



Peddinghaus

Peddinghaus Anlagen & Maschinen GmbH

Operating Instructions and Spare Parts List

for

Long Blade Shear
for Plate and Rounds

2 BR 4 / 300 / 2



Product No.
20019 – 2 BR 4/ 300 / 2

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Description

Long blade shear for plate and rounds 2 BR 4 / 300 / 2

- Particularly rugged machine frame of tempered steel.
- Special frame design guarantees trouble-free feeding of the material.
- Blades of high-grade tool steel, hardened and ground.
- Hand-lever with safety spring.
- Infinitely adjustable hold-down.
- The operator has a clear view over the full blade length enabling work to be carried out on layouted plate.

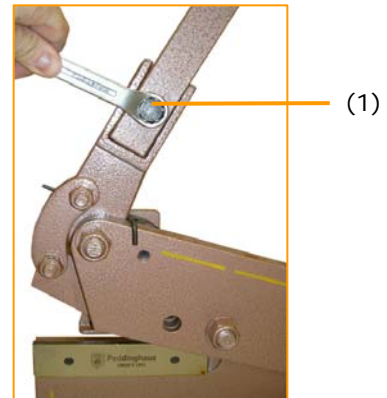
Technical Data

Model 2 BR 4 / 300 / 2		
plate	up to mm	4
rounds	up to mm	13
blade length	mm	300
net weight	kg	30
part no.		20019

Mounting the hand lever

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

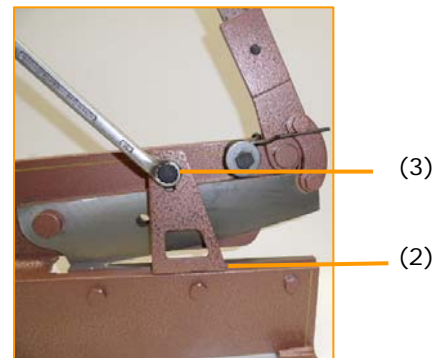
- By means of a size 19 open-jaw spanner or box spanner release the screw (1) and remove the screw.
- Insert the hand lever into the lever shoe guide.
- Fix the hand lever by means of the screw (1).



Cutting flat bar - adjusting the hold-down

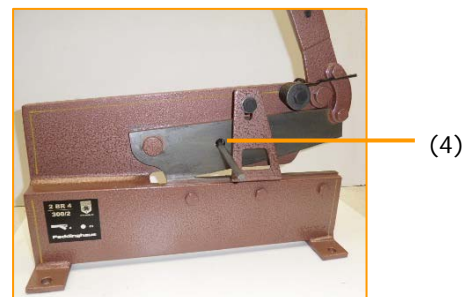
Prior to shearing operations the hold-down must be set to the workpiece. There should be a gap (2) of approx. 1 to 2 mm between the upper edge of the material and the lower edge of the hold-down.

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

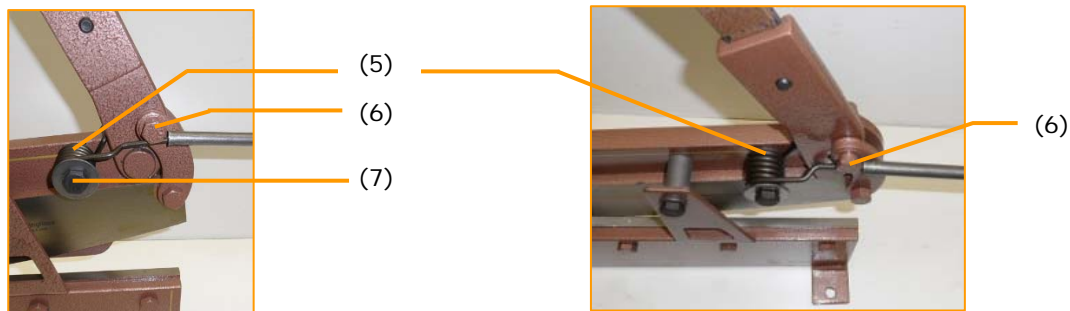


Shearing round bar

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



Changing the torsion spring



Operations:

- Using a pipe of approx. 15cm length as a lever, remove the torsion spring (5) from the guide of the screw (6).
- By means of a size 19 open-jaw spanner or box spanner release the screw (7) and remove the screw.
- 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 or box spanner, release and remove the three screws (8).
- From the front side, remove the bottom blade (9) from its seat.

