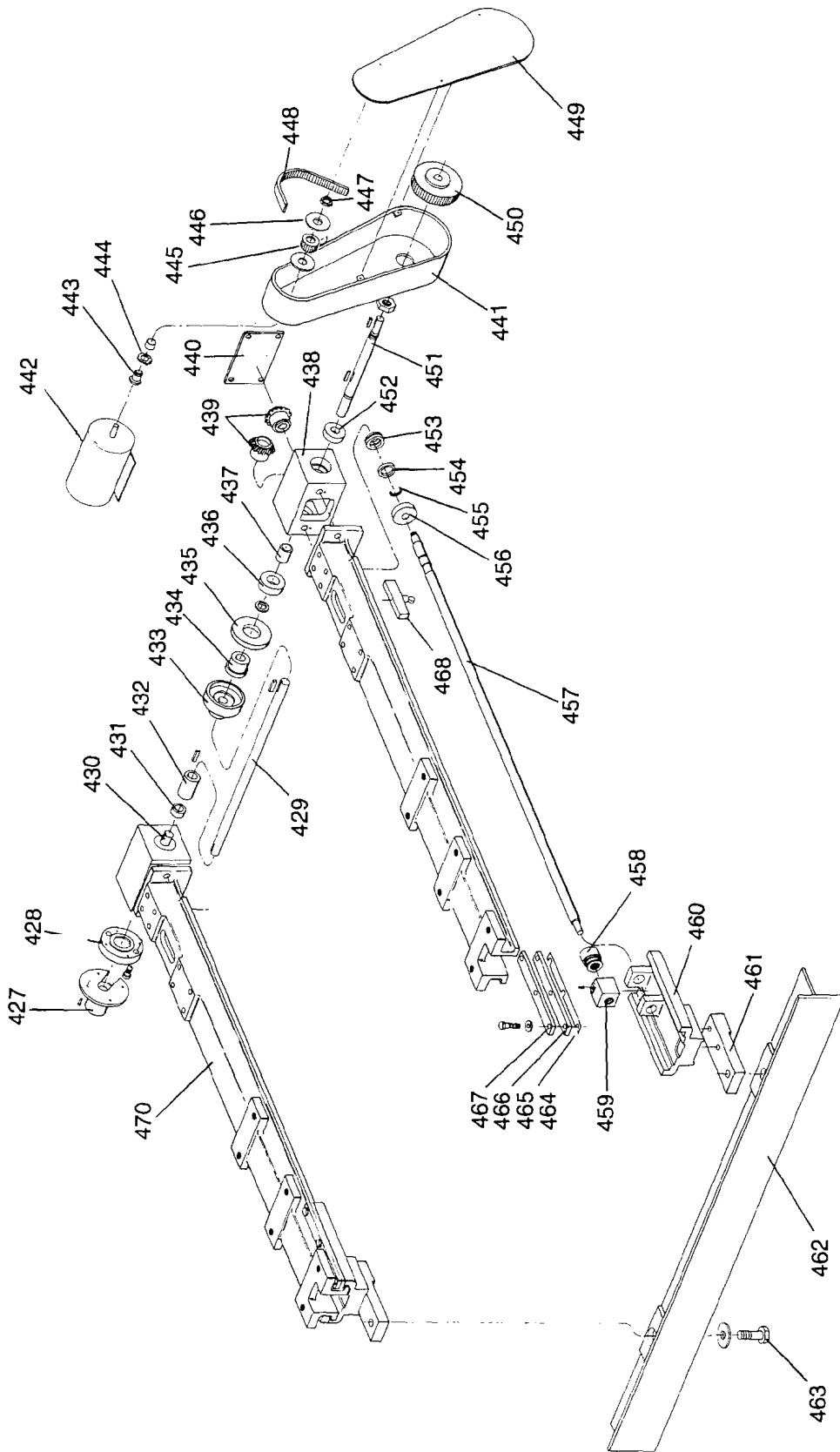
Power/Manual Back Gage



Power/Manual Back Gage

Item	Description
311	Handle
312	Cover, Counter Housing
313	Collar, Set
314	Gear
315	Shaft, Measure Box
316	Spacer, Gear
317	Bearing, Ball
318	Housing, Back Gage Counter
319	Block, Shaft Clamp
320	Spacer, Clamp
321	Gear Helical
322	Jam Nut
323	Collet, Counter Gear
324	Counter
325	Cover, Gear Housing
326	Gear, Miter
327	Miter Gear Housing
328	Bearing, Inner Race
329	Spacer, Bearing
330	Washer
331	Shaft, Miter Gear
332	Universal Joint
333	Shaft, Universal Drive
334	Coupling, Drive Shaft
335	Shaft, Upper Universal Drive
336	Nut, Timing Pulley
337	Pulley, Timing
338	Guard, Timing Pulley
339	Washer, Timing Pulley
340	Hub, Timing Pulley
341	Motor
342	Base B.G. Counter and Motor
343	Belt Timing
344	Pulley, Timing
345	Spacer, Timing Pulley

