



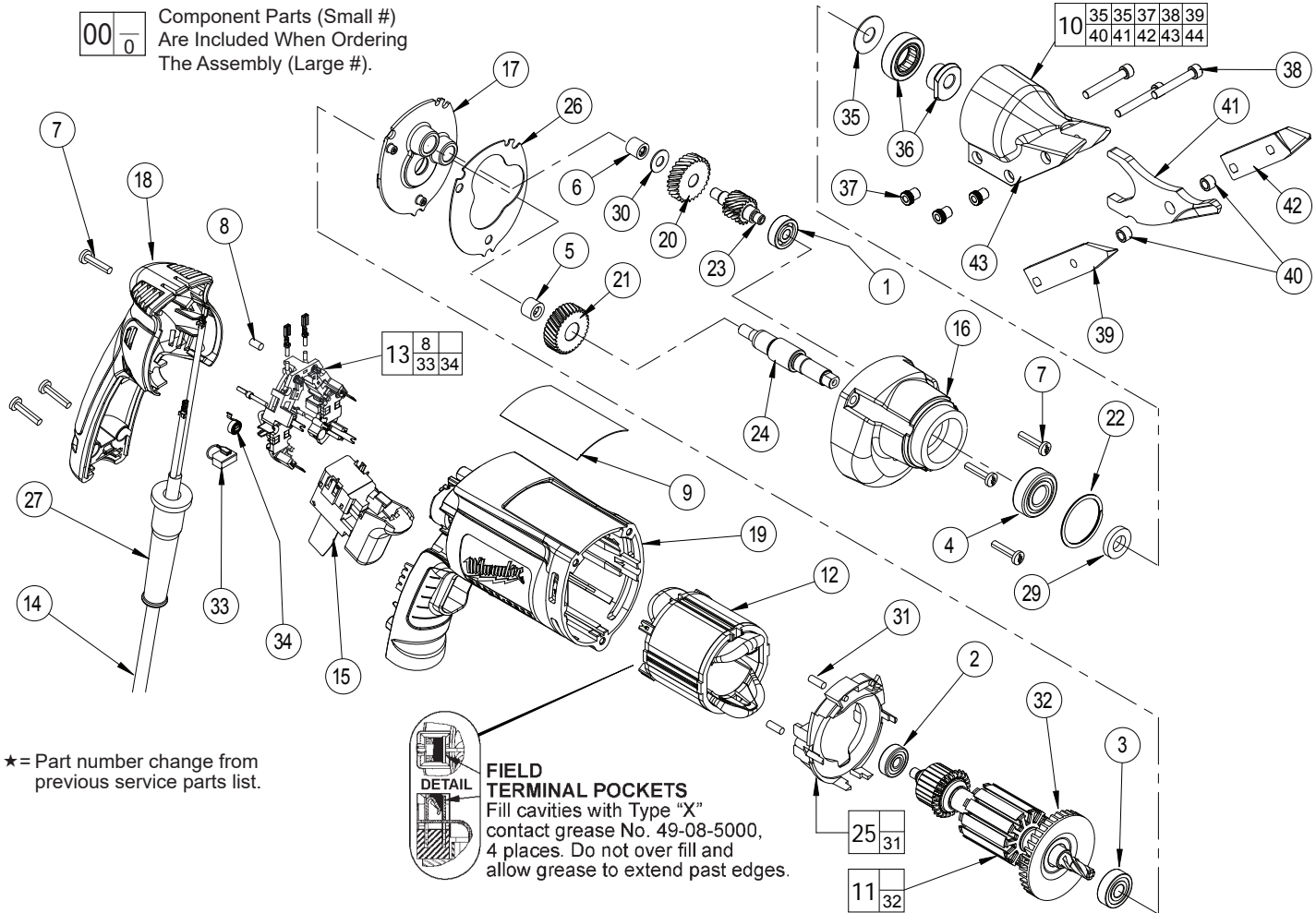
SERVICE PARTS LIST

BULLETIN NO.
54-44-0552

| | | | | |
|--|------------------------------|-------------|---|-------------------|
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN 54-44-0551 | DATE Oct. 2019 |
| 18 GAUGE SHEAR | | | | |
| CATALOG NO. 6852-20 | SERIAL NUMBER PREFIX & BREAK | A80C | WIRING INSTRUCTION 58-01-1807 | |

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 | 23-66-2625 | Switch | (1) |
| 16 | 28-14-2394 | Gearcase | (1) |
| 17 | 28-28-2320 | Diaphragm | (1) |
| 18 | 31-15-2010 | Handle Halve | (1) |
| ★ 19 | 31-50-4010 | 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) |

