

Strip-Tec™ wire stripper

STI - 8

Maintenance and Operation Manual



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 **NASCO-OP™**
Power of Numbers
800-321-3396

Contents

1.	Introduction	1
1.1.	The STI-8 Metal Sizing Shear	1
2.	Warnings	2
2.1.	Operating Warnings	2
2.2.	Warning Labels	4
2.2.1.	<i>Positioning of Labels</i>	7
2.3.	Important Information	8
2.3.1.	<i>Serial Number Plate</i>	8
2.3.2.	<i>Electric Motor Rotation</i>	8
2.3.3.	<i>Continual Improvement Policy</i>	9
2.4.	A Cautionary Tale	9
3.	Installation	10
3.1.	Lifting & Transporting	10
3.2.	Siting & Installation	11
3.2.1.	<i>Electrical Power Supply</i>	11
3.3.	Fixed Station Mounting	11
3.4.	Hydraulic Fluid	11
3.5.	Dimension & Technical Specification	12
4.	Operation of the Shear	13
4.1.	Starting & Stopping Electrically Driven Models	13
4.1.1.	<i>Start & Stop Buttons</i>	13
4.1.2.	<i>Use of the Electrical Isolator Switch</i>	13
4.1.3.	<i>The Emergency Stop (E-Stop) Button</i>	14
4.2.	Foot Pedal Control	14
4.2.1.	<i>Using the Foot Pedal</i>	14
4.2.2.	<i>Siting the Foot Pedal</i>	14
4.3.	Adjusting the Stroke	15
4.4.	The Blade Guard	16
4.5.	Protective Clothing	16
4.6.	Shearing Large Items	17
4.7.	Shearing Small Items	17
5.	Periodic, Routine Care & Maintenance	18
5.1.	Introduction	18
5.2.	Warnings	18
5.3.	Hydraulic Fluid	18
5.3.1.	<i>Storage, Handling & Disposal</i>	18
5.3.2.	<i>First Aid Measures</i>	18
5.3.3.	<i>Fire Fighting Measures</i>	19
5.4.	Daily Operator Inspection	19
5.5.	Weekly Routine Maintenance	20
5.6.	Three Month Periodic Maintenance	21
5.7.	Twenty-Four Month Periodic Maintenance	22
5.8.	Forty-Eight Month Periodic Maintenance	22

6.	Servicing & Repair	23
6.1.	Troubleshooting - General	23
6.1.1.	<i>Hydraulic Fluid is getting hot</i>	23
6.1.2.	<i>The Shear runs too slowly</i>	24
6.1.3.	<i>Loss of power when cutting heavy items</i>	24
6.1.4.	<i>The Shear will not repeat stroke.</i>	24
6.1.5.	<i>The Hydraulic Fluid becomes aerated or frothy</i>	24
6.1.6.	<i>Motor trips out due to overload or overheating</i>	24
6.1.7.	<i>The Motor trips out repeatedly</i>	24
6.2.	Electrical Cable Schedule - Three Phase	25
6.2.1.	STI-8	25
6.2.2.	STI-8	25
6.3.	Electrical Cable Schedule - Single Phase	26
6.3.1.	STI-8	26
6.3.2.	STI-8	26
6.4.	Electrical Wiring Diagram	27
6.4.1.	Three Phase	27
6.4.2.	Single Phase	27
6.5.	Hydraulic Circuit Diagram	28
6.6.	Shear Blade Turning & Changing	29
6.6.1.	<i>Introduction</i>	29
6.6.2.	<i>Replacing or Turning the Top Blade</i>	29
6.6.3.	<i>Removing the Blade Guard</i>	29
6.6.4.	<i>Removing side movement from the Main Pivot</i>	30
6.6.5.	<i>Replacing or Turning the Bottom Blade</i>	30
6.6.6.	<i>Starting the Shear after Changing or Turning the Blades</i>	31
6.7.	Resealing the Hydraulic Rams	31
6.8.	Changing Suction Filter	33
6.9.	Hydraulic System Relief Valve	33
6.9.1.	<i>Testing for Over-Pressure</i>	33
6.9.2.	<i>Resetting</i>	34
6.10.	Foot Pedal Control Cable	35
6.10.1.	<i>Renewing the Control Cable</i>	35
6.10.2.	<i>Adjusting The Control Cable</i>	36
7.	Illustrations	37
7.1.	Grease Points	37
7.2.	Hydraulic Tank	38
7.3.	Shear Stand	38
7.4.	Blade Guard	39
7.5.	Foot Pedal & Stroke Control Mechanism	39
7.6.	Motor, Pump & Bell Housing	41
7.7.	Blades & Jaws	43
8.	Spare Parts	44
8.1.	Ordering Spare Parts	44
8.2.	Shear Body & Guard	45
8.3.	Hydraulic Ram	46
8.4.	Hydraulic Power Pack	47
8.5.	Stroke Adjuster & Foot Pedal Mechanism	48

9.	Record Keeping	49
9.1.	Useful Contacts	49
9.2.	Training, Safety & Ownership Records	50
9.3.	End of Life Disposal	50
10.	Operator Training Record	51
11.	Shear Safety Checklist	52
11.1.	Warning Signs	52
11.2.	Machine Integrity	52
11.3.	Control Functions	52
12.	Ownership Registration	53
13.	Declaration of Conformity	55

1. Introduction

1.1. The STI-8 Metal Sizing Shear

Strip Tech Shears are designed to give long and trouble-free life. The Shear is controlled using a direct acting Foot Pedal. When the Foot Pedal is held down the Shear will cycle continuously until the Foot Pedal is released upon which the Shear will return to the open position. The pressure applied to the Foot Pedal directly corresponds to the running speed of the Shear.

Remember that scrap metal processing can be hazardous. Before operating the equipment, it is important that you read the safety instructions contained in this manual. Please ensure that your operators are fully trained in the use of the Shear and, should you decide against a service contract, that you conduct periodic safety reviews of the equipment's safety features and Warning Labels. Replacement Warning Labels and other items of safety equipment such as the Blade Guard, Foot Pedal, Control Cable, and Tongs can be obtained at cost from the manufacturer. If you would like more safety or operating information for this type of scrap metal processing equipment, then this can be obtained by contacting any one of the organisations listed at the end of this manual.



This manual covers the single and three phase versions of the STI-8 Auto Shear.

If you need any further help or assistance, or wish to order parts or a service contract, please contact your local agent or the manufacturer:

STRIP TEC
3700 N. COMMERCE STREET
FORT WORTH, TEXAS 76106
www.striptec.com

2. Warnings



**READ & UNDERSTAND THIS SECTION BEFORE OPERATING
THE SHEAR**

2.1. **Operating Warnings**

BEFORE OPERATING THIS Shear ENSURE THAT:

- You, as the operator, have read and understood this manual.
- You are fully familiar with the Shear's controls.
- The Blade Guard is correctly fitted.
- Any Covers are in place and correctly fitted.
- All Warning Notices are clean and legible.
- The Foot Pedal and Control Cables are free from damage.
- There are no obstructions to any air vents or intakes.
- You are wearing appropriate Protective Clothing.
- The working area around the Shear is clear of metal and debris.
- The Hydraulic Fluid level is correct.
- Visual Daily Operator Inspection Checks have been carried out.
- You have carried out a Shear Safety Inspection using the Shear Safety Checklist.

DO NOT UNDER ANY CIRCUMSTANCES ATTEMPT TO SHEAR:

- Totally enclosed vessels, cylinders, gas containers, aerosols or any other pressurised container.
- Vessels containing volatile or flammable substances, acids or alkalines.
- Ammunitions, cartridges, or explosive material of any type.
- Hardened or high-speed steels, engine pistons, automotive valves or valve seats.
- Any metal or substance likely to fly from the blades of the Shear while being cut.
- Inflated automobile tires.
- Any other substances likely to cause injury to the Operator or by-stander.

DO NOT:

- Hold bundles of items while shearing.
- Put hands or fingers into open ends of tubes or cylinders while shearing. Do not put hands or fingers in to open sided sections.
- Attempt to cut small items without the use of pliers or tongs.
- Operate from the front, back or right hand side of the Shear.

ALWAYS:

- Stand between the material being cut and the Stop/Start controls of the Shear.
- Use the Shear from the Left (Control Box) side.
- Always hold lengths of material to the right hand side of the body.
- Use the Blade Guard to clamp material when possible.

DANGEROUS WORKING PRACTICES

- Do Not point items to be sheared towards the body.
- Do Not operate the Shear in the manner shown in the following illustrations:

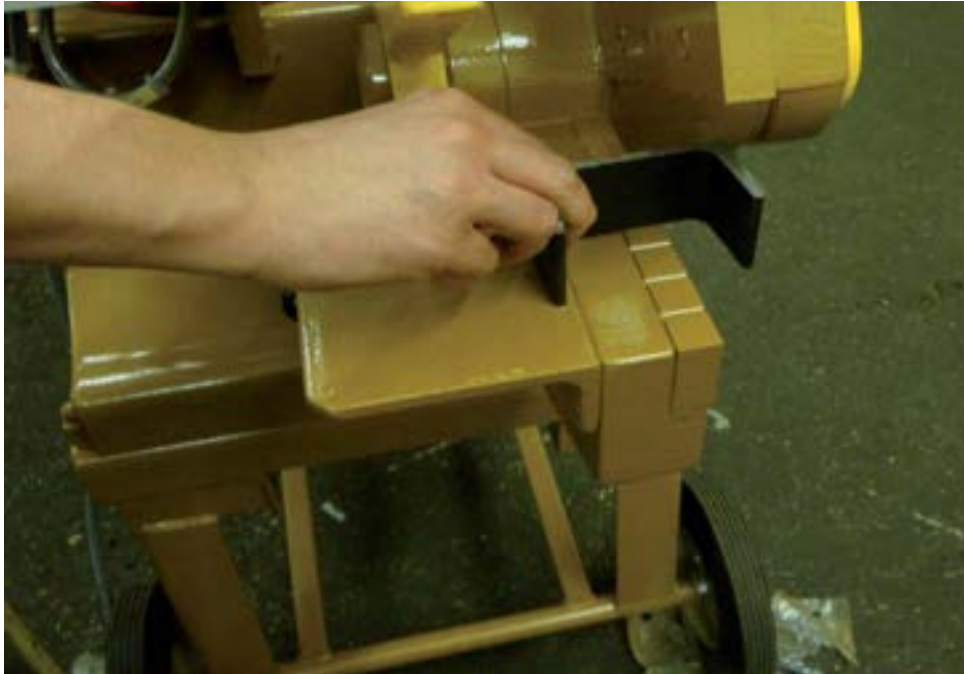


Material and tools may jerk up or jump out of the closing blades causing injury.



Always hold materials and tools to the right hand side of the body.

STI-8



2.2. Warning Labels

The Warning Labels illustrated are examples of those attached to the STI-8 Shear. Keep all notices clean and legible. Replacement labels can be obtained directly from Strip Tec.

Label A.



WARNING

Do not start, operate or service machine until you have read and understood the operator's manual.

Failure to do so could result in serious injury.

Label B.

SAFETY INSTRUCTIONS

1. Read and understand the Operation Manual and all safety labels before operating this machine.
2. Only a single trained person is to be permitted to operate this equipment. No unauthorised persons should operate this machine.
3. No persons under the age of 18 should operate this machine.
4. Keep the working area around the machine clear from metal or debris.
5. The equipment is only to be used for the purpose for which it is constructed.
6. Do not attempt to shear pressurised containers, ammunitions, hardened steels, metals likely to fly from the blades of the shear, inflated tires or any other substances likely to injure the operator or a bystander.
7. Use tongs to handle small items.
8. Do not hold bundles of items whilst shearing
9. Do not put hands or fingers into open ends of tubes or cylinders whilst shearing.
10. Under no circumstances are the safety characteristics of this equipment to be altered.
11. Daily visual operator checks must be carried out to ensure that all guards and safety features are retained and function correctly.
12. Do not wedge foot pedal in operating position.

Label C.



Label D.



Label E.



Label F.



WARNING


- Shear hazard.
One operator only.
Keep hands clear from under blade.
DO NOT operate with guard removed.
DO NOT operate with guard raised.
Turn power OFF before servicing.**

Label G.


Do not run motor before filling machine with hydraulic oil to heavy black line.

Use only oils :


- BP HLP46
- Shell Tellus Oil 46
- Mobil DTE25
- Esso NUTO H46



Motor direction must be clockwise as seen from the end.
DO NOT run motor anti-clockwise, this will result in pump damage.



Machine should be lifted with the aid of a forklift using the forklift sockets.



Label H.



Label J.



Crush Hazard.

Stand clear when this shear is in operation

Label K.

 **WARNING!**

Scrap metal handling can be hazardous.