Dismantling the upper blade:

- By means of a size 19 open-jaw or box spanner, release the screw (10).
- By means of a size 24 open-jaw or box spanner, release the bolt (11) and beating slightly with a hammer knock the bolt out of its seat.
- Remove the upper blade (12).

Mount the new blades in reverse sequence.

Changing the round blade

- Remove the upper blade - see chapter "Changing the plate shear blades".
- From the opposite side, knock the round blade (14) out of its seat (15) by means of a 16 mm bolt (13).



(13)



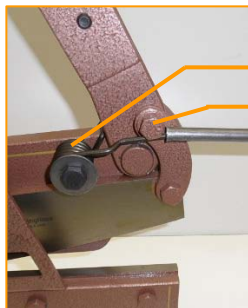
(15)

(14)

Mount the new blade in reverse sequence.

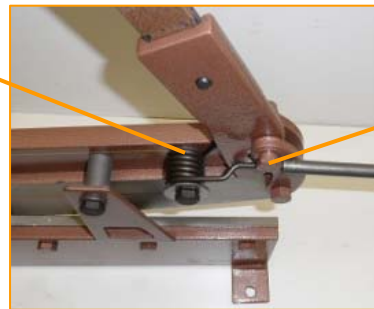
Changing the elements of the driving parts set

- Remove the torsion spring (16) from the guide of the screw (17) using a pipe as a lever.
- Release the screws (18) by means of a size 19 open-jaw spanner or box spanner and remove them.
- Release the bolt (19) 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.

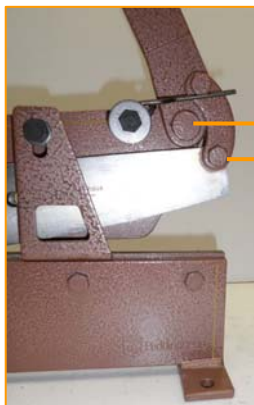


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(19)

(18)

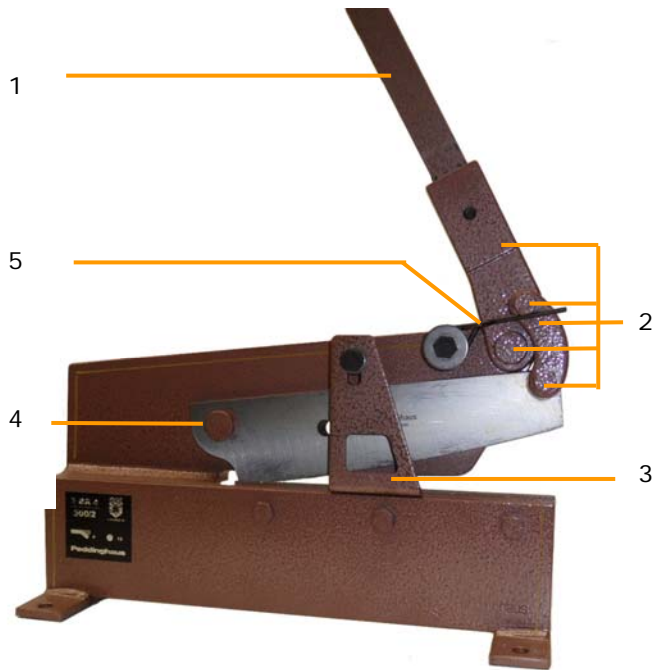
(19)

(18)



Fit the new parts in reverse sequence.