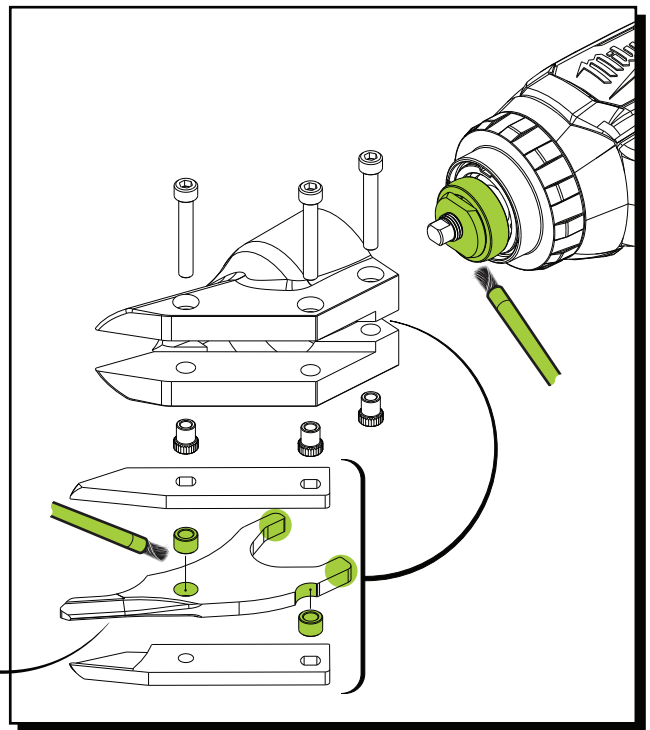
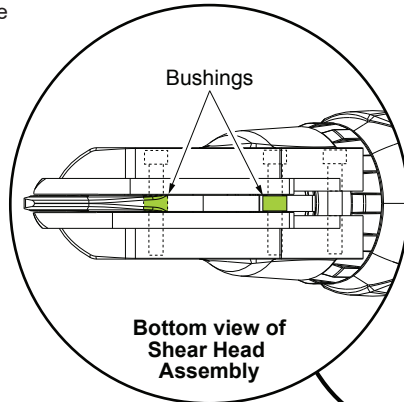
FIG. 16 LUBRICATION:
Place 5 grams (3/16 oz.) of Type "Y" Grease, No. 49-08-5270 on top of the inserted intermediate ball bearing (1) and on the intermediate pinion (23). After inserting the balance of the gearing mechanism (20, 30, 28 and 21), place 13 grams (1/2 oz.) of "Y" Grease at the armature pinion 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).

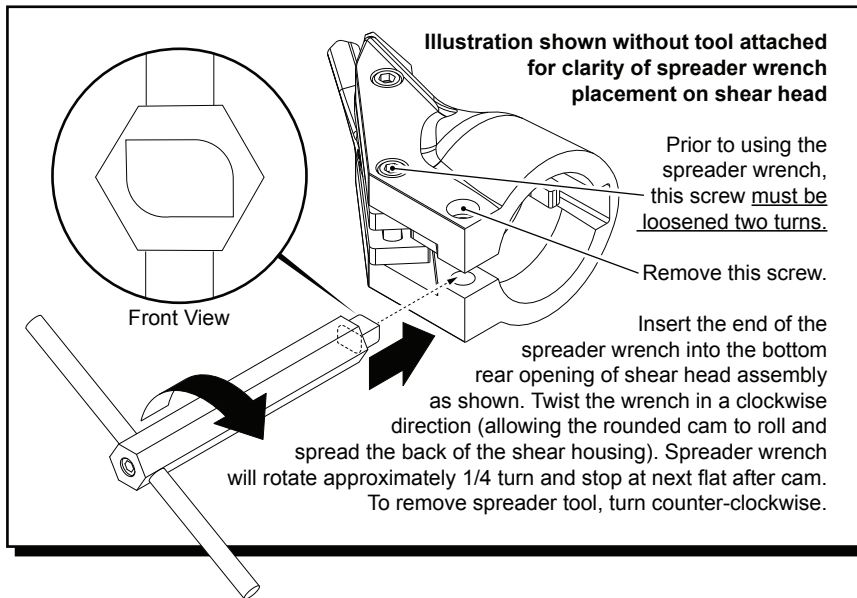
5,6,17 Before assembly, lightly coat all press fit areas with lightweight spindle oil.

FIG. 5,6,17 NOTES:
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