

**T E C H N I C A L M A N U A L**

**OPERATOR'S, ORGANIZATIONAL, DIRECT SUPPORT  
AND GENERAL SUPPORT MAINTENANCE  
MANUAL INCLUDING REPAIR PARTS LIST**

**F O R**

**SHEARING MACHINE, METAL-SQUARING  
MODEL NOS. 132, 137, 142 and 152  
(PECK, STOW, AND WILCOX CO., INC)  
(NSN 3445-00-239-0706)**

W A R N I N G

Before operating, machine must be leveled and securely lagged to floor.

TECHNICAL MANUAL }  
No. 9-3445-102-14&P }

HEADQUARTERS  
DEPARTMENT OF THE ARMY  
WASHINGTON, DC, 25 April 1980

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FOR

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(PECK, STOW, AND WILCOX CO., INC)  
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**REPORTING OF ERRORS**

**You can improve this manual by recommending improvements using DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2 located in the back of this manual. Mail your form direct to: Commander, US Army Armament Materiel Readiness Command, ATTN: DRSAR-MAS, Rock Island, IL 61299. A reply will be furnished direct to you.**

**NOTE**

This manual is published for the purpose of identifying an authorized commercial manual for the use of the personnel to whom the shearing machine is issued.

Manufactured by: Roper Whitney, Inc.  
2833 Huffman Blvd  
Rockford, IL 61101

Procured under Contract No. DAAA09-76-C-6234

This technical manual is an authentication of the manufacturer's commercial literature and does not conform with the format and content specified in AR 310-3, Military Publications. This technical manual does, however, contain available information that is essential to the operation and maintenance of the equipment.

**INSTRUCTIONS FOR REQUISITIONING PARTS  
NOT IDENTIFIED BY NSN**

When requisitioning parts not identified by National Stock Number, it is mandatory that the following information be furnished the supply officer.

- 1- Manufacturer's Federal Supply Code Number-
- 2- Manufacturer's Part Number exactly as listed herein.
- 3- Nomenclature exactly as listed herein, including dimensions, if necessary.
- 4- Manufacturer's Model Number-
- 5- Manufacturer's Serial Number (End Item)
- 6- Any other information such as Type, Frame Number, and Electrical Characteristics, if applicable.
- 7- If DD Form 1348 is used, fill in all blocks except 4, 5, 6, and Remarks field in accordance with AR 725-50.

Complete Form as Follows:

(a) In blocks 4, 5, 6, list manufacturer's Federal Supply Code Number followed by a colon and manufacturer's Part Number for the repair part.

(b) Complete Remarks field as follows:

Noun: (nomenclature of repair part)

For: NSN:

Manufacturer:

Model:

Serial:

Any other pertinent information such as frame number, type, dimensions, etc.

