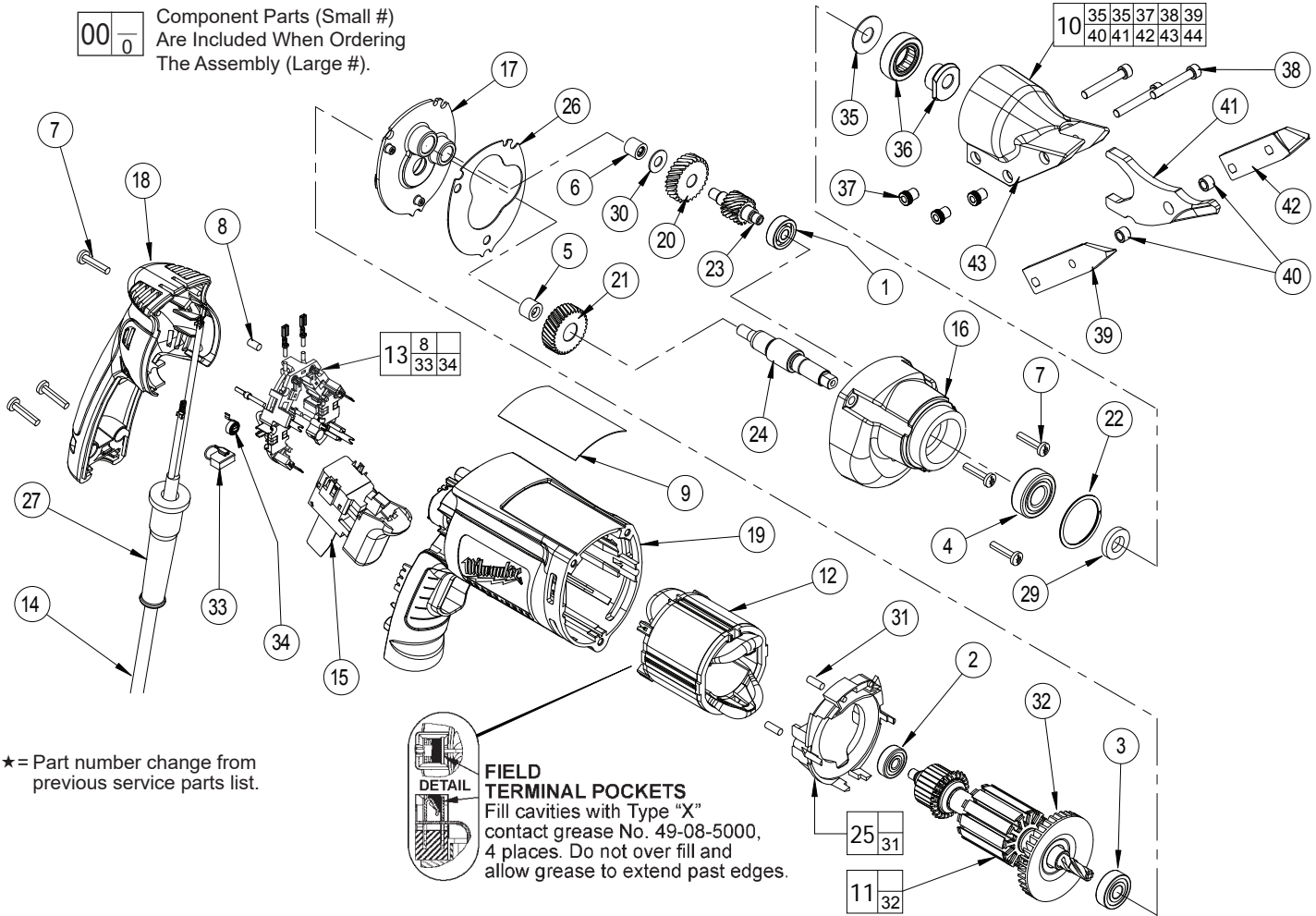


SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS			REVISED BULLETIN 54-44-0550	DATE Oct. 2019
18 GAUGE SHEAR				
CATALOG NO. 6852-20	SERIAL NUMBER PREFIX & BREAK	A80B	WIRING INSTRUCTION 58-01-1805	

EXAMPLE:

00 0
Component Parts (Small #)
Are Included When Ordering
The Assembly (Large #).



