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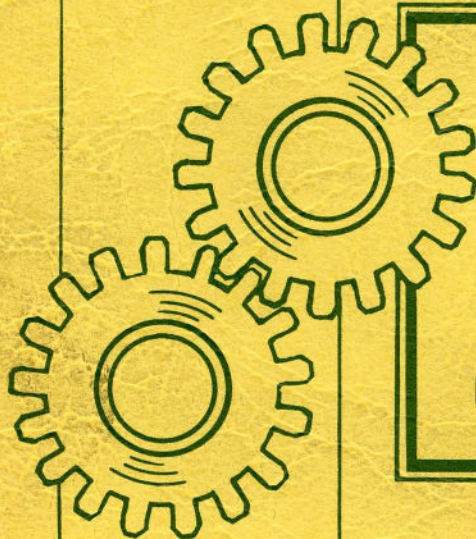
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**PARTS LIST
AND
ILLUSTRATIONS**



**MODEL NO.
1025**

POWER SQUARING SHEAR

WYSONG & MILES COMPANY

P. O. Box 21168 • Highway 29 North • Phone (919) 621-3960

GREENSBORO, NORTH CAROLINA 27420

WYSONG AND MILES COMPANY

P.O. BOX 21168

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TELEPHONE : (919) 621-3960

PARTS LIST AND ILLUSTRATIONS FOR 1025 WYSONG POWER
SQUARING SHEAR

When ordering parts, please refer to the item number, quantity, name of part, part number and serial number of the machine. The serial number will be found stenciled on the table outside the RH side gauge.

Nov. 1977

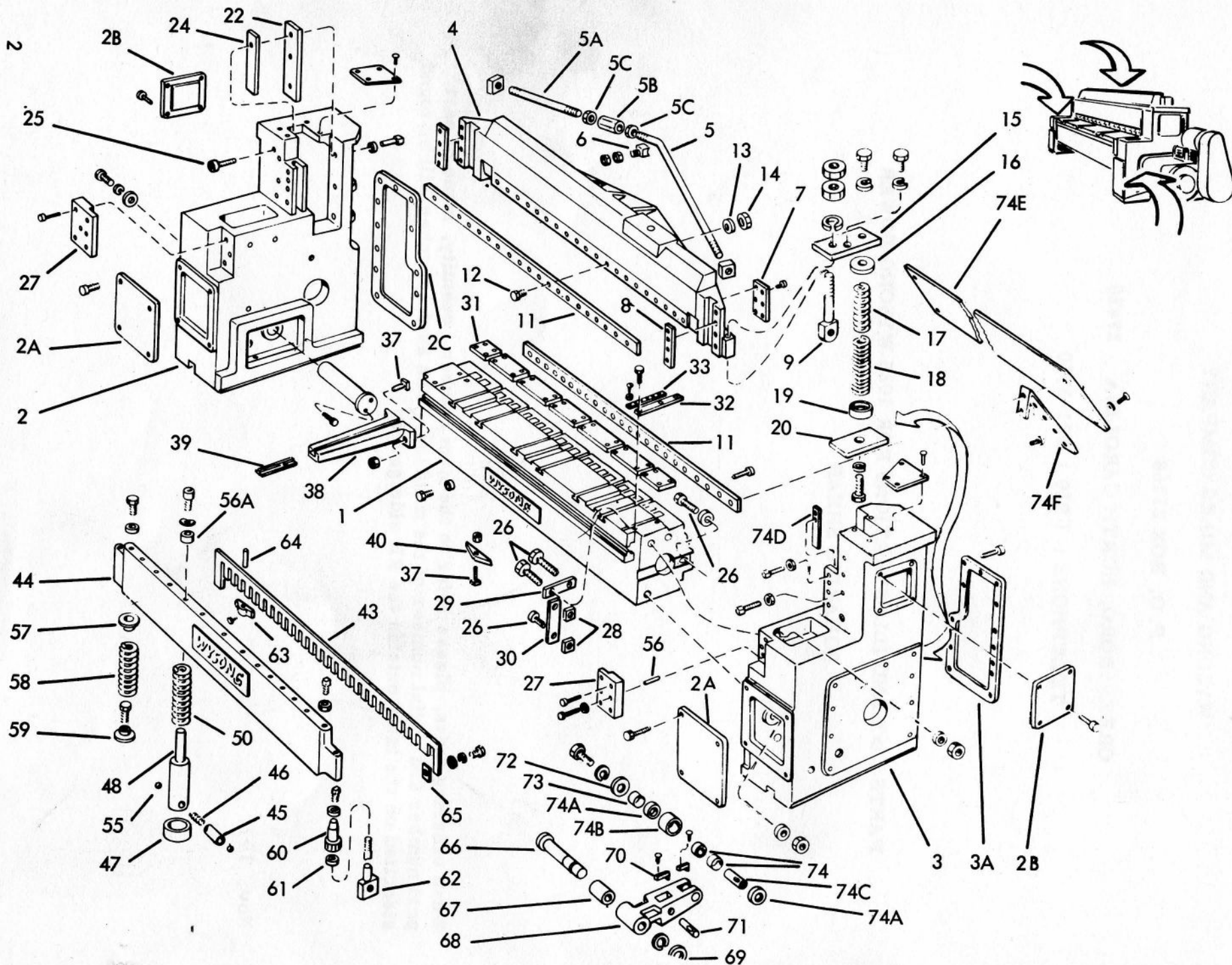


FIG. 1 TABLE - END HOUSINGS - HOLD DOWN - KNIFE BAR ASSEMBLY

1025 WYSONG POWER SHEAR

TABLE, END HOUSING, HOLDDOWN & KNIFE BAR ASSEMBLIES
(See Figure 1)

<u>ITEM</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
1	1	Table	S25-76
2	1	LH End Housing	S25-75
2A	2	Front Cover	S10S-257
2B	2	Side Cover	S10S-258
2C	1	LH Rear Cover	S30S-55
3	1	RH End	S25-74
3A	1	RH Rear Cover	S30S-55
3B	2	Top Cover (End Housings)	S25S-164
4	1	Knife Bar	7071-191
5	1	Tension Rod - Long	S25S-169
5A	1	Tension Rod - Short	S25S-170
5B	1	Tension Rod Turnbuckle	8GS-133
5C	2	Tension Rod Nuts	3323-035
6	1	Tension Rod Stud	8GS-36
9	2	Eyebolt	S10S-192
9A	2	Knife Bar Washer	S25S-181
* 9B	2	Jam Nuts, 2-4-1/2	3320-015
9C	2	Whole Nuts, 2-4-1/2 Hvy, S.F. Hex. Nuts	3319-018
11	2	Blades, 124" x 4" x 1"	4720-686
12	32	Blade Bolts (3/4 x 4)	3342-032
13	32	Blade Bolt Washers	3328-155
14	32	Blade Bolt Nuts	3319-008
15	2	Spring Compression Bars	S10S-183
16	2	Top Spring Seat	7N-31
17	2	Inside Counterbalance Spring (B-68)	3504-6602
18	2	Outside Counterbalance Spring (B-68)	3504-770
19	2	Bottom Spring Seat	7N-30
20	2	Lower Spring Seat Base	S10S-32
22	2	Rear Knife Bar Gib w/7041-182 Micarta	7371-015
24	2	Knife Bar Take Up Gib w/7041-143 Micarta	7371-007
25	2	Knife Bar Take Up Gib Stud	7471-120
26	2	Table Bolt 1" - 8 x 7"	3308-140
26A	6	Table Bolt 1"-8 x 6"	3308-137
27	2	Table Adjusting Lug	7K-69
28	8	Table Bolt Washer	S10S-213
28A	8	Table Washer	8FS-084
29	2	Table Bolt Locking Plate (Short)	S25S-263
30	2	Table Bolt Locking Plate (Long)	S25S-281
31	2	Table End Plate	S10S-65
31A	2	Table Plate 1/4" x 6" x 13-1/4"	7471-089
31B	3	Table Plate 1/4" x 6" x 15-1/4"	7471-088
31C	2	Table Plate 1/4" x 6" x 23-1/4"	7471-087
32	2	Side Gauge	SGS-18
33	3	Table Scale	2201-003
33A	6	Scale Locking Button	7KS-036
37	4	T-Bolt w/Nut & Washer	3342-443
38	2	Table Extension	7067-167
39	2	Disappearing Stop	6385-011
40	1	Bevel Gauge (Optional)	S10S-553