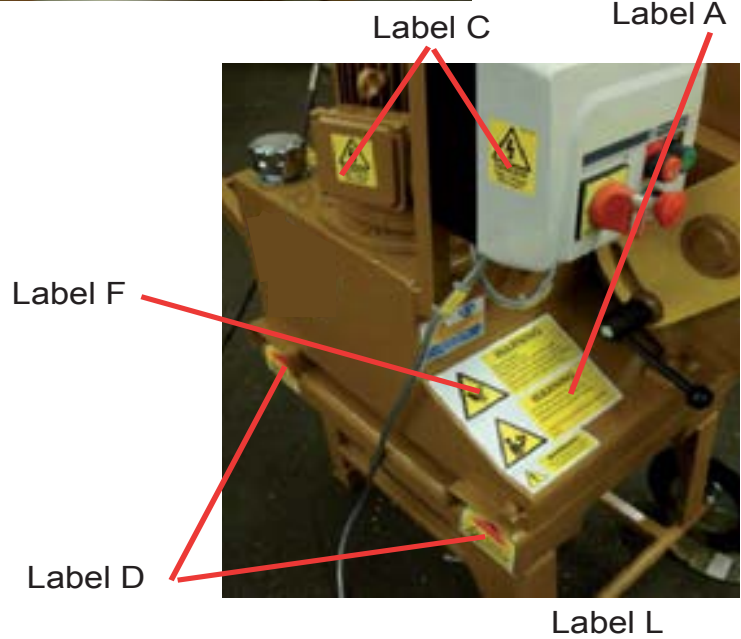
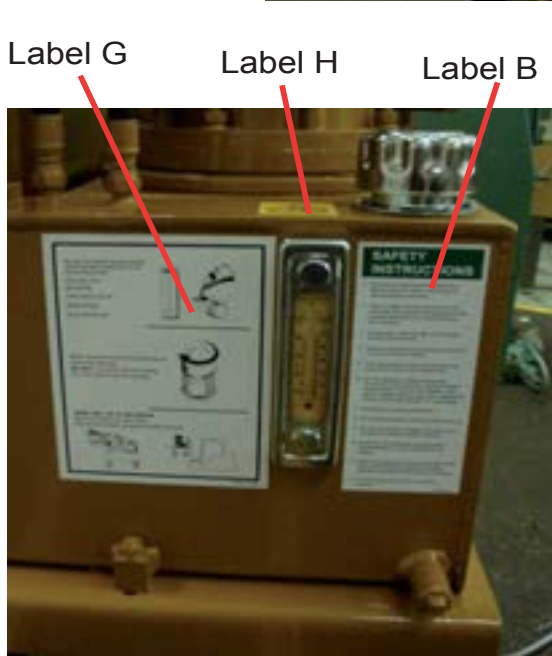
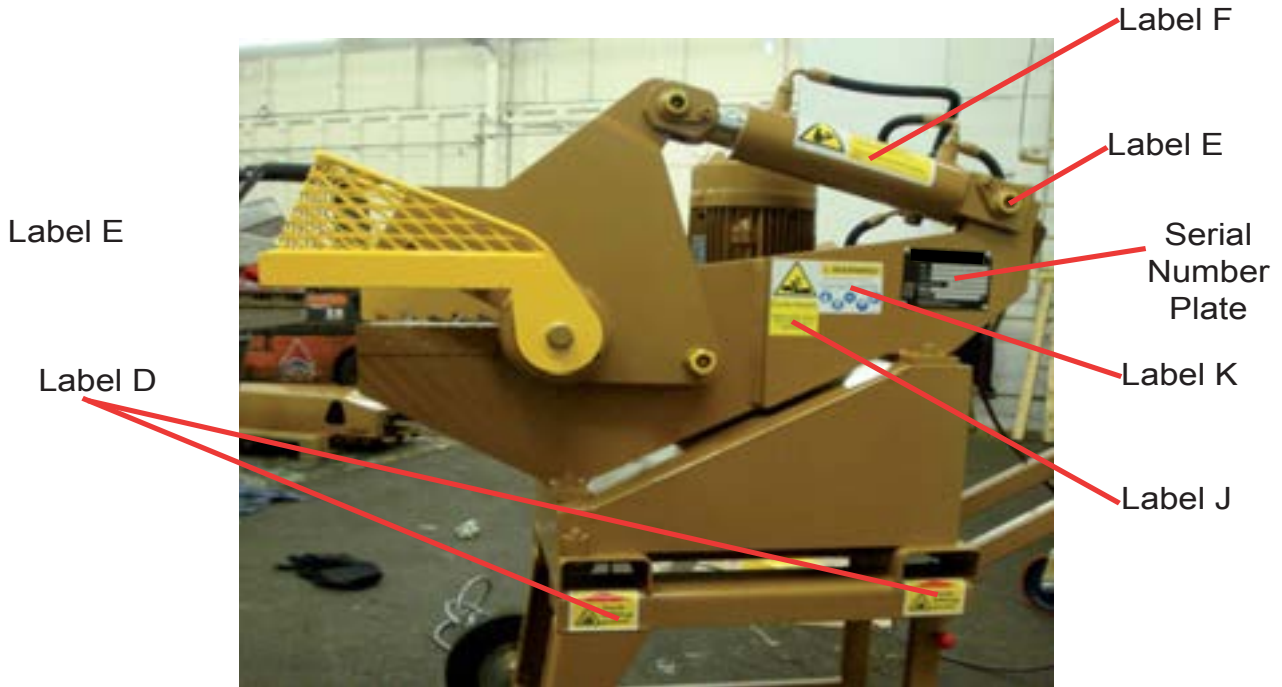
Wear protective clothing at all times whether operating, adjusting or servicing this machine.



Label L.



2.2.1. Positioning of Labels



2.3. Important Information

2.3.1. Serial Number Plate

Below is an example of a STRIP TEC serial number plate declaring the EEC requirement for a CE Mark along with the gross weight of the unit and the maximum working pressure of the hydraulic system.



Note: The working pressure and weight is specific to each machine and should not be taken as a standard for similar machines.

2.3.2. Electric Motor Rotation



Electric motor rotation is clockwise at the fan end.



Do not run the motor anti-clockwise as this will result in Hydraulic Pump damage.

2.3.3. *Continual Improvement Policy*

Strip Tec reserves the right to make changes and/or improvements to our machines without obligation to incorporate such changes on machines previously sold.

2.4. **A Cautionary Tale**

The STI-8 model Shear pictured below came into the manufacturer's works for reconditioning and resale in May 2001. It had been operating in the field since November 1989. At some time during its history, the Shear had been refurbished by someone other than the manufacturer. The Blade Guard had been removed and not re-fitted. The Foot Pedal had been modified by removing a large section of shielding. Removal of the Foot Pedal shrouding could result in accidental operation of the equipment by either the operator, someone stumbling onto the Pedal, or even a piece of falling metal. All Warning Labels had been removed.

Modifications of this type cannot be condoned since they could result in serious injury to the operator. If you see, are offered, or are asked to work on, a Shear which has been altered in such a way as to compromise operator safety, then please contact the manufacturer, trade organisation, and/or your local Health and Safety Executive. Replacement Guards, Foot-Pedals, Control Cables and Warning Labels can be obtained from the manufacturer.



3. Installation

3.1. Lifting & Transporting

For safe movement of the Shear there are two Fork Lift Channels as shown below. Use at all times when lifting the Shear and check the capacity of the equipment to be used.



Fork Lift Channels



Do not attempt to lift the Shear by any other means

The Shear is equipped with a two wheeled stand which allows the Shear to be moved by hand using the collapsible handle. The handle is locked in place by a catch, which can be released by holding the handle and pulling the red knob, this will allow the handle to swing down inside the frame. Remember to check that the catch has properly snapped into place before attempting to move the Shear using the Handle.



It is important to ensure the frame and body of the Shear are secured together to prevent the Shear from tipping forward when moved. It is also advisable to use a forklift to move the Shear over greater distances or over rough or uneven ground.

3.2. Siting & Installation

The Shear must be sited on level ground, ideally on sound concrete, and in good ambient lighting. The Shear must not be allowed to rock back and forth while in operation. Site the Shear in a position which will allow the Operator to walk freely and unhindered around all sides. Ensure that the working area around the Shear is kept clear of metal and debris.

3.2.1. *Electrical Power Supply*

The Shear installation requires a 32A, single or three phase electrical supply. As part of the installation, we strongly recommend the use of an earth leakage trip or Residual Current Detector (RCD).

Ensure that the electrical supply is compatible with the Shear. Use armoured supply cable complying with local regulations. Route the supply lead in such a manner as to leave it free from trapping points and areas where it is likely to hinder the efficient operation of the Shear, or cause a hazard.



The electrical supply to the Shear must only be installed by an approved electrician.

3.3. Fixed Station Mounting

If the Shear is to be used at a fixed location, it can be mounted directly onto a fixed bench or table. This can be done by splitting the machine from the stand by removing the three fixing bolts. These fixing points can then be used to secure the Shear Body to the bench or table.

3.4. Hydraulic Fluid

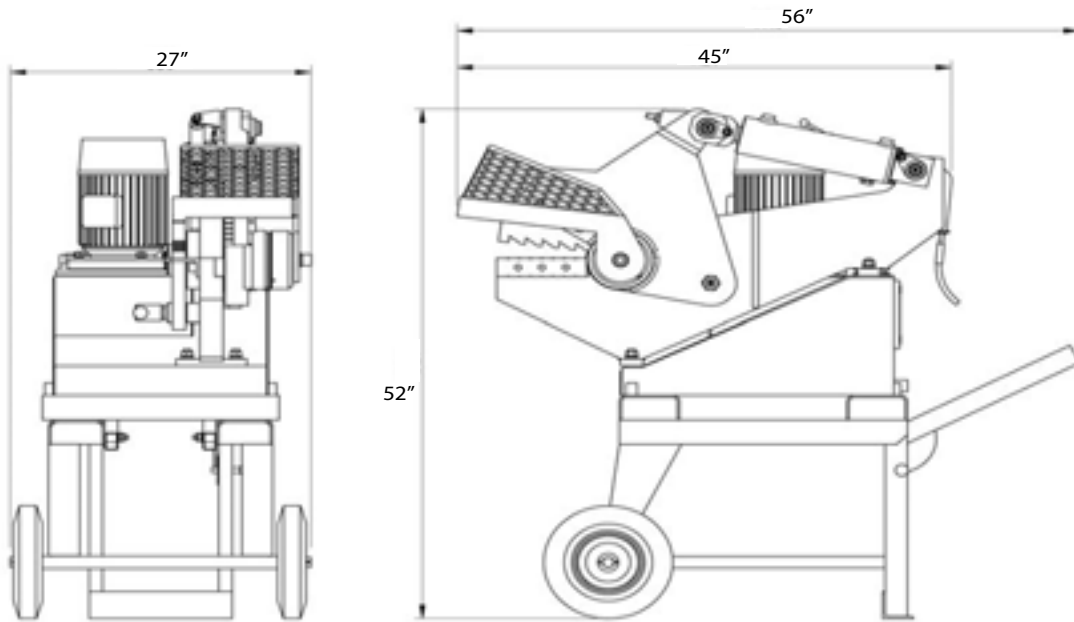
Do not run the Shear before filling the Hydraulic Tank with Hydraulic Oil; do not use a liquid other than hydraulic oil. Fill up to the heavy black line on the Level gauge. Recommended oil types:

- BP HLP 46;
- Shell Tellus Oil 46;
- Mobile DTE 25;



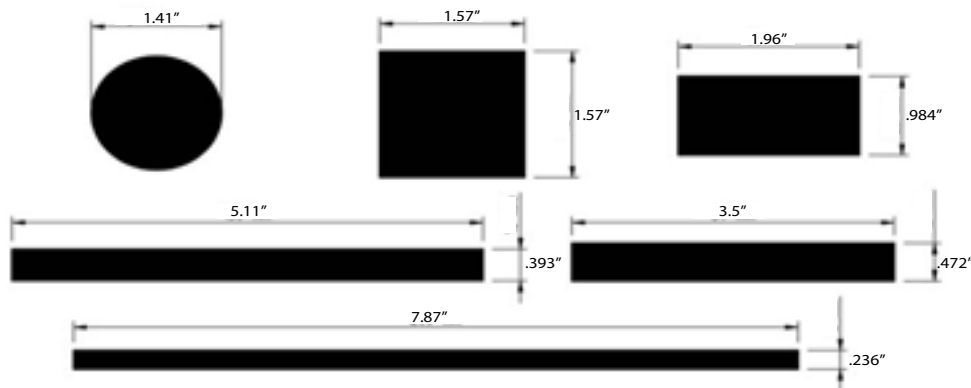
Monitor the oil temperature and do not allow it to exceed 150 degrees Farenheight.

3.5. Dimension & Technical Specification



	Single Phase	Three Phase
Weight (with Oil)	925 lbs	925 lbs
Blade Length	8"	8"
Tip to Tip Opening	6"	6"
Shearing Height	37"	37"
Cutting Control	Single-Cut Repeating	Single-Cut Repeating
Power Supply	220/240V 60Hz	440 V 60Hz
Cutting Speed (Max Opening)	Up to 8 cycles/min	Up to 8 cycles/min
Cutting Speed (25% Opening)	Up to 27 cycles/min	Up to 27 cycles/min
Motor Power Rating	5hp	5hp
Noise Level	75dbA	75dbA
Oil Capacity	13.5 Gallon	13.5 Gallon

Cutting Capacity (Mild Steel 43A):



4. Operation of the Shear



The Shear must only be operated by a single person at any time. Persons operating the Shear must have received adequate training and have read and understood this manual



Use the Shear Safety Checklist at least once a day.

4.1. Starting & Stopping Electrically Driven Models

4.1.1. Start & Stop Buttons

Pressing the green button marked 'START', or 'I', will energise the starter, and in turn start the Electric Motor on the Shear. If, on pressing the green Button, the Motor fails to start, ensure the E-Stop Button has been reset and the Isolator Switch is set to the ON position.

Pressing the red Button marked 'STOP', or 'O', stops the electric motor on the Shear. This button also acts as the reset for the thermal overload trip switch used to protect the electric motor.



It is good practice to test the Stop Button each time you start up the Shear. The Stop Button must be kept in good working order to protect the Operator.

4.1.2. Use of the Electrical Isolator Switch

If the Shear is not to be used for long periods of time or if maintenance is to be carried out, set the Isolator Switch to the OFF position.

4.1.3. *The Emergency Stop (E-Stop) Button*

The Emergency Stop button should only be used to stop the Shear when there is a risk of injury to the operator, for routine stopping of the Shear use the Stop Button. Once the E-Stop Button has been pressed it locks the Shear from restarting until it has been reset. To reset the E-Stop Button, gently twist it clockwise and it should spring back to its normal position.

4.2. **Foot Pedal Control**

4.2.1. *Using the Foot Pedal*

Always start up the Shear before depressing the Foot Pedal. Depressing the Foot Pedal activates the shearing action at a speed controlled by the amount of depression. Releasing the Foot Pedal Plate should always return the Top Jaw of the Shear to the open position. The Foot Pedal should be placed so that easy up and down movement of the Foot Pedal Plate can be achieved.

When the Foot Pedal is depressed, the Top Jaw of the Shear will close until the Top and Bottom Blade meet each other. If the Foot Pedal is held at mid point of travel, the movement of the Top Jaw will stop, both on the up and down stroke. This enables the Shear to nip and hold an item to be sheared.

The Ram will repeat stroke automatically by keeping the Foot Pedal in the fully depressed position.

The Foot Pedal is fully shielded to prevent accidental operation of the equipment. The Control Cable is direct-acting, ensuring that the Shear always returns to the fully open position when pressure is released from the Foot Pedal. Always check that the Foot Pedal and Control Cable are free from damage or kinks before operating the equipment.



Only a single person must operate and feed the Shear. Do Not operate the Shear if the Foot Pedal or Control Cable are damaged. Do Not wedge the Foot Pedal in the down position. Do Not modify the Foot Pedal.

4.2.2. *Siting the Foot Pedal*

The Foot Pedal should be sited slightly forward of the Shear and to the left hand side of the Shear, giving the Operator easy access to the control buttons.

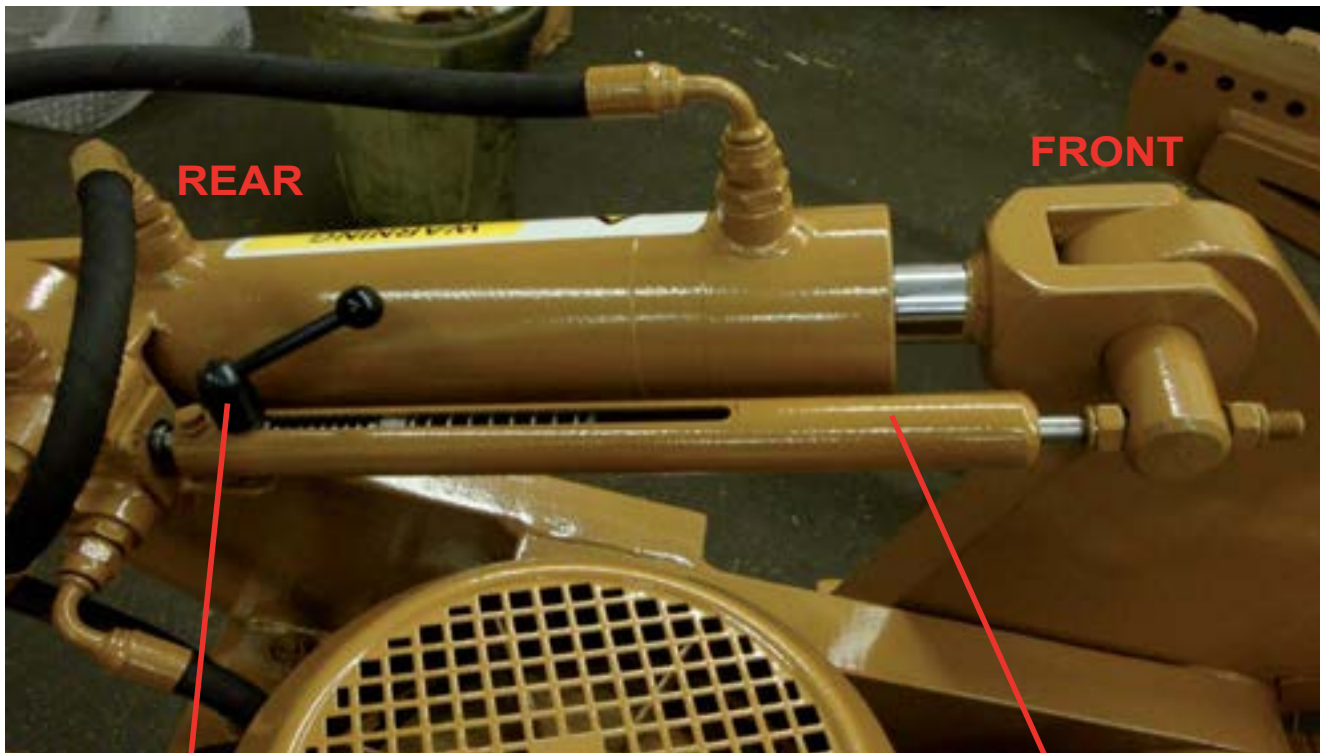


Only operate and feed the Shear from the LEFT (Control Box Side).

