

The
Magnum Shear™
X Model Series™

Instruction Manual
For X13 & X20

Please Read Before Use

Updated July, 2005

Made By
Gunntech Mfg., Inc.
In The USA

USA, 800-406-8998

International, 208-772-0175

!!!! WARNING!!!! EXTREMELY SHARP BLADE!

WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS INJURY! USING THIS MACHINE WITH RESPECT AND CAUTION WILL CONSIDERABLY LESSEN THE POSSIBILITY OF PERSONAL INJURY.

****NOTICE: THE BLADE MUST BE PLACED IN THE HEAD WITH THE FLAT SIDE TOWARD THE OPERATOR.***

SAFETY RULES FOR THE MAGNUM SHEAR™

1. READ AND UNDERSTAND INSTRUCTION MANUAL BEFORE OPERATING THE MAGNUM SHEAR™.
2. IF YOU ARE NOT THOROUGHLY FAMILIAR WITH THE OPERATION OF THE MAGNUM SHEAR™, OBTAIN ADVICE FROM A QUALIFIED INSTRUCTOR OR CALL: 800-406-8998
3. STAY ALERT. DO NOT OPERATE WHILE UNDER THE INFLUENCE OF DRUGS, ALCOHOL OR MEDICATION.
4. ALWAYS WEAR SAFETY APPROVED EYE PROTECTION WITH SIDE SHIELDS (ANSI Z87.1)
5. KEEP WORK AREA CLEAN AND FREE OF DEBRIS.
6. KEEP CHILDREN AND UNAUTHORIZED PERSONS A SAFE DISTANCE FROM TOOLS AND WORK AREA.
7. MAKE SURE TOOL IS SECURE. OPERATE ONLY ON A FIRM SUBSTRATE OR SOLID STAND.
8. USE THE RIGHT TOOL. DO NOT FORCE THE TOOL OR USE FOR A JOB, WHICH IT WAS NOT DESIGNED.
9. KEEP BLADE SHARP. A DULL BLADE MAY NOT CUT SOME MATERIALS.
10. ALWAYS KEEP HANDS AWAY FROM BLADE WHILE OPERATING OR CARRYING.
11. DO NOT ALTER OR MISUSE THIS TOOL. THE MAGNUM SHEAR IS PRECISION BUILT; MODIFICATIONS NOT SPECIFIED MAY RESULT IN A DANGEROUS CONDITION.
12. MAINTAIN TOOLS WITH CARE. KEEP BLADE SHARP AND CLEAN. FOLLOW INSTRUCTIONS FOR LUBRICATING AND CHANGING ACCESSORIES.
13. USE ONLY RECOMMENDED ACCESSORIES. THE USE OF IMPROPER ACCESSORIES MAY CAUSE HAZARDS OR INJURY.
14. NEVER LEAVE THE TOOL UNATTENDED. SECURE THE HANDLE WITH THE HANDLE LOCK PLATE OR MAG LOCK™ WHEN NOT IN USE.
15. WARNING: THE DUST GENERATED BY CUTTING CERTAIN WOOD, WOOD FIBER AND/OR PVC PRODUCTS CAN BE INJURIOUS TO YOUR HEALTH. BUT SINCE THE MAGNUM SHEAR™ DOESN'T CREATE ANY DUST, WE SUGGEST THAT YOU DON'T EAT THE SMALL CHIPS SOMETIMES CREATED WHEN CUTTING. ☺

