



Operating Instructions and Parts Manual 14ga. x 52-inch Hydraulic Shear

Model HS-1452



JET

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1.0 IMPORTANT SAFETY INSTRUCTIONS

READ ALL INSTRUCTIONS BEFORE USING THIS MACHINE.

WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury. Replace warning labels if they become obscured or removed.
3. This pneumatic Hydraulic shear is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a shear, do not use until proper training and knowledge have been obtained.
4. Do not use this machine for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
5. Always wear ANSI approved safety glasses/face shields while using this shear. *Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.*
6. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair. Non-slip footwear or anti-skid floor strips are recommended.
7. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
8. Do not exceed the rated capacity of this shear; use hand tools for small or narrow parts. Do not attempt to shear hardened materials.
9. Sheet metal stock has sharp edges. To prevent cuts, use leather work gloves when handling.
10. Keep hands and fingers clear of the area in front and rear of the shear.
11. Do not place your hands between material being sheared and the shear table.
12. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after maintenance is complete.
13. 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.
14. Provide for adequate space surrounding work area and non-glare, overhead lighting.
15. Keep the floor around the machine clean and free of scrap material, oil and grease.
16. Keep visitors a safe distance from the work area. **Keep children away.**
17. Make your workshop child proof with padlocks, master switches or by removing starter keys.
18. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
19. Maintain a balanced stance at all times so that you do not fall or lean against moving parts. Do not overreach or use excessive force to perform any machine operation.
20. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
21. Use recommended accessories; improper accessories may be hazardous.
22. Maintain tools with care. Keep tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.
23. Do not stand on the machine. Serious injury could occur if the machine tips over.
24. Unplug or lock out power to the machine when not in use.

⚠ WARNING: This product can expose you to chemicals including lead which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to <http://www.p65warnings.ca.gov>.

⚠ WARNING: Some dust, fumes and gases created by power sanding, sawing, grinding, drilling, welding and other construction activities contain chemicals known to the State of California to cause cancer and birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead based paint
- crystalline silica from bricks, cement and other masonry products
- arsenic and chromium from chemically treated lumber

Your risk of exposure 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 dust masks that are specifically designed to filter out microscopic particles. For more information go to <http://www.p65warnings.ca.gov/> and <http://www.p65warnings.ca.gov/wood>.

Familiarize yourself with the following safety notices used in this manual.

⚠ CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠ WARNING This means that if precautions are not heeded, it may result in serious or even fatal injury.

2.0 About this manual

This manual is provided by JET covering the safe operation and maintenance procedures for a JET Model HS-1452 Hydraulic Shear. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide years of trouble-free operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

3.0 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 outside recommended guidelines 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
1 Year – Motors; Machine Accessories
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; Air 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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5.0 General Features and Terminology

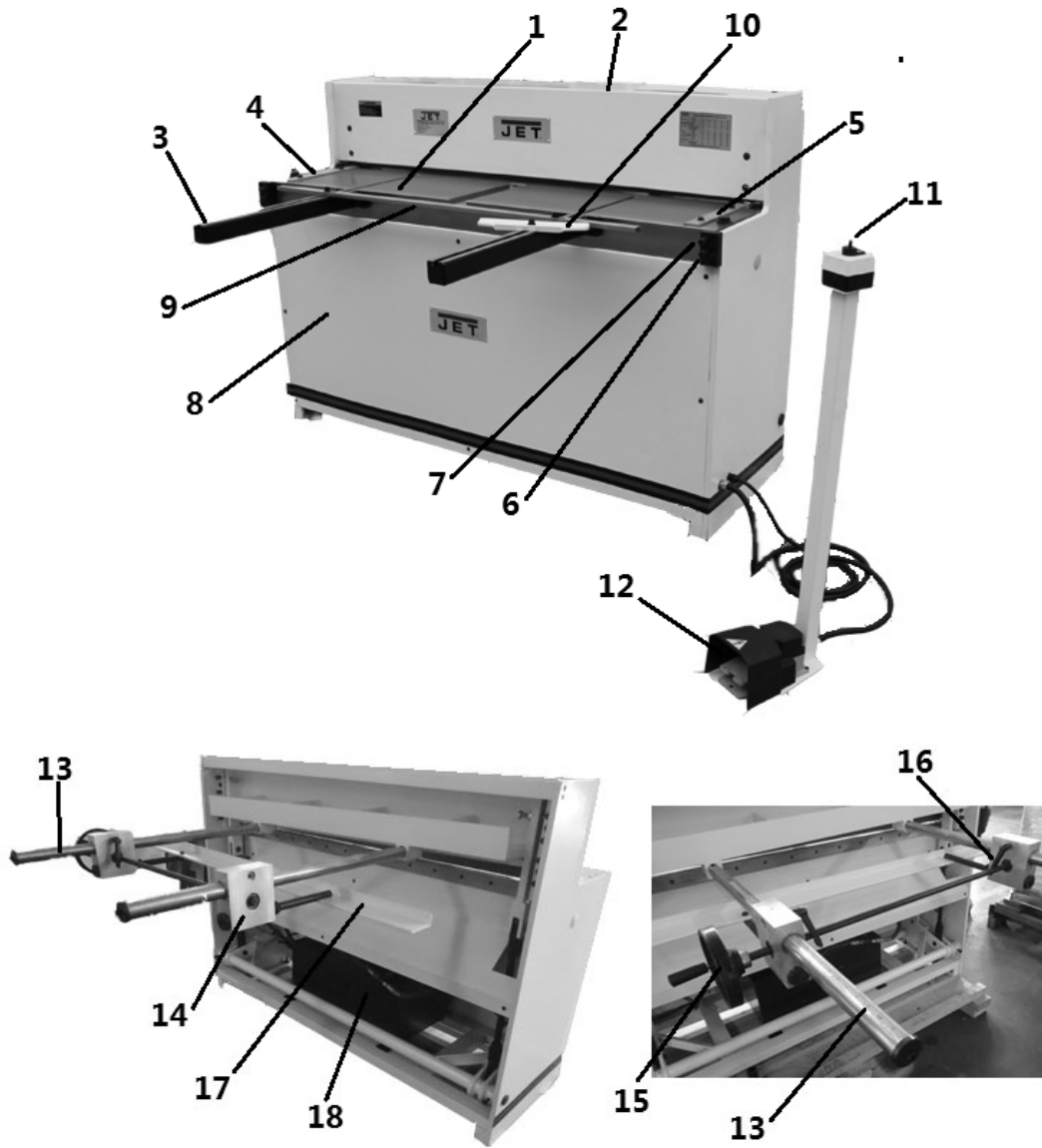


Figure 1

- | | | | |
|---|-------------------------|----|------------------------------|
| 1 | Table | 10 | Bevel Gauge |
| 2 | Cutter Bar | 11 | On/Off Switch |
| 3 | Front Arm Extension | 12 | Foot Pedal |
| 4 | Left Scale | 13 | Scale |
| 5 | Right Scale | 14 | Adjusting Block |
| 6 | Table Adjustment Screws | 15 | Adjusting Handwheel |
| 7 | Table Adjustment Screws | 16 | Adjusting Block Knobs |
| 8 | Front Cover | 17 | Rear Stop |
| 9 | Front Stop | 18 | Hydraulic Regulator Assembly |

6.0 Specifications

Model Number.....	HS-1452-1T.....	HS-1452-3T.....
Stock Number.....	756205.....	756206.....

