

\* **Shear Blade Repair and Maintenance**



Punch Tools provides grinding services for your shear blades. We have field technicians who can remove your old blades and reinstall the blades once they are sharpened.

**Grinding Limits**

Most four edge shear blades are designed to allow for regrinding both the thickness and width of the blades. However, there are practical limits to the amount of material that can be removed before the blade should be replaced. The following chart can be used as a guide in determining whether your blades are nearing the minimum grinding limits...

| Nominal Spec Blade | Minimum Thickness | Minimum Width |
|--------------------|-------------------|---------------|
| 1" x 3"            | 7/8"              | 2 3/4"        |
| 1" x 4"            | 7/8"              | 3 3/4"        |
| 1 1/8" x 5"        | 1"                | 4 3/4"        |
| 1 1/2" x 5 1/2"    | 1 1/8"            | 5 3/8"        |
| 1 3/4" x 6 1/2"    | 1 5/8"            | 6 1/8"        |

Shear blades must be reground to the same exact tolerances as new blades to ensure quality cuts and maintain a high level of productivity. The recommended tolerances are as follows...

- WIDTH** – Parallel to within 0.005" from end to end.
- THICKNESS** – Parallel to within 0.003" from end to end. No variation greater than 0.001" within any 12" length.

Initial blade clearance is adjusted by moving the shear table in and out. If blade thickness is less than reference minimum "T", proper blade clearance may not be possible. If width is reduced less than the reference minimum "W", the blade may not cross full length.

Feel free to call us if you have any questions.

Accurpress, Accurshear, Allsteel, American Hercules, Betenbender, Century, Cincinnati, Deem, HTC, Herr-Voss, Lodge & Shipley, Pacific, Piranha, Standard Industrial

**Website: [www.punchtools.com](http://www.punchtools.com) · Email: [sales@punchtools.com](mailto:sales@punchtools.com)**