X Model Parts List

Ref.No.	Part No.	Description
01	851	BASE
02	862	STEEL SHAFT (2)
03	852	HEAD
04	861	CAM SHAFT (Cam Assembly)
05	853	RETAINER (2)
06	854	ANVIL
07	866	BEARING RUNNER (2)
08	864	FRONT/ BACK STOP (Cam Assembly)
09	870	TABLE
10	857	RAIL (2)
11	855	TAIL
12	856	RULED FENCE
13	860	HANDLE RECIEVER (Cam Assembly)
14	858U	HANDLE UPPER
15	858L	HANDLE LOWER
16	865	CAM BEARING SLEEVE (2)
17	839	BACK FOOT (2)
18	838	FRONT FOOT (2)
19	836	TAIL CAP/PLUG (2)
20	837	LOCK PLATE
21	869	BLADE STOP (White Plastic)
22	859	RETURN SPRING (2)
23	849	BLADE
24	868	HANDLE GRIP
25	847	HITCH PIN (2) (Parts Bag Assembly)
26	848	ROLL CASTER (2) (Parts Bag Assembly)
27		Hone Stone (Parts Bag Assembly)
28	844	ALLEN WRENCH (Parts Bag Assembly)
29	875	LOWER HEAD BUSHING (2)
30	876	UPPER HEAD BUSHING (2)
31	873	CAM BEARING (2)
32	874	RETAINER BEARING (2)
33	887A	M12 BH BOLT (2)
34	887B	M12 HEX BOLT (2)
35	850	BACK STROKE STOP
36	892	WING M8 NUT
37	883	FRONT STOP M8 (5/16") BOLT
38	889	TAIL/TABLE M6 BOLT (2)
39	886	SHAFT, RAIL, RETAINER M8 SET SCREW
40	882	ANVIL, TABLE M6 BH SCREW (12)
41	890	CASTOR M4 SCREW (8)
42	884	BLADE M8 SET SCREW (6)
43	888	RAIL/BASE M6 HEX BOLT (2)
44	835	INSTRUCTION MANUAL (Parts Bag Assembly)

Assembly Instructions

X13 & X20 Magnum Shear™

Updated March 2005

Please Read All Instructions Before Starting

Step 1

A. (fig.1) Remove **Power**

Assembly from box and stand on one end.

NOTE: *Do not remove wire tie holding Plastic Blade Guard in place.*

!CAUTION! VERY SHARP BLADE!

B. Insert **Pipe Rails** into 1" holes in **Base**, aligning *through* hole in **Pipe Rails** with *threaded* hole in **Base**.

(Rubber mallet may be necessary)

NOTE: (fig.1a) *Loosen set screws if they interfere with insertion.*

C. Attach each **Pipe Rail** to **Base** with a **M6 X 40 Hex Head Bolt** and **M6 Star Washer**. Finger tight only.

Do Not Tighten At This Time.

Fig. 1

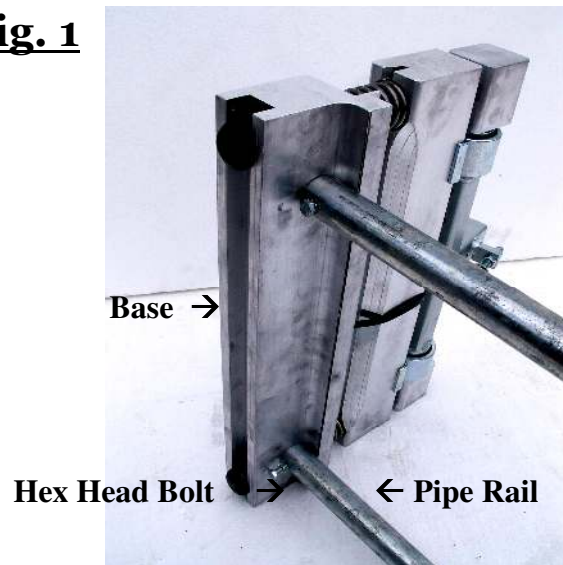
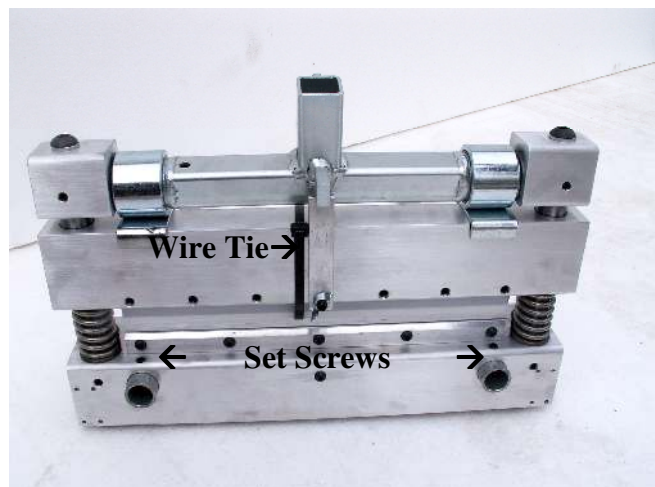