Materials:

Frame.....	steel.....	steel.....
Table.....	steel.....	steel.....
Blades.....	ground hardened steel.....	ground hardened steel.....
Front Stop.....	steel.....	steel.....
Rear Stop.....	steel.....	steel.....

Motor and Electricals:

Motor type.....	totally enclosed fan cooled, induction, capacitor start.....	totally enclosed fan cooled, induction.....
Horsepower.....	3 HP (2.2 kW).....	3 HP (2.2 kW).....
Phase.....	single.....	3.....
Voltage.....	115/230V (prewired 230V).....	230V.....
Listed FLA (full load amps).....	26.5A/13.3A.....	8.3A/4.5A.....
Starting amps.....	45.6A/28.5A.....	18.2A/10.6A.....
Running amps, no load.....	18.5A/9.6A.....	4.5A/2.1A.....
Start capacitor.....	300MF 175VAC.....	n/a.....
Run capacitor.....	80µF 250VAC.....	n/a.....
Cycle.....	60Hz.....	60Hz.....
Motor speed.....	1700 RPM.....	1700 RPM.....
Power cable length.....	200 cm (6.6 ft).....	200 cm (6.6 ft).....
Power plug included.....	no.....	no.....
Foot pedal cable length.....	8.2 ft. (250cm).....	8 ft. (200cm).....
On/Off switch.....	rotary.....	rotary.....
Control.....	Foot pedal.....	Foot pedal.....
Noise emission.....	40-60 dB.....	40-60 dB.....

Capacities:

Material thickness capacity – mild steel.....	14 gauge.....	14 gauge.....
Shearing length capacity.....	52" (1320mm).....	52" (1320mm).....
Back stop capacity.....	25-1/2" (650mm).....	25-1/2" (650mm).....
Front stop capacity.....	23-1/2" (600mm).....	23-1/2" (600mm).....

Dimensions :

Shipping carton (LxWxH).....	172 x 83 x 130cm (67.75"x32.7"x51.2").....	172 x 83 x 130cm (67.75"x32.7"x51.2").....
Machine size (LxWxH).....	158x196x108cm (62.2"x77"x42.5").....	158x196x108cm (62.2"x77"x42.5").....

Hydraulic System:

Hydraulic hose length.....	9.8 ft. (300cm).....	9.8 ft. (300cm).....
Operating/maximum hydraulic pressure (psi).....	870psi (6Mpa).....	870psi (6Mpa).....
Strokes per minute.....	20 with load.....	20 with load.....
Recommended Hydraulic hose diameter.....	Φ16mm.....	Φ16mm.....

Weights:

Net.....	595 kg (1335 lb).....	595 kg (1335 lb).....
Shipping.....	660 kg (1456 lb).....	660 kg (1456 lb).....

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.



Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.

7.0 Set-Up and Assembly

7.1 Hole center dimensions

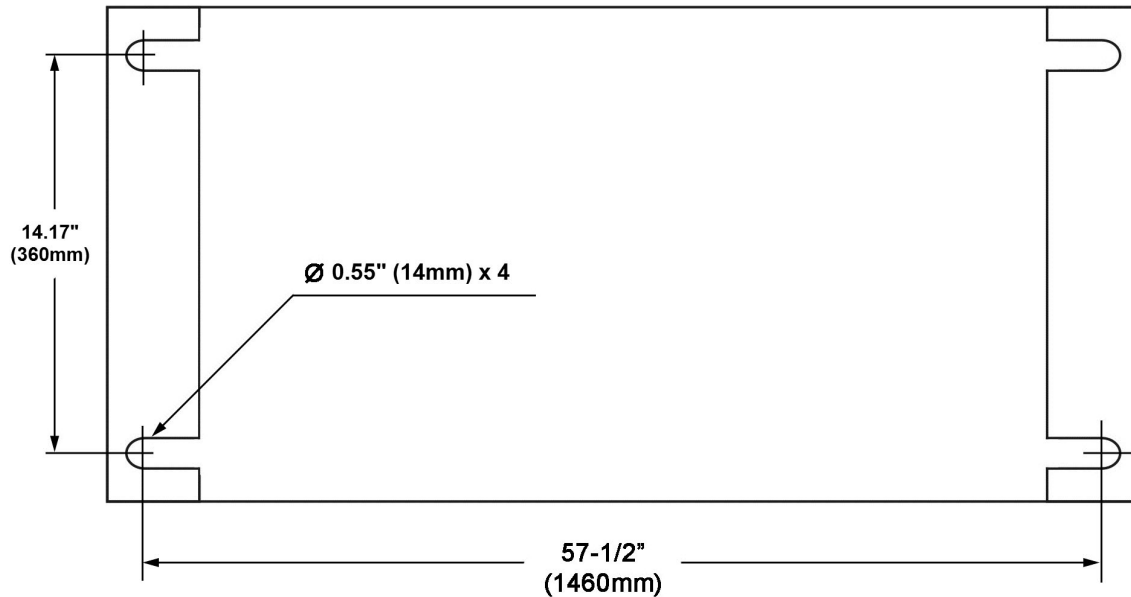


Figure 2

7.2 Unpacking

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Shear is assembled and running properly.

Compare the contents of your container with the following list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

Contents of the Shipping Container

- 1 Hydraulic Shear with Foot Pedal
 - 2 Front Arm Extensions
 - 1 Front Stop, with hardware
 - 1 Rear Stop, with hardware
 - 2 Scale Rods
 - 2 Adjusting Block Assemblies
 - 1 Bevel Gauge, with hardware
 - 1 Instructions and Parts Manual
 - 1 Product Registration Card
1. Remove the crating material from around the machine.

2. Clean the protectant from all exposed metal surfaces with a mild solvent or kerosene, and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline, as these may 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. Place straps below the table (you may have to remove front cover), and use properly rated lifting equipment to move the machine to a level foundation. Machine location must allow access to all sides. Use shims at floor if needed.

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

6. When the machine sits evenly, secure it to the floor using proper fasteners. Refer to Figure 2.

7.3 Stop assemblies

Refer to Figure 1.

1. Attach the two *front arm extensions* (3) to the bed with four *hex cap screws* and four

washers. Level arm extension surfaces with the table before tightening.

2. Attach *front stop* (9) to front arm extensions with T-screws and wing nuts.
3. Attach *rear stop* (17) to the Adjusting Block (14) with six hex cap screws and six flat washers.
4. Insert a *scale rod* (13) through each adjusting block assembly and into cutter bar. The scales must face up.

7.4 Electrical connections

⚠WARNING Electrical connections must be made by a qualified electrician in compliance with all relevant codes. This machine must be properly grounded to help prevent electrical shock and possible fatal injury.

7.4.1 Grounding instructions

This machine must be grounded. In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded. Repair or replace a damaged or worn cord immediately.

7.4.2 Extension cords

The use of an extension cord is not recommended. Try to place shop equipment within reach of the power source. If an extension cord becomes necessary, make sure the cord rating is suitable for the amperage listed on the machine's motor plate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating.