1025 WYSONG POWER SHEAR

TABLE, END HOUSING, HOLDDOWN & KNIFE BAR ASSEMBLIES
(See Figure 1)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>NAME OF PART</u>
40A	1	T-Bolt w/Nut & Washer	3342-443
43	1	Finger Guard	S25S-166
44	1	Holddown	7271-088
44A	1	Holddown Cap Guard	7471-002
* 44B	1	Barrier Guard	6291-004
47	16	Holddown Foot	7474-034
* 47A	16	Holddown Feet w/4544-279, Neoprene Inserts (Opt.)	7374-015
48	16	Holddown Pin	7471-103
48A	16	" O " Ring, Parker 327	3255-174
50	16	Holddown Pressure Springs (B-95)	3504-498
56	2	Dowel Pin	8GS-108
56A	16	Holddown Foot Washer	3328-201
57	2	Top Spring Seat	S10S-173
58	2	Holddown Return Spring (B-96)	3504-564
59	2	Lower Spring Seat	S10S-172
60	2	Holddown Locking Nut	7271-067
61	2	Holddown Pull Rod Washer	8GS-19
62	2	Holddown Pull Rod	S10S-174
63	3	Finger Guard Guide	S10-54
64	3	Finger Guard Guide Pin	8HS-115
65	2	Finger Guard Spacer Blocks	S25S-173
66	2	Holddown Lever Pin	S25S-133
66A	2	Holddown Lever Pin Washer	8GS-23
66B	1	Holddown Lever Pin Bevel Washer LH	8GS-173
66C	1	" O " Rings, (RH Side)	3255-301
67	2	Holddown Lever Pin Bushing	3134-230
68	2	Holddown Lever	7071-185
69	2	Holddown Lever Pin Washer	8GS-23
70	4	3/8- 16 x 3/4 Socket Set Screw	3306-096
70A	2	1/2 x 4 Roll Pin	3329-063
74	2	Cam Roller	3108-018
74A	2	Cam Roller Pin	7174-284
74D	2	Holddown Gib	S10S-40
74E	1	Ramp Plate	7211-079

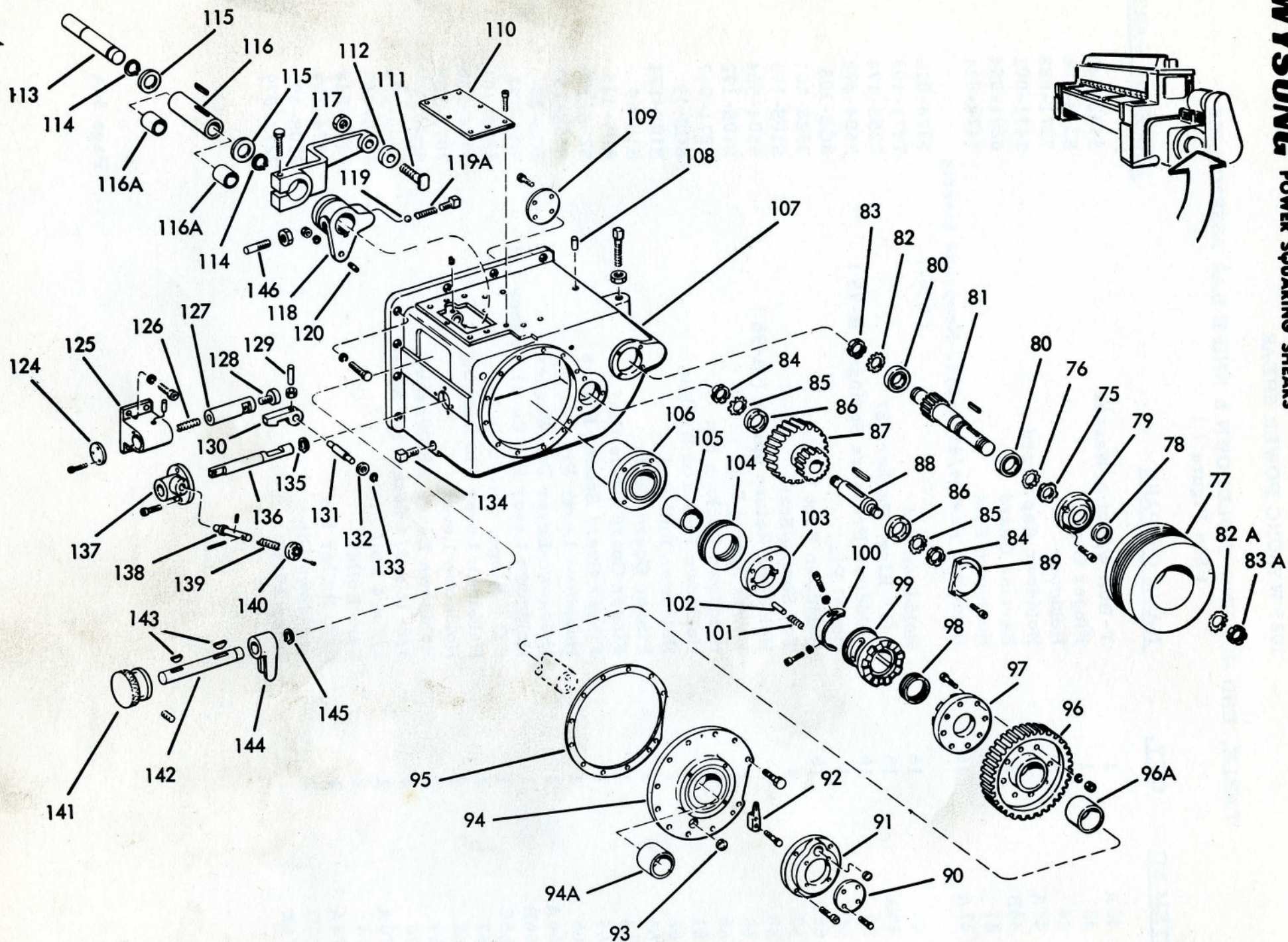


FIG. 2 GEAR CASE ASSEMBLY

1025 WYSONG POWER SHEAR

GEAR CASE ASSEMBLY

(See Figure 2)