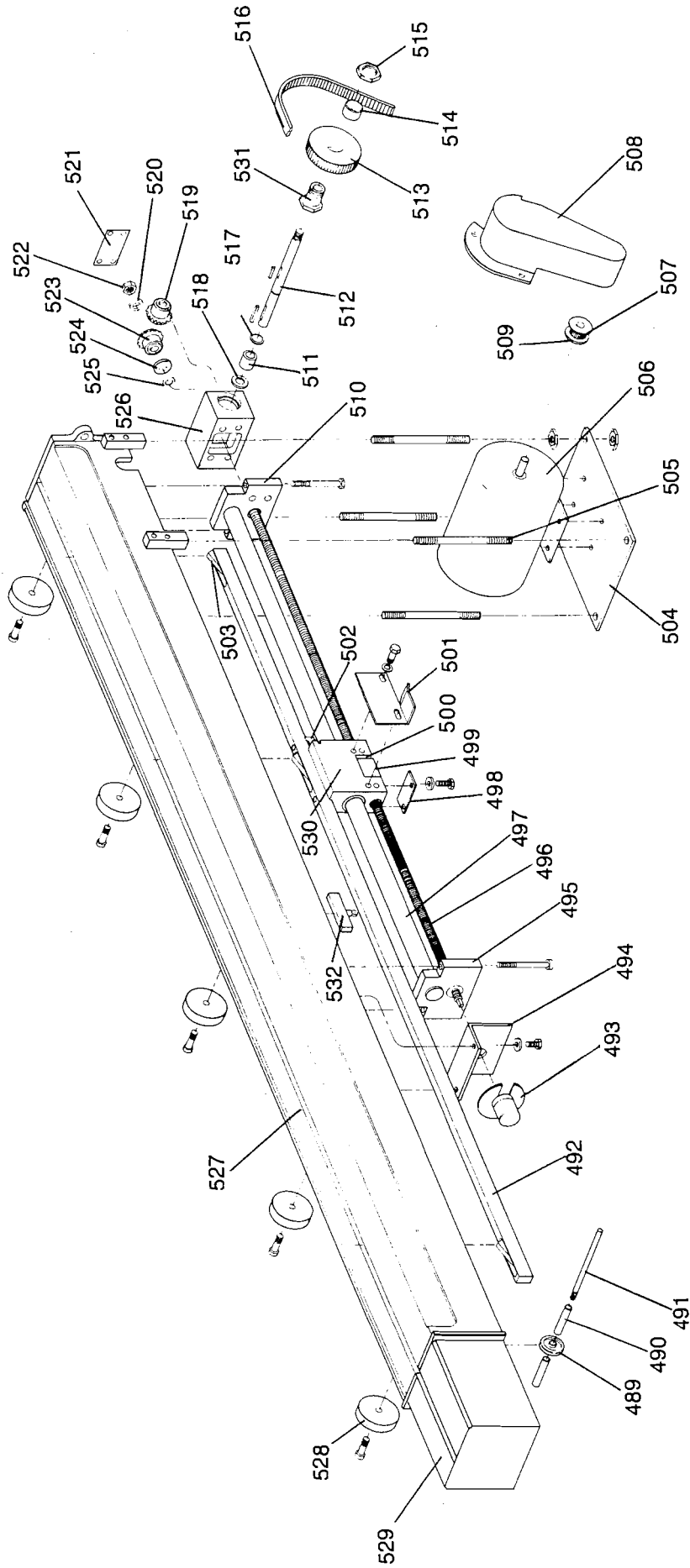
CNC Back Gage



CNC Back Gage

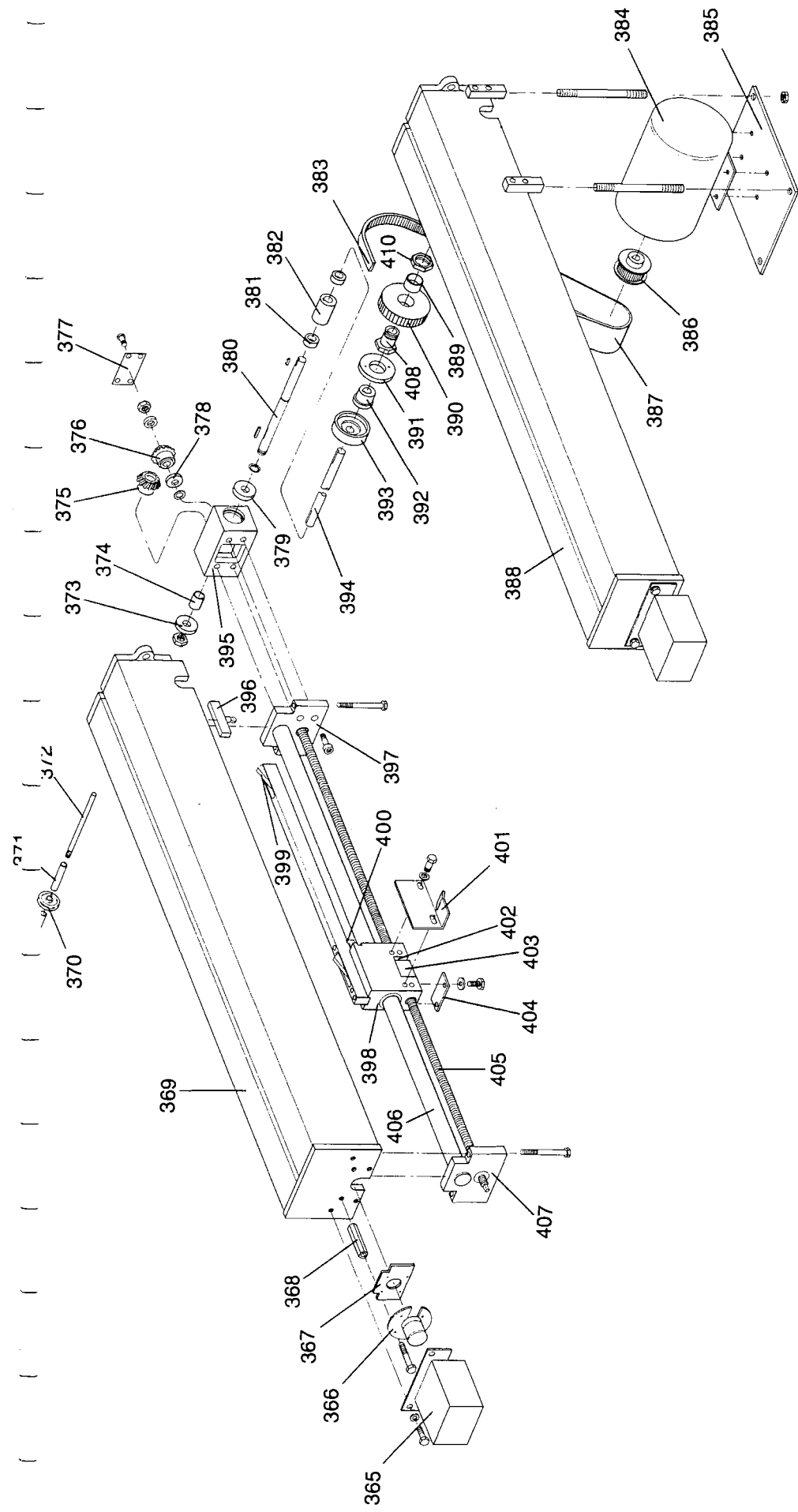
Item	Description
427	Encoder
428	Adapter, Encoder
429	Cover, Cross Shaft (Not Shown)
430	Shaft, Gear, L.H.
431	Collar, Set
432	Coupling, Cross Shaft
433	Shoe, Clutch
434	Drum, Clutch
435	Ring, Locking
436	Bearing
437	Spacer, Miter Gear
438	Housing, Miter Gear
439	Screw, Miter Gear
440	Cover, Miter Gear
441	Guard, Belt
442	Motor
443	Hub, Timing Pulley
444	Washer, Wave
445	Pulley, Timing
446	Washer, Timing Pulley
447	Nut, Timing Pulley
448	Belt, Timing
449	Plate, Belt Guard Front
450	Pulley, Timing
451	Shaft, Gear R.H.
452	Bearing
453	Bearing
454	Spacer
455	Ring, Retaining
456	Washer, Rubber
457	Screw, Slide
458	Driving, Nut (Adjustable)
459	Driving, Nut (Stationary)
460	Slide
461	Extension Back Gage
462	Gage, Back Stop
463	Screw, Shoulder
464	Shim, .005
465	Shim, .003
466	Insert, Delrin
467	Slide, Gib
468	Switch, Proximity
469	Cover, Cross Shaft (Not Shown)
470	Rail, Back Gage