Use the chart in Figure 17 as a general guide in choosing the correct size cord. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Recommended Gauges (AWG) of Extension Cords

Amps	Extension Cord Length *					
	25 feet	50 feet	75 feet	100 feet	150 feet	200 feet
< 5	16	16	16	14	12	12
5 to 8	16	16	14	12	10	NR
8 to 12	14	14	12	10	NR	NR
12 to 15	12	12	10	10	NR	NR
15 to 20	10	10	10	NR	NR	NR
21 to 30	10	NR	NR	NR	NR	NR

*based on limiting the line voltage drop to 5V at 150% of the rated amperes.

NR: Not Recommended.

Table 1

8.0 Adjustments

8.1 Adjustment for the shearing edge gap

The relationship between plate thickness and cutting edge data is shown in Figure 3.

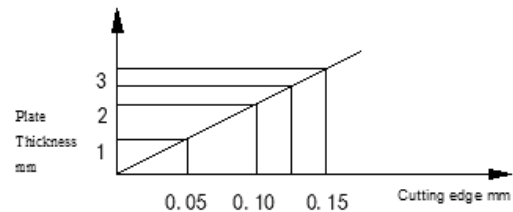


Figure 3

To adjust gap (Figure 4):

1. Loosen bolts (1,2,3).
2. Tighten bolt (4) to increase gap. Loosen bolt (4) and tighten bolt (3) to decrease gap. NOTE: Adjust equally at both ends of machine.
3. Check gap with feeler gauge.
4. When gap value and shear plate thickness correspond, tighten nut (2) and bolts (1).

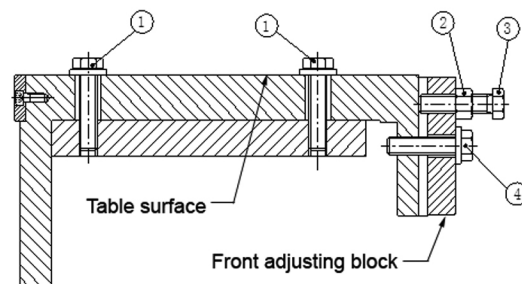


Figure 4

8.2 Adjustment for back gauge

Position rear stop to “0” on the scales, and verify that stop plate is parallel to shear. If not, loosen screw (1) and rotate nut (2) until aligned. Retighten screw (1).

To adjust rear stop for operations, loosen handle (4) and rotate handwheel (5) until desired measurement is reached. Lock handle (4).

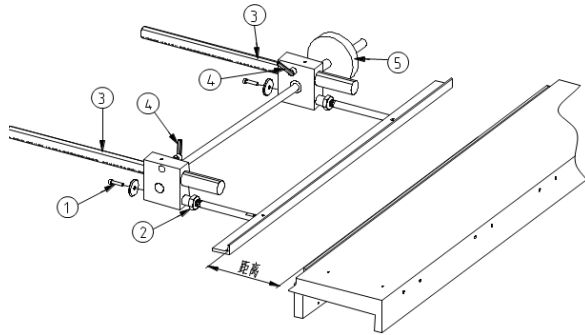


Figure 5

9.0 User-maintenance

CAUTION Use care when working with or around the knives.

The 2-way upper knife can be removed and flipped 180°, for a new edge before having to be sharpened.

Wipe the blades lightly with oil.

Lubricate all pivot points on the machine daily.

10.0 Troubleshooting the HS-1452

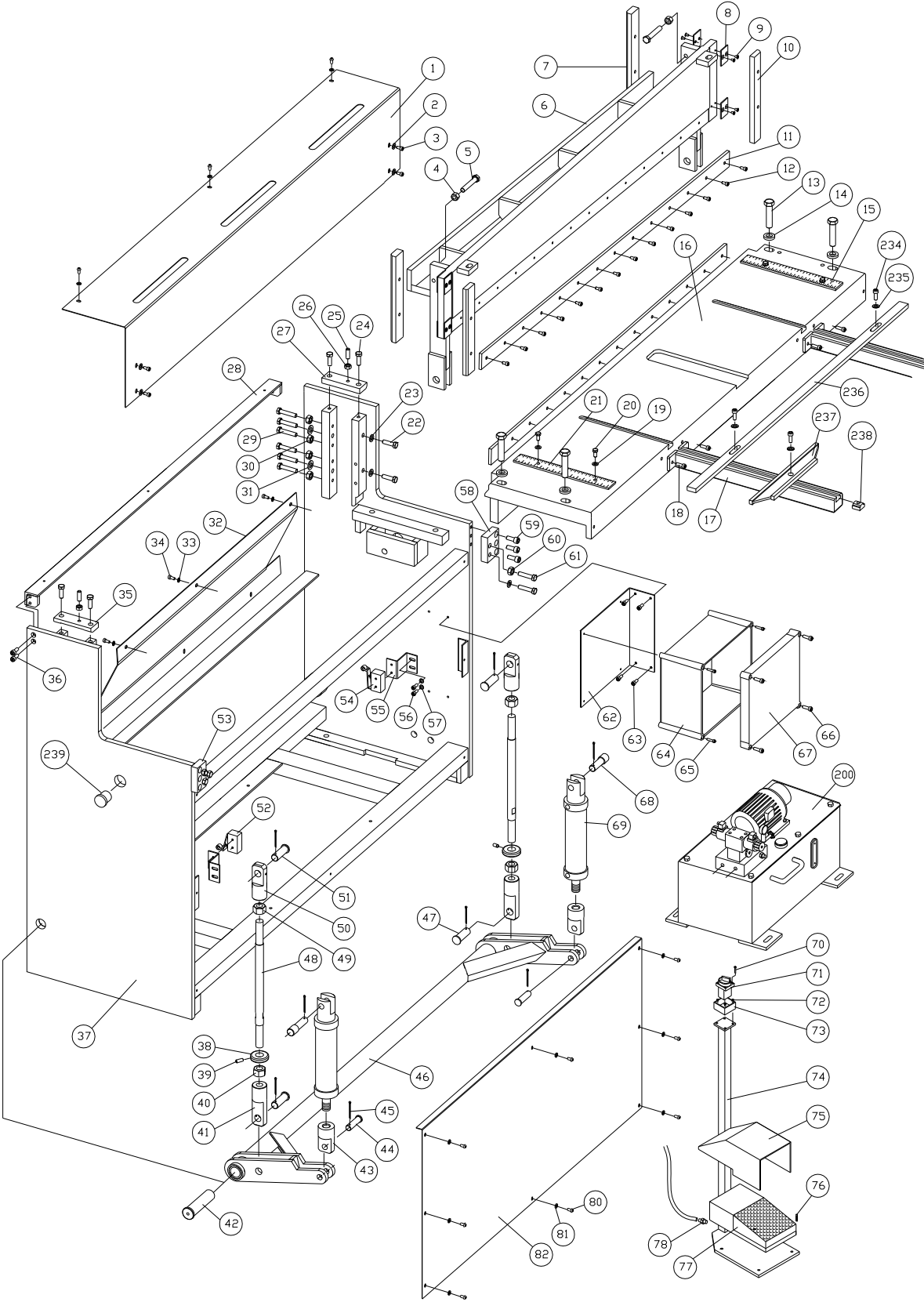
Trouble	Probable Cause	Remedy
Blades will not cut material.	Incorrect gap between blades.	Increase gap for thicker gauge metals.
	Material exceeds machine capacity.	Stay within capacity.
	Blades are dull.	Replace or sharpen blades.
Unsatisfactory cuts.	Blades dull.	Replace or sharpen blades.
	Incorrect gap between blades.	Correct gap.
	Loose gibs.	Remove backlash from gibs.
Cuts not square.	Inadequate hold-down pressure.	Adjust pressure of hold-down.
	Blade gap unequal.	Adjust gap equally across length of blade.
	Uneven guide contact.	Place work against guide consistently.