4.3. Adjusting the Stroke

The Top Jaw opening may be adjusted to suit the type of material being sheared. To achieve this:

- First stop and switch off the Shear with the Jaws in the closed position.
- Turn the Stroke Control Lever anti-clockwise.
- Slide the Lever up or down the Stroke Adjuster Tube. Sliding to the FRONT shortens the stroke, sliding to the REAR increases it.
- When the desired position has been obtained, turn the Control Lever clockwise to lock it in place.



Stroke Adjuster Handle

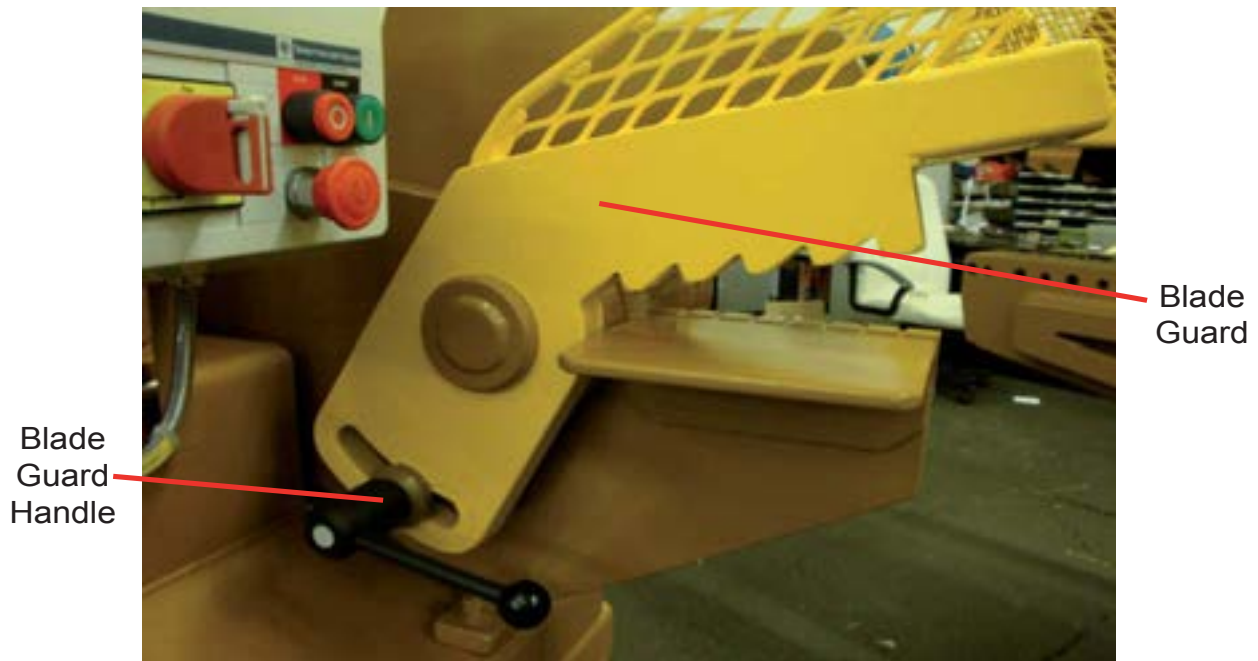
Stroke Adjuster Tube



Always switch off and Isolate the Shear before adjusting the Stroke Adjuster Mechanism.

4.4. The Blade Guard

The Shear is equipped with a Blade Guard which also acts as an Infeed Clamp. The Guard is adjustable and is locked in place using the Blade Guard Handle. The Guard should always be adjusted to leave minimum space for the feeding of material in order to prevent the material being sheared from kicking up or skidding forward.



Do not use the Shear if the Blade Guard is; incorrectly fitted, broken, bent or if the securing bolts are loose.



**Do Not use the Shear without the Blade Guard in Place.
Always adjust the Guard to the lowest position.**

4.5. Protective Clothing

The following Protective Clothing must be worn at all times, for operating and maintaining the Shear:

- Safety Goggles with side screens or Full-Face Visor
- Safety Helmet (Hard Hat)
- Steel Toe Capped Safety Boots
- Gloves and Protective Apron

4.6. Shearing Large Items

Always adjust the Blade Guard to suit the material to be cut.



If the Jaw stops moving part way through cutting a large item, release the Foot Pedal. Ensure that the material to be cut is within the capacity of the Shear (See Section 3.5, Page 12), if it is try to cut the material again ensuring that the Foot Pedal is fully depressed. If the Jaw stops again consult the Troubleshooting Guide (See Section 6.1, Page 23)



4.7. Shearing Small Items

When shearing small items, always use tongs or long handled pliers in order to keep hands well clear of the Blade and Blade Guard.



Do Not feed small items directly by hand.

5. Periodic, Routine Care & Maintenance

5.1. Introduction

Most sites on which the Shear may be operated are by their nature extremely dirty. You will see from the following Routine and Periodic Maintenance Schedule that emphasis is placed on regularly cleaning some aspects of the Shear. To this end, we also strongly recommend that a good quality industrial vacuum cleaner be acquired as part of the maintenance kit.

5.2. Warnings



- For electrical adjustments and/or inspections, use Qualified Personnel, familiar with the latest I.E.E. Regulations, or local equivalent.
- Wear full protective clothing when carrying out maintenance on this Shear.
- Do not modify in any way, the mechanisms or intended operation of this equipment.
- For safety and to achieve optimum performance only use genuine Strip Tec approved parts.

5.3. Hydraulic Fluid

5.3.1. *Storage, Handling & Disposal*

- Store hydraulic fluids under cover away from sources of heat.
- Dispense carefully into clean containers and avoid contact with skin or eyes.
- Use local official collection points for disposal. Do not pollute drains or soil.

5.3.2. *First Aid Measures*

- EYE: Flush with water for 15-20 minutes. Seek medical attention if irritation develops.
- SKIN: Wash immediately with soap and water. Remove contaminated clothing and launder before reuse. Discard shoes and leather articles saturated with the product. Obtain medical advice if irritation occurs.
- INHALATION: Remove exposed person to fresh air. If breathing is laboured give oxygen. If breathing has stopped apply artificial respiration. Get immediate medical attention.
- INGESTION: DO NOT INDUCE VOMITING. If conscious, give 2 glasses of water. If vomiting does occur, keep head below hips to reduce risk of aspiration. Get immediate medical attention.
- Used oils pose a higher health risk and suitable measures should be taken to avoid continuous or repeated contact with them.

5.3.3. Fire Fighting Measures

- Use carbon dioxide, dry chemical or alcohol foam.



Never use Water to combat any Oil or Fuel Fire.

- Avoid spraying directly into storage containers because of the danger of boil over.
- Water may be used to cool nearby heat exposed areas / objects / packages.
- Prevent runoff from fire control or dilution from entering streams, sewers, or drinking water.
- Combustion Products: Toxic fumes may be produced on burning or exposure to heat.



Fires in confined spaces should be dealt with by trained personnel wearing self contained breathing apparatus.

5.4. Daily Operator Inspection



Always switch off and isolate the Shear from the main electrical supply before maintenance.

1. Check Hydraulic Fluid Level Gauge, if low arrange for top up. (See Illustration 2A, Page 38).
2. Check for signs of hydraulic fluid leaking from Hydraulic Hoses, Rams and Power Pack. Report any defect to the Supervisor.
3. Check for loose, missing or damaged items such as Cables, Switches, Covers, Signs and Warning labels, flat or blistered Hoses. Report any defect to the Supervisor.
4. Check the Electrical cables are intact and fully shielded/insulated. Report any defect to the Supervisor.
5. Check that the Stop Button and Emergency Stop Buttons are working correctly. Check that the Mains Isolator operates correctly. Report any defect to the Supervisor.
6. Ensure that the housing of the Foot Pedal Control is free from debris and any obstructions to the mechanism. Ensure that the Foot Pedal Plate moves smoothly in both directions, and rests in the uppermost position. Report any defect to the Supervisor.

7. With the Top Jaw in the fully down position, check that the Shear blades are intact, seated correctly and free from chips or breakages. (See Illustration 7A, Page 43). Report any defect to the Supervisor.
8. Ensure that the immediate area around the Shear is clean and free from any obstructions, metal or debris underfoot. This will prevent accidental stumbling or slipping. Ensure that you can operate the Shear comfortably and that you have good visibility of all working parts.
9. Ensure that all motor ventilation grills are free from obstruction.
10. Ensure that all warning labels are present, clear and legible. Report any missing or damaged labels to the Supervisor.
11. Report any defect, unusual occurrence or incident to the Supervisor.

Use the Shear Safety Check list at least once a day

5.5. Weekly Routine Maintenance



Always switch off and isolate the Shear from the main electrical supply before maintenance.

1. Grease the Jaw Main Pivot, the Blade Guard Pivot (see Illustration 1A, Page 37), the Jaw Thrust Pad and both the Main Ram Pivots.
2. Test the Shear Blades, for tightness and correct adjustment. (See Illustration 7A, Page 43)
3. Test the Foot Pedal control for correct adjustment. (See Illustration 5A, Page 39)
4. Vacuum or brush down the Power Pack.
5. Vacuum or brush down any dust and debris build up on the Blade Guard.
6. Vacuum or wipe down the Warning Labels and ensure that they are legible at all times.
7. Vacuum or wipe down the Control Box Legend and Instruction Plates. Ensure that all are legible.

Note: The grease used for routine lubrication must be suitable for both Nylon 66 and Phosphor Bronze Bearings.

5.6. Three Month Periodic Maintenance



Always switch off and isolate the Shear from the main electrical supply before maintenance.

To include previous items 1 to 7.

8. Check and top up the hydraulic fluid level if necessary. (See Illustration 2A, Page 38)
9. Test the Top Jaw Main Pivot for side movement, adjust the Take Up Screw if necessary. (See Illustration 1A, Page 37 and Section 6.6.4, Page 30)
10. Clean off any excess grease from the Top Jaw Main Pivot and Thrust Pad.
11. Apply a light oil to the Stroke Adjuster Mechanism Springs and Bearing. (See Illustration 1B, Page 37)
12. Apply a light oil to the Control Chain, the pivot of the Chain Housing, all ends of the Control Cables and the Foot Pedal pivot (See Illustration's 5A & 5D, Page 39 & 41).
13. Check the Stroke Adjuster Springs are intact and not squashed. Replace if damaged. (See Illustration 5B, Page 40).
14. Examine the Hydraulic Hoses for scuffing, replace if damaged and re-route if needed.
15. Remove the Pump Motor fan cowl with care to expose the Motor ventilation impeller. Vacuum the impeller and down the Motor cooling fins. Replace the fan cowl, check the Motor Terminal Box Cover fixings for tightness. (See Illustration 6A, Page 41).
16. Examine and test all Shear Blade fixings. Use only well-fitting hexagon wrenches if adjustment is needed. (See Illustration 7A, Page 43)
17. Examine and test the Foot Pedal ensuring a clearance of (0.25in) between the Foot Pedal Plate and the Housing when in the fully depressed position (See Illustration 5A, Page 39).
18. Examine the Foot Pedal Cable for kinks and breakages. Replace if damaged. (See Section 6.10, Page 35-36)
19. Restore the mains power supply, and test that the Shear functions correctly.

5.7. Twenty-Four Month Periodic Maintenance



Always switch off and isolate the Shear from the main electrical supply before maintenance.

To include previous items 1 to 20.

20. Change Pump Suction Filters. (See Section 6.8, Page 33)

5.8. Forty-Eight Month Periodic Maintenance



Always switch off and isolate the Shear from the mains electrical supply before maintenance.

To include items 1 to 21.

21. Renew the Hydraulic Fluid. Due to the high cost of hydraulic fluids, it might first be worth asking your local oil supplier if they can revitalise the fluid in situ. If the only course of action is to change the fluid. (See Section 3.5, Pages 12 for the quantity required) Press down and turn anti-clockwise to unscrew the Filler Cap. (See Illustration 2A, Page 38). Located at the rear of the Hydraulic Tank is a drain plug. Choose a suitable container or containers to drain the old oil into. Remove the Drain Plug from the tank but keep the plug close to hand to stop the flow quickly if needed. Refill the tank to the heavy black line on the sight gauge. Use only ISO 46 grade hydraulic fluid.
22. Renew the Hydraulic Filler Breather Cap. Contained within the Filler Cap is a 10 micron filter element preventing air born dusts from contaminating the hydraulic fluid. It is good practice to renew this filler cap when filling the Hydraulic Tank with a substantial quantity of new hydraulic fluid.
23. Grease the Stand Wheels. (See Illustration 1A, Page 37)

6. Servicing & Repair

6.1. Troubleshooting - General



Always switch off and isolate the Shear from the main electrical supply before maintenance.

6.1.1. *Hydraulic Fluid is getting hot*



The Oil temperature Should Not exceed 65 degrees centigrade

The possible reasons for hydraulic fluid getting hot are numerous. The following are some of the main causes:

- A. Ensure items being processed are within the capabilities of the Shear.
- B. Power pack needs topping up with hydraulic fluid. Refill to heavy black line on sight gauge.
- C. Motor cooling fan and fins need cleaning.
- D. Hydraulic Pump Suction Element clogged. Replace with new element.
- E. Split or loose Hydraulic Hose and/or connections inside the Hydraulic Tank.
- F. Hydraulic Control Valve is not moving full stroke. Check for dirt or a bent Valve Spool.
- G. Hydraulic Ram seals need renewing. Test the Ram by bottoming out and monitoring return flow of hydraulic fluid.
- H. Pump fitting cracked or seal burst. Replace with new Pump. Also check the Relief Valve setting.



Maximum relief valve setting 220 BAR (3200PSI).

- I. Pump bearings worn out and Pump body scored. Check Suction Filter for aluminium filings. Replace the Pump and Suction Filters.



Always switch off and isolate the Shear from the main electrical supply before maintenance.