Power Squaring Arm



Power Squaring Arm

Item	Description
489	Skate Wheel
490	Spacer, Skate Wheel
491	Screw, Hex
492	Housing, Dis. Stop
493	Encoder
494	Bracket, Encoder
495	Block, Front Bearing
496	Screw, Front
497	Shaft, Thomson
498	Keeper, Nut
499	Nut, Drive (Stationary)
500	Nut, Drive (Adjustable)
501	Trip, Prox. Switch
502	Clamp, Dis. Stop Housing
503	Stop, Disappearing
504	Base, Front Gage Motor
505	Rod, Drive Support
506	Motor
507	Pulley, Timing Belt
508	Cover, Power Squaring Arm
509	Washer, Timing Pulley
510	Block, Rear Bearing
511	Spacer, Miter Gear
512	Shaft, Miter Gear
513	Pulley, Timing — 36 Tooth
514	Bushing
515	Nut, Timing Pulley
516	Belt, Timing
517	Ring, Retaining
518	Bearing
519	Gear, Miter
520	Spacer
521	Cover, Housing
522	Nut
523	Gear, Miter
524	Bearing
525	Ring, Retaining
526	Housing, Miter Gear
527	Arm, Power Squaring Arm
528	Disk, Side Gage
529	Guard, Dis. Stop Housing
530	Slide
531	Hub, Timing Pulley
532	Switch, Limit