<u>ITEM NO.</u>	<u>QTY</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
75	1	Lock Nut (N-11)	3346-012
76	1	Lock Washer (W-11)	3344-012
77	1	Flywheel	7071-182
77A	1	Flywheel Key	S10S-363
77B	1	Flywheel Retainer	7074-174
78	1	Pinion Shaft Seal (60810)	3211-029
79	1	Pinion Shaft Bearing Cap	S10-7
80	2	Pinion Shaft Bearings (SKF-22311)	3166-201
81	1	Pinion Shaft	S25S-177
82	1	Lock Washer (W-11)	3344-011
82A	1	Lock Washer (W-09)	3344-010
83	1	Lock Nut (N-11)	3346-012
83A	1	Lock Nut (N-09)	3346-010
84	2	Lock Nut (N-09)	3346-010
85	2	Lock Washer (W-09)	3344-010
86	2	Intermediate Shaft Bearings (SKF-22309)	3166-199
87	1	Intermediate Gear	S25S-178
88	1	Intermediate Shaft	S10S-6
88A	1	Intermediate Shaft Spacer	S10S-7
89	1	Intermediate Shaft Bearing Cap	S10-8
90	1	Housing Indicator Cover	8G-105
91	1	Top Center Indicator Housing	8G-41
91A	1	Indicator Cover	8GS-172
91B	1	Indicator Cover Retaining Ring	8GS-103
92	1	Top Center Indicator	8G-42
93	1	Oil Level Gauge (B-5592)	3249-026
94	1	Gear Case Cover	S10-6
94A	1	Gear Case Cover Bushing (S10-16)	3134-535
95	1	Gear Case Cover Gasket (S10S-268)	4904-095
96	1	Bull Gear	S10S-1
96A	1	Bull Gear Bushing (S10-17)	3134-540
97	1	Clutch Drive Plate	S10S-150
98	1	Bull Gear Spacing Collar	S10S-141
99	1	Clutch Driven Plate	S10S-179
100	1	Clutch Release Cam (8HS-116)	6091-061
101	4	Clutch Springs (B-65)	3504-160
102	4	Clutch Spring Stud	S38S-118
103	1	Non-Repeat Cam	S10-81
104	1	Thrust Bearing (Aetne G-47)	3103-047
105	1	Eccentric Shaft Bearing Bushing RH (7N-34B)	3134-525
106	1	Eccentric Shaft Bearing, Outside, RH	S10-14
107	1	Gear Case	S10-5
108	1	Air Vent	3202-020
109	1	Gear Case Rear Cover	S10-68
110	1	Gear Case Hand Cover	8HS-129
111	1	Non-Repeat Roller Stud	S52S-103
112	1	Non-Repeat Arm Roller	7KS-41
113	1	Non-Repeat Arm Pivot Shaft	8HS-46

1025 WYSONG POWER SHEAR

GEAR CASE ASSEMBLY

(See Figure 2)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
114	2	Truarc Lock Rings (5100-100)	3351-032
115	1	Sleeve Retaining Collar	8HS-45
115A	1	Sleeve Retaining Collar	8HS-88
116	1	Non-Repeat Arm Sleeve	8HS-44
	1	Non-Repeat Arm Sleeve Key 1/4 x 1/4 x 2	7HS-793
116A	2	Non-Repeat Arm Sleeve Bushing (8H-22)	3134-035
117	1	Non-Repeat Arm	8H-23
118	1	Non-Repeat Pawl Lifting Lever	8H-20
119	1	Steel Ball	1/2"
119 A	1	Non-Repeat Slide Spring (B-37)	3504-028
120	1	Pawl Striking Stud	8HS-48
124	1	Clutch Bracket Spring Cap	8H-18
125	1	Clutch Bracket	8H-30
126	1	Cam Slide Spring (B-89)	3504-098
127	1	Cam Retracting Slide	S10S-245
128	1	Cam Follower (S10S-246)	3107-105
129	1	Pawl Lifting Pin	8HS-41
130	1	Non-Repeat Pawl	8HS-40
131	1	Pawl Slide Pin	8HS-37
132	1	Pawl Retaining Collar	8FS-046
133	1	Truarc Lock Ring (5100-62)	3351-022
134	1	Drain Plug(Magnetic)	3837-006
135	1	Truarc Lock Ring (5100-100)	3351-032
136	1	Pawl Engaging Plinger (Foot Treadle)	8HS-42
	1	Pawl Engaging Plunger Stop Collar	8HS-88
137	1	Pawl Engaging Plunger Guide	7K-154
138	1	Lock Pin	7KS-96
139	1	Truarc Lock Spring (B-58)	3504-078
140	1	Pin Guide	7KS-97
141	1	Non-Repeat Shifting Knob	8HS-52
142	1	Shifting Arm Shaft	8HS-47
142A	1	"O" Ring	3255-053
143	2	Woodruff Key (# 15)	3301-025
144	1	Lifting Lever Shifting Arm	8H-21
	1	Shifting Arm Thrust Collar	8HS-51
145	1	Truarc Lock Ring (5100-100)	3351-032
146	1	Lifting Lever Shifting Stud	8HS-49