Fig. 1A



Step 2

- A.** (fig.2) Slide **Tail Piece** onto **Pipe Rails** and align through holes.
- B.** Place **Table Top** on **Base** and **Tail Piece**.
- C.** Insert (2) $\frac{1}{4}$ " X $3\frac{1}{2}$ " **Carriage Bolt** through outer holes in the **Table Top**, **Tail piece** and **Pipe Rails**.
- D.** (fig.2a) Place **Cap Washers** over bolt threads and attach $\frac{1}{4}$ " **Nylok Nuts**. Finger tight only. **Do Not Tighten At This Time**.
- E.** (fig.2b) Insert (4 for **X13** - 5 for **X20**) **M6 X 12 BH Cap Screws** through **Table Top** and thread into **Base**. Using a **4 mm Allen Wrench** tighten firmly.
- F.** Insert (2 for **X13** - 3 for **X20**) **M6 X12BH Cap Screws** through inner holes in **Table Top** and thread into **Tail Piece**. Using a **4 mm Allen Wrench** tighten firmly.

Fig. 2

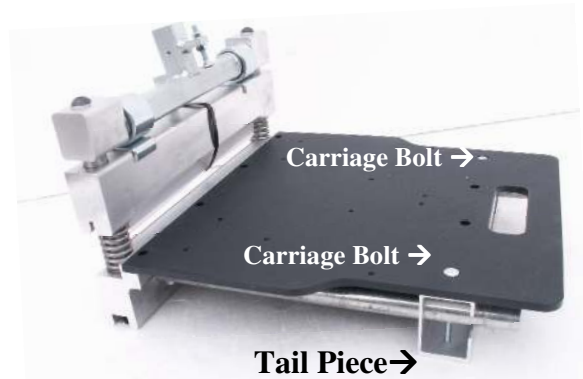


Fig. 2A



Fig. 2B



Step 3

A. (fig.3) Insert **Tail End Plugs** into each end of **Tail Piece**.

B. Tighten $\frac{1}{4}$ " **Nylok Nuts** until bolt end is flush with nut.

NOTE: Over tightening will cause the Tail Piece to distort.

C. Attach **Black Plastic Caps** onto **Cap Washers**.

D.(fig.1) Tighten firmly **M6 X 40 Hex Head Bolts**

NOTE: Over tightening will cause the Pipe Rails to distort.

E. (fig.1a) Tighten firmly **Pipe Rail set screws**.

NOTE: Over tightening will cause the Pipe Rails to distort.

F. (fig.4) Attach each **Castor** to front of **Base** with (4) **M4X10 Phillips Head Screws**.

Note: A Storage Area is located in the Tail Piece and can be used to store accessories and tools.