Table 2

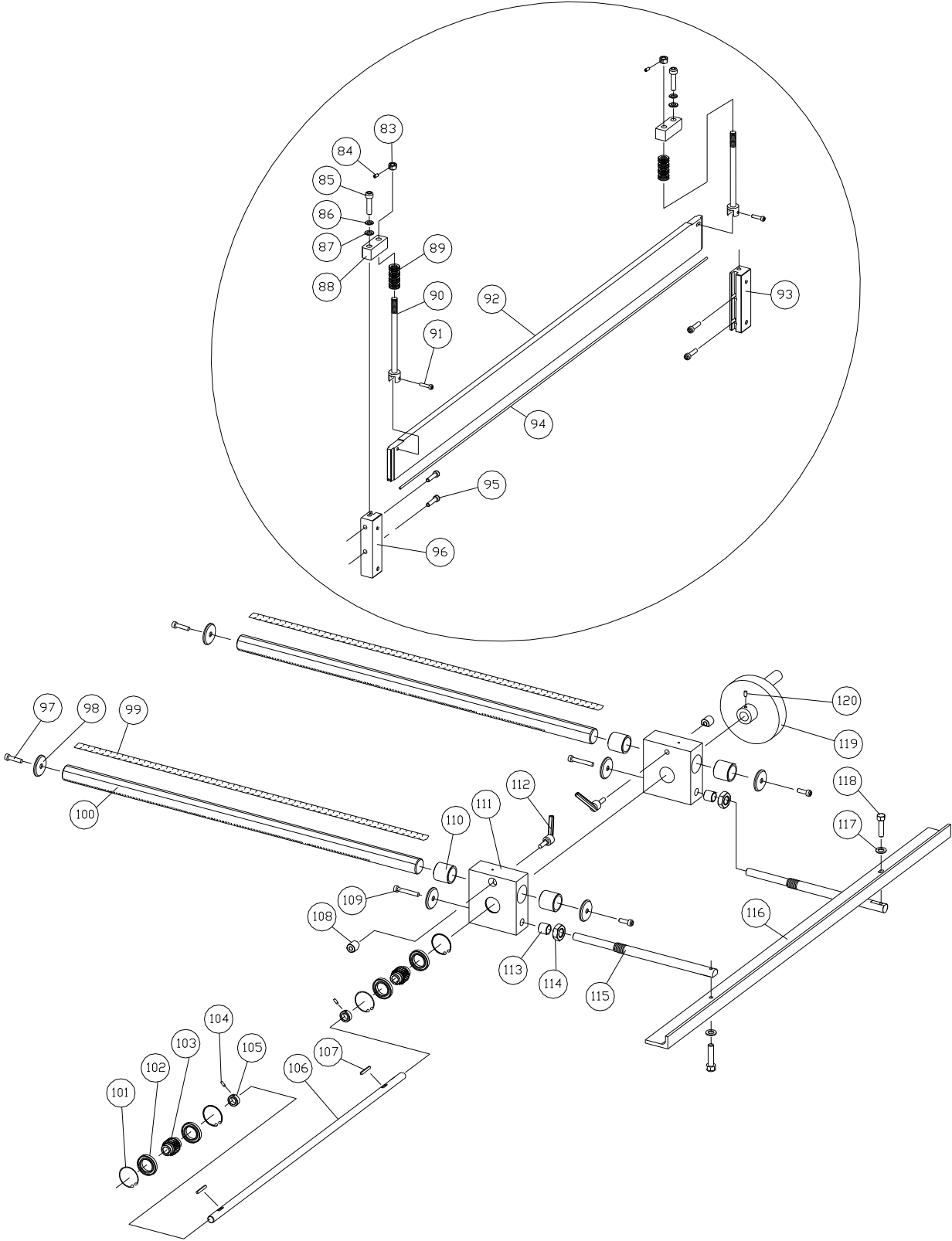
11.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

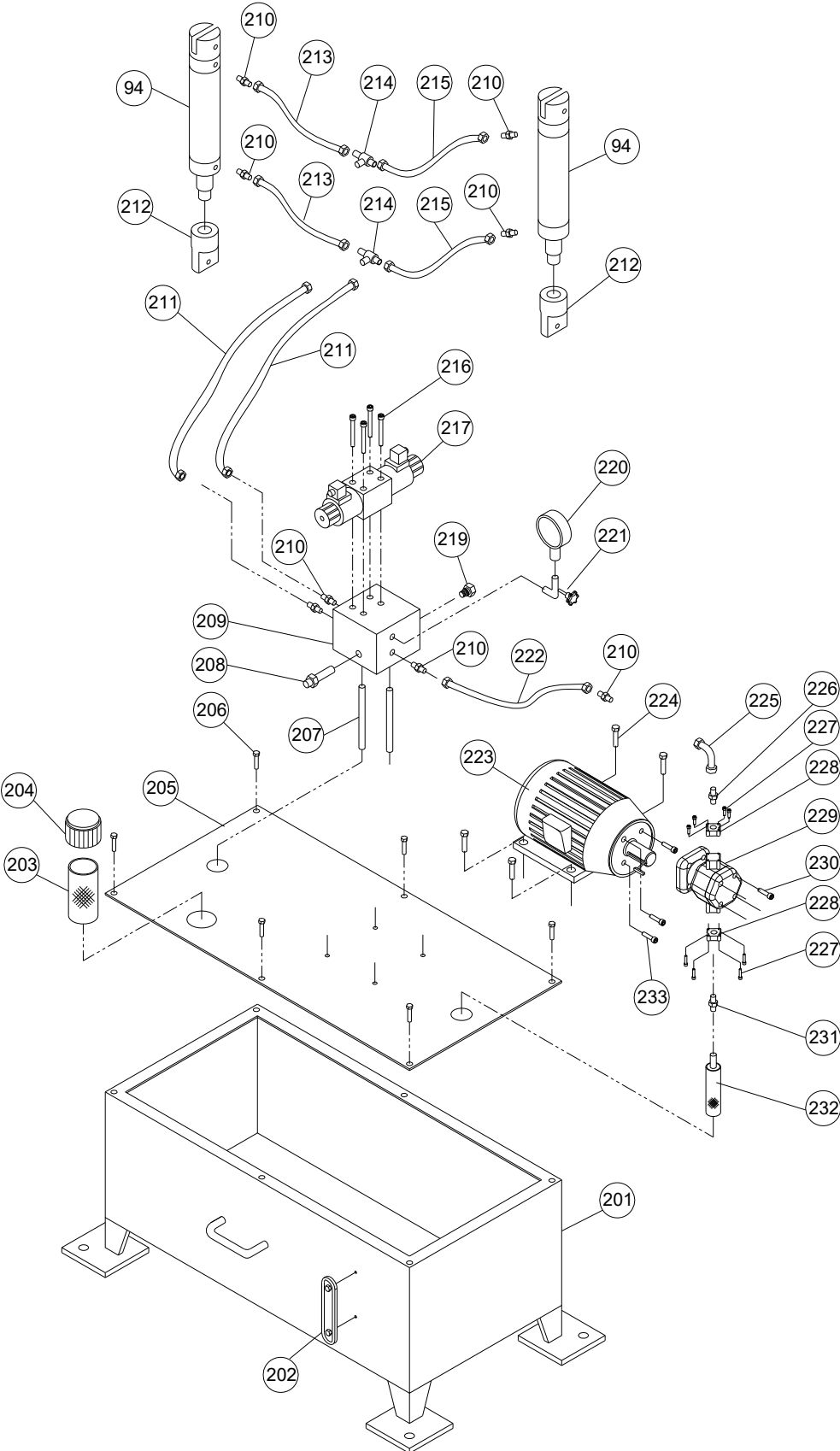
11.1.1 HS-1452 Hydraulic Shear – Exploded View