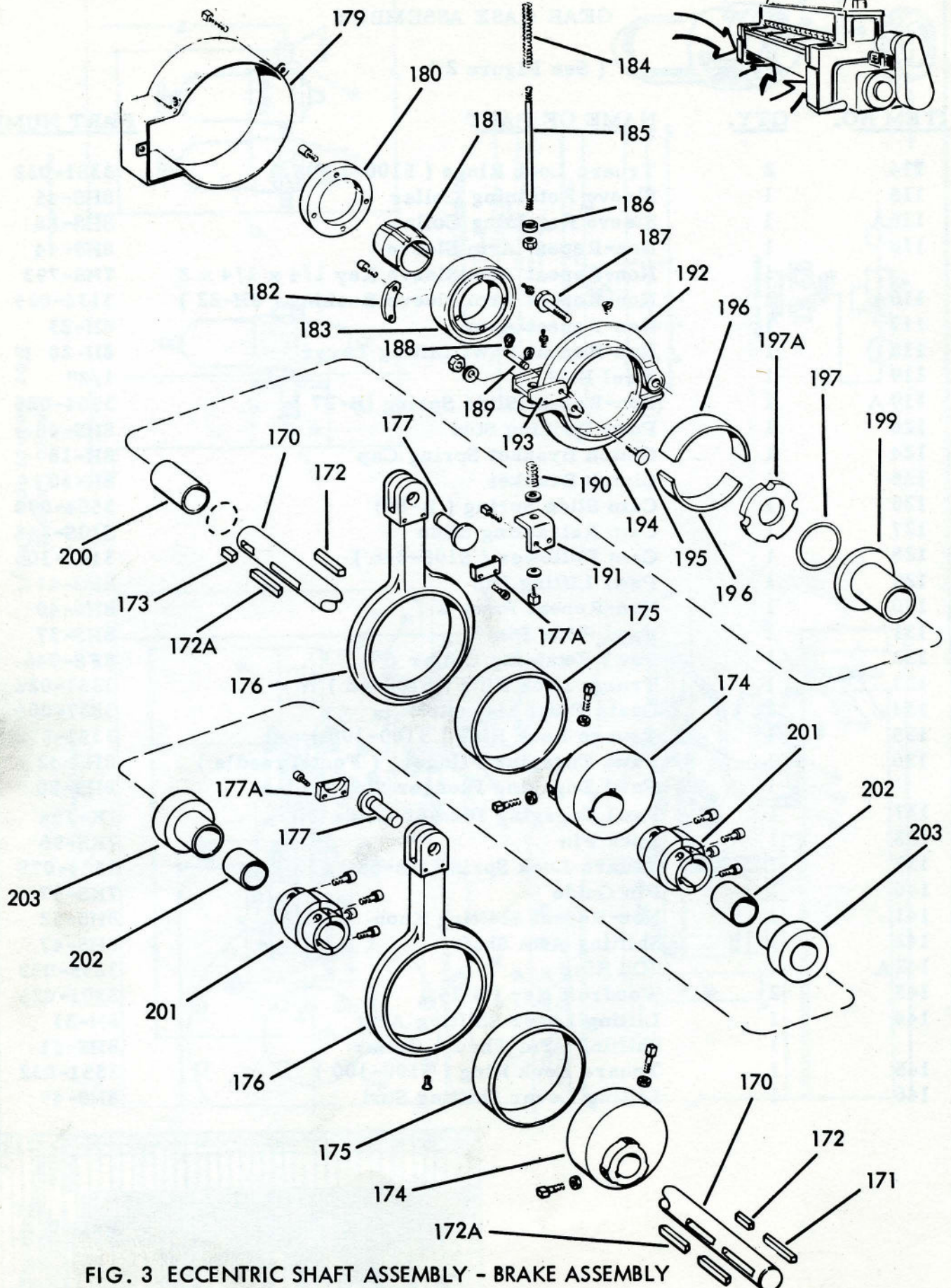


FIG. 3 ECCENTRIC SHAFT ASSEMBLY - BRAKE ASSEMBLY

ECCENTRIC SHAFT AND BRAKE ASSEMBLIES FOR 1025 SHEAR
(See Figure 3)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
170	1	Eccentric Shaft	S25S-165
171	2	Clutch Driving Key	8HS-32
172	2	Eccentric Key	8GS-61
172A	2	Eccentric and Holddown Cam Key	8GS-96
173	1	Clamping Sleeve Key	S12S-97
174	2	Eccentric	S7-2
175	2	Eccentric Strap Bushing	3134-665
176	2	Eccentric Strap	S10-75
177	2	Connection End Pin	S10S-171
177A	2	Keeper Plate	S10-83
179	1	Brake Cover	4506-500
180	1	Clamping Sleeve Collar	S10S-70
181	1	Brake Drum Clamping Sleeve	S10S-67
182	1	Brake Cam	S10S-68
183	1	Brake Drum	S10-40
184	1	Brake Spring (B-21)	3504-290
185	1	Spring Stud	S10S-76
*185A	3	Lock Nuts (5/8-11)	3324-028
186	1	Spring Stud Washer	8HS-102
*186 A	1	Blade Washer	S10S-208
187	1	Brake Pivot Stud	S10S-69
*187A	1	Brake Pivot Stud Washer	S10S-73
187B	1	Lock Nut, 3/4-10	3324-014
188	2	Lock Rings (5100-87)	3351-029
189	1	Brake Arm Pivot Stud	S10S-75
190	1	Spring (B-2)	3504-320
191	1	Male Brake Shoe Stop	8HS-104
191A	1	Square Head Set Screw	
191B	1	Jam Nut	
192	1	Female Brake Shoe	S10-41
193	1	Brake Arm	S10S-72
*193A	1	Brake Arm Spacer	S10S-91
194	1	Male Brake Shoe	S10-42
195	1	Cam Follower (CF-1-3/4)	3107-012
*195A	1	Lock Nut (3/4-16)	3324-030
196	2	Brake Lining (1/4 x 2 x 13-1/2)	4540-020
197	1	Oil Seal (61121)	3211-075
197A	1	Brake Thrust Washer	S10S-71
199	1	Eccentric Shaft Bearing Outside, LH	S10-15
200	1	Eccentric Shaft Bearing Bushing	3134-510
201	2	Holddown Cams	S25-49
201A	8	Holddown Cam Screws w/ Brass Inserts (7/16 x 1-1/2)	3356-152
202	2	Eccentric Shaft Bearing Bushings Inside LH & RH	3134-515
203	2	Eccentric Shaft Bearings, Inside, LH & RH	S10-31

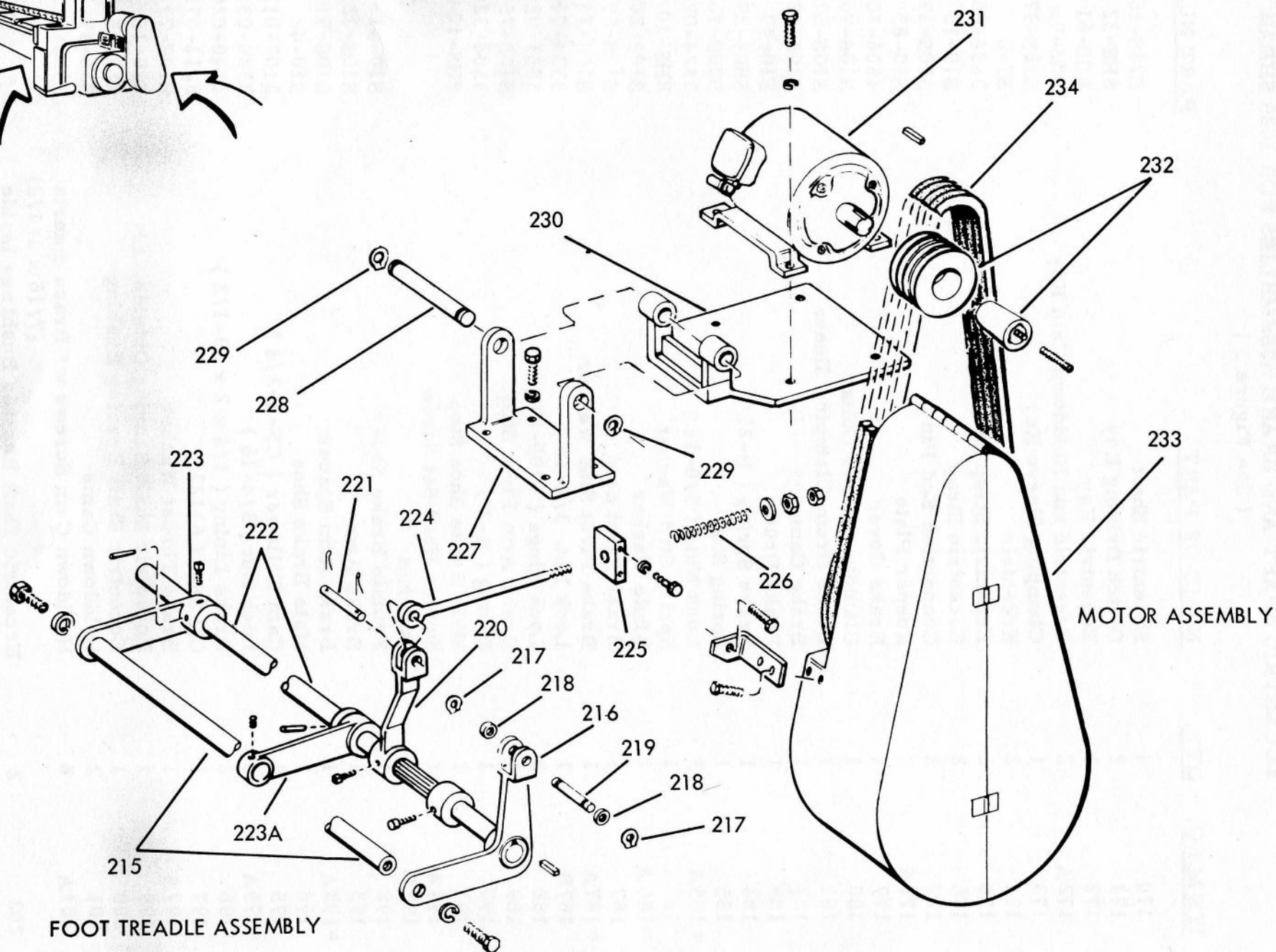
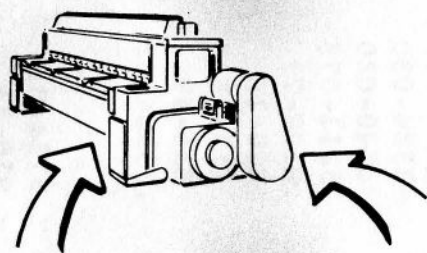