6.1.2. *The Shear runs too slowly*

- A. Check D to I as for 6.1.1.

6.1.3. *Loss of power when cutting heavy items*

- A. Check that the clearance between the Foot Pedal Plate and Housing is not less than (0.25in) when in the fully depressed position, (See Illustration 5A, Page 39).
- B. Check D to I as for 6.1.1.
- C. Check Motor to Pump drive couplings for slippage.

6.1.4. *The Shear will not repeat stroke.*

- A. Examine the Stroke Adjuster Springs. Replace if squashed or damaged.
- B. Ensure the Foot Pedal is free to move and that the control cable is correctly connected and undamaged.

6.1.5. *The Hydraulic Fluid becomes aerated or frothy*

- A. Hydraulic fluid return line hose from the Control Valve to the Hydraulic Tank is loose. Check all hoses are undamaged and correctly tightened.
- B. Hydraulic pump shaft seals worn out. Replace the Hydraulic Pump

6.1.6. *Motor trips out due to overload or overheating*

- A. Ensure the items being sheared are within the capabilities of the Shear.
- B. Check the Motor Fan Blades and air passageways are clear from dust and debris.
- C. With the Shear Isolated from the electrical supply, open the Electrical Control Box. Reset the contact overload.

6.1.7. *The Motor trips out repeatedly*

- D. Check A & B as for 6.1.6.
- E. Have a qualified electrician check the overload settings, the incoming voltage supply, and all connections for corrosion which could cause a voltage drop.

6.2. Electrical Cable Schedule - Three Phase

Cable No.	Size	Cores	Cable	Source	Destination
SO	8-10ga	4	THW	32A Plug	Main Control Panel Isolator
SO	8-10ga	4	THW	Main Control Panel	Pump Motor

6.2.1. STI001

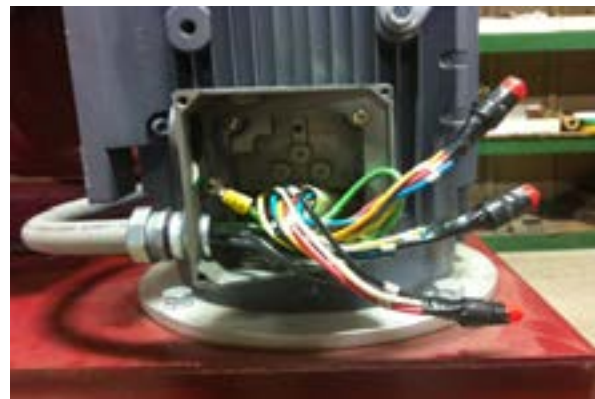


Source: 32A Plug

Destination: Main Control Panel Isolator

Core No.	Plug Terminal No.	Isolator Terminal No.	Function
Earth	Earth	Earth	Earth
1	1	L1	Power Supply
2	2	L2	Power Supply
3	3	L3	Power Supply

6.2.2. STI002



Source: Main Control Panel Relay

Destination: Pump Motor

Core No.	Relay Terminal No.	Motor Terminal No.	Function
Earth	Earth	Earth	Earth
1	2 -T1		Motor Winding
2	4 -T2		Motor Winding
3	6 -T3		Motor Winding

6.3. Electrical Cable Schedule - Single Phase

Cable No.	Size	Cores	Cable	Source	Destination
SO	8-10ga	3	THW	32A Plug	Main Control Panel Isolator
SO	8-10ga	3	THW	Main Control Panel	Pump Motor

6.3.1. STI001



Source: 32A Plug

Destination: Main Control Panel Isolator

Core No.	Plug Terminal No.	Isolator Terminal No.	Function
Earth	Earth	Earth	Earth
1	Live	L1	Power Supply
2	Neutral	L3	Power Supply

6.3.2. STI002



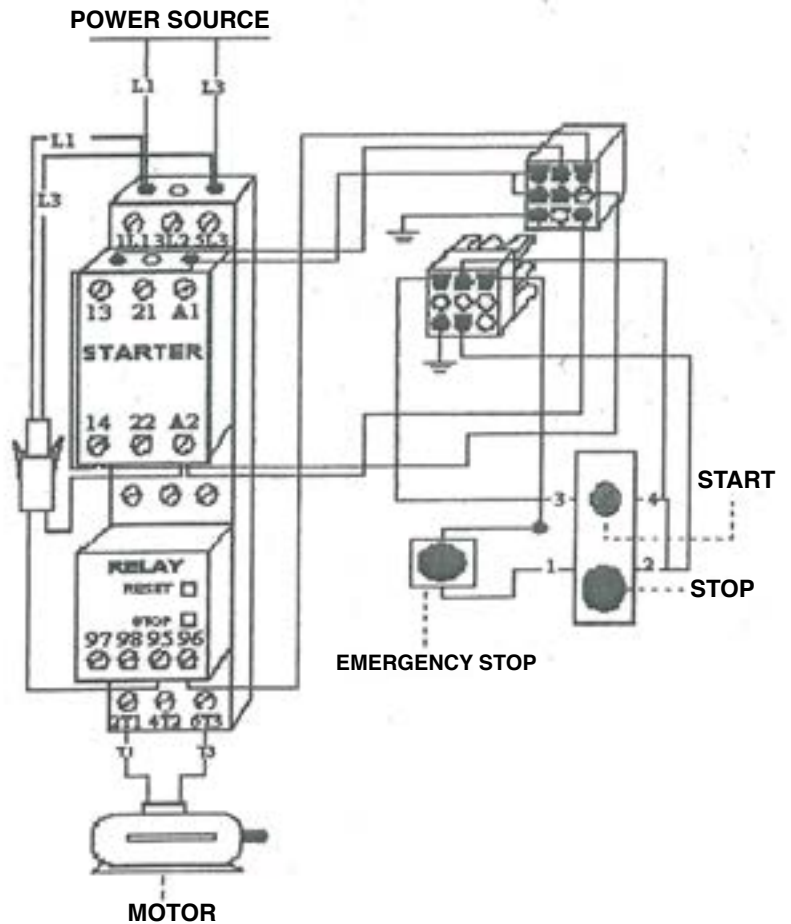
Source: Main Control Panel Relay

Destination: Pump Motor

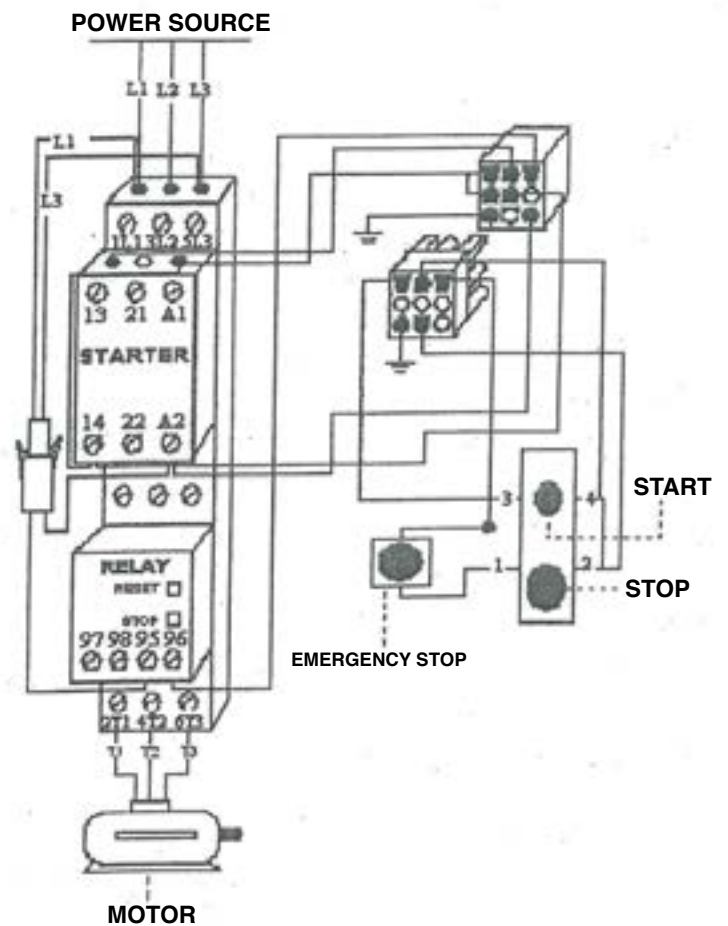
Core No.	Relay Terminal No.	Motor Terminal No.	Function
Earth	Earth	Earth	Earth
1	2 -T1	Either	Motor Winding
2	6 -T1	Either	Motor Winding

Note: Connect Motor Terminals for Motor rotation to be CLOCKWISE at fan end.

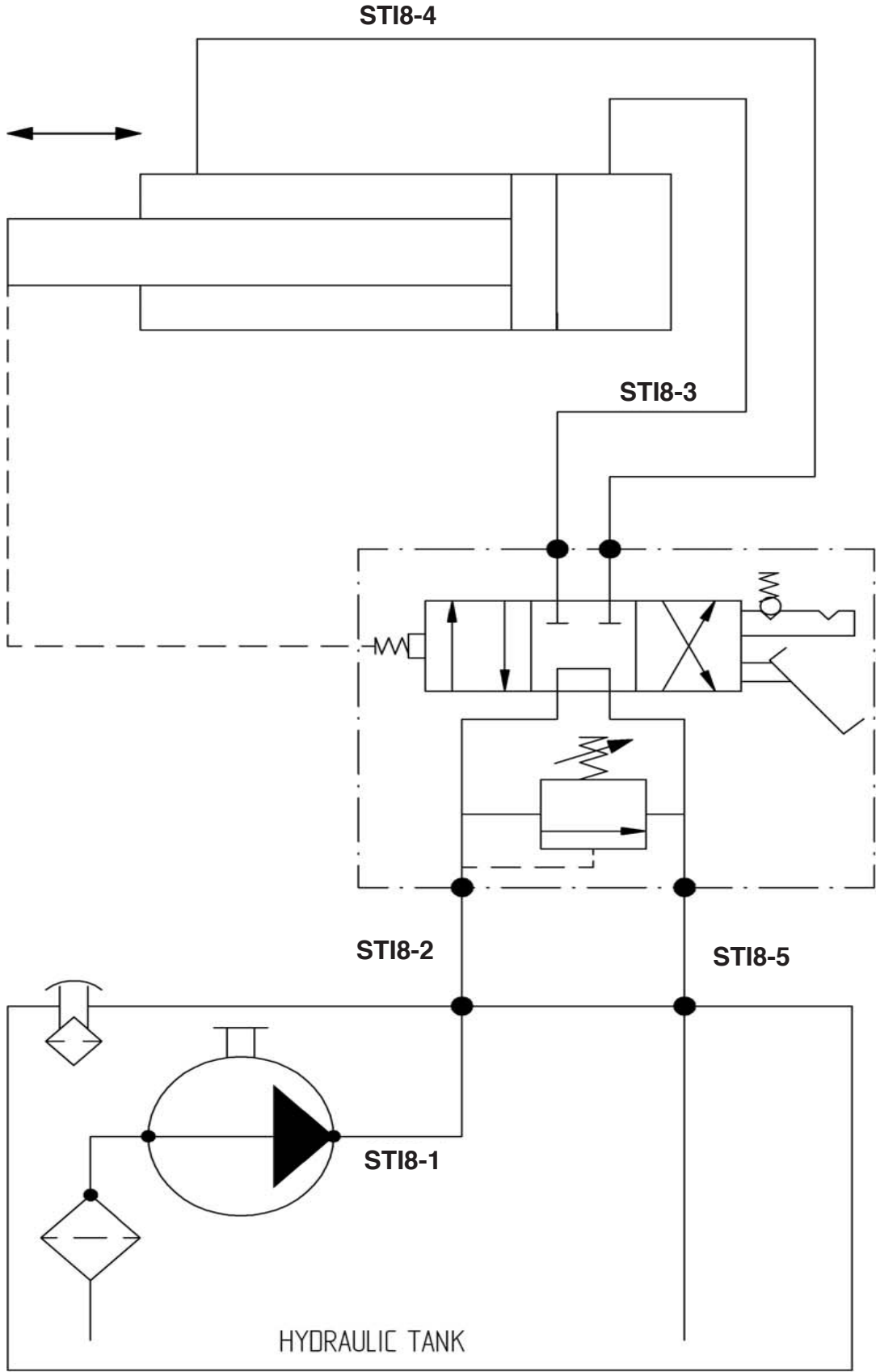
6.4.1 WIRING FOR A 110-220 SINGLE PHASE



6.4.2 WIRING FOR A 220-440 THREE PHASE



6.5. Hydraulic Circuit Diagram



6.6. Shear Blade Turning & Changing

(See Section 8.2, Page 45)



Always switch off and isolate the Shear from the main electrical supply before maintenance.



Always wear Gloves when handling Blades. Only use Strip Tec Blades.

6.6.1. Introduction

The Blades supplied with the Shear are not re-grindable, however they have four cutting edges and can be rotated through eight cutting positions.

Note: The fixing screws are smeared with copper based grease to aid subsequent removal.

6.6.2. Replacing or Turning the Top Blade

- Close the Top Jaw, stop and isolate the Shear from the electrical supply.
- Remove the Top Blade.
- At this point, examine the Top Jaw where the Blade sits, it should be flat and burr free, file off any burrs or change if damaged. It is important that the Blade sits against the Jaw without any gaps. Rectify if this is not the case.
- Remove any burrs from the Top Blade, choose a new cutting edge and refit the Top Blade with the M16 Screws, Items 9. Ensure that the Top Blade Screws are tight.

Note: Top and Bottom Blades are interchangeable and should be replaced or turned at the same time for optimum Blade life and cutting performance.

6.6.3. Removing the Blade Guard

Excessive side movement in the Main Pivot Bearing will negate Bottom Blade settings. This requires the removal of the Blade Guard.

- Unscrew the Blade Guard Adjustment Handle and Washer, Items 2 and 3.
- Remove the right hand Fixing Screw and Washers, Items 6, 7 and 8.
- Support the Blade Guard, Item 5, and slide the Guard Pivot, Item 1, out from the left side.
- The Guard can then be lifted and removed from the Shear.

Note: When replacing the Blade Guard grease the Guard Pivot before refitting.

6.6.4. *Removing side movement from the Main Pivot*

With the Blade Guard removed it is possible to remove any side movement in the Main Pivot.

- First unscrew the Take-Up Screw, Item 23, by about six turns.
- Remove the Pivot Lock Nut's Grub Screw, Item 19.
- With the aid of a soft drift or peg spanner tighten the Pivot Lock Nut, Item 20, as far as possible.
- Replace Grub Screw and tighten.
- Re-tighten the Take-Up Screw and its Lock Nut.

6.6.5. *Replacing or Turning the Bottom Blade*

Before replacing or turning the Bottom Blade remove any side movement from the Main Pivot as any side movement will negate Bottom Blade setting and will reduce cutting efficiency and Blade life.