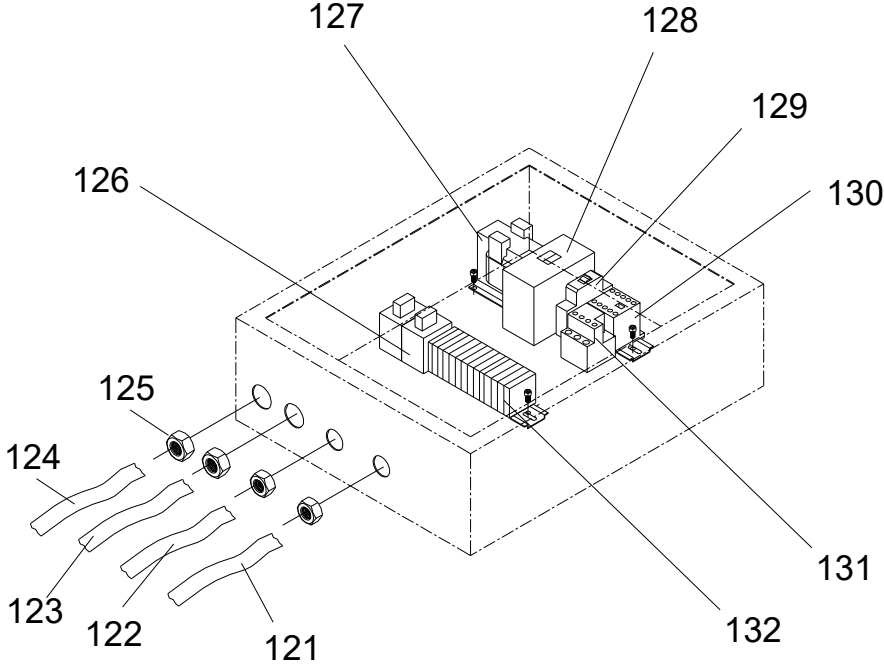
11.1.2 HS-1452 Rear Stop and Press Plate – Exploded View



11.1.3 HS-1452 Hydraulic Regulator Assembly – Exploded View



11.1.4 HS-1452 Control Box – Exploded View



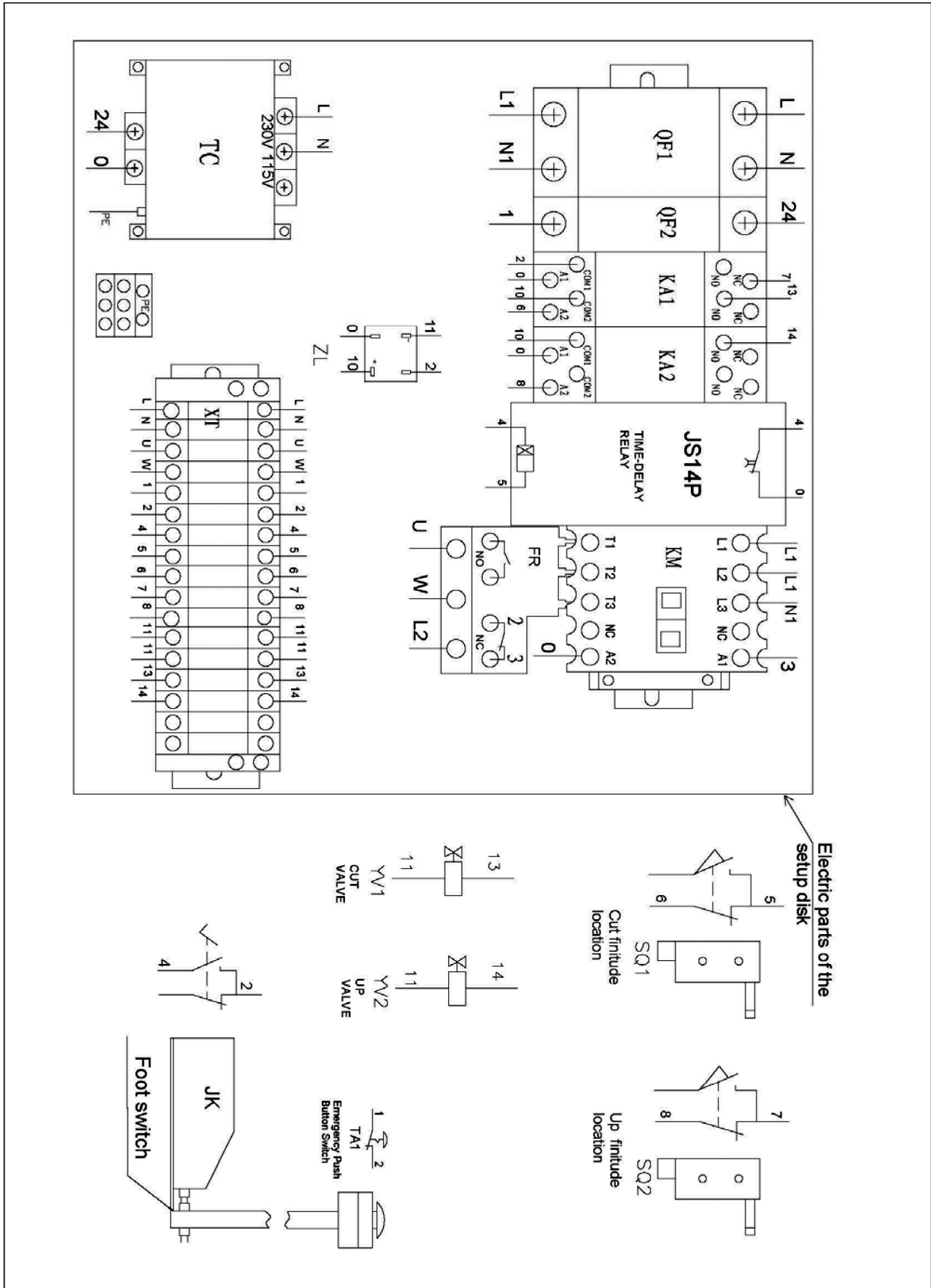
11.1.5 HS-1452 Hydraulic Shear Assembly – Parts List

