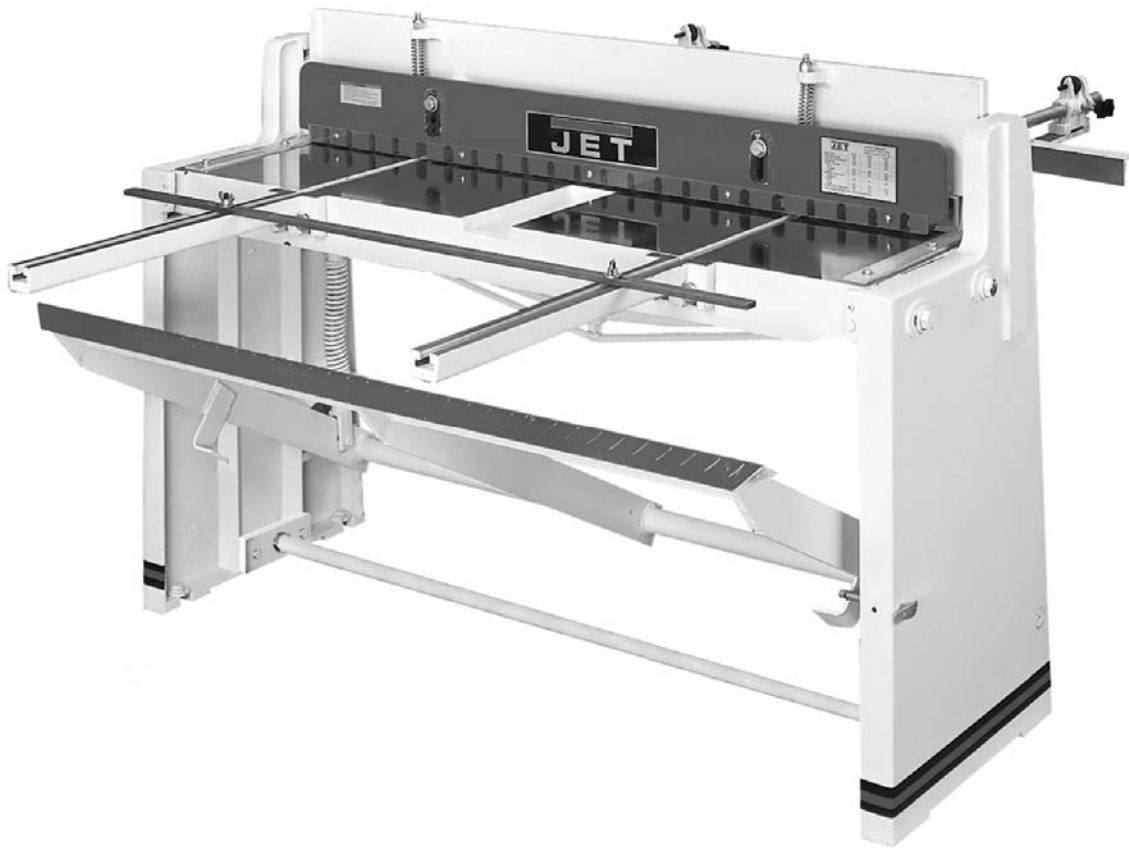




Operating Instructions and Parts Manual Foot Shear

Models: FS-1636H, FS-1652H



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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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Warnings

1. Keep guards in place and in working order.
 2. Keep all body parts away from moving parts. Avoid placing any part of your body near belts, cutters, gears, etc.
 3. Do not exceed rated capacity on this brake.
 4. Keep the work area clean. Cluttered areas and workbenches invite accidents.
 5. Keep children away. All visitors should be kept a safe distance from the work area.
 6. Make your workshop child proof with padlocks, master switches or by removing starter keys.
 7. Don't force the machine. It will do the job better and safer at the rate for which it was designed.
 8. Use the right machine. Don't force a machine or attachment to do a job for which it was not designed.
 9. Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
 10. Always use safety glasses. Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.
 11. Don't overreach. Keep proper footing and balance at all times.
 12. Maintain tools with care. Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
 13. Never stand on a machine. Serious injury could occur if the machine tipped.
 14. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function - check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
 15. Sheet metal stock has sharp edges. To prevent cuts, use caution when handling.
 16. Keep hands and fingers clear of the area in front and rear of the brake.
 17. Do not use the machine for any purpose other than for which it was designed
 18. Failure to comply with all of these warnings may cause serious injury.
 19. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint
 - crystalline silica from bricks and cement and other masonry products, and
 - arsenic and chromium from chemically treated lumber.
- Your risk from those exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles
20. Do not operate tool while under the influence of drugs, alcohol or any medication.