- Close the Top Jaw, stop and isolate the Shear from the electrical supply.
- Remove the Bottom Blade.
- Slide Bottom Blade into place, with a new cutting edge selected, and temporarily fit two ISO M16 Cap Screws, Item 16, and nip up tight. This will allow the correct amount of shims to be selected.
- Steel shims are available in thicknesses of 0.125mm 0.25mm and 0.50mm (0.01", 0.02" & 0.04"). It is preferable to use thicker shims rather than multiples of thin shims. Test the gap between the Top and Bottom Blade with the appropriate amount of shims adding or subtracting if necessary. A push fit should be achieved with the shims at the mid point and both ends of the blades. If the gap at the front of the blades (furthest from the pivot) is larger or smaller than the gap nearest to the pivot, it will be necessary to readjust the Take-Up Screw. Unscrewing the Take-Up Screw widens the gap at the front of the Blades and screwing in the Take-Up Screw closes the gap at the front of the Blades.
- When an equal gap is achieved and the right amount of shims selected remove the Bottom Blade and place the shims between where the Blade sits and the Bottom Jaw. Then replace the Blade with a new cutting edge selected.
- Fit all three ISO M16 Cap Screws and tighten equally. There should now be a gap between the top and bottom blades, the gap size must not be less than 0.125mm (0.005") along the length of the blade. If a gap exists greater than 0.25mm (0.01") then more shim steel may be added between the Blade and the Bottom Jaw.



Never set the Blades in hard contact with each other.

- At no time must the Top and Bottom Blades be set in hard contact with each other, this can be dangerous to the Operator and will also result in short Blade life.
- The ISO M16 Cap Screws should not protrude from the Blades when fully tightened, Rectify if this is the case.

- Replace and correctly position the Blade Guard if removed or repositioned. It is good working practice to grease the Guard Pivot before reassembly whenever the Guard is removed.

6.6.6. *Starting the Shear after Changing or Turning the Blades*

Before starting the Shear ensure the Blade Guard has been replaced and correctly positioned.



Never operate the machine with the Blade Guard Removed

On starting up the Shear the Top Jaw will automatically return to the Open position. On first closing of the Jaws exercise a slow controlled approach speed and ensure no hard contact of Blades exist. Rectify if hard contact occurs.

6.7. Resealing the Hydraulic Rams

(See Section 8.3, Page 46)



Always switch off and isolate the Shear from the main electrical supply before maintenance.

- Before removing the Hydraulic Ram from the Shear, ensure that a chock has been fitted between the Blades of the Top and Bottom Jaws, this will stop the Top Jaw swinging down and causing any damage or injury.



Always chock the Top Jaw to stop movement.

- Fully protect the extended chrome Piston Rod, Item 6, from scuffs and bruises. Plug all disconnected hydraulic pipes and fittings. Also plug the Cylinder, Item 17, ports.
- Remove the Hydraulic Ram to a clean area, preferably under cover away from the weather. Protect from dirt or dust. Ensure that the Ram is safely supported remembering that the centre of gravity will change as it is dismantled.
- Hold the main Cylinder Body, in a vice, taking care not to deform the Cylinder tube.
- Remove the Grub Screw, Item 18. With a peg spanner, unscrew the Gland, Item 8, and pull the Piston Rod, out of the Cylinder with all internals attached.
- The Ram Seal Kit consists of Items: 7, 9, 10, 12, 13 and 14. When removing seals from the Hydraulic Ram make notes of any seal identification marks and note the

relevant position of the seal marks relative to the Piston Rod or Cylinder. Ensure that new seals have the same identification marks as the seals previously fitted to the Ram.

- Remove the Pin, Item 16, from the Rear Piston Half, Item 15. Once removed, unscrew the Rear Piston Half and slide all components off the Piston Rod. Inspect the Piston Rod and remove or polish out any burrs or score marks. Deep score marks to Piston Rods may be temporarily filled with an epoxy putty providing that it is properly applied.
- Remove the Wiper seal, Item 7, from the Gland. Also remove the 'O' ring, Item 10, and the Single Acting Seal, Item 9. Examine for burrs and score marks. If all seems satisfactory, fit a new 'O' ring along with a new Single Acting Seal - note, fit radiused and numbered side of seal inward and towards the pressure, the flat side facing outward. Fit a new Wiper Seal then slide the Cylinder Gland on to the Piston Rod.
- Remove the 'O' Rings and Piston Seal, Items 12, 13 and 14, from the Front and Rear Piston Halves, Items 11 and 15. Examine both Piston Halves for burrs and score marks. If all seems satisfactory, fit a new Piston Seal. Also fit new 'O' rings. Slide the assembly on to the Piston Rod. Screw the Rear Piston Half onto the Piston Rod. Ensure that the rear holes line up exactly, and refit the Pin, through both the Piston Rod and Rear Piston Half. Ensure the pin does not protrude from either side of the Rear Piston Half, rectify if this is the case.
- Wipe out the Ram Cylinder and ensure that the Cylinder bore is free from any score marks. If this is not the case, it will be necessary to polish out any light score marks. Otherwise seal damage will occur the instant the Hydraulic Ram is put under pressure. Deep score marks to Cylinder bores can not be adequately repaired - replace the cylinder. When all seems satisfactory, smear the Cylinder bore with Hydraulic Oil and refit the Piston Rod assembly into the Ram Cylinder.
- Tighten the Gland and refit the Grub Screw when the holes align.
- Examine the Cylinder clevis and the Piston Rod clevis bores for burrs and any defects. Test the bores with the appropriate Clevis pins prior to refitting the Hydraulic Ram.
- After refitting the Hydraulic Ram to the Shear, check the fluid level in the Hydraulic Tank before start-up and after the first cycle. If necessary top up with clean Hydraulic Fluid.



Only use genuine Strip Tec approved seals and parts. Use of non approved parts may invalidate the warranty.

6.8. Changing Suction Filter

(See Illustration's 6B-6C, Page 42 and Section 8.4, Page 47).



Always switch off and isolate the Shear from the main electrical supply before maintenance.

Isolate the Shear from the Mains Power Supply. Disconnect the motor cable at the Motor Terminal Box

Remove the motor cowl. Install the lifting eye into the top of the motor shaft. Unscrew the four Motor fix ngs and using suitable lifting equipment lift up the Electric Motor and store away from the working area.

Unscrew the four Bell Housing Screws, then lift the Bell Housing. Unscrew the Hydraulic Pump Delivery Hose connection taking care not to damage the gasket.

Lift the Bell Housing further to expose the Suction Filter. Unscrew the filter from the pump fitting and replace.

Reassemble in reverse.

6.9. Hydraulic System Relief Valve

(See Illustration 5C, Page 40)

This section requires the use of a combined flow and pressure meter capable of measuring pressures from 0 to a minimum of 250 bar.

6.9.1. Testing for Over-Pressure

With the Shear switched off and isolated from the mains electrical supply:

- Install a pressure gauge in to the hydraulic system at the junction of the Hydraulic Tank Bulkhead fitting and the Pressure Line Hose number STI-8-2 (See Section 6.5, Page 28).
- Place a substantial item, known to be above the shearing capacity of the Shear and long enough to pass under the Blade Guard, into the Shear Jaw. Lock the Blade Guard in the down position then turn on and start up the Shear.
- Keep a watchful eye on the pressure gauge and slowly depress the Foot Pedal until the pressure gauge reading is stable. If the pressure gauge reading is above 220 Bar (3200 PSI), the System Relief Valve must be reset to 220 Bar (3200 PSI).

IMPORTANT SAFETY NOTE:

A pressure gauge reading of less than 220 Bar (3200 PSI) is not to be taken as requirement to readjust the Hydraulic System Relief valve. Pressure loss elsewhere in the hydraulic system will also give a low pressure gauge reading (See Section 6.1 on Trouble Shooting and if uncertain contact the Manufacturer).

6.9.2. Resetting



Always switch off and isolate the Shear from the main electrical supply before maintenance.



Maximum Relief Valve setting is 220 BAR (3200 PSI).

With the Shear switched off and isolated from the mains electrical supply:

- Install a pressure and flow meter in to the Hydraulic System, at the junction of the Hydraulic Tank bulkhead fitting and the pressure line hose number 200B-2 (See Section 6.5, Page 28). Ensure that the flow meter valve is fully open to give no resistance.
- Turn on and start up the Shear. Keep a watchful eye on the flow meter pressure gauge, and slowly close the flow meter valve until, and not more than 220 Bar (3200 PSI) is reached. This will establish that the Hydraulic Pump is able to produce the maximum working pressure of the Shear.
- Ensure that the Shear Top Jaw is in the fully open position. Switch off and isolate the Shear from the mains electrical supply.
- Disconnect the flow meter, and reconnect hose number 200B-2 to the Hydraulic Tank bulkhead. Disconnect pressure line hose number 200B-3 from the rear port of the Hydraulic Cylinder, and connect this hose to the inlet side of the flow meter. Remove the Filler Breather Cap from the Hydraulic Tank, and use a short hose from the outlet of the flow meter to the tank filling point, completing the circuit.
- Ensure that the flow meter valve is fully open, to give no resistance. Locate the Foot Pedal control to a comfortable operating distance from the flow meter. Start up the Hydraulic Pump motor and keep a watchful eye on the flow meter pressure gauge. Fully depress the Foot Pedal control and keep it depressed. At the same time, slowly close the flow meter valve until one of two things happen :
 1. The pressure gauge reading stops increasing at or below 220 Bar (3200PSI).
 2. The pressure gauge reading continues increasing and passes 220 Bar (3200PSI).



Do not for any reason allow the pressure to rise above 228 Bar (3306 PSI).

- At this point release the Foot Pedal and allow the Shear to run in neutral for a few minutes. This will prevent the Pump Motor from overheating.

- If the hydraulic pressure is above 220 Bar (3200PSI) do not alter the flow meter setting. Depress the Foot Pedal and, with the aid of a 13mm spanner, reset the System Relief valve by first loosening the Lock Nut then turning the Relief Valve Adjustment Grubscrew anti clockwise until the flow meter pressure gauge reading is 220 Bar (3200PSI). Nip up the Relief Valve Lock Nut, ensure that the pressure gauge reading has not altered, and release the Foot Pedal.
- If the hydraulic pressure is below 220 Bar (3200PSI), alternate between slowly closing the flow meter valve and turning the Relief Valve Adjustment Grubscrew clockwise until the hydraulic pressure is up to, and not above, 228 Bar (3306 PSI). Then, by adjusting only the System Relief Valve Grubscrew, lower the hydraulic pressure to 220 Bar (3200PSI). Nip up the Relief Valve Lock Nut, ensure that the pressure gauge reading has not altered, and release the Foot Pedal.
- After either of the above, switch off and isolate the Shear from the mains electrical supply.
- Reconnect all hoses, examine the Hydraulic Fluid Level Gauge and top up if needed. Return the Filler Breather Cap.



Check all hose connections are secure and Do Not leak before running the machine for long periods.

6.10. Foot Pedal Control Cable

(See Illustration's 5A & 5D, Pages 39 & 41 and Section 8.5, Page 48)



Always switch off and isolate the Shear from the main electrical supply before maintenance.

6.10.1. Renewing the Control Cable

To fit a new Control Cable, first remove the old Cable by starting at the Foot Pedal and work towards the Shear.

- Remove the Clevis, Item 50, and Horseshoe Clip Pin, Item 52. Save these for later assembly.
- Slide the PVC Dust Cap, Item 49, off the Control Cable
- Remove the Control Cable Cleat, Item 43, and fixings, Items 44, 45 and 46. Note the position of the Cable relative to the Mounting Plate, Item 48, and remove the Lock Nut, Item 47, releasing the Cable from the Foot Pedal Housing.
- At the Shear end of the Control Cable, slacken off the Chain Link Adaptor Lock Nut. Turn the inner part of the Control Cable to unscrew the Cable from the Chain Link Adaptor, Item 4.

- Note the position of the Cable relative to the Mounting Bracket. Slide the PVC Dust Cap upwards, and unscrew the inside Lock Nut, Item 2, thereby releasing the Cable from the Shear.
- Lightly oil each end of the new Control Cable, and using the saved Clevis parts, refit the new Cable in reverse. Take care to press home the PVC Dust Caps at each end of the Cable.

Note: Replacement parts are available at cost from Strip Tec Systems

6.10.2. *Adjusting The Control Cable*



The Foot Pedal Plate must not be adjusted higher than the sides of the Foot Pedal Housing.

Use the Lock Nuts either side of the Mounting Plate inside the Foot Pedal to raise and lower the Foot Pedal Plate position. When the Foot Pedal Plate is fully depressed, ensure that a clearance of $\frac{1}{4}$ (0.25in) is maintained between the Foot Pedal Plate and the Foot Pedal Housing.

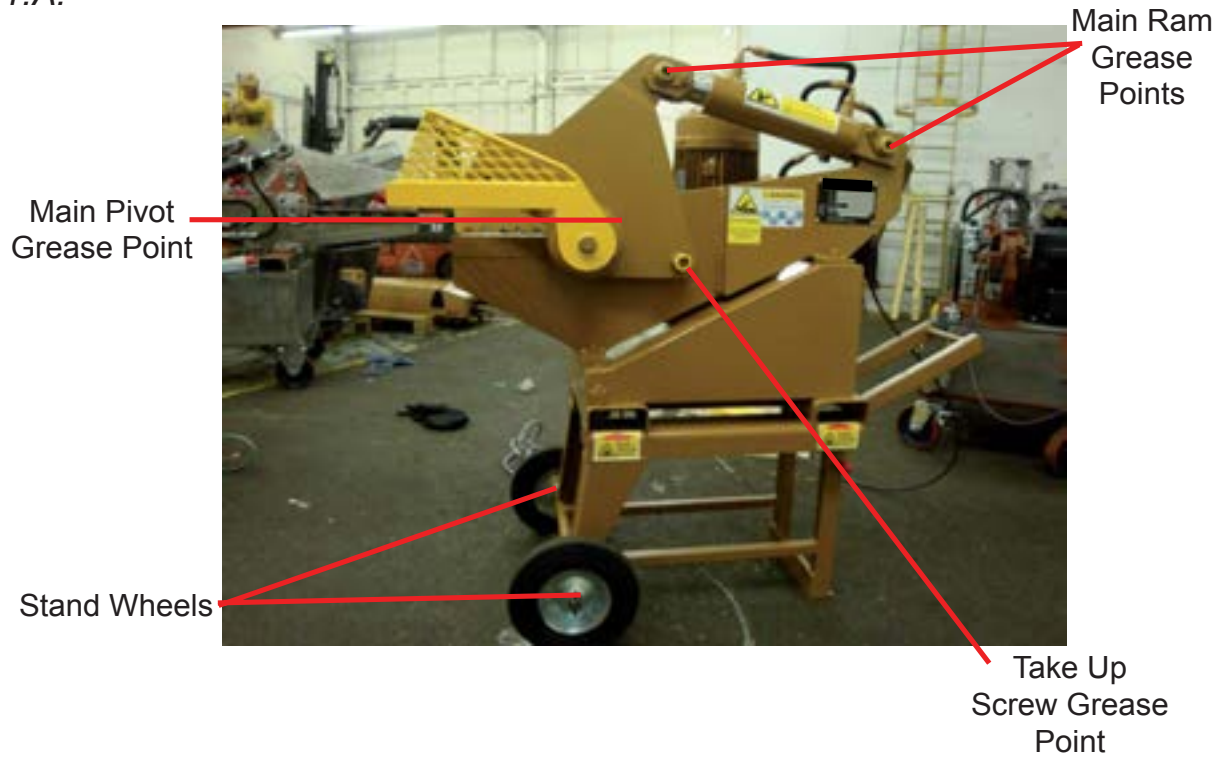


Do not modify in any way the mechanism or the intended operation of the Foot Pedal control. Never adjust the Foot Pedal Plate to be higher than the Sides of the Foot Pedal Housing