CNC Front Gage

Item	Description
365	Cover, Encoder
366	Encoder
367	Plate, Encoder Mtg.
368	Post, Encoder Mtg.
369	Housing, Front Gage L.H.
370	Wheel, Skate
371	Spacer, Skate Wheel
372	Screw, Hex
373	Bearing
374	Spacer, Miter Gear
375	Gear, Miter
376	Gear, Miter
377	Cover Miter
378	Bearing
379	Bearing
380	Shaft, Miter Gear R.H., C.H.
381	Collar, Set
382	Coupling, Cross Shaft
383	Belt, Timing
384	Motor
385	Base, Front Gage Motor
386	Pulley, Timing
387	Cover, Front Gage Timing Belt
388	Housing, Front Gage R.H.
389	Bushing
390	Pulley, Timing Belt
391	Ring, Locking
392	Drum, Clutch
393	Shoe, Clutch
394	Shaft, Cross
395	Housing, Miter Gear
396	Switch, Proximity
397	Block, Rear Bearing
398	Slide
399	Stop, Front
400	Clamp, Disappearing
401	Trip, Proximity Switch
402	Nut, Driving (Adjusting)
403	Nut, Driving (Stationary)
404	Keeper, Nut
405	Screw, Front Gage
406	Shaft Thomson
407	Block, Front Bearing
408	Hub, Timing Pulley
409	Bushing
410	Nut, Timing
411	Washer, Wave (Not Shown)
412	Cover, Cross Shaft (Not Shown)
413	Shaft, Miter Gear, R.H. (Not Shown)

WARNING

USE OF FOOT CONTROLS ON MACHINERY LACKING EFFECTIVE POINT OF OPERATION SAFEGUARDS CAN CAUSE SERIOUS INJURY TO THE OPERATOR.

Foot controls should only be used where "Point of Operation" and "Pinch Point" guarding devices have been properly installed and are utilized so that it is **IMPOSSIBLE** for the operator's hands or fingers to remain within the point of operation during the machine cycle.

IT IS THE RESPONSIBILITY OF THE USER to determine the suitability of a foot control for the user's intended use and to determine that the foot control chosen by the user and wiring up and installation of the same will comply with all Federal, State and Local safety and health regulations and codes.

Due to the unlimited variety of business equipment, instruments, machines and vehicles on which our foot switches are used, the thousands of standards, and customers' varying interpretations of the standards covering these applications, it is impossible for **LINEMASTER** personnel to be experts on standards and requirements for all these products. We offer over 150 stock foot switch models and guards plus a large variety of specials which are made to customer specifications. We can advise you what is available in our foot switch line and you can examine models to see what meets your needs. We believe our customers' engineering departments should be the qualified experts in their own product field and know what specifications or details they require in a foot switch for their equipment. If one of our stock models meets their needs, they can specify it, or possibly ask for a modification of a stock model if that is required.

SHOULD YOU HAVE ANY QUESTIONS OR IF ANY OF THE ABOVE WARNING IS UNCLEAR, PLEASE CALL LINEMASTER SWITCH CORPORATION.

(860) 974-1000; FAX (860) 974-0691 OR (800) 974-3668.

READ INSTRUCTIONS on reverse side of this page.

DEFINITIONS:

POINT OF OPERATION - The point or area of the machine or equipment where the work piece or material is actually positioned and work is being performed during any process such as cutting, shearing, punching, forming, welding, riveting, assembling, etc..

PINCH POINT - Any point at which it is possible for a portion of the body to be caught and injured between moving machine or equipment or work piece parts.

HEAVY DUTY ANTI-TRIP FOOT SWITCH

1. **⚠ WARNING: TO AVOID PERSONAL INJURY, DO NOT USE THIS SWITCH ON MACHINERY WITH AN UNGUARDED POINT OF OPERATION.**

⚠ READ WARNING STATEMENT on reverse side of this page.

2. When wiring up this device make sure **POWER IS OFF AND LINES ARE DEAD.**
3. This device is for use in ordinary locations, TYPE 2, 4 and 13 and intended to be permanently connected by means of conduit, flexible cord or other system in accordance with the **NATIONAL ELECTRICAL CODE.**
When wiring up this device with flexible cord an **UNDERWRITERS LABORATORIES LISTED** liquidtight connector **MUST BE** provided. Use appropriate pipe thread sealant at assembly to seal connector threads. When threading into the conduit opening, **CARE** must be taken to tighten the threaded joint sufficiently to prevent loosening but should **NOT BE FORCED.** The conduit threads should be kept clean; free from dirt and foreign materials that would hinder proper installation.
4. **MODELS 511-B & 511-B3** are supplied with non-adjustable actuating mechanism. Factory set to operate approximately 3/4 treadle stroke.
5. **MODELS 511-B2 & 511-B4** are supplied with right interior switch with non-adjustable actuating mechanism. Left interior switch with an adjustable actuating mechanism, set at factory to operate as Double-Pole Double-Throw.

