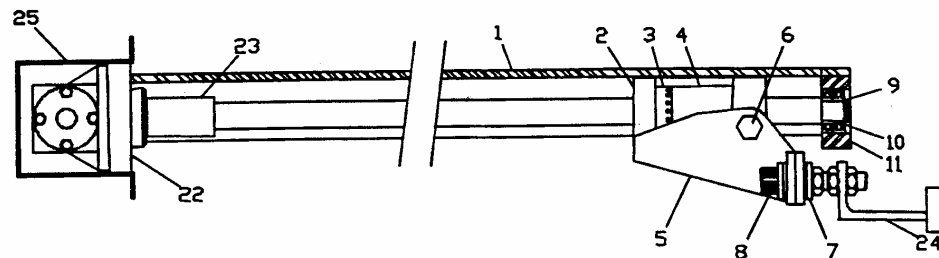
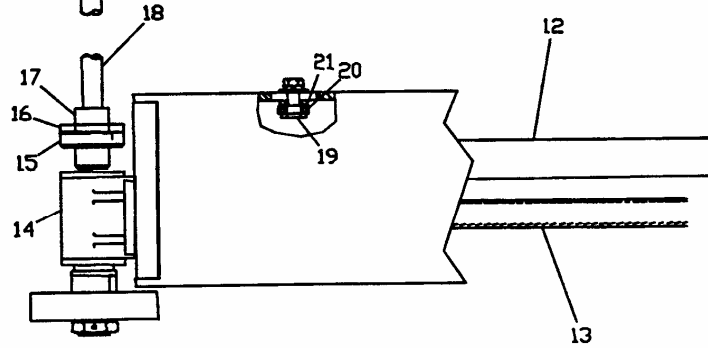
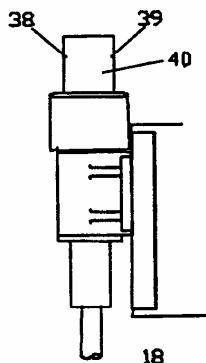
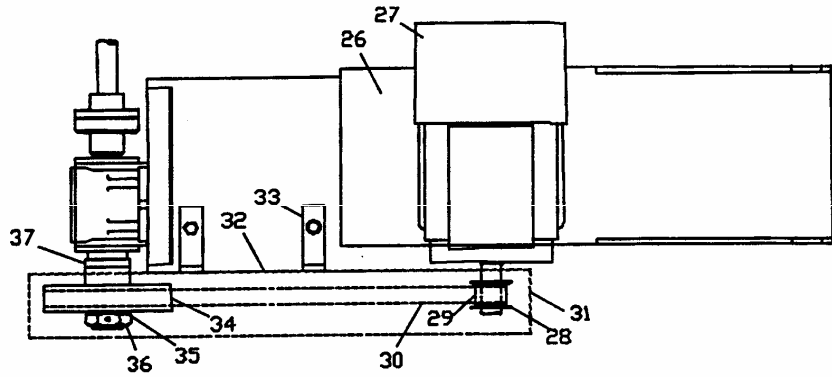


H25 & H50 Series Hydraulic Squaring Shears

BACK GAUGE

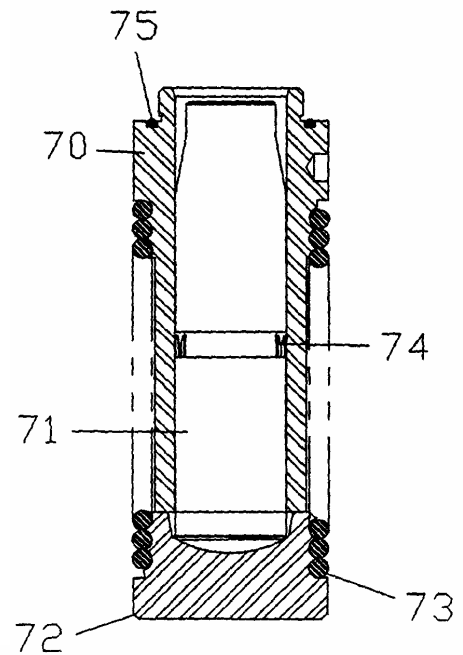
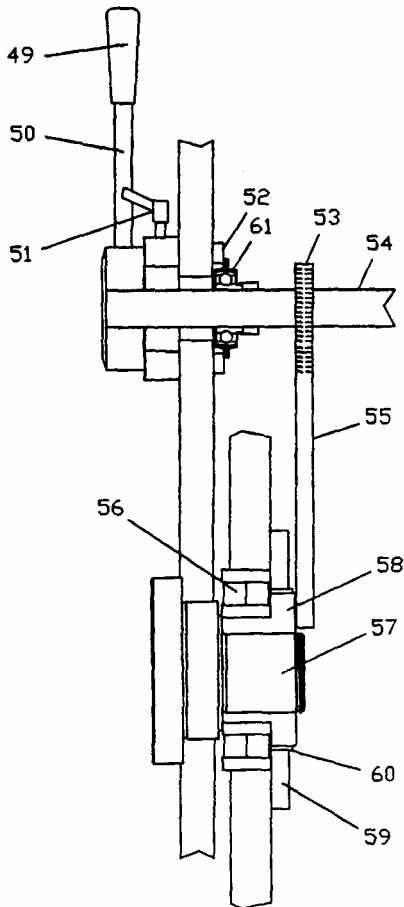