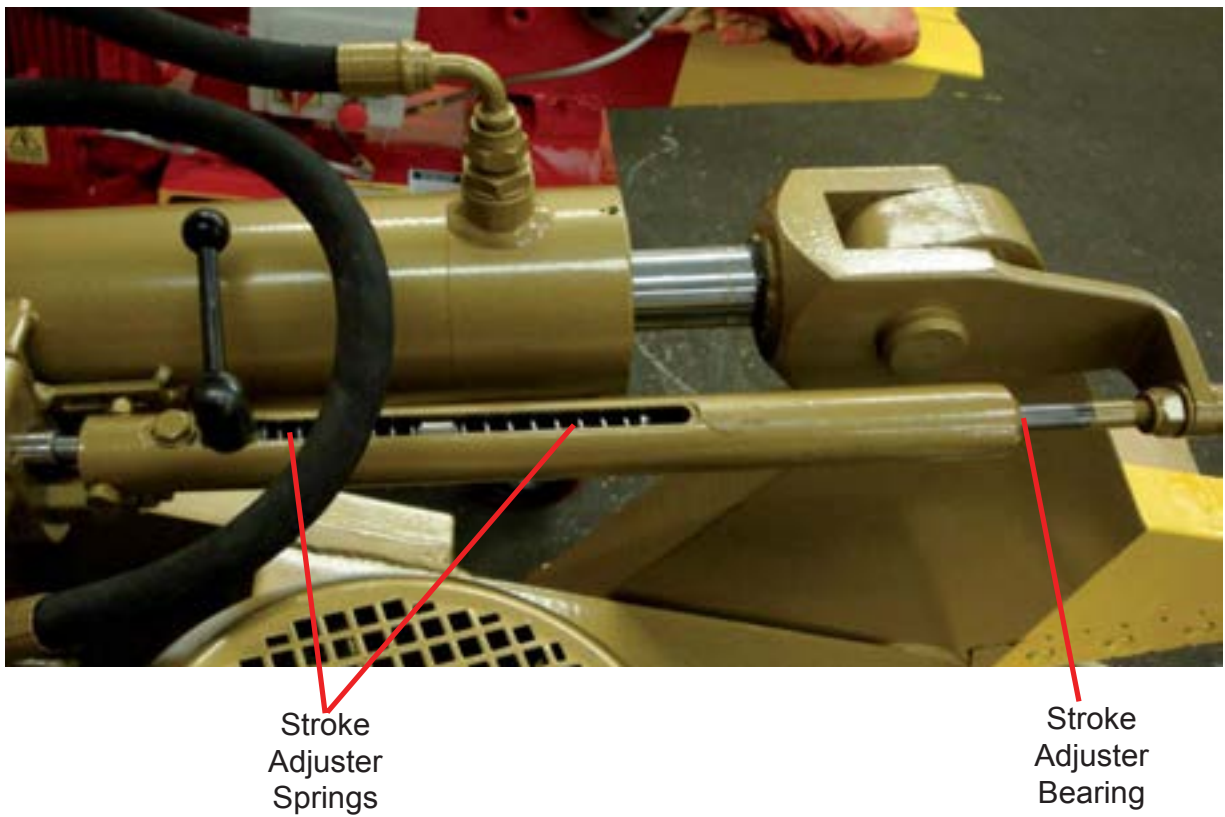
7. Illustrations

7.1. Grease Points

1.A.



1.B.



7.2. Hydraulic Tank

2.A.



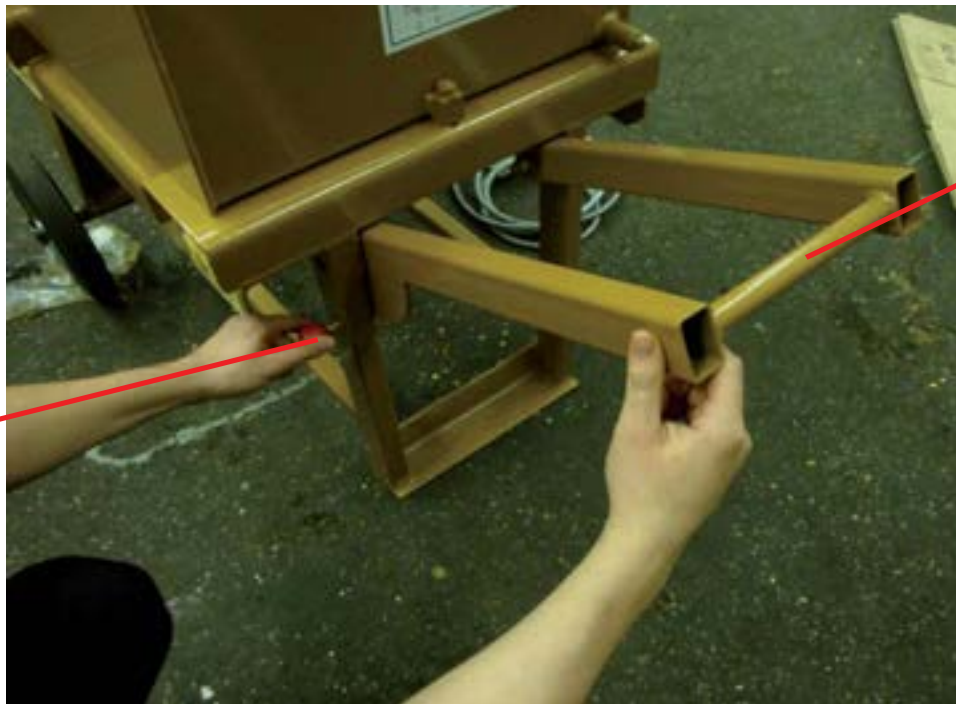
Filler /
Breather
Cap

Level &
Temperature
Gauge

Tank Drain
Plug

7.3. Shear Stand

3.A.

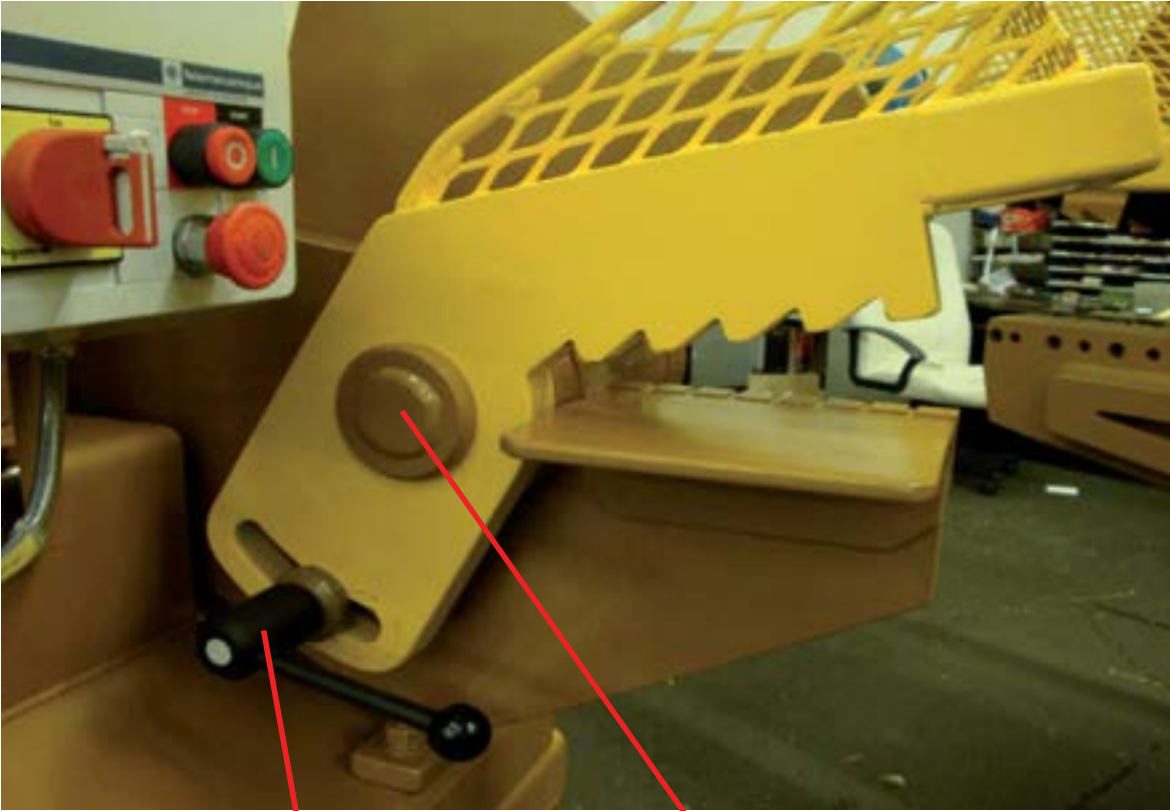


Red
Knob

Stand
Handle

7.4. Blade Guard

4.A.



Guard Adjustment Handle

Guard Pivot Pin

7.5. Foot Pedal & Stroke Control Mechanism

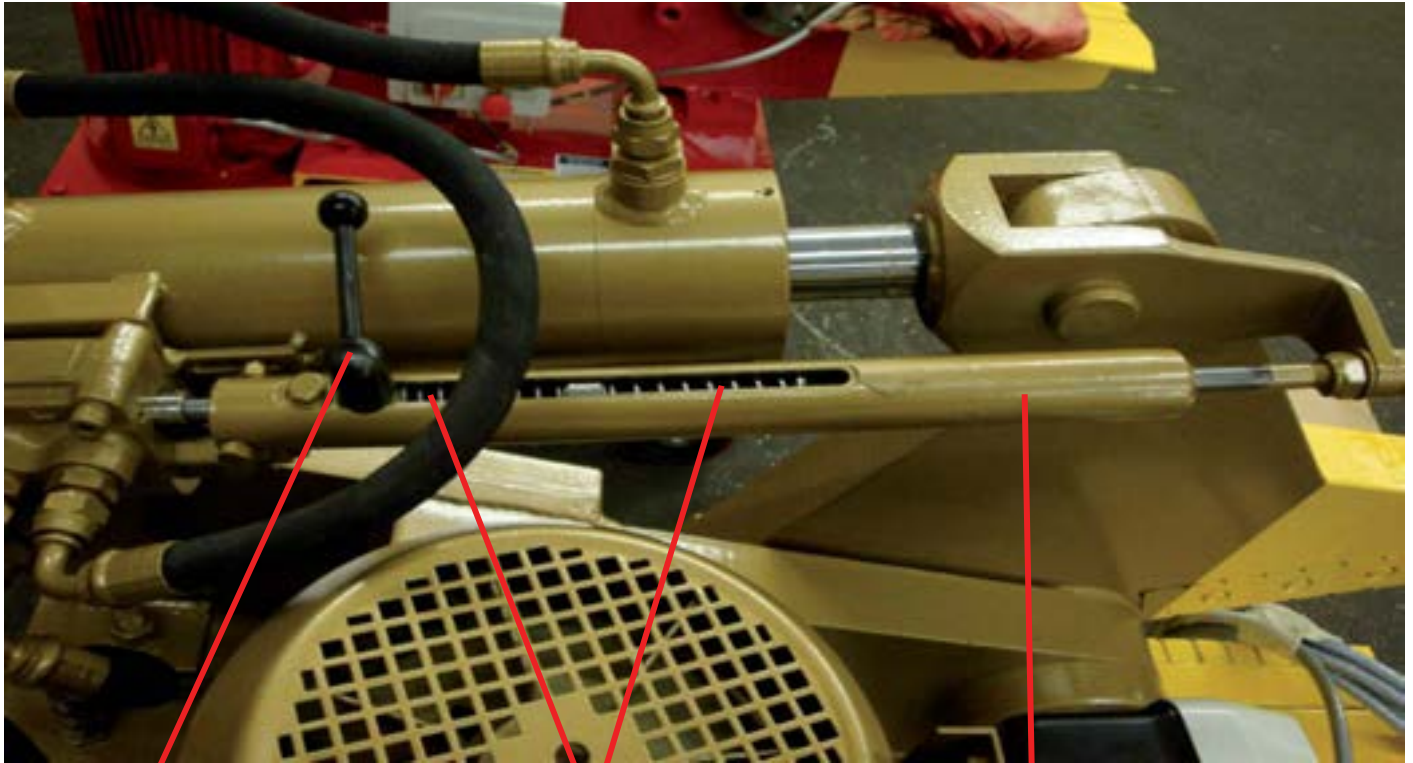
5.A.



Foot Pedal Housing

Foot Pedal Plate

5.B.

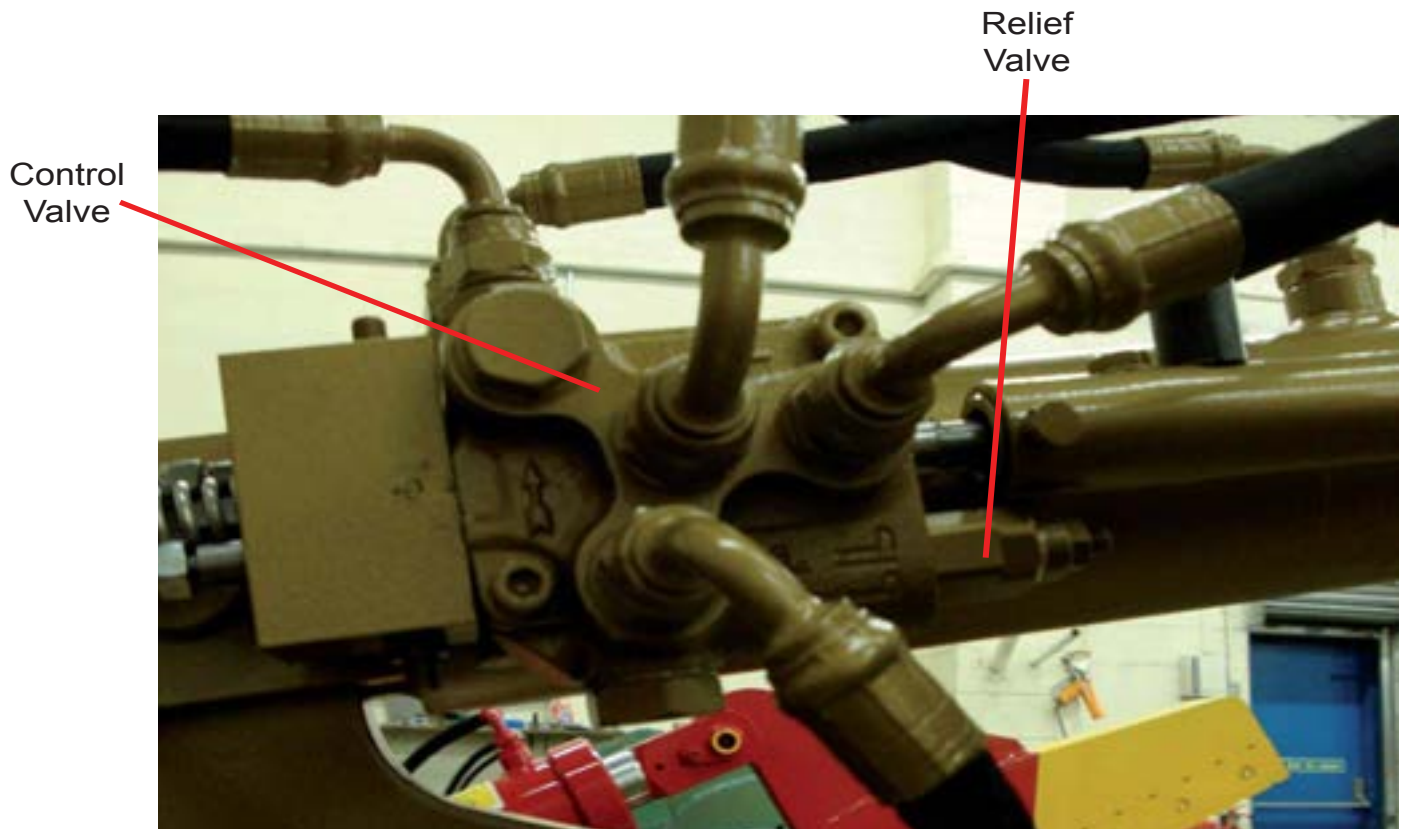


Stroke Adjuster Handle

Stroke Adjuster Springs

Stroke Adjuster Tube

5.C.