Index No.	Part No.	Description	Size	Qty
1	HS1252-1G	Cover		1
2	TS-1550041	Flat Washer	M6	7
3	TS-2246122	Hex Socket Button Head Screw	M6x12	7
4	HS1252-4	Copper Nut	M12	2
5	HS1252-5	Copper Bolt	M12x70	2
6	HS1252-6G	Upper Beam		1
7	HS1252-7	Fixed Plate		2
8	HS1252-8	Block		8
9	TS-1533032	Cross Recess Head Screw	M5x10	16
10	HS1252-10	Fixed Plate		2
11	HS1252-11	Blade		2
12	HS1252-12	Bolt	M6x12	28
13	TS-1510071	Hex Cap Screw	M16x70	4
14	HS1252-14	Washer		4
15	HS1252-15	Scale		1
16	HS1252-16G	Table		1
17	HS1252-17	Support Rod		2
18	TS-1505031	Socket Head Cap Screw	M10x25	4
19	TS-1550061	Flat Washer	M8	4
20	TS-1490021	Hex Cap Screw	M8x16	4
21	HS1252-21	Scale		1
22	TS-149105	Hex Cap Screw	M10x35	4
23	TS-1550071	Flat Washer	M10	4
24	TS-1491041	Hex Cap Screw	M10x30	4
25	TS-2279301	Hex Socket Set Screw	M10x30	2
26	TS-2311101	Hex Nut	M10	2
27	HS1252-27	Upper Limit Block (RH)		1
28	HS1252-28	Upper Support		1
29	TS-2210501	Hex Cap Screw	M10x50	12
30	TS-2311101	Hex Nut	M10	8
31	TS-1550071	Flat Washer	M10	4
32	HS1252-32G	Rear Plate		1
33	TS-1550041	Flat Washer	M6	6
34	TS-2246122	Hex Socket Button Head Screw	M6x12	6
35	HS1252-35	Upper Limit Block (LH)		1
36	TS-1504041	Socket Head Cap Screw	M8x20	4
37	HS1252-37G	Body		1
38	HS1252-38	Block		2
39	TS-1523051	Hex Socket Set Screw	M6x16	2
40	TS-2310201	Hex Nut	M20	2
41	HS1252-41	Lower Connecting Block		2
42	HS1252-42	Pin		2
43	HS1252-43	Cylinder Adaptor		2
44	HS1252-44	Clevis Pin		2
45	HS1252-45	Cotter Pin	3.2x45	8
46	HS1252-46G	Connecting bar		1
47	HS1252-47	Clevis Pin		2
48	HS1252-48	Link Rod		2
49	TS-2310201	Hex Nut	M20	2
50	HS1252-50	Upper Connecting Block		2
51	HS1252-51	Clevis Pin		2
52	HS1252-52	Lower Limit Switch		1
53	HS1252-53	Adjusting Block		1
54	HS1252-54	Upper Limit Switch		1
55	HS1252-55	Stand for Limit Switch		2
56	TS-1503031	Socket Head Cap Screw	M6x12	4
57	TS-1550041	Flat Washer	M6	4
58	HS1252-58	Adjusting Block		1

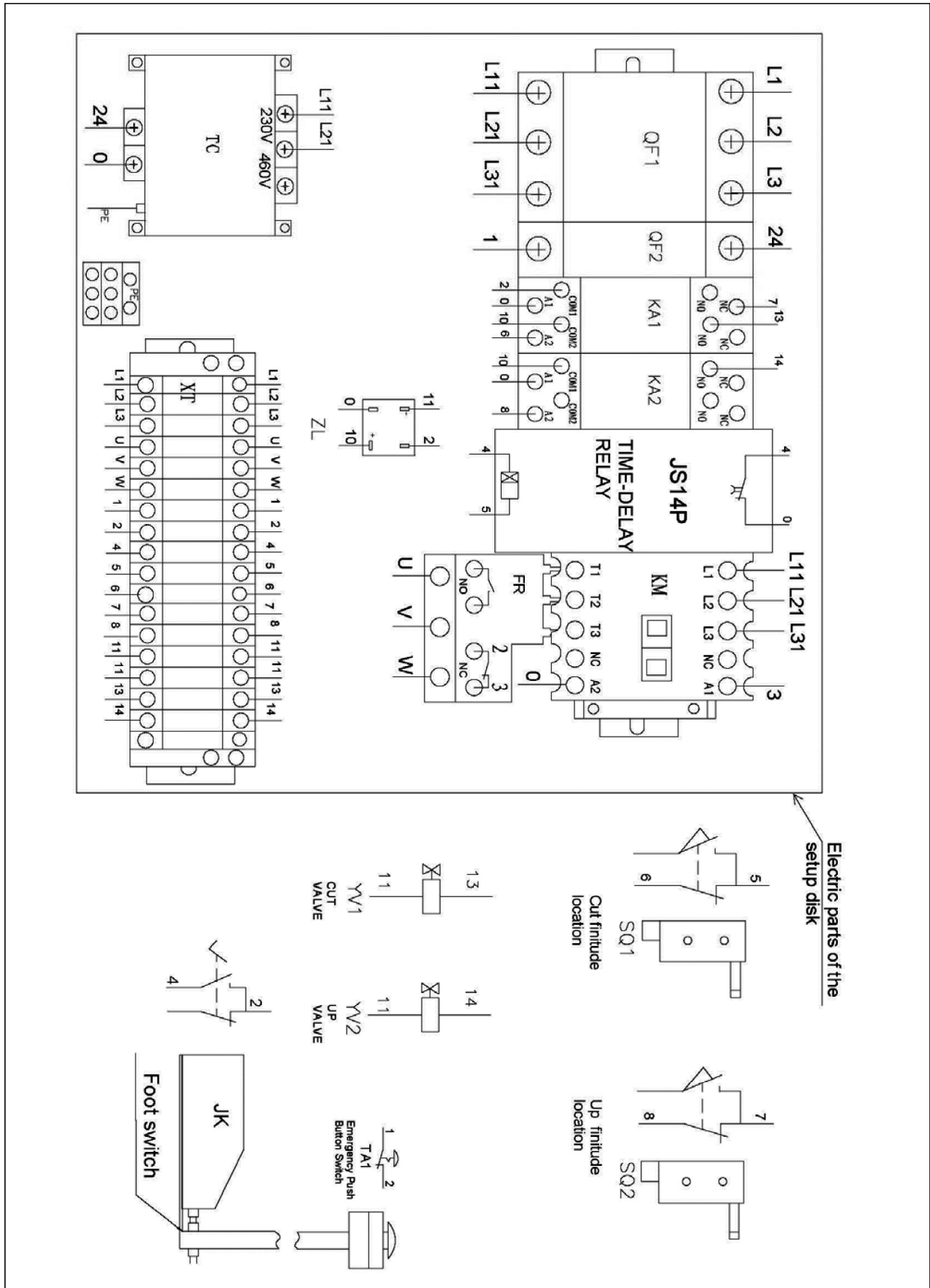
Index No.	Part No.	Description	Size	Qty
59	TS-1505031	Socket Head Cap Screw	M10x25	6
60	TS-2311101	Hex Nut	M10	2
61	TS-2210451	Hex Cap Screw	M10x45	2
62	HS1252-62	Stand for Electric Box		1
63	TS-1503031	Socket Head Cap Screw	M6x12	4
64	HS1252-64	Electric Box		1
65	TS-1503081	Socket Head Cap Screw	M6x35	4
66	HS1252-66	Electric Box Bolt		4
67	HS1252-67	Electric Box Cover		1
68	HS1252-68	Clevis Pin		2
69	HS1252-69G	Cylinder		2
70	HS1252-70	Screw	ST4.2x45	4
71	HS1252-71	Select Switch	XB2-ED23	1
72	TS-1532042	Cross Recess Head Screw	M4x12	4
73	HS1252-73	Switch Box		1
74	HS1252-74G	Post		1
75	HS1252-75	Pedal Guard	YBLT-YDT1/11	1
76	TS-1501041	Socket Head Cap Screw	M4x12	4
77	HS1252-77	Pedal Switch	YBLT-YDT1/11	1
78	HS1252-78	Strain Relief	M20x1.5	1
80	TS-2246122	Hex Socket Button Head Screw	M6x12	8
81	TS-1550041	Flat Washer	M6	8
82	HS1252-82G	Front Plate		1
83	HS1252-83	Nut	M12	2
84	TS-1521021	Hex Socket Set Screw	M4x6	2
85	TS-1505061	Socket Head Cap Screw	M10x40	2
86	TS-2361101	Lock Washer	M10	2
87	TS-1550071	Flat Washer	M10	2
88	HS1252-88	Block		2
89	HS1252-89	Coiled Spring	25x12.5x1.5	48
90	HS1252-90	Rod		2
91	TS-1503071	Socket Head Cap Screw	M6x30	2
92	HS1252-92	Hold-down		1
93	HS1252-93	Guide Slot (RH)		1
94	HS1252-94	Rubber Seal		1
95	TS-1504071	Socket Head Cap Screw	M8x35	4
96	HS1252-96	Guide Slot (LH)		1
97	HS1252-97	Socket Head Cap Screw	M8x20	4
98	HS1252-98	Washer		6
99	HS1252-99	Scale		2
100	HS1252-100	Scale Rod		2
101	HS1252-101	Retaining Ring	37	4
102	HS1252-102	Bearing (37x25x7)	61805	4
103	HS1252-103	Small Gear		2
104	TS-1522011	Hex Socket Set Screw	M5x6	2
105	HS1252-105	Ring		2
106	HS1252-106	Connecting Bar		1
107	HS1252-107	Flat Key	5x20	2
108	HS1252-108	Block		2
109	TS-1504081	Socket Head Cap Screw	M8x40	2
110	HS1252-110	Sliding Bushing		4
111	HS1252-111	Sliding Block		2
112	HS1252-112	Adjustable Handle	M10x50	2
113	HS1252-113	Spacer		2
114	HS1252-114	Nut	M20x1.5	2
115	HS1252-115	Fixed Shaft		2
116	HS1252-116	Rear Stop		1
117	TS-1550061	Flat Washer	M8	2
118	TS-1490031	Hex Cap Screw	M8x20	2
119	HS1252-119	Handwheel	Φ150xΦ16	1
120	TS-2276081	Hex Socket Set Screw	M6x8	1
121	HS1252-121	Cable for Limit Switch	2x0.75mm ²	1