Specifications

Model Number.....	FS-1636H.....	FS-1652H.....
Stock Number.....	752636.....	752652.....
Capacity (mild steel).....	16 gauge.....	16 gauge.....
Shearing Length Capacity.....	36".....	52".....
Back Gauge Capacity.....	30".....	30".....
Front Gauge Capacity.....	28".....	28".....
Overall Dimensions (LxWxH).....	46" x 74" x 42".....	63" x 74" x 42".....
Weight (Net/Shipping).....	816 lb / 882 lb.....	1014 lb / 1091 lb.....

Uncrating and Clean-Up

1. Remove the crate from around the machine.
2. Carefully clean all rust protected surfaces with a mild solvent or kerosene and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline. These will damage painted surfaces.
3. Coat all machined surfaces with a light coat of oil to inhibit rust.
4. Remove the bolts holding the machine to the skid.
5. Carefully move the machine to a level foundation. Machine location must allow access to all sides.

Assembly Note: Prior to shipment the foot shear is adjusted at the factory for proper operation. If the machine does not operate properly, or the stand does not sit squarely on the floor proceed to setup.

Stop Assembly

The (#) in the text refers to the breakdown.

1. Attach the two front arm extensions #6 to the bed with four hex socket cap screws and washers.
2. Attach the stop to the front extension arms with T-nuts #72.
3. Attach the rear stop #59 to the adjusting block assembly #61.
4. Insert the rod # 58 through the adjusting block assembly and into the cutter bar. Tighten in place with setscrews.

Setup

1. Loosen four bolts #21. Loosen adjusting screws #18 & 19. The bed must rest squarely on the right and left hand side panels at all four corners while screws are loose. Shim legs at floor if necessary. Tighten hardware.
2. Use set screw #18 and hex cap screw #19, to adjust the lower blade towards or away from the upper blade. The distance between the upper and lower blades should be 0.002-0.005".

Do not let the blades overlap.

3. Place a heavy sheet of paper (~0.005") in the cutting position, along the entire length of the bed, and slowly press the foot lever.
4. If the shear does not cut the paper move the lower blade towards the upper blade.
5. If the shear cuts the paper on the ends, but not the center, turn the tie-rod adjusting screw #37, clockwise until the paper is cut the entire length.
6. If the shear cuts the paper in the center, but not the ends, turn the tie-rod adjusting screw #37, counter-clockwise until the paper is cut the entire length.
7. Make sure the scales #15 and #16 on top of the bed are square to the blade, and also show the correct distance from the blade.
8. Make test cuts to verify the scale is correct.

Blade Care

The 2-way upper blade can be removed and flipped 180°, for a sharp edge before having to sharpen the blade.

Wipe the blade lightly with oil. Lubricate all pivot points on the machine daily.