FIG. 4 FOOT TREADLE / EMBLY - MOTOR ASSEMBLY

1025 WYSONG POWER SHEAR

FOOT TREADLE AND MOTOR ASSEMBLIES

(See Figure 4)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
215	1	Foot Treadle	8HS-61
216	1	Clutch Pawl Lever	8H-24
217	2	Truarc Lock Rings (5100-62)	3351-022
218	1	Spring Lever Pin Washer	8HS-59
219	1	Pawl Lever Pin	8HS- 56
220	1	Foot Treadle Spring Lever	8HS-25
221	1	Spring Lever Pin	8HS-58
222	1	Foot Treadle Shaft	8HS-62
223	1	Foot Treadle Lever	7K-73
223A	1	Foot Treadle Arm	8G-18
224	1	Treadle Spring Eyebolt	8GS-97
225	1	Treadle Spring Guide Bracket	8HS-57
226	1	Treadle Spring (B-28)	3504-222
227	1	Motor Base Bracket	7271-072
228	1	Motor Base Bracket Pivot Shaft	7QS-19
229	2	Truarc Lock Rings (5100-100)	3351-032
230	1	Motor Base	7271-101
230	4	Motor Base Sruuds	7274-064
231	1	15 HP., 1800 RPM, Motor (254T Frame)	4226-014
232	1	Motor Pulley - 3-Groove	3407-015
* 232A	1	Bushing 2517 x 1-5/8	3401-024
233	1	Belt Guard	7471-113
234	3	V-Belts (B-90)	3418-067
	1	Back Plate for Belt Guard	7471-114
	3	Spacers for Belt Guard	7471-095
	1	Spring Washer	8HS-60
	3	Foot Treadle Key	S12S-97
	2	1-1/2 Set Collar	3302-025