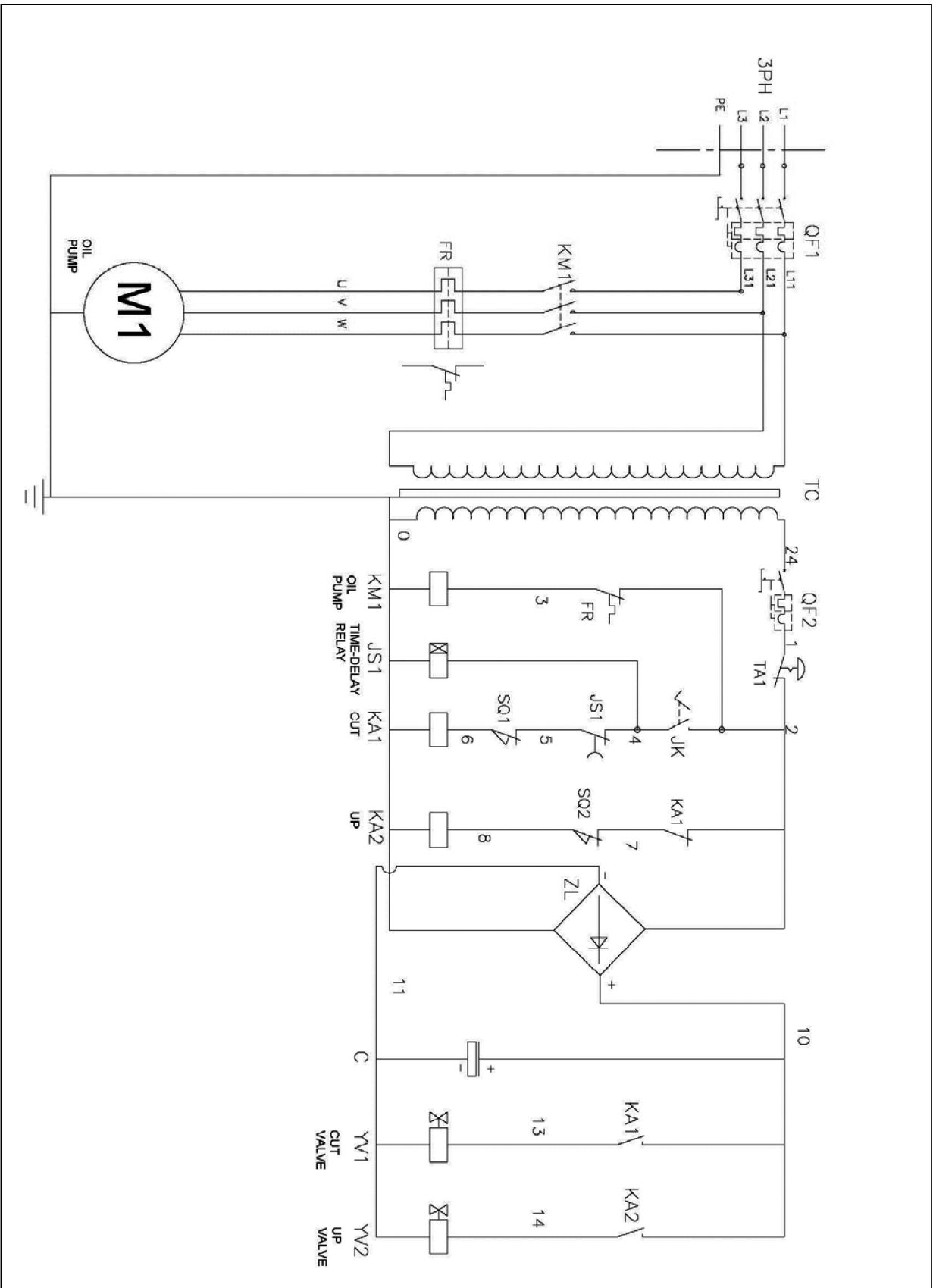
Index No.	Part No.	Description	Size	Qty
122	HS1252-122	Cable for Magnetic Valve	6x0.5mm ² 1.5m	1
123	HS1252-123	Power Cable (for 1PH)	3x2.5mm ²	1
	HS1252-123/3	Power Cable (for 3PH)	4x1.5mm ²	1
124	HS1252-124	Control Cable	6x0.5mm ² 2.5m	1
125	HS1252-125	Strain Relief	M16x1.5	3
126	HS1252-126	Slave Relay	HH54P	2
127	HS1252-127	Transformer (for 1PH)		1
	HS1252-127/3	Transformer (for 3PH)		1
128	HS1252-128	Time Relay	JS14P 0.1-0.99S	1
129	HS1252-129	Breaker (for 1PH)	DZ47-63 1P C5/2P C16	1
	HS1252-129/3	Breaker (for 3PH)	DZ47-63 1P C5/3P C10	1
130	HS1252-130	A.C. Contactor (for 1PH)	CU11 AC24V	1
	HS1252-130/3	A.C. Contactor (for 3PH)	CN-6 AC24V	1
131	HS1252-131	Thermal Relay (for 1PH)	RHN-10 17-8.5	1
	HS1252-131/3	Thermal Relay (for 3PH)	RHN-5M 5.5-8.5	1
132	HS1252-132	Junction Terminal	UK3N 10A	1
200	HS1252-200	Hydraulic Station		1
201	HS1252-201	Oil Tank	50L	1
202	HS1252-202	Oil Gauge	LS-50	1
203	HS1252-203	Filter	JL-04	1
204	HS1252-204	Filter Cap	JY-50	1
205	HS1252-205	Cover		1
206	TS-1482041	Hex Cap Screw	M6x20	8
207	HS1252-207	Oil Return Hose		2
208	HS1252-208	Regulating Valve	Y1 3/4-16UNF	1
209	HS1252-209	Block		1
210	HS1252-210	Straight Fitting	M16x1.5	8
211	HS1252-211	Hydraulic Hose	Φ18x300mm	2
213	HS1252-213	Hydraulic Hose	Φ18x430mm	2
214	HS1252-214	T-Fitting	M16x1.5	2
215	HS1252-215	Hydraulic Hose	Φ18x930mm	2
216	HS1252-216	Socket Head Cap Screw	M5X100	4
217	HS1252-217	Magnetic Valve	DSG-02-3C6	1
219	HS1252-219	Valve	D1 3/416UNF	1
220	HS1252-220	Hydraulic Pressure Gauge		1
221	HS1252-221	Gauge Switch		1
222	HS1252-222	Hydraulic Hose		1
223	HS1252-223	Motor	2.2kW 1PH	1
	HS1252-223/3	Motor	2.2kW 3PH	1
224	TS-1490051	Hex Cap Screw	M8x30	4
225	HS1252-225	Hydraulic Hose		1
226	HS1252-210	Straight Fitting	M16x1.5	1
227	HS1252-227	Screw	M6x25	8
228	HS1252-228	Connect Block		2
229	HS1252-229	Hydraulic pump	RGP-2A-F11R	1
230	HS1252-230	Socket Head Cap Screw	M10x25	4
231	HS1252-210	Straight Fitting	M16x1.5	1
232	HS1252-232	Filter		1
233	HS1252-233	Hex Bolt	M8x30	4
234	TS-1505031	Socket Head Cap Screw	M10x25	3
235	TS-1550071	Flat Washer	M10	3
236	HS1252-236	Front Stop		1
237	HS1252-237G	Bevel Gauge		1
238	HS1252-238	T-Nut		3
239	HS1252-239	Plug		2
	LM000165	ID Label, HS-1452 (not shown)		1
	JET-203	JET Logo (not shown)	203 x 68mm	1