Fig. 3

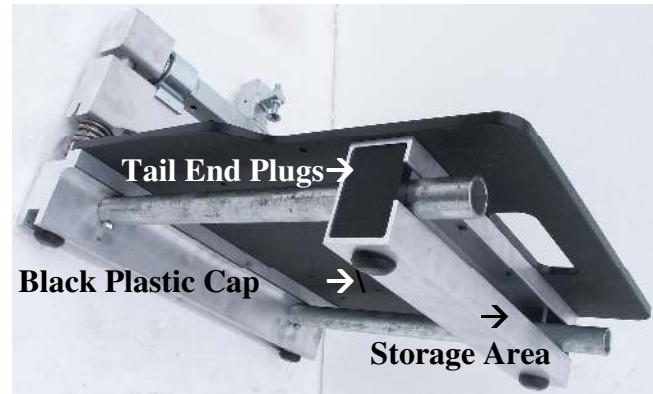
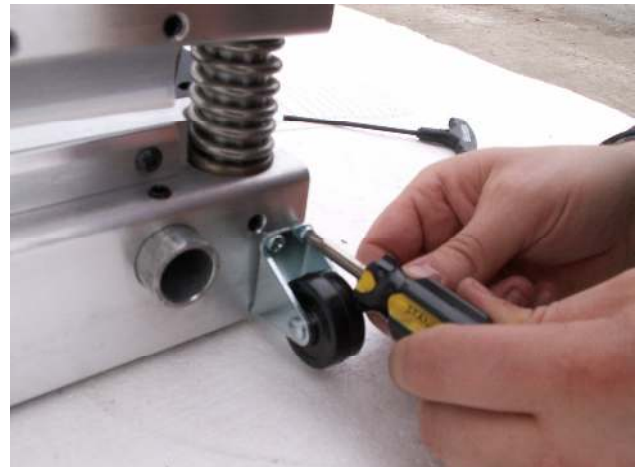


Fig. 4



!CAUTION! VERY SHARP BLADE!

Getting Started

X13 & X20 Magnum Shear™

Step 1 Set Up To Cut

!CAUTION! VERY SHARP BLADE!

A. (fig.5) After assembly start by placing the **Fence** onto the **Table Top** by inserting it into one of the hole sets.

NOTE: 2 - 90 degree and 4 - 45 degree locations.

NOTE: The Fence is a friction fit and requires effort to insert or remove.

B. (fig.5a) Insert **Handle Extention** into **Cam Reciever**, aligning through hole, and insert a **Hitch Pin**.

C. Insert **Handle** into **Handle Extention**, aligning through hole, and insert a **Hitch Pin**.

D. (fig.6) While holding **Handle** in the down (front) position loosen **Wing Nut** and swing **Back Stroke Stop** away from **Cam**.