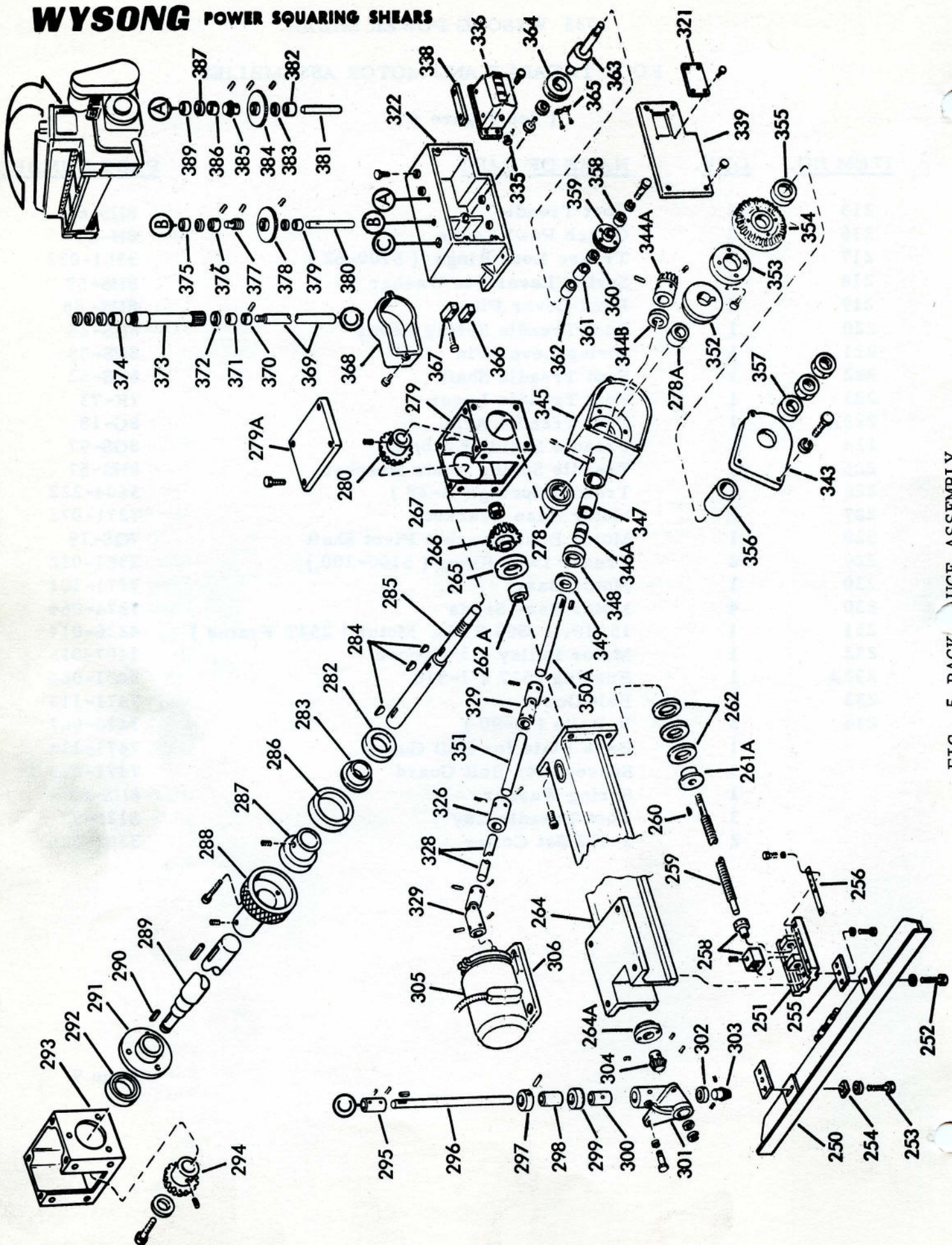


FIG. 5 BACKAUGE ASSEMBLY

RUN-CREEP POWER OPERATED BACK GAUGE ASSEMBLY (36" RANGE) FOR 1025
SHEAR

(See Figure 5)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
250	1	Back Stop Angle	6267-043
251	2	Slide	7H-457
252	1	Back Gauge Stud	7HS-266
253	1	Back Gauge Stud	7HS-266
253A	2	Back Gauge Stop Washer	7HS-261
254	1	Rail Bushing	7HS-269
255	2	Slide Extension	7HS-703
256	4	Slide Gib w/7041-109 Micarta Insert	7HS-606
258	2 ea.	Driving Nut	7H-252 & 7H-253
259	2	Slide Screw	BGS-65
260	2	Woodruff Key	
261A	2	Screw Spacing Collar	7HS-249
262	2	Thrust Bearings (Aetna G-18)	3103-018
262A	2	Bearing Spacer	7HS-248
264	2	Rail	7H-290
264A	2	Screw Bushings	7H-286
265	2	Bearing 6208-2RS	3178-185
266	2	Gauge Screw Miter Gears (L-115-Y)	7HS-257
267	2	Nuts (1/2" - 20 Castle)	3321-210
278	1	Bearing (6206-2RS)	3178-275
278A	1	Spacer	BGS-58
279	1	RH Gear Housing	BG-62
279A	2	Gear Housing Cover	7HS-805
280	1	Horizontal Miter Gear (L-115-Y)	7HS-256
282	1	Bearing (6208-2RS)	3178-185
283	1	Bearing Spacer	7HS-577
284	3	Woodruff Key 3/8 x 1	
285	1	Horizontal Drive Shaft, Short	BGS-66
286	1	Locking Ring w/ Screws	6067-525
287	1	Clutch Drum (Inside)	7HS-807
288	1	Clutch Shoe (Outside)	7H-261
289	1	Horizontal Drive Shaft, Long	7HS-279
290	1	Key	
291	1	LH Gear Housing Cover	7H-257
292	1	Bearing (6205-2RS)	3178-274
293	1	LH Gear Housing	7H-256
294	1	Horizontal Miter Gear (L-105-Y)	BGS-61
295	1	Coupling	BGS-85
296	1	Miter Gear Shaft	BGS-36
297	1	Collar	BGS-33
298	2	Bearings, B-1014-8	3120-179
299	Not Required		
300	1	Sleeve	BGS-12
301	1	Front Drive Housing	BG-40
301A	1	Bearing, B1014-8	3120-179
302	1	Thrust Bearing (Aetna F-1)	3102-001

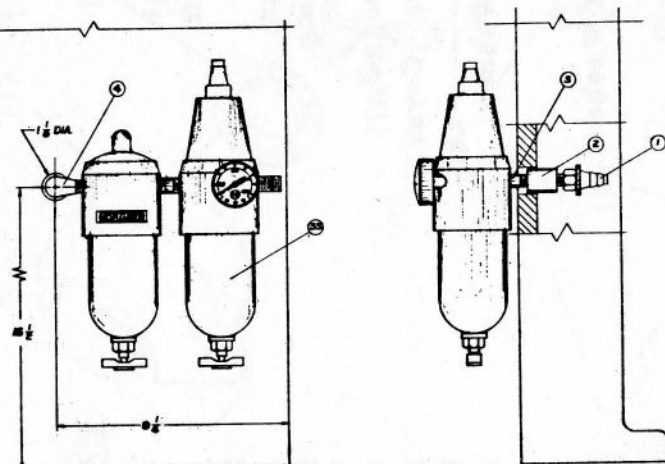
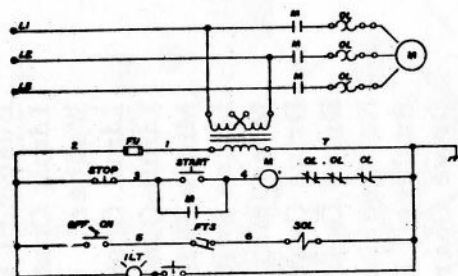
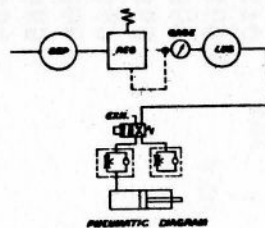
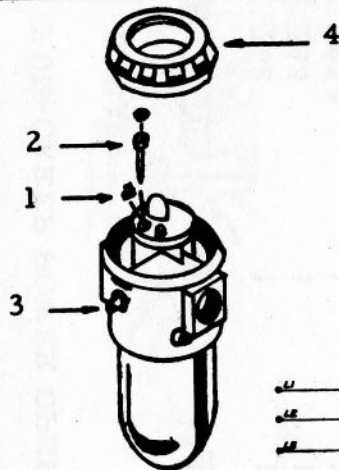
<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
303	1	Screw Miter Gear (L101-Y)	3436-167
304	1	Miter Gear (L-101-Y)	BGS-57
305	1	1/2 HP, Dinabrake Run-Creep Motor, Frame U56	4250-004
306	1	Motor Base	BG-61
321	1	Measuring Box Dial Cover	7HS-332
322	1	Measuring Box	BG-32
326		Not Required	
328		Not Required	
328A	1	Morse 14L100 Timing Sprocket, Type 6F 3/8" bore (BGS-371)	3415-012
328B	1	Morse 285L100 Timing Belt	3413-010
328C	1	Support Bearing Block Rod	BG-212
328D	1	Bearing Block	BGS-210
328E	1	Morse TL28L100 Timing Sprocket, Type 3F	3415-015
328F	1	Morse TL1610 Tpaer Lock Bushing, 5/8" bore	3401-009
328G	1	Water Pump Bearing (ND 88P158D)	3132-051
328H	1	Belt Cover	BGS-209
329	2	Universal Joint (Upper)	BGS-358
		(Lower)	BGS-359
335	1	Miter Gear (G465-Y)	3436-151
336	1	Veeder Root Unit (V-113023)	2201-201
338	1	Counter Clamping Plate	BGS-79
338A	1	Clamping Plate Cushion	7416-032
339	1	Measuring Box Cover	BG-33
343	1	Gear Box Cover	BG-10
344A	1	Pinion (Globe B1020-3)	BGS-34
344B	1	Thrust Washer	BGS-49
345	1	Gear Box	BG-19
346A	1	Sleeve	BGS-28
347	2	Bearing (B1616)	3110-112
348	2	Needle Bearing (IR1216)	3112-109
349	1	Washer	BGS-49
350A	1	Bevel Pinion Shaft	BGS-35
351	1	Universal Drive Shaft	BGS-262
352	1	Plate	BG-7
353	1	Washer	4540-461
354	1	Bevel Gear	BG-73
355	1	Thrust Washer	BGS-30
356	1	Spacer	BGS-59
357	1	Thrust Washer	BGS-30
358	1	Washer	BGS-46
359	1	Worm Gear	3436-205
360		Not Required	
361	1	Bushing (B-812- 4)	3120-125