Control Valve

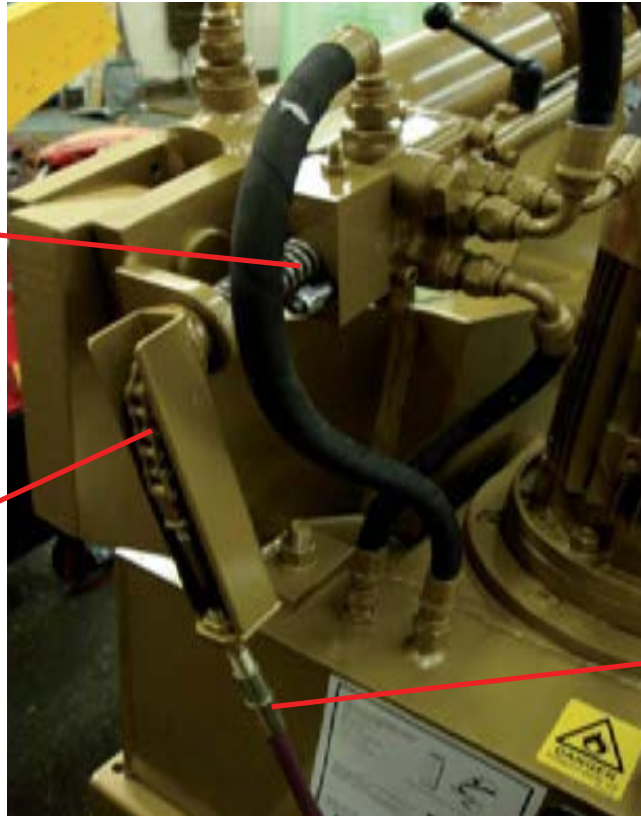
Relief Valve

5.D.

Valve Spring

Control Chain

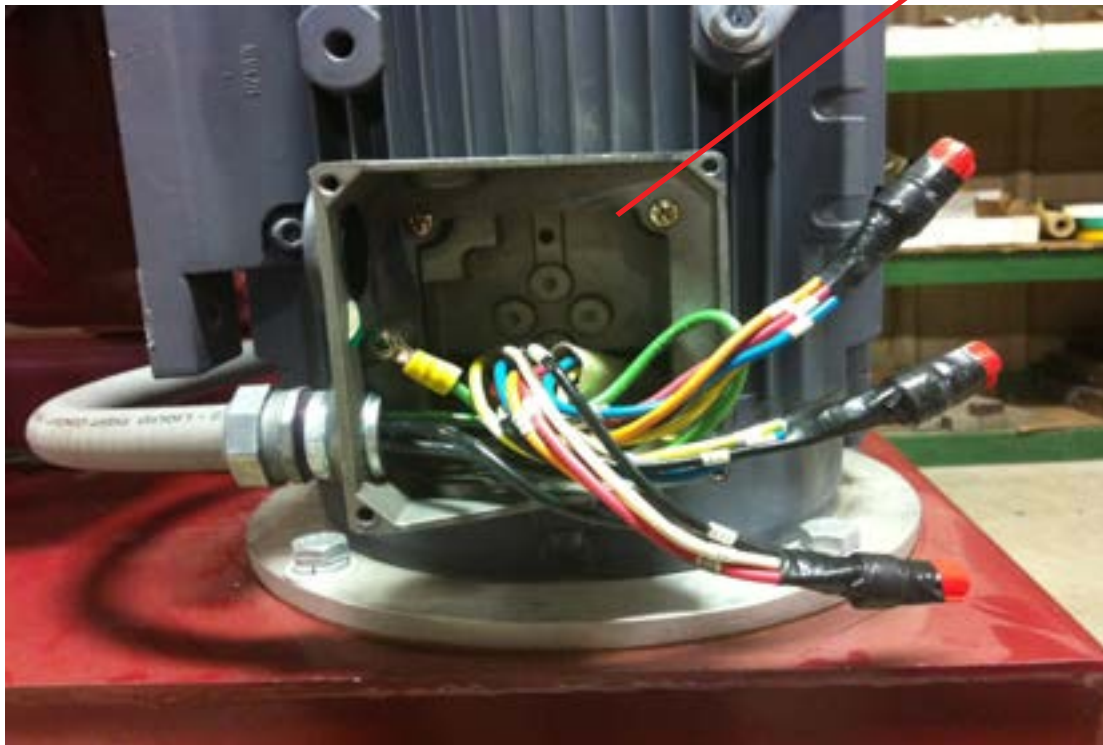
Control Cable



7.6. Motor, Pump & Bell Housing

6.A.

Motor Terminal Box



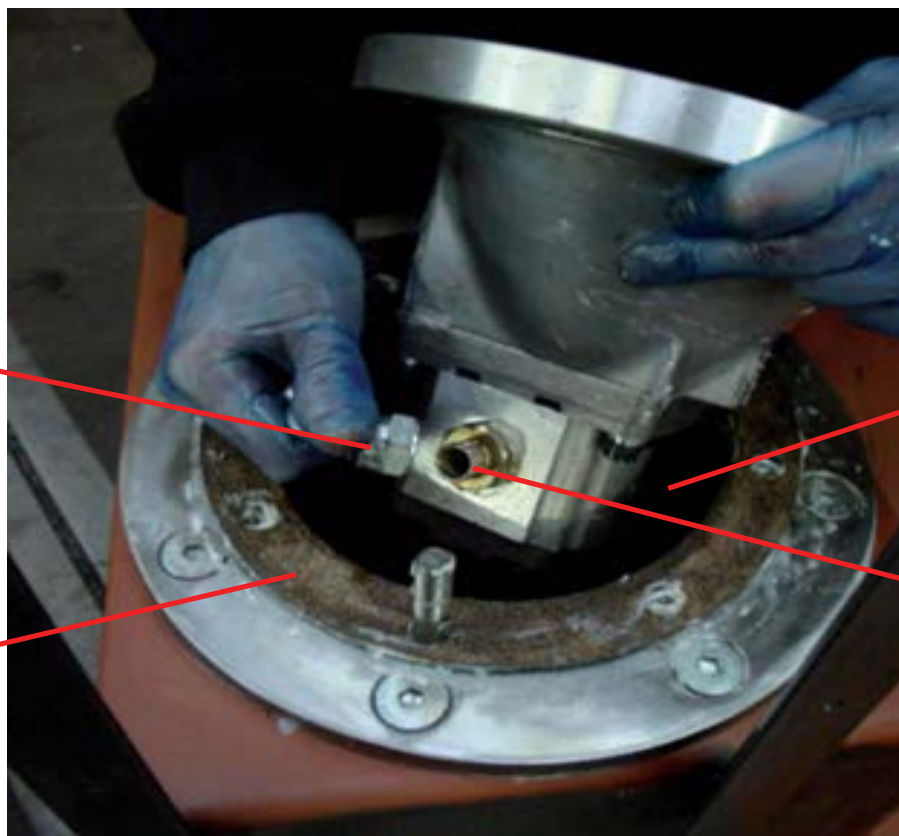
6.B.



Bell Housing

Drive Coupling

6.C.



Pump Hose

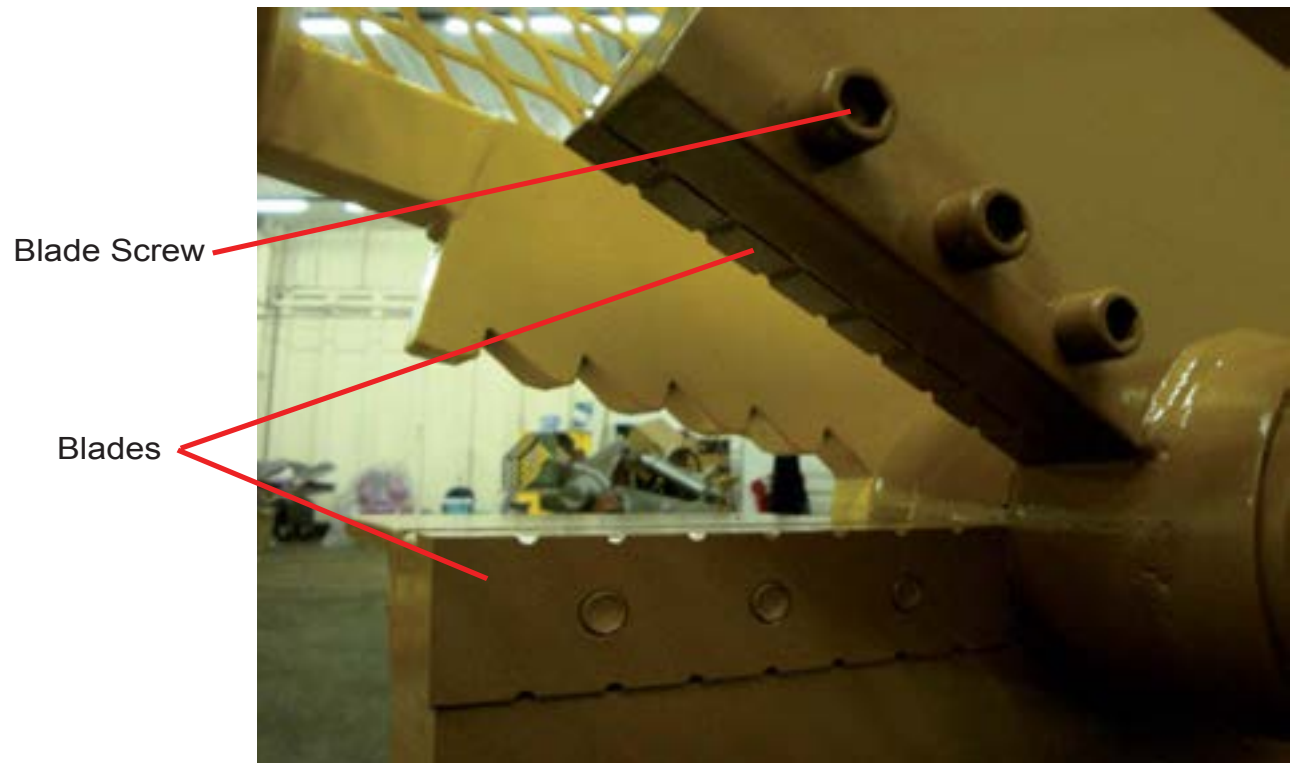
Suction Filter

Gasket

Pump Connection

7.7. Blades & Jaws

7.A.



8. Spare Parts

8.1. Ordering Spare Parts

When ordering spares you will need the following:

- Type of equipment
- Model number
- Machine serial number
- Voltage rating
- Color

This information will be found on the serial number plate attached to the machine. Please also quote the page and part number required.

Spares can be ordered directly from the manufacturer or by contacting your local agent.



For Safety and Optimum Performance only use Genuine Strip Tec Approved Parts. Use of non approved parts may invalidate the warranty.