Fig. 5

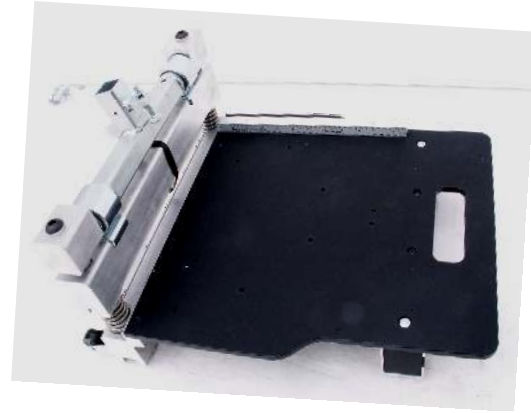


Fig. 5A

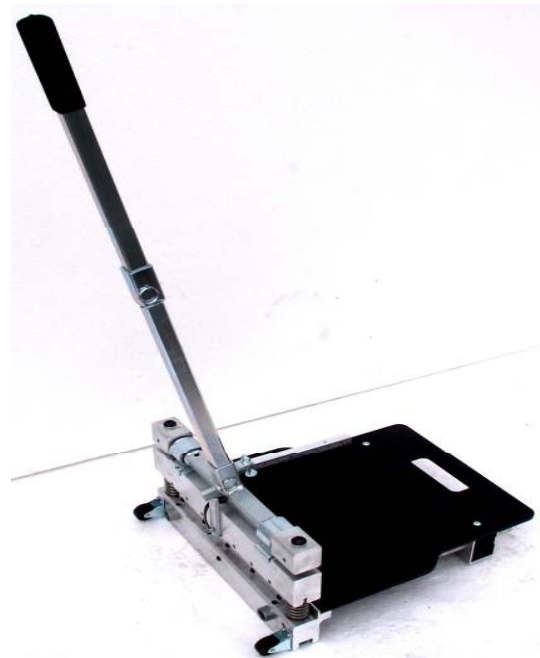
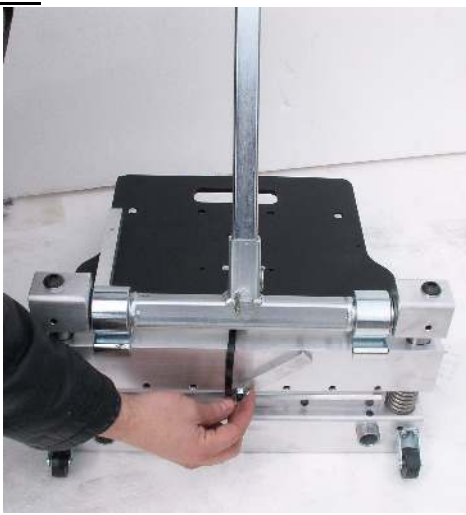


Fig. 6



E. (fig.7) Move **Handle** to the up (back) position, remove wire tie and **Plastic Blade Guard**.

F. (fig.6) While holding **Handle** in the down (front) position loosen **Wing Nut** and move **Back Stroke Stop** toward **Cam**. Tighten **Wing Nut**

The Magnum Shear is now ready to cut.

Fig. 7



Step 2 Set Up For Storage

!CAUTION! VERY SHARP BLADE!

!CAUTION! HANDLE IS UNDER EXTREME PRESSURE DO NOT ALLOW TO SLAM BACK!

A. (fig.8) While holding **Handle** in the down (front) position, Remove **Back Stroke Stop** by taking off **Wing Nut**. Insert **Lock Plate** between the **Cam Shaft** and **Head**.

B. Hook **Lock Plate** onto **Adjustable Front Stop** and lock it by pulling back.

C. (fig.8a) Insert **Back Stroke Stop** through slot in **Lock Plate** and tighten **Wing Nut**.

D. When not in use, the **Lock Plate** can be stored in the **Parts Storage** area located in the **Tail** section of the machine.

The Magnum Shear is now locked and ready for transport or Storage.

Fig. 8



Fig. 8A



OPERATING THE MAGNUM SHEAR™

!Caution! Blade is Extremely SHARP!

NOTE: Some very dense products may take extreme pressure to cut

1. General Information

- A. (fig. 9) Your Magnum Shear™ is equipped with a **34** inch (Two part) **HANDLE** that is grasped by the operator and pushed downward. This will drive the **BLADE** through the piece of material. Lift the **HANDLE** and repeat. (See list of acceptable material and size limitations on **Pg. 6**)
- B. It is recommended that you hold the work piece, to be cut, firmly in place until blade strikes it. **ALWAYS KEEP HANDS AWAY FROM BLADE WHILE OPERATING OR CARRYING.**
- C. Do not allow the **HANDLE** to slam back after making a cut.
- D. You should spray a fine layer of light oil (10W motor oil or WD40) over the **POWER ASSEMBLY** once a month to prevent surface rust.
- E. Some softer materials do not require the use of the **HANDLE EXTENSION.**
- F. The **BLADE** must be placed in the **HEAD** with the flat side toward the operator. (fig. 10)
- G. A burr will form on the flat side of the **BLADE** after the first few cuts; this is normal use the included honing stone to remove. (See: **Honing The Blade**)
- H. Small nicks or chips may appear on the knife-edge of the **BLADE** after cutting harder materials such as Laminate Flooring. They usually do not affect the performance of the **BLADE**, and do not need to be removed when sharpening or honing.
- I. The **FENCE** may be positioned in various locations on the **TABLE TOP** and is removable allowing materials to be placed on it from any direction. (fig. 11)
- J. The use of the **FENCE** is not required while cutting.
- K. It is important to secure the **HANDLE** in the down (front) position with the **LOCK PLATE** (in the parts bag) while carrying, storing or transporting this tool. (fig. 8)