* = Part number change from previous service parts list.

FIELD TERMINAL POCKETS
Fill cavities with Type "X" contact grease No. 49-08-5000, 4 places. Do not over fill and allow grease to extend past edges.

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0640	Ball Bearing	(1)
2	02-04-0645	Ball Bearing	(1)
3	02-04-0852	Ball Bearing	(1)
★ 4	02-04-1020	Ball Bearing	(1)
5	02-50-1611	Needle Bearing	(1)
6	02-50-2400	Needle Bearing	(1)
7	06-82-7275	7-18 x .75 Slotted Plastite T-20	(6)
8	45-30-0035	Slug	(1)
9	12-99-2665	Service Nameplate	(1)
10	48-08-0500	Shear Head Assy. (Includes 35 thru 44)	(1)
11	16-10-2210	Armature Assembly	(1)
12	18-07-2206	Field	(1)
13	22-18-1210	Brush Card Assembly	(1)
14	22-64-6510	Cord Set	(1)
15	23-66-2587	Switch	(1)
★ 16	28-14-2394	Gearcase	(1)
17	28-28-2320	Diaphragm	(1)
18	31-15-2010	Handle Half	(1)
19	31-50-2010	Motor Housing	(1)
20	32-40-0100	Intermediate Gear	(1)
21	32-75-0115	Spindle gear	(1)
★ 22	34-80-1400	Retaining Ring	(1)
23	36-66-0125	Intermediate Pinion	(1)
★ 24	38-50-5754	Spindle	(1)
25	42-14-0450	Baffle Assembly	(1)
26	43-44-0985	Gasket	(1)
27	44-76-0210	Cord Protector	(1)
★ 29	45-88-0396	Chuck Washer	(1)
30	45-88-7990	Thrust Washer	(1)
31	45-30-0030	Slug	(2)
32	22-84-0845	Fan	(1)
33	22-18-1310	Brush Assembly	(2)
34	23-52-1610	Brush Spring	(2)
35	45-88-7310	Washer	(1)
36	43-16-0100	Eccentric Assembly	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
37	43-84-0460	Knurled Insert	(3)
38	06-75-2115	10-24 x 1-1/4 Skt. Hd. Cap Screw	(3)
39	48-44-0170	Blade - Right Side	(1)
40	42-40-0520	Bushing	(2)
41	48-44-0150	Blade - Center	(1)
42	48-44-0160	Blade - Left Side	(1)
43	43-76-0400	Shear Housing	(1)
44	49-96-0070	5/32 Hex Allen Wrench (Not Shown)	(1)

FIG. LUBRICATION:

16 Place 5 grams (3/16 oz.) of Type "Y" Grease, No. 49-08-5270 on top of the inserted intermediate ball bearing (1) and on the intermediate pinion (23). After inserting the balance of the gearing mechanism (20, 30, 28 and 21), place 13 grams (1/2 oz.) of "Y" Grease at the armature pinion centerline in the gearcase and fill to the top of the intermediate gear (20). Grease must contact at least 25% of the intermediate gear teeth.