RUN-CREEP POWER OPERATED BACK GAUGE ASSEMBLY (36"RANGE) FOR 1025

SHEAR

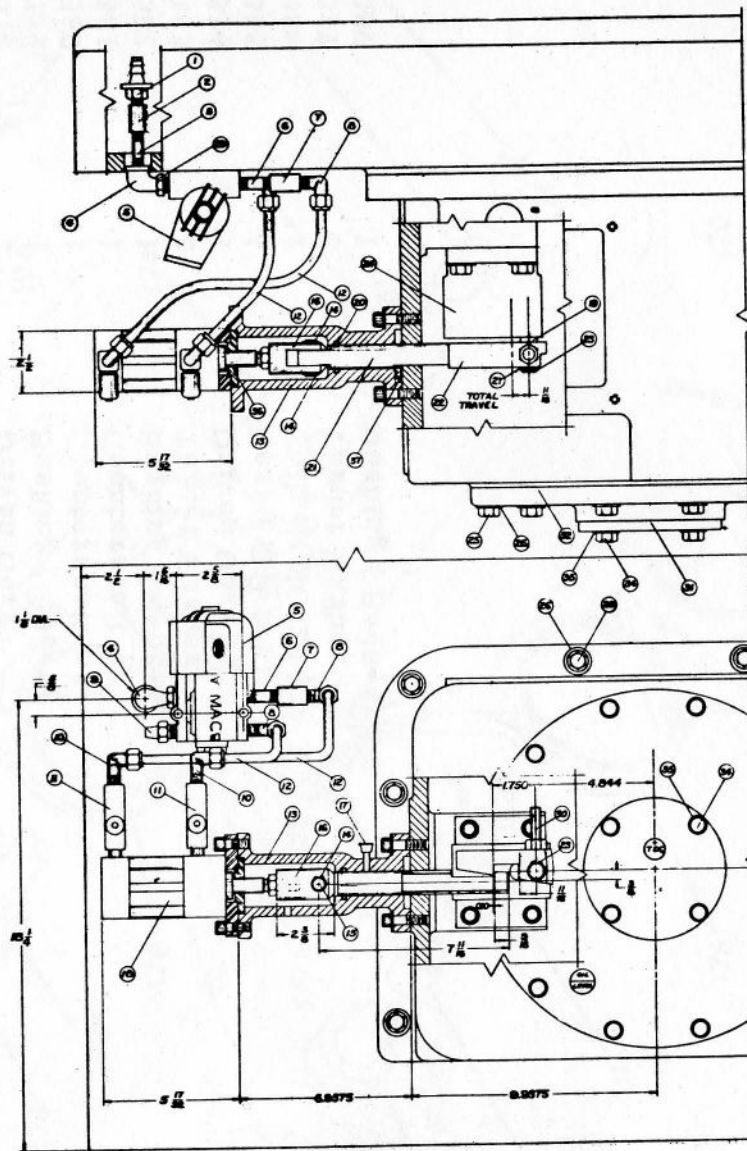
(See Figure 5)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
362	1	Bushing (B-812-4)	3120-125
363	1	Limit Control Shaft	BGS-80
363A	1	Washer	BGS-042
364	2	Limit Control Drum	BGS-386
365	2	Limit Control Spring	BGS-45
366	1	Micro Switch	WZ-2R-A2
367	1	Micro Switch (DT-2R-A7)	WZ-2R-A2
368	1	Measuring Box Rear Cover	BG-34
369	1	Drive Gear Shaft	BGS-130
369A	1	Drive Gear Shaft Washer	BGS-43
370		Not Required	
371	1	Bushing (B-1013-4)	3120-167
372	1	Drive Gear Thrust Washer	BGS-38
373	1	Drive Gear	BGS-77
374	1	Bushing (B-1418-6)	3120-251
375	1	Bushing (B-48-4)	3120-036
376	1	Collar (SC-25)	3302-007
377	1	Worm, (Boston HULH)	3436-213
378	1	Driven Gear	BG-28
379	1	Bushing (B48-4)	3120-036
380	1	Countershaft	BGS-78
381	1	Countershaft	BGS-78
382	1	Bushing (B-48-4)	3120-036
383	2	Thrust Washer	BGS-81
834	1	Driven Gear	BG-28
385	1	Gear (G46 5 Y)	3436-151
386	1	Collar (SC-25)	3302-007
387	2	Thrust Washer	BG-81
389	1	Bushing (B-48-4)	3120-036



VIEW OF L.H. AND R.H. FRAMES

Basic Layout
For Reference Only!



VIEW OF R.H. END FRAME

37	GUIDE, PIVOT	1
36	SPACER	1
35	3/8 MEDIUM LOCK WASHER	8
34	3/8-16 X 1 1/2 HEX HD CAP SCREW	4
33	PL. WEL. LUB. UNIT	1
32	COVER-GEAR CASE	1
31	COVER-HOUSING INDICATOR	1
30	PIVOT LIFTING STUD	1
29	3/8 X 3/4 BUSHING	1
28	1/2-13 X 2 HEX HD CAP SCREW	7
27	PIVOT RETAINING COLLAR	1
26	1/2 MEDIUM LOCK WASHER	18
25	1/2-13 X 1 1/2 HEX HD CAP SCREW	18
24	CLUTCH BRACKET	1
23	WALDES RING 5000-62	1
22	NON-REPEAT PIVOT	1
21	PIVOT ENGAGING PLUNGER	1
20	PARKER O-RING 224	1
19	PIVOT SLIDE PIN	1
18	AIR CYLINDER 5" BORE 1" STROKE	1
17	STYLE B OIL HOLE COVER	1
16	CLAVIS, AIR CYLINDER	1
15	ENGAGING PLUNGER PIN	1
14	WALDES RING 5000-60	2
13	CYLINDER BRACKET	1
12	3/8 COPPER TUBING	CTL
11	FLOW CONTROL VALVES 3/8	2
10	BRASS ELLS 3/4 PIPE 3/4 FLAIR	2
9	1/2-13 X 1 1/2 TIE MUFFLER	1
8	BRASS ELLS 3/4 PIPE 3/4 FLAIR	2
7	COUPLING, 3/8	1
6	WIPPLE, 3/8	1
5	VALVE, SOL. INTC 3/8 BORE 1-1/2	1
4	ELL, STREET 3/4	2
3	WIPPLE, 3/8	2
2	COUPLING, 3/8	2
1	FITTING, 3/8 PUSH LOC	2

WYSONG			
THE LAYOUT OF ELECTRO-PNEUMATIC CLUTCH TRIP			
REV.	DATE	BY	CHKD.
1	10-10-75	W. J. H.	W. J. H.
WYSONG, INC.			