BACK GAUGE

ITEM	DESCRIPTION	H-25 SERIES	H-50 SERIES
1	Channel, L.H. back gauge rail (36")	7220-005	6290-153
	Channel, R.H. back gauge rail (36")	7220-005	6290-154
	Channel, L.H. back gauge rail (48")	7220-007	6290-143
	Channel, R.H. back gauge rail (48")	7220-007	6290-144
2	Slide, L.H.	7420-012	6490-309
3	Nut, driving	7016-139	7016-139
4	Nut, stationary driving	7020-002	7020-002
5	Bracket, back stop mtg.	7220-001	6290-140
6	Pin, S.U. bracket pivot	7420-009	7420-009
7	Washer	3356-402	6490-322
8	Screw	3303-169	3303-169
9	Ring, retaining	3351-029	3351-029
10	Bearing	3178-696	3178-696
11	Block, front screw support	7420-030	6490-311
12	Rod or Rail, Support (36")	7420-014	3162-105
	Rod or Rail, Support (48")	7420-023	3162-110
13	Screw, ASM (36")	3358-088	3358-088
	Screw, ASM (48")	3358-089	3358-089
14	T-drive	7020-001	7020-001
15	Shoe, clutch	6498-003	6498-003
16	Ring, locking	7416-317	7416-317
17	Drum, clutch	6498-004	6498-004
18	Shaft, cross (10 ft)	7420-007	7420-007
	Shaft, cross (12 ft)	7420-028	7420-028
19	Pin, swing up roller	7420-011	7420-011
20	Bearing	3178-692	3178-692
21	Spacer, swing-up roller	7420-019	7420-019
22	Block, screw support - rear	7420-005	6490-312
23	Coupling, B.G. screw (R.A.G.B.)	7486-579	7486-579
24	Angle, back stop (10 ft)	7220-002	6290-142
	Angle, back stop (12 ft)	6290-067	6290-168
25	Cover, cross shaft (10 ft)	7420-037	7420-037
	Cover, cross shaft (12 ft)	7420-038	7420-038
26	Base, motor	7220-010	6490-406
27	Motor	4210-163	4210-163
28	Flange, pulley	3415-594	3515-594
29	Pulley, B.G. motor (12T)	7420-006	7420-006
30	Belt, timing (36 in.)	3413-048	3413-048
	Belt, timing (48 in.)	3413-061	3413-061
31	Cover, timing belt (36 in.)	7220-009	6290-141
	Cover, timing belt (48 in.)	7220-003	7220-003
32	Plate, belt cover rear (36 in.)	7420-033	6490-304
	Plate, belt cover rear (48 in.)	7420-018	7420-018
33	Bracket, belt cover	7420-020	7420-020
34	Pulley, driven (48T)	7420-002	7420-002
35	Washer, wave	3520-355	3520-355
36	Nut, timing pulley	7420-013	7420-013
37	Hub, timing pulley	7420-003	7420-003
38	Encoder	3900-026	3900-026
39	Coupling, encoder	6498-084	6498-084
40	Adapter, encoder	6498-085	6498-085