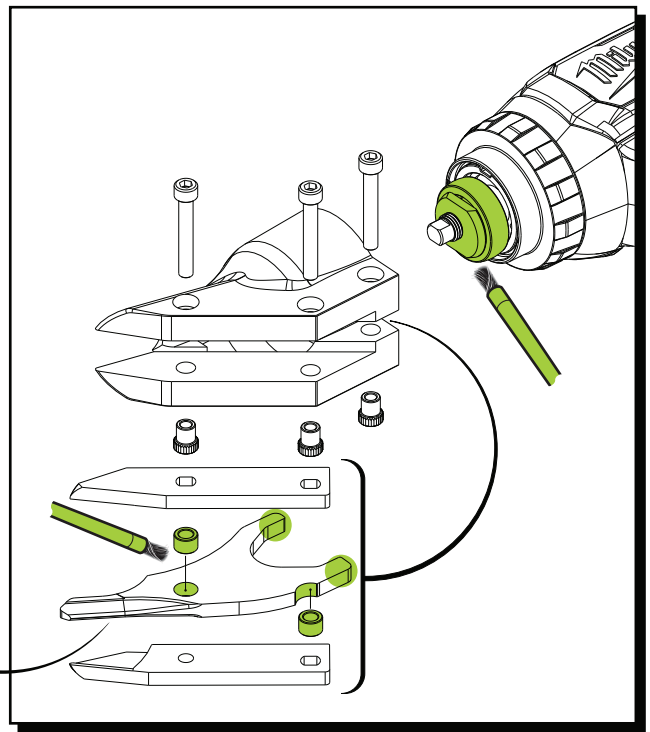
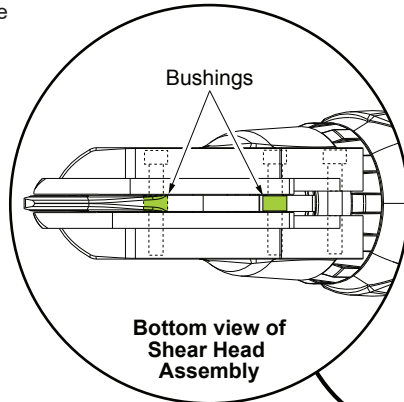
36,40,41 During assembly, use a dab of Type "E" Grease, No. 49-08-4122 to lubricate flats, pivot hole and sides of center blade (41), eccentric assembly (36) and bushing (40).

5,6,17 Before assembly, lightly coat all press fit areas with lightweight spindle oil.

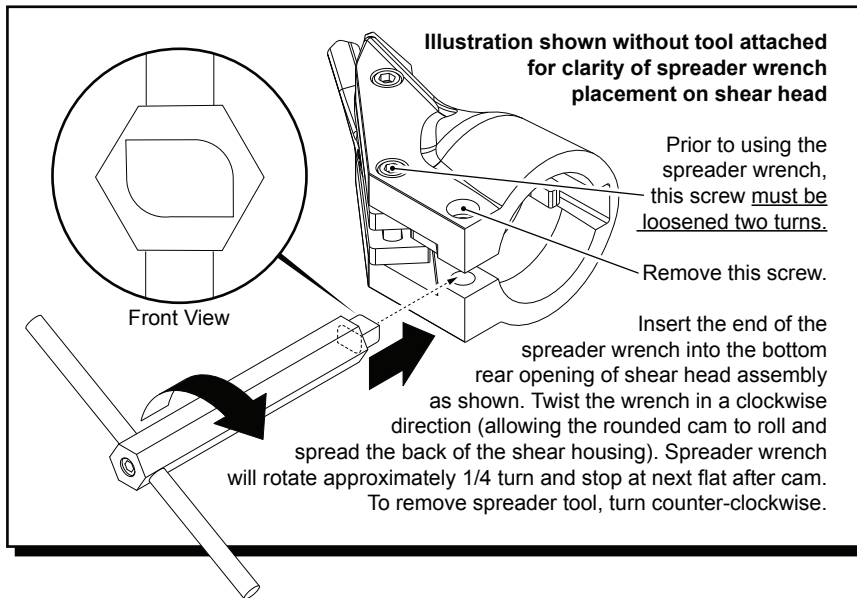
FIG. NOTES:

5,6,17 Needle bearings to be pressed flush to .010 under flush from the end which has the vendors identification.

When servicing **Shear Head Assembly No. 48-08-0500** pay close attention to the placement of the Bushings. One is to be placed in the hole of the Center Blade and is to be held in place with the front most screw on the Shear Housing. The other bushing is to be located below the small concave notch of the Center Blade and is to be secured with the middle screw on the Shear Housing. Prior to assembly, it is recommended to use Type 'E' Grease, No. 49-08-4122 on the following areas: Place a dab of grease in the pivot (bushing) hole and on the bushing notch of the Center Blade. Place a dab of grease on the rear flats of the Center Blade. Coat both bushings completely with grease. Place a liberal amount of grease on the entire Eccentric Assembly.



REMOVING SHEAR HEAD ASSEMBLY FROM TOOL



SERVICE TOOLS:

Spreader Wrench No. 61-30-0300
for 14 Gauge Shear Head 48-08-0505
used on Shear No. 2636-20

for 18 Gauge Shear Head 48-08-0507
used on Shear 2637-20

Spreader Wrench No. 61-30-0310
for 18 Gauge Shear Head 48-08-0500
used on Shears 2635-20 and 6852-20