Spring Tension

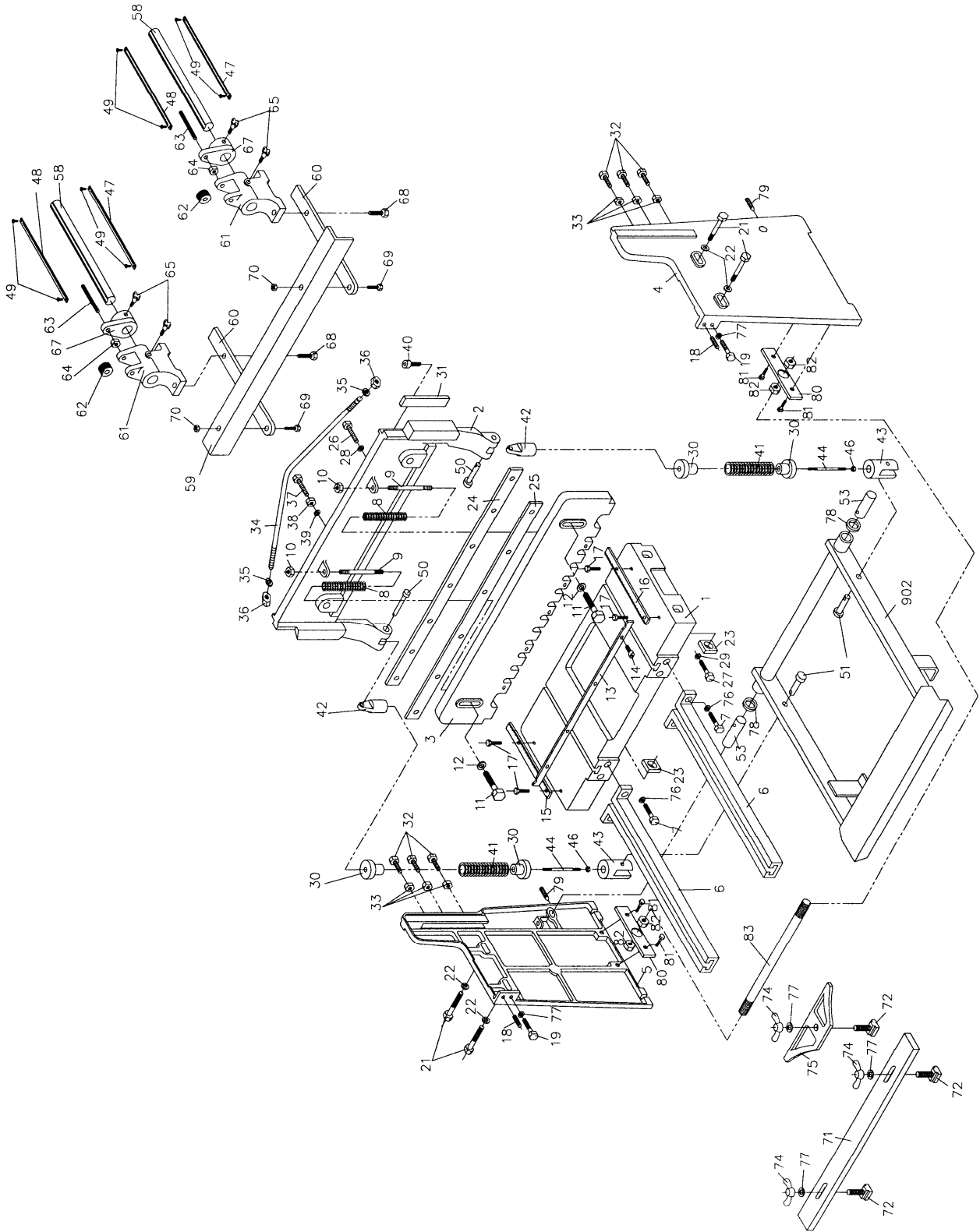
The spring return can be adjusted on the foot lever by tightening #46 hex nuts.

The spring return can be adjusted on the hold down #3 by tightening #10 hex nuts.

Gib Adjustment

There are three hex cap screws #32 that can be adjusted for play in the shim #31. Adjust for smooth travel.