BLADE GAP ADJUSTMENT

ITEM	DESCRIPTION	H-25 SERIES	H-50 SERIES
49	Handle, tapered plastic	2203-039	2203-039
50	Arm, blade gap adjustment	6490-081	6490-081
51	Handle, locking	2203-047	2203-047
52	Spacer, blade-adjustment shaft	516.04.10.000.00	516.04.10.000.00
53	Gear, pinion	6490-051	6490-223
54	Shaft, blade adjustment	6490-061 (10 ft) 6490-079 (12 ft)	6490-297 (10 ft) 6490-345 (12 ft)
55	Segment, gap adjustment gear	6490-086	6490-112
56	Bearing	3166-170	3166-175
57	Pivot, blade gap eccentric	6490-062	6490-217
58	Bushing, blade gap eccentric	6490-085	6490-216
59	Ring, seal	6490-084	6490-222
60	Felt	3211-365	3211-365
61	Bearing, 2-bolt flange	3146-420	3146-420
	Support, center bearing	6490-386	6490-080
	Cover, left side blade gap gear		6490-219
	Standoff, blade gap cover		6490-234
	Shield, sprocket cover opening		6490-267



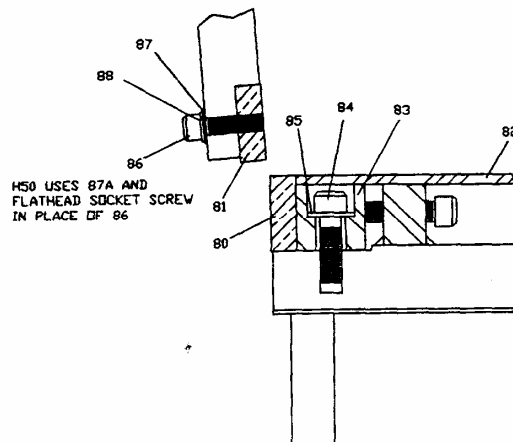
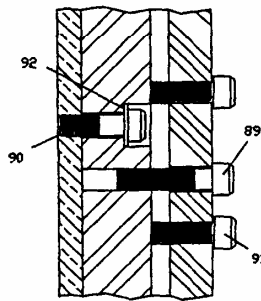
HOLDDOWN CYLINDER

Assembly P/N 6390-063

ITEM	DESCRIPTION	ALL MODELS
70	Body	6490-430
71	Piston	6490-400
72	Holddown Foot	008.17.11.100.00
73	Return Spring	008.17.13.200.00
74	Seal	3211-851
75	O-Ring	3255-513
	Optional neoprene cup for holddown feet	008.17.17.000.00

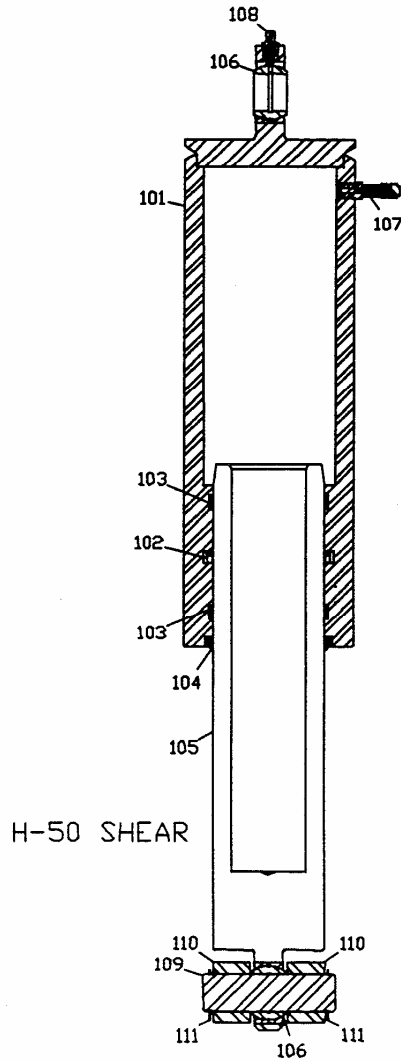
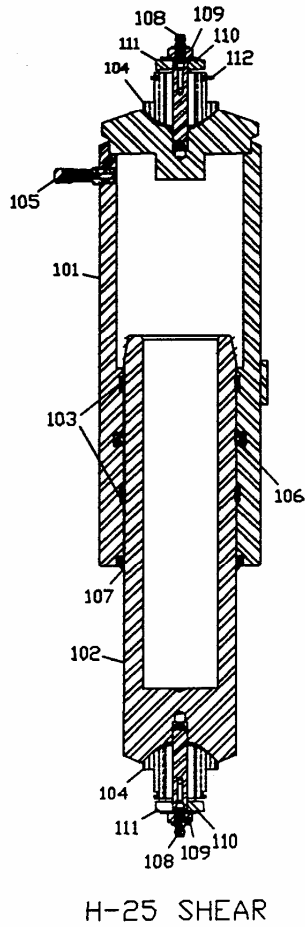
BLADE DETAIL