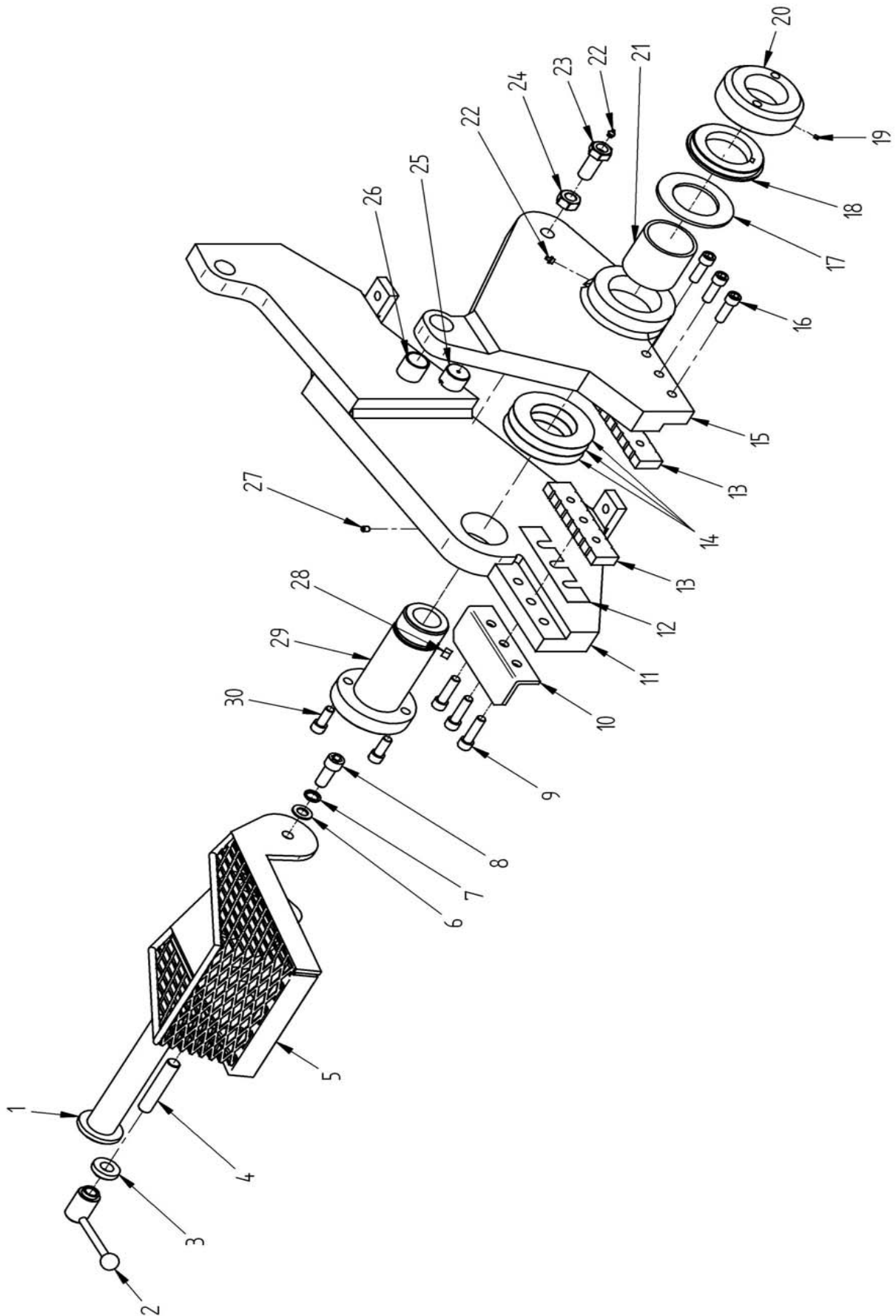
Strip Tec

3700 North Commerce Street

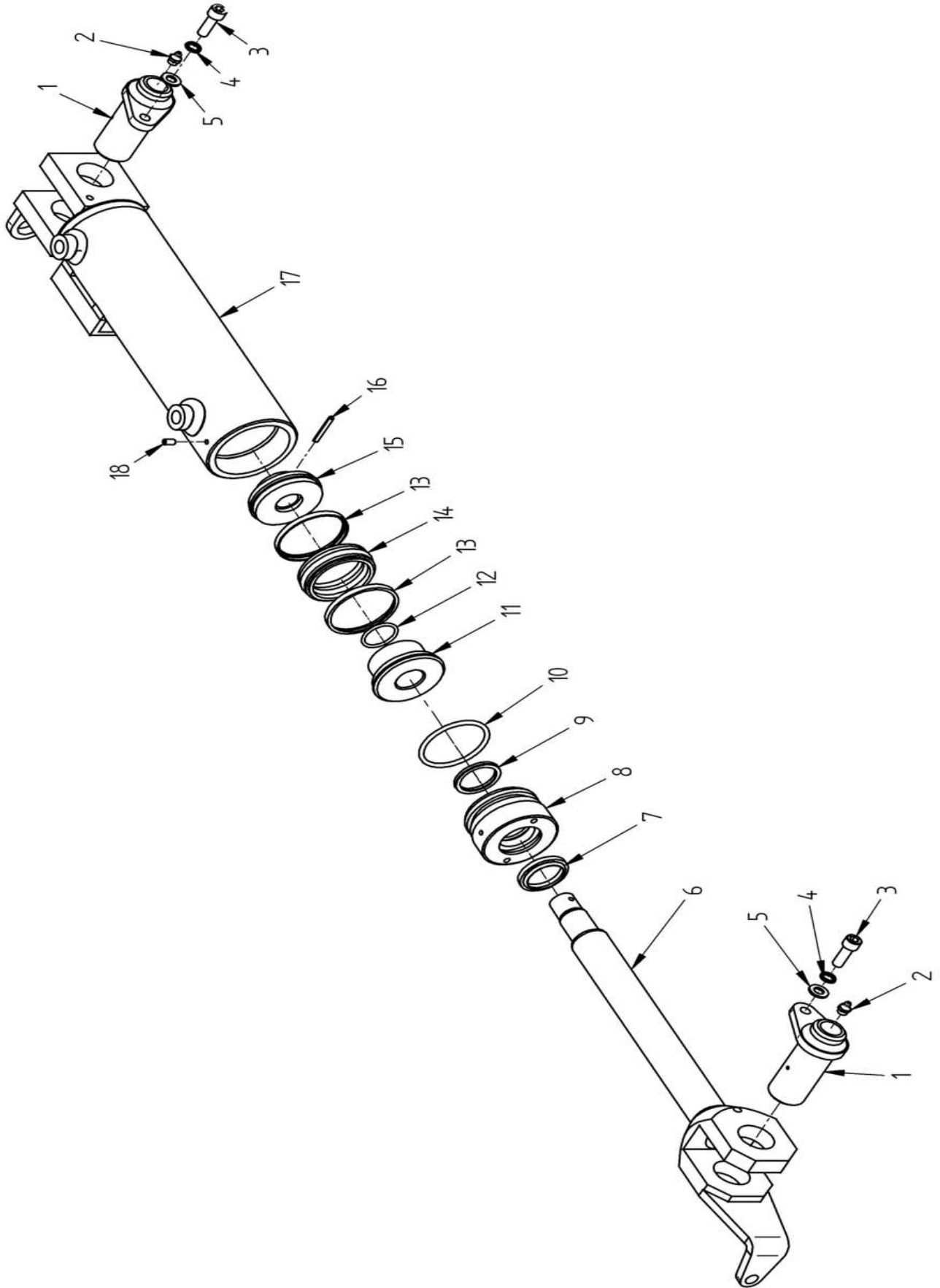
Fort Worth, Texas 76106

www.striptec.com

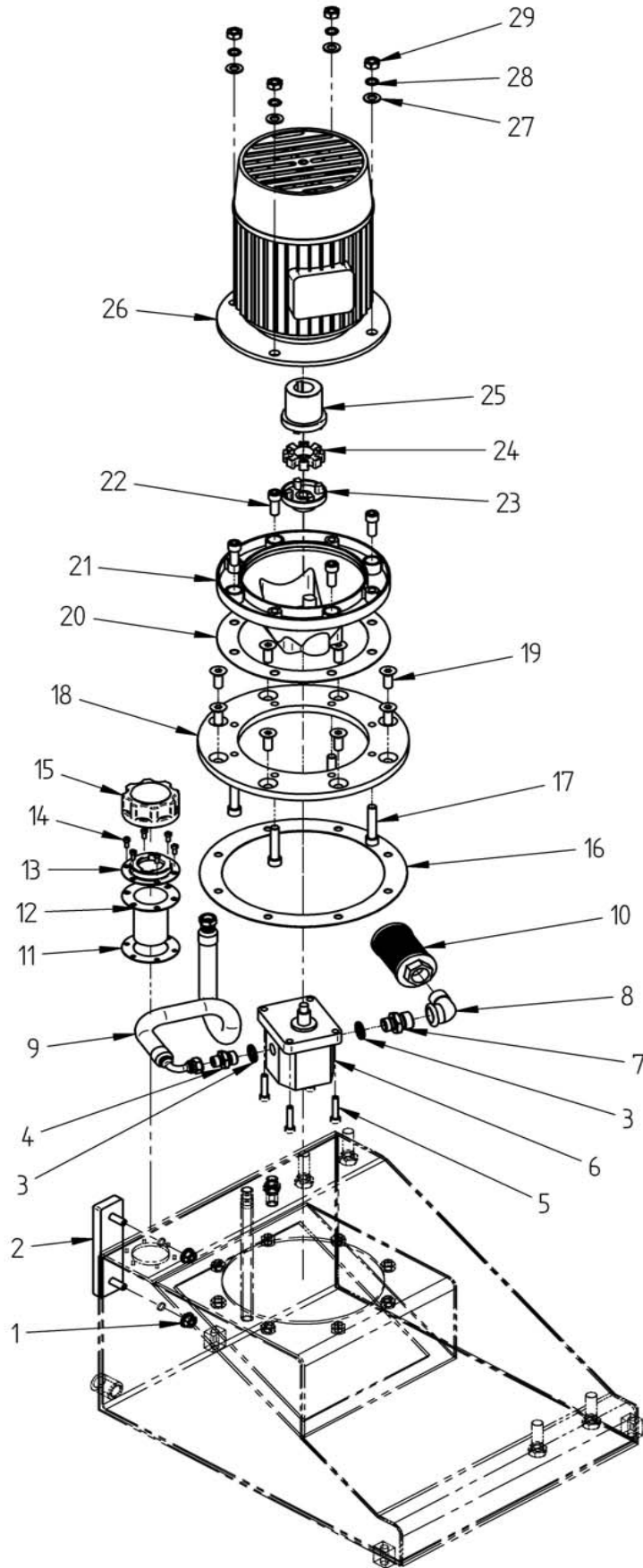
8.2. Shear Body & Guard



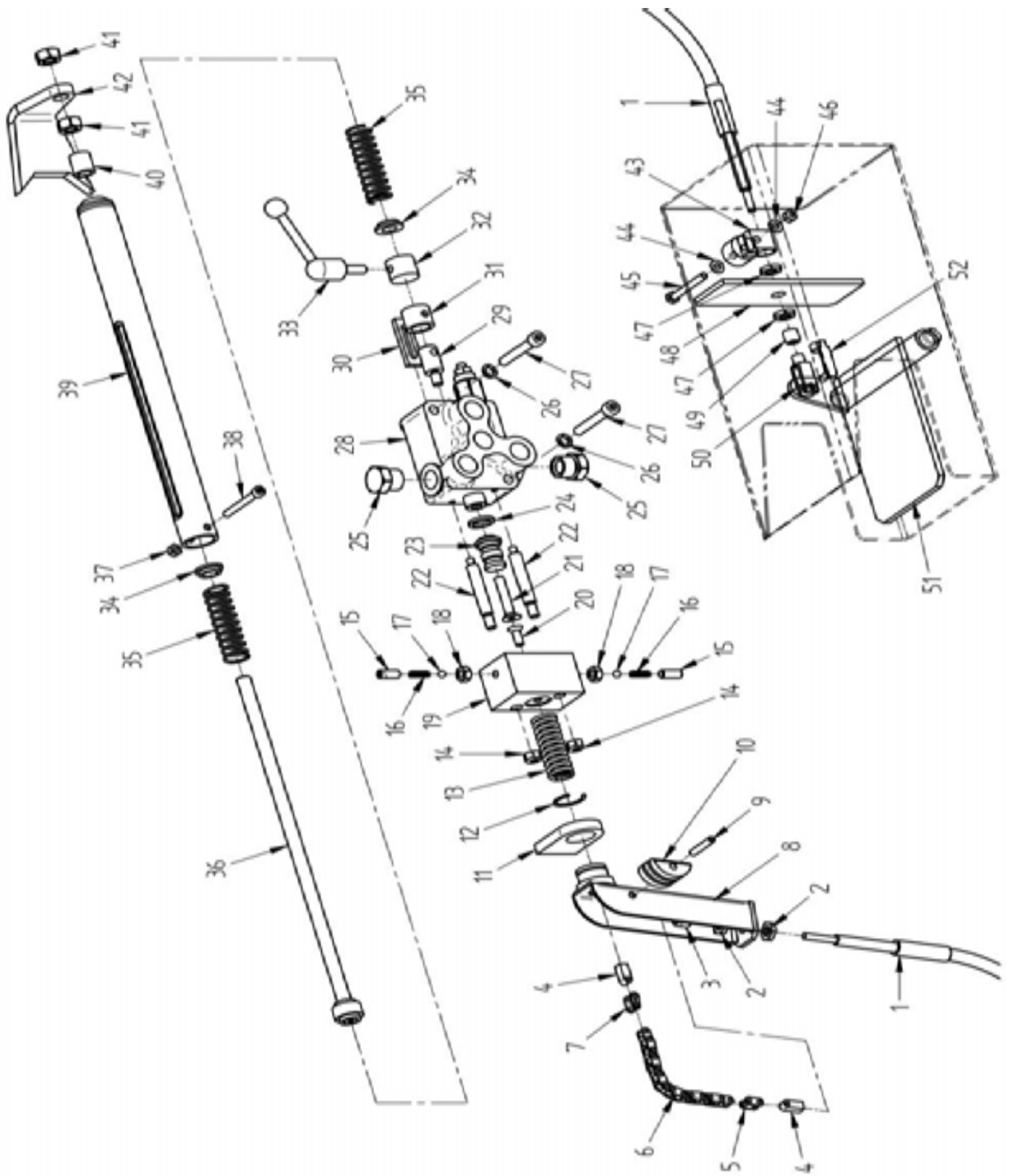
8.3. Hydraulic Ram



8.4. Hydraulic Power Pack



8.5. Stroke Adjuster & Foot Pedal Mechanism



9. Record Keeping

9.1. Useful Contacts

If you require any additional generic safety or operational information on the use of hydraulic alligator shears, or other scrap metal processing equipment, then the following contacts may be of assistance:

Institute of Scrap Recycling Industries, Inc (ISRI)
1325 G Street NW, Suite 1000, Washington DC 20005-3104, USA
Tel: +1 202/737-1770, Fax:+ 1 202/626-0900
www.isri.org email: isri@isri.org

American National Standards Institute (ANSI)
1819L Street, NW, Washington, DC 20036, USA
Tel: +1 202/293-8020, Fax: + 1 202/293-9287
General enquiries: + 1 202/642-4900
www.ansi.org

Occupational Safety & Health Administration (OSHA)
Office of Public Affairs – Room N3647
200 Constitution Avenue
Washington, DC 20210
Tel: +1 202/693-1999
www.osha.gov

Strip Tec
3700 North Commerce Street
Fort Worth, Texas 76106
www.striptec.com

9.2. Training, Safety & Ownership Records

The following pages are provided for photocopying as required.

- Operator Training Record
- Shear Safety Checklist
- Owner Registration Form



Always chock the Top Jaw to stop movement.



Do not use any heat source to cut open the Hydraulic Tank

10. Operator Training Record

This Operating and Instruction Manual must be read before operating the equipment.

- It is the owner's responsibility to ensure that all operators are fully trained in the use of this equipment, and that each individual operator is given access to this manual.
- All operators should be fully trained in safe working practices, and be fully familiar with the safety features of this equipment, which include the Blade Guard, Foot Pedal, Control Cables and Warning Labels, and their correct usage.
- No unauthorised persons should operate this machine. No persons under the age of 18 should operate this machine.

For your protection, and for the safety of the operators, we have included the following record:

I have read this Operating and Instruction Manual and I am fully familiar with the safety features on this equipment. I understand that scrap metal processing can be hazardous and the importance of correct working practices:

Machine Owner:	Signature	Date
1st Operator	Signature	Date
2nd Operator	Signature	Date
3rd Operator	Signature	Date
4th Operator	Signature	Date
5th Operator	Signature	Date
6th Operator	Signature	Date
7th Operator	Signature	Date
8th Operator	Signature	Date
9th Operator	Signature	Date
10th Operator	Signature	Date
11th Operator	Signature	Date
12th Operator	Signature	Date
13th Operator	Signature	Date
14th Operator	Signature	Date
15th Operator	Signature	Date
16th Operator	Signature	Date
17th Operator	Signature	Date

Attach additional sheet for subsequent operators if necessary

11. Shear Safety Checklist

Shear Model:

Serial Number:

11.1. Warning Signs

Check that all Signs and Warning Labels are in place and in good, legible condition:

- Safety Instructions
- Protective Clothing Warning Sign
- Two Shear Hazard Labels
- Read Instruction Manual Label
- Foot Pedal Warning Label
- Inflammable Liquid Label

11.2. Machine Integrity

Check the following:

- Shear Blades - must be intact, seated correctly, free from chips or cracks
- Hydraulic fluid level
- Hydraulic fluid leaks
- Loose, missing or Damaged items
- Working area - must be free from obstruction, debris, oil and metal
- Ventilation Grills - must be free from obstruction
- Blade Guard - must be properly fitted and intact

11.3. Control Functions

Check the following Control Functions for correct operation:

- Mains Isolator
- Start Button
- Stop Button
- Foot Pedal
- Stroke Adjuster

Report all Problems to the Supervisor Immediately

Checked By (Print):

Signature:

Date:

Photocopy for use as required

12. Ownership Registration

If you have purchased your STI Shear second-hand, then please copy this form and use it to fax your details back to us. This will allow us to keep you informed of any updates relating to your equipment.

Contact:

Company Name:

Address:

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Telephone:

Fax:

Email:

Type of equipment:

Model:

Serial Number (shown on black plate):

Colour of equipment:

Strip Tec

3700 North Commerce Street

Fort Worth, Texas 76106

www.striptec.com