**INSTRUCTIONS  
AND PARTS IDENTIFICATION**

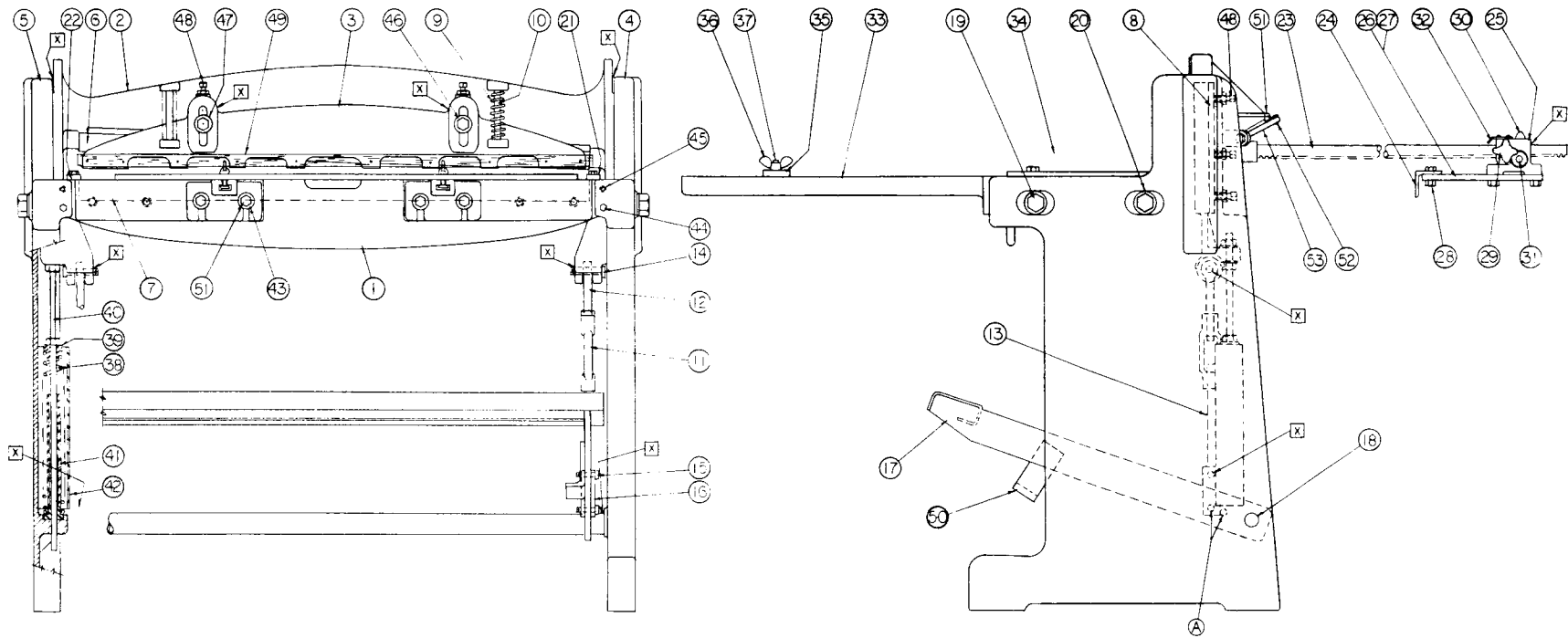
**132-137-142-152 FOOT SQUARING SHEAR**

**I N D E X**

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Parts List . . . . .	3
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KEEP THIS INSTRUCTION SHEET WITH SHEAR

# PARTS IDENTIFICATION CHART - 132-137-142-152 FOOT SQUARING SHEAR

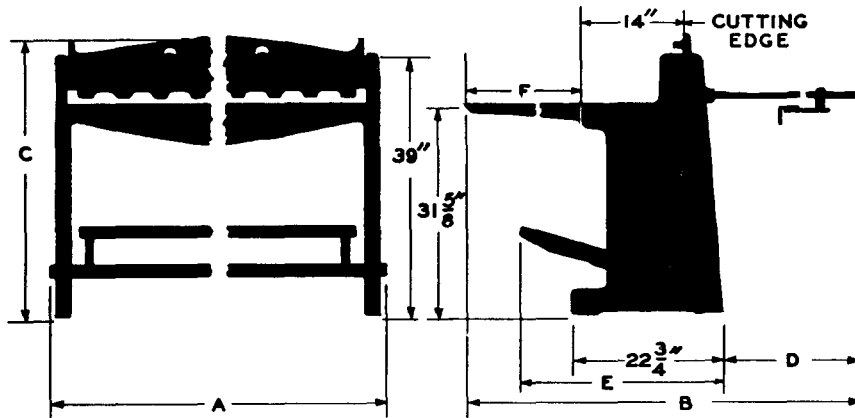


LUBRICATE POINTS [X] WITH SAE 30 OIL DAILY

## PARTS LIST — 132-137-142-152 FOOT SQUARING SHEAR

INDEX	PART NAME	137	152
1	Bed	11411	11369
2	Crosshead	Spec 2472	Spec 2474
3	Holddown	B/M 6528	15083
4	R.H. Leg	15084	15084
5	L.H. Leg	15085	15085
6	Upper Blade	10484	11381
7	Lower Blade	10485	11381
8	Gib	10478	10478
9	Holddown Spring	14966	15086
10	Holddown Stud	15720	15087
11	Turnbuckles	A 63190	A 63190
12	Upper Treadle Rod	A 63178	A 63178
13	Lower Treadle Rod	A 63179	A 63179
14	Crosshead Pin	A 63176	A 63176
15	Connecting Link Pin	A 63177	A 63177
16	Connecting Link	12235	12235
17	Treadle Assembly	B/M 14839	B/M 15092
18	Treadle Hinge Pin	11819	11819
19	Bed to Leg Bolts	5/8 X 4 hex cap scr	5/8 X 4 hex cap scr
20	Special Washers	10483	10483
21	R.H. Side Gauge	15294	15294
22	L.H. Side Gauge	15295	15295
23	Back Ga. Arm	10480	10480
24	Back Gauge Bar	14777	11394
25	Back Gauge Holder	10481	10481
26	R.H. Link	10499	10499
27	L.H. Link	10500	10500
28	Pivot Stud	A 5330	A 5330
29	Hand Knob	10514	10514
30	Handwheel	10497	10497
31	Pinion	10502	10502
32	Pointer	10492	10492
33	Front Arm	10489	10489
34	Bevel Gauge	10479	10479
35	Front Gauge	10493	11389
36	Wing Nut	10491	10491
37	Tee Bolt	10475	10475
38	Treadle Spring	14967	15088
39	Spring Collar	10388	10388
40	Spring Rod	15717	15717
41	Spring Guide	15718	15091
42	Spring Cover	15719	15555
43	Special Washers	10473	10473
44	"Bed Out" Adj. Screw	A 643	
45	"Bed In" Adj. Screw	A 643	
46	R.H. Holddown to Crosshead Bolt	A 5659	
47	L.H. Holddown to Crosshead Bolt	1/2 X 1-3/4 hex cap scr	
48	Gib & Holddown Adj. Screws		
49	Finger Guard	B 669	B 6611
50	Treadle Stop	on treadle	on treadle
51	Front Arm Bolts	7/16 X 1-1/4 hex cap scr	