ITEM	DESCRIPTION	H-25 SERIES	H-50 SERIES
80	Blade, bed	4762-201 (10 ft)	4720-696 (10 ft)
		4762-261 (12 ft)	4720-776 (12 ft)
81	Blade, ram	4760-201 (10 ft)	4724-696 (10 ft)
		4760-261 (12 ft)	4724-776 (12 ft)
82	Bolster, cover (H-25)	6490-367 (10 ft) 6490-373 (12 ft)	
	Cover, right (H-50)		6490-286 (10 & 12 ft)
	Cover, center (H-50)		6490-287 (10 ft) 6490-344 (12 ft)
	Cover, left (H-50)		6490-288 (10 & 12 ft)
	Bolster, table blade	6490-366 (10 ft) 6490-374 & 375 (12 ft)	6490-361 (10 ft) 6490-360 (12 ft)
84	Screw	3303-146	3303-154
85	Washer	6490-057	3328-145
86	Screw	3303-737	3305-193
87	Washer	6490-054	3328-160
87A	Nut, hex		3319-008
88	Washer, lock	3327-212	
89	Screw	3303-365	3303-168
90	Screw	3303-735	3305-197
91	Screw	3303-365	3303-168
92	Washer	6490-054	3328-160

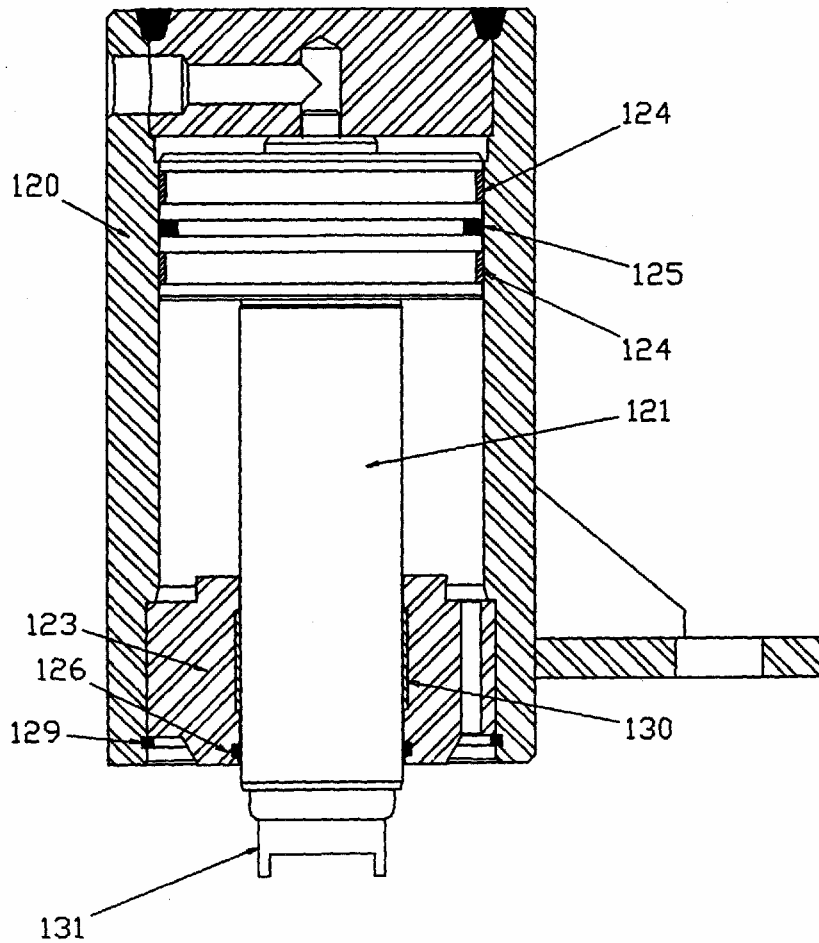


NITROGEN RETURN CYLINDER

ITEM	DESCRIPTION	H-25 SERIES	DESCRIPTION	H-50 SERIES
Assembly – 6390-061		Assembly – 6390-062		
101	Housing, cylinder	6290-223	Housing, cylinder	6290-224
102	Piston, return cylinder	004.15.11	Seal assembly	3211-885
		.000.00		
103	Ring, wear	3188-045	Ring, wear	3188-045
104	Joint, self-aligning	6490-415	Wiper, rod	3211-733