Breakdown for FS-1636H & FS-1652H Foot Shear



Parts List for the FS-1636H & FS-1652H Foot Shear

Index No.	Part No.	Description	Size	Qty
1	FS1636N-1	Table		1
	FS1652N-1	Table		1
2	FS1636N-2	Cutter Bar		1
	FS1652N-2	Cutter Bar		1
3	FS1636N-3	Hold Down		1
	FS1652N-3	Hold Down		1
4	FS1636N-4	R.H. Side Panel		1
5	FS1636N-5	L.H. Side Panel		1
6	FS1636N-6	Front Arm Extension		2
7	FS1636N-7	Screw	M12x45	4
8	FS1636N-8	Spring		2
9	FS1636N-9	Stud		2
10	FS1636N-10	Nut	M12	2
11	FS1636N-11	Screw	M12x80	2
12	FS1636N-12	Washer		2
13	FS1636N-13	Finger Guard		1
	FS1652N-13	Finger Guard		1
14	FS1636N-14	Screw	M6x12	4
15	FS1636N-15	Table Scale (L.H.)		1
16	FS1636N-16	Table Scale (R.H.)		1
17	FS1636N-17	Screw	M8x20	4
18	FS1636N-18	Set Screw	M10x45	2
19	FS1636N-19	Screw	M10x50	2
21	FS1636N-21	Bolt	M16x115	4
22	FS1636N-22	Washer	M16	4
23	FS1636N-23	Nut	M16	4
24	FS1636N-24	Upper Knife		1
	FS1652N-24	Upper Knife		1
25	FS1636N-25	Lower Knife		1
	FS1652N-25	Lower Knife		1
26	FS1636N-26	Screw	M10x40	7
27	FS1636N-27	Screw	M10x45	6
28	FS1636N-28	Washer		7
29	FS1636N-29	Washer		6
30	FS1636N-30	Spring Cap		4
31	FS1636N-31	Gib		2
32	FS1636N-32	Screw	M10x55	6
33	FS1636N-33	Nut	M10	6
34	FS1636N-34	Rod		1
	FS1652N-34	Rod		1
35	FS1636N-35	Washer	M16	2
36	FS1636N-36	Nut	M16	2
37	FS1636N-37	Screw	M16x80	1
38	FS1636N-38	Nut	M16	1
39	FS1636N-39	Washer	M16	1
40	FS1636N-40	Hex Socket Cap Screw	M10x30	2
41	FS1636N-41	Spring		2
42	FS1636N-42	Swivel Top		2
43	FS1636N-43	Swivel Bottom		2
44	FS1636N-44	Stud		2
46	FS1636N-46	Nut	M16	2
47	FS1636N-47	Scale (metric)		2
48	FS1636N-48	Scale (inches)		2
49	FS1636N-49	Screw	M4x8	4
50	FS1636N-50	Pin	Ø12x70	2
51	FS1636N-51	Pin	Ø12x45	2
53	FS1636N-53	Brake Pin		2
58	FS1636N-58	Rod		2
59	FS1636N-59	Stop		1

.....	FS1652N-59.....	Stop	1
60	FS1636N-60.....	Extension Bar	2
61	FS1636N-61.....	Adjusting Block	2
62	FS1636N-62.....	Adjusting Dial.....	2
63	FS1636N-63.....	Adjusting Screw.....	2
64	FS1636N-64.....	Nut	M10.....
65	FS1636N-65.....	Knob	4
67	FS1636N-67.....	Adjusting Bracket.....	2
68	FS1636N-68.....	Screw.....	M10x25.....
69	FS1636N-69.....	Bolt.....	M10x25.....
70	FS1636N-70.....	Nut	M10.....
71	FS1636N-71.....	Stop	1
.....	FS1652N-71.....	Stop	1
72	FS1636N-72.....	"T" Nut.....	3
74	FS1636N-74.....	Wing Nut.....	M10.....
75	FS1636N-75.....	Bevel Gauge	1
76	FS1636N-76.....	Washer	4
77	FS1636N-77.....	Washer	M10.....
78	FS1636N-78.....	Washer	2
79	FS1636N-79.....	Set Screw	M10x50.....
80	FS1636N-80.....	Plate.....	2
81	FS1636N-81.....	Screw.....	M12x35.....
82	FS1636N-82.....	Nut	M16.....
83	FS1636N-83.....	Connection Bar.....	Ø16x1081mm.....
.....	FS1652N-83.....	Connection Bar.....	Ø16x1463mm.....
902	FS1636N-902.....	Pedal Assembly.....	1
.....	FS1652N-902.....	Pedal Assembly.....	1
.....	FS-1636N-ID.....	ID Label (not shown).....	1
.....	FS-1652N-ID.....	ID Label (not shown).....	1
.....	FS1636N-W.....	Warning Label (not shown).....	1
.....	FS1636N-J.....	JET Label (not shown).....	1

Ordering Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday (see our website for business hours). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.



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