MODEL 1025 WYSONG SHEAR
ELECTRO-PNEUMATIC CONTROL
PARTS LIST & INSTRUCTIONS

(See Figure 6)

<u>ITEM NO.</u>	<u>QTY.</u>	<u>NAME OF PART</u>	<u>PART NUMBER</u>
20	1	"O" Ring, Parker # 214	3255-104
18	1	Air Cylinder	3742-001
11	2	Valve, Flow Control	3759-002
37	1	Guide, Pawl	8G-047
13	1	Bracket, Cylinder	8G-054
21	1	Plunger, Pawl Engaging	8GS-128
15	1	Pin, Engaging Plunger	8GS-130
16	1	Clevis, Air Cylinder	8GS-174
36	1	Spacer, Electro-Pneumatic	8GS-180
5	1	Valve, 4-Way	3752-020
9	1	Muffler, Exhaust 3/8"	3774-003
33	1	Filter/Regulator/Lubricator	3772-002

FITTINGS

2	Push Lok 30628-6-6B	3813-003
2	Nipple, Close 1/4 Galvanized	3835-002
2	Push Lok 2103-4-6 Adapter	3875-036
4	Push Lok 30182-6-6B	3805-004
1	Elbow, 3/8" Galvanized	3833-005
3	Street Elbow, 3/8" Galvanized	3833-006
1	Nipple, 3/8"x 2" Galvanized	3835-049
	Hose, 3/8 Push Lok 801-6	3802-002

ELECTRO-PNEUMATIC CONTROL OPERATING INSTRUCTIONS

When Electro-Pneumatic Foot Switch is used, the Foot Treadle and Linkage is replaced by an air cylinder controlled by a solenoid operated 4-way Valve and Electric Foot Switch. An On/Off Switch in the Push Button Station replaced the Treadle Lock. The Single Stroke/Continuous Stroke Selector on the gear case remains the same.

TO OPERATE THE SHEAR:

1. Depress the " Start" Pushbutton and wait briefly for the flywheel to come up to speed.
2. Locate the gauging at the desired position.
3. Set the stroke mode, Single or Continuous, on the gear case.
4. Turn the Off-On Selector Switch to "On" position.
5. Depressing the Foot Switch will now cycle the shear.

CONSTANT DENSITY LUBRICATION

Maximum recommended operating pressure and temperature for transparent bowls are 250 PSI at 120 degrees Fahrenheit ambient, 200 PSI at 160 degrees Fahrenheit ambient, or 100 PSI at 175 degrees Fahrenheit ambient.

This is a constant density Lubricator, setting the oil density adjusting screw with 1/16" Allen wrench at a given air flow determines the density of oil in the air. Once the oil density is set, it will then remain constant even though the air flow is varied over a wide range.

TO ADJUST THE LUBRICATOR:

1. Open the oil density adjusting screw (2) by turning it counter-clock-wise to upper limit stop.
2. Turn on the air to the system.
3. With power on the machine, Off-On Switch in on position and main motor off, depress the Foot Switch repeatedly counting the cycles between drops.
4. Oil density is varied by turning adjusting screw slowly clockwise until there is one drop 12-18 cycles. Allow Lubricator to operate approximately 1 minute to stabilize drip rate.

The Lubricator Reservoir may be filled with oil when the system is under air pressure. To do this, press the Vent Valve Button (3) and unscrew the Top Cap.(4). Add oil to within 1/4" of the top of the bowl and replace the cap. The Vent Button must be pressed while replacing the cap.

INSTRUCTIONS FOR CHECKING A MALFUNCTIONING
ELECTRO-PNEUMATIC AIR OPERATED REMOTE CONTROL UNIT

1. Set the air pressure on the Filter Regulator Unit at 60 to 80 PSI gauge. As a precaution, change the gauge with some other piece of equipment to see if the problem might not lie in the Pressure Gauge itself. The Pressure Gauge reading should be the same.
2. Adjust the Flow Control Valves wide open. Using a 1/4" diameter rod or screwdriver, depress the manual button in the top of the Mac Solenoid Valve. Adjust the Flow Control Valve at the head end of the cylinder so that the piston does not slam into the cylinder head. The Flow Control Valve on the rod end may then be adjusted in the same manner so that the piston does not slam into the cylinder head on the rod end, or the plunger does not hit the clutch release cam.
3. Should the operation of the cylinder still be sluggish or in-operative, disconnect the air line to the Flow Control Valve on the head end of the cylinder and remove the Flow Control itself. Again, manually energize the Solenoid Valve to see if the cylinder retracts the Pawl Engaging Plunger. In some instances oil has accumulated in the head end of the cylinder. Should there be an accumulation of oil within the cylinder, it must be dismantled and cleaned out.
4. On occasion the jam nut on the air cylinder clevis has loosened allowing the piston rod to rotate and lose its setting. Should this occur, the adjustment may be made as follows:

The air cylinder should be in the full retracted position. The Pawl Slide Pin and Non-Repeat Pawls should be pulled to the extreme limit of its travel. There should be approximately .005" clearance between the hook on the pawl engaging plunger and the non-repeat pawl as indicated on the layout.

5. After all checks and adjustments have been made, the operation of the cylinder may then be checked electrically.
6. On occasion the Non-Repeat Pawl has been kicked to the upright position by the Non-Repeat Arm. By removing the gear case hand hole cover, the action of the pawl engaging plunger and the non-repeat pawl may be seen. Should the non-repeat pawl be struck in an upright position, it can be removed and the pin hole buffed out providing additional clearance. Drills or Reamers will not work since this is a hardened piece.

Technical drawing of a mechanical assembly, likely a conveyor system component, showing dimensions and construction details.

Dimensions:

- Overall width: 28"
- Overall height: 50"
- Vertical spacing on the left: 20" and 30"
- Horizontal spacing at the bottom: 16 1/2"
- Horizontal dimension at the top: "D"
- Horizontal dimension at the bottom: "C"

Annotations and Labels:

- END FRAME** (top right)
- CAUTION - INSERT WOOD PL. CONCRETE. REMO...**
- 1" DIA. HOLD DOWN BOLT MUST T...**
- TO LINE UP WITH HOLE IN**
- 2" IRON PIPE, WELD TO SHEE...**
- NUT INSIDE. MAKE NUT FROM 3...**
- NOTE:**
- HOLD DOWN BELTS, BO...**
- MAINTAINED WITH NUTS...**
- TO SUSPEND HOLD DOWN**
- 3/4 SQ. NUT**
- 1/2 SQ. BOX**
- FRONT OVERHEAD DRIVE GEAR**
- BASE OF END HOUSINGS & TUG**
- 1/4 DIA. COILED HOLE**
- CUTTING LINE**
- 36 BACK GEAR RANGE**
- BASELINE**
- MOTOR** (on the right)

NOTE: HOLD DOWN BOLTS, BOLTS, NUTS & PIPES ARE NOT FURNISHED. WITH MACHINE. USE WOODEN FRAMES TO SUSPEND HOLD DOWN BOLTS TO SECURE ACCURATE LOCATION

825, 1025
FLAME PLANS