105	Valve, tank	3822-093	Piston, return cylinder	6490-416
106	Seal assembly	3211-885	Bearing, self-aligning	3130-010
107	Wiper, rod	3211-733	Valve, tank	3822-093
108	Fitting, grease	3306-022	Fitting, grease	3206-050
109	Bolt, safety	6490-413	Pin, top support	6490-421
110	Washer, flat	3328-007	Ring, snap	3351-032
111	Washer, white neoprene	6490-414	Support, cylinder top	6490-418
112	Ring, snap	3351-039		



H-25 SERIES CYLINDER ASSEMBLIES



RIGHT HAND, MAIN CYLINDER ASSY – 6390-066

LEFT HAND, MAIN CYLINDER ASSY – 6390-067

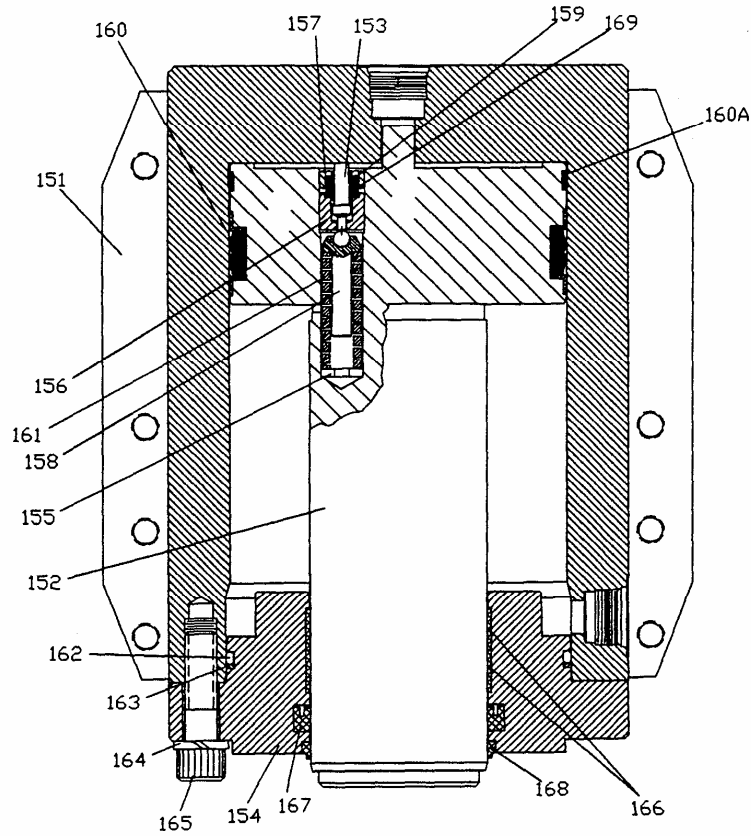
ITEM	DESCRIPTION	H-25 SERIES
120	Body, LH cylinder	606.14.23.000.00
121	Piston	6490-450
123	Cap, rod	6490-446
124	Slydring, piston	3211-892
125	Seal Assembly	3211-894
126	Wiper Assembly	3211-889
129	Ring, ametric internal	3351-620
130	Slydring rod	3211-891
131	Block, cylinder/ram	6490-452*

*Block is custom fit – consult Wysong

ITEM	DESCRIPTION	H-25 SERIES
120	Body, LH cylinder	606.14.27.000.00
121	Piston	6490-451
123	Cap, rod	6490-448
124	Slydring, piston	3211-893
125	Seal Assembly	3211-895
126	Wiper Assembly	3211-889
129	Ring, ametric internal	3351-605
130	Slydring rod	3211-891
131	Block, cylinder/ram	6490-452*