## ENGINEERING DATA



## SPECIFICATIONS

SHEAR	A	B	C	D	E	F	BLADE LENGTHS	APPROX. SHIPPING WEIGHT
132*	39 3/8"	69 1/4"	39 7/8"	29 1/2"	27 1/4"	19 5/8"	31 1/2"	540
137	45 1/8"	75 7/8"	40 1/4"	29 1/2"	27 1/4"	26 1/4"	37"	650
142	50"	76 1/4"	41 3/8"	29 1/4"	30 3/4"	26 1/4"	43"	785
152	60"	75 7/8"	42 1/4"	29 1/4"	34 1/4"	26 1/4"	53"	952

\*No. 132 Shear furnished without holddown.



**INSTRUCTIONS  
FOR  
ADJUSTING FOOT SHEARS**

**WARNING  
BEFORE OPERATING**  
Machine must be leveled  
and securely lagged to  
floor.

BEFORE OPERATING

Remove Shear From Skids and Lag in Place

1. This shear has been tested to capacity at factory. Do not exceed rated capacity on nameplate.
2. To set up shear, remove from skids and place on level foundation. Back off all leg-to-bed bolts (19 & 20) and loosen adjusting screws (44) and (45). Bed must rest squarely on right and left hand leg ledges at all four corners when bolts are loose. If necessary, shim legs at the floor, to level bed on ledges. LAG SHEAR SECURE LY TO FLOOR.
3. To adjust blade for cutting, (after setting up or changing blades), first make sure leg-to-bed bolts (19 & 20) are tight. CAUTION: Move bed toward crosshead blade by means of adjusting screws (44) and (45), screw (44) moves bed "out", increasing clearance between upper and lower blade - (45) moves bed "in", decreasing clearance. Position lower blade within a few thousandths of the upper blade, being careful that lower blade does not overlap the upper. Place a sheet of heavy paper (approx. .005") the full length of cut, between the blades and slowly depress the treadle. If shear does not cut paper, move bed blade in toward upper blade as necessary, by carefully readjusting screws (44 & 45) at either or both sides. If shear cuts paper on ends but not in center, it will be necessary to turn crosshead tie rod adjusting nut (51) clockwise until paper cuts full length of blade. If shear cuts in center but not on ends, reverse direction of turn on crosshead tie rod adjusting nut (51).  
NOTE: This adjustment is carefully made at the factory and should not be necessary on a new shear.
4. When blades are properly adjusted, tighten leg-to-bed bolts (19 & 20) securely before cutting stock.
5. Always keep blades sharp. Wiping blades occasionally with oil will increase blade life.
6. Lubrication should be maintained between crosshead and leg bearing surfaces. Lubricate all points (X) daily.
7. Front, back and side gauges are provided for use as required. Side and back gauges are graduated in sixteenths and adjustment is provided to keep graduations aligned with blade cutting edges.
8. Crosshead adjustment - use gib screws (48) to adjust gib setting. This setting should hold crosshead (1) snugly against ways in legs (3 & 4), yet not bind the crosshead movement. This adjustment should not be necessary in new shear.
9. It is suggested that an extra pair of blades be available for use when blades are removed for sharpening. Blades should be returned to factory for regrinding.
10. Two leverage holes (A) are provided in each treadle lever arm for the lower connecting link pins. The treadle as shipped will give ample leverage for cutting soft steel within the rated capacity of the machine, but greater leverage can be obtained for cutting maximum capacity stock by moving the lower connecting link pins to the holes nearest the hinge pins.
11. To adjust shear after blades have been changed, back off the leg-to-bed bolts (19 & 20) and following instruction #3 above. CAUTION: Use heavy gloves when handling shear blades.
12. When ordering replacement parts from the factory, be sure to give machine number, serial letter and part name.
13. Holddown adjustment - set holddown to engage sheet before blades.

By Order of the Secretary of the Army:

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Major General, United States Army  
The Adjutant General

E. C. MEYER  
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