SPECIAL NOTE:

In many applications it is highly desirable to wire the Normally Closed Circuit to the adjustable left switch and the Normally Open Circuit to the non-adjustable right switch. In such a case the 511-B2 can then be adjusted to have the Normally Closed Circuit remake near the top of the treadle release stroke. **EXAMPLE:** This means that in a press control circuit, the operator must go through a substantial portion of the treadle release stroke before he can reset the control circuit for another operation.

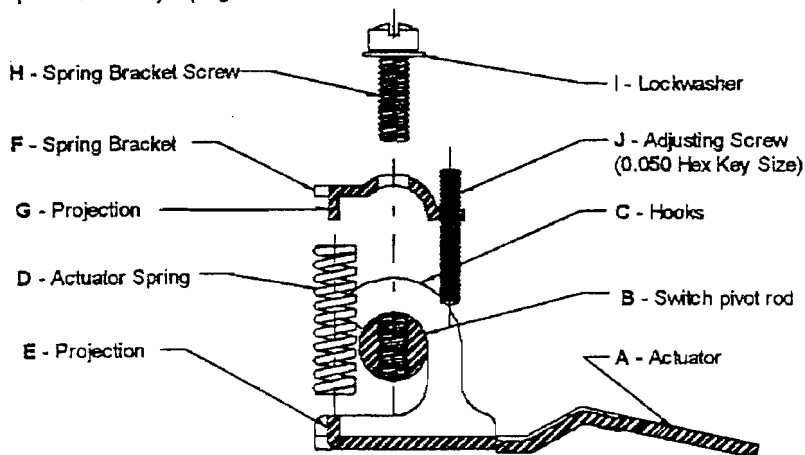
6. **TO CHANGE ADJUSTMENT** of the operating point of the left interior switch, depress the treadle to the point where you want the switch to operate. With the treadle depressed to the desired operating point, turn the adjusting screw until the switch snaps.

Turn clockwise to lower the operating point and counter-clockwise to raise it.

Apply Loctite Corporation Threadlocker Adhesive #290 (or equivalent) penetrating low-viscosity anaerobic liquid adhesive to adjusting screw "J" after changing adjustment.

Avoid applying an excessive amount of the liquid adhesive to prevent migration.

Remove excess liquid adhesive by wiping.



7. Tighten the cover screws such that an effective seal is obtained with the gasket. Tighten to 30 to 35 in—lb. (3.4 to 4.0 Nm); two tightenings required.
8. **CLEANLINESS** must be observed during installation and in use.

On a **REGULAR BASIS**, lubricate the treadle pivot rod with one or two drops of lubricating oil on that portion of the pivot rod that extends between the outside of the base and inside of the treadle; two places.

On a **REGULAR BASIS**, inspect foot switch frequently to guard against wear, damage, unlawful alterations or removal of guards, or for unusual enclosure deterioration and the like. Inspect the entire length of the connecting cord (or wiring system) from where it enters the foot switch to the equipment its wired up to for wear, loose strain relief connections and the like. **DO NOT OPERATE** the foot switch if any of the above is observed or if the nameplate or warning labels have been obscured or removed.

It is **IMPERATIVE** that inspection authorities and users exercise more than ordinary care with regard to installation and maintenance and that this information sheet be made available to the end user, operators, maintenance personnel and to others responsible for the proper installation and safe operation of this foot switch.

ADDITIONAL COPIES of this information sheet and warning labels are available upon request.

Form 534-W6 Rev. G