*Block is custom fit – consult Wysong

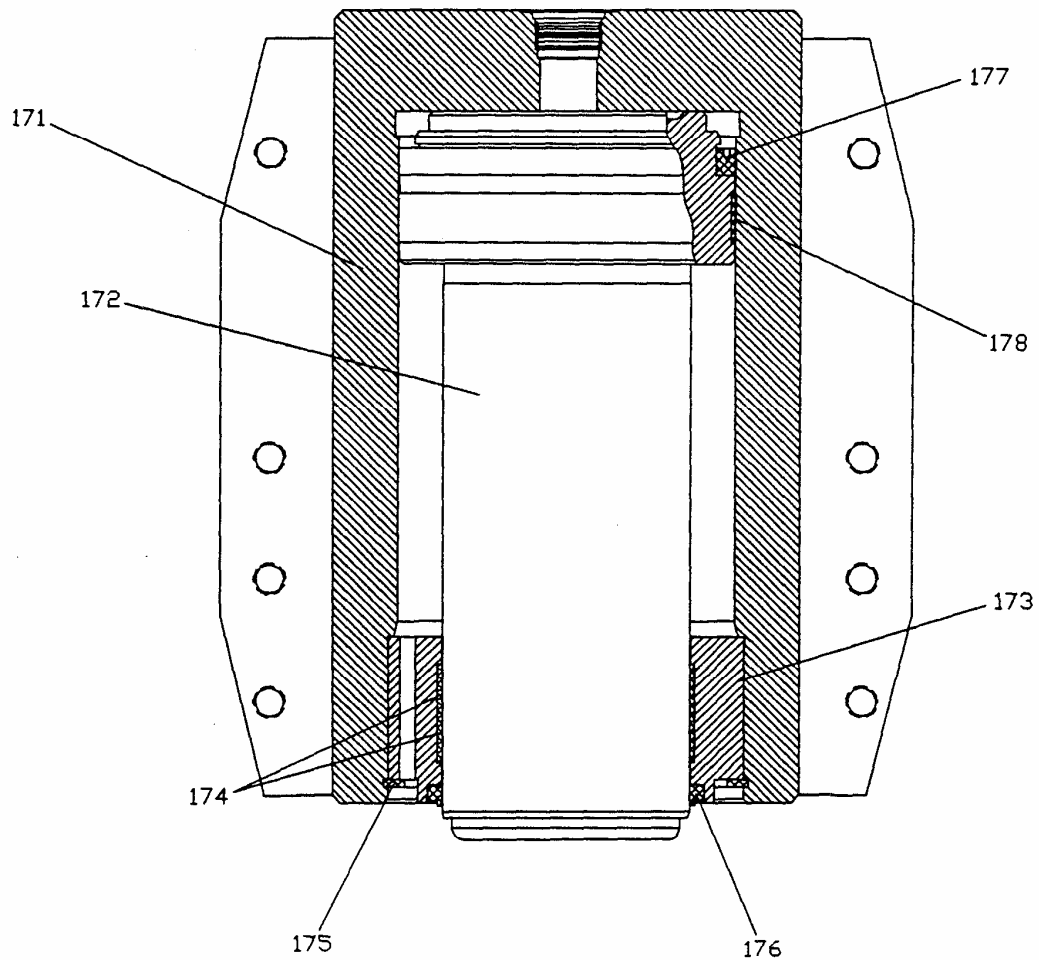
H-50 MAIN CYLINDER ASSEMBLY



Assembly - 6390-037

ITEM	DESCRIPTION	H-50 SERIES	ITEM	DESCRIPTION	H-50 SERIES
151	Cylinder, L.H. Main	6290-139	161	Spring, ball valve	3510-137
152	Piston, L.H.	6490-393	162	O-Ring	3255-234
153	Plunger	616.14.13.003.00	163	Backup O-Ring	3255-434
154	Cap, rod	6490-316	164	Washer, lock	3327-012
155	Washer	616.14.13.006.00	165	Screw, 3/4-10 SHC	3303-164
156	Seat, ball	616.14.13.004.00	166	Bearing, rod	3188-038
157	Plug, locking	616.14.13.005.00	167	Seal, rod	3211-812
158	Assembly, ball valve	6390-022	168	Wiper, rod	3211-735
159	Screw, #8-32 SHC	3306-007	169	Spring, ball seat	3510-052
160	Seal, piston	3211-809			
160A	Bearing, rod	3188-012			

H-50 SERIES, SLAVE CYLINDER ASSEMBLY



Assembly - 6390-036

ITEM	DESCRIPTION	H-50 SERIES
171	Cylinder, R.H. Slave	6290-136
172	Piston, R.H.	613.14.11.000.00
173	Cap, rod	6490-317
174	Bearing, rod	3188-039
175	Ring, ametric internal	3351-626
176	Wiper, rod	3211-736
177	Seal, piston	3211-811
178	Bearing, piston	3188-035