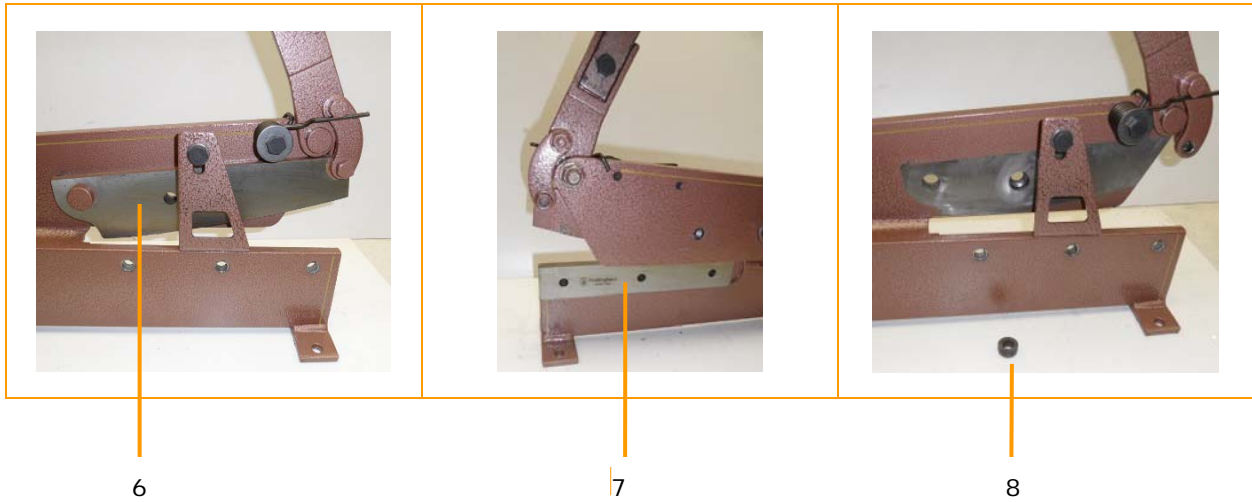
Spare parts

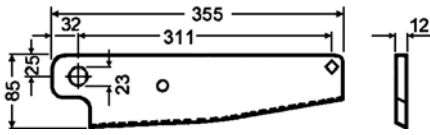
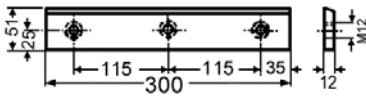
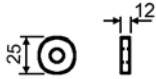


5 – torsion spring complete

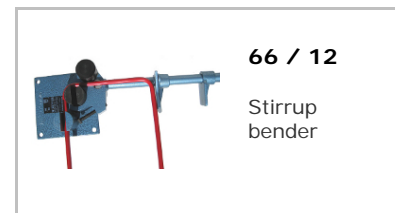
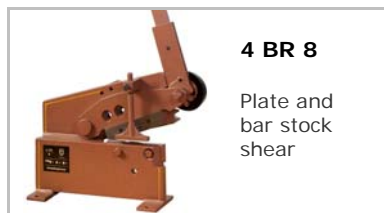
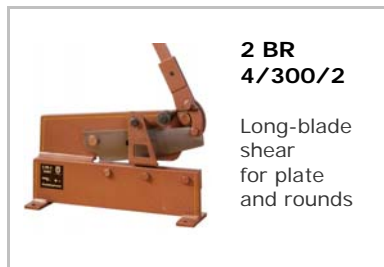
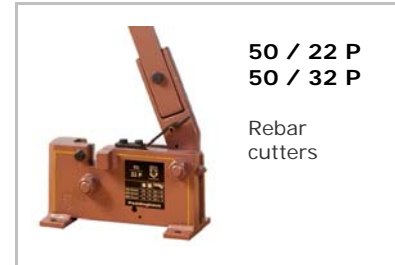
Item	Description	Part number	Quantity
1	hand operating lever	20129 152 10 00	1
2	driving parts, set	20129 152 50 00	1
	– lever shoe		1
	– pivot pin complete		1
	– hex. head screw complete		1
	– torsion spring screw complete		1
	– knife clamps		2
3	plate hold-down	20129 173 01 01	1
4	pivot pin complete	20126 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 	20001 5 1000	1
7	bottom blade 	20006 5 1001	1
8	round blade 	20055 5 1002	1


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





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