Fig. 9



Fig. 10

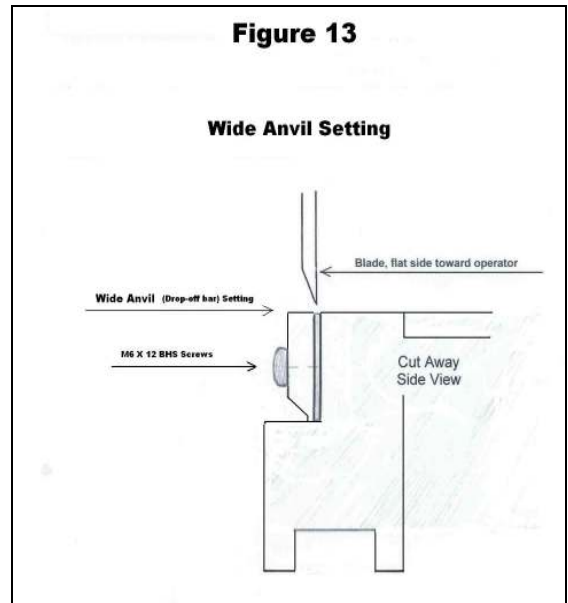
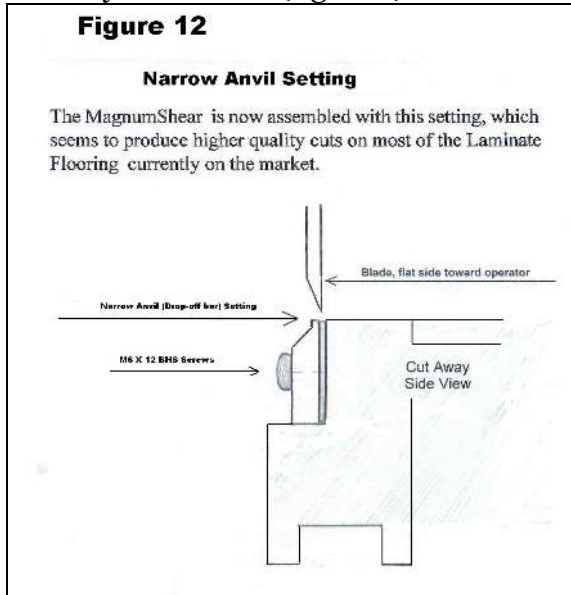


Fig. 11



- L. The **ANVIL** has **2** edges, one **1/16"** (**1.5mm**) wide and one **3/16"** (**4.5mm**) wide. Some materials need more support at this point to make a clean cut. To change, remove the **M6 x 12 BH SCREWS** and flip the **ANVIL** over. (fig. 12 & 13)
- M. **Do not** remove, loosen or adjust the length of, the **M12 x 35 BH SCREWS** (2 on top) **unless a repair is needed.** (fig. 11a)
- N. The **BLADE STOP** may eventually become worn and replacements can be purchased from your dealer. (fig. 11a)

Fig. 11A



2. Setting the Blade Depth

- A. (fig. 11) Loosen the **STOP SCREW NUTS** and turn the **STOP SCREW** away from the **Head** until it is loose.
- B. Rotate the **HANDLE** downward until the **BLADE** is resting on the **BLADE STOP**.
- C. Turn the **STOP SCREW** toward the **HEAD** until it just makes contact.
- D. Tighten the **STOP SCREW NUTS**.



*The Professional's
Best Shot*