HYDRAULIC UNIT

ITEM	DESCRIPTION	H-25 SERIES	H-5010 SERIES	H-5012 SERIES
190	Breather, filler	3202-100	3202-100	3202-100
191	Filter, suction	3764-295	3764-296	3764-296
192	Hose, hydraulic	3898-708	3898-657	3898-657
193	Pump	3257-126	3257-132	3257-132
	Flange	3257-073	3257-064	3257-074
194	Coupling, pump	3428-216	3428-223	3428-135
	Insert, coupling	3428-217	2428-222	2428-134
	Coupling, motor	3428-218	3428-220	3428-150
195	Motor (230 / 460 volt)	4428-053	4432-014	4434-014
		20 Hp	30 Hp	40 Hp
196	Manifold	3773-661	3773-661	3773-661
197	Valve, 4-way	3759-281	3759-281	3759-281
	Valve, cartridge	3760-040	3760-040	3760-040
	Cover, valve solenoid	3760-341	3760-341	3760-341
198	Hose, return	3898-655	3898-656	3898-656

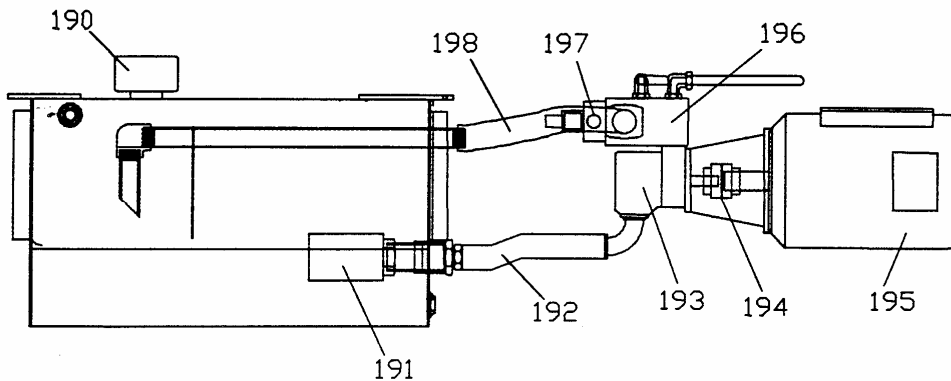
Main Pressure:

To check main hydraulic pressure, remove Allen plug from the rear facing side of aluminum manifold and screw in a gauge and hose assembly. The pressure port is threaded 7/16-20 UNF.

Remove plastic cover from cartridge valve in sub-plate on side of manifold. Adjust this valve for correct pressure.

Bring ram down on ½ inch or ¾ inch plate to stall out ram. Tape the top of stroke switch up so ram will return.

Pressures: H-25, 2900 psi
H-50, 3700 psi



H50 SERIES POWER BLADE GAP ADJ.

ITEM	DESCRIPTION	H-25 SERIES	H-50 SERIES
201	Pulley, timing (shaft end)	3415-004	3415-004
202	Belt, timing	3413-063	3413-063
	Pulley, timing (potentiometer)	3415-217	3415-217
203	Potentiometer	3956-502	3956-502
204	Bracket, potentiometer (top)	6490-428	6490-428
	Bracket, potentiometer (bottom)	6490-429	6490-429
205	Cover, potentiometer	6290-199	6290-199
206	Bracket, mounting	6290-196	6290-196
207	Boss, hub guide	6490-082	6490-082
208	Ring, bearing support	516.04.10.000.00	516.04.10.000.00
209	Bearing, 2-bolt flange	3146-420	3146-420
210	Pinion, gap adjustment	6490-051	6490-223
211	Shaft, gap adjustment	6490-061 (10 ft) 6490-079 (12 ft)	6490-297 (10 ft) 6490-345 (12 ft)
212	Sprocket, driven	6290-113	6290-113
213	Screw	3308-081	3308-081
214	Sprocket, idler	3412-130	3412-130
215	Washer, idler sprocket	7416-383	7416-383
216	Torque limiter	3412-282	3412-282
	Bushing	3412-284	3412-284
217	Sprocket	3412-283	3412-283
218	Motor	4403-063	4403-063
219	Reducer	3436-123	3436-123
220	Chain	3430-035	3430-035