12.1 Electrical Connections – single phase only (HS-1452)

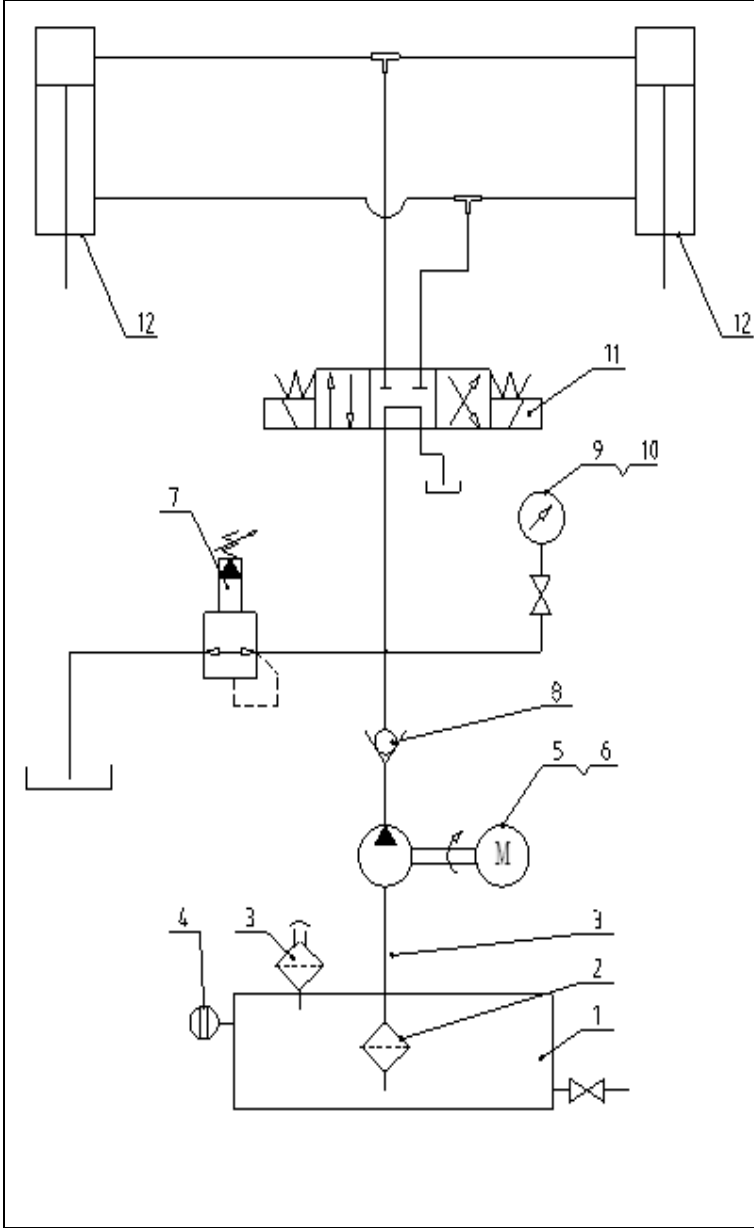


12.2 Electrical Connections – 3 phase only (HS-1452)





13.0 Hydraulic diagram (HS-1452)



No.	Description	Qty
1	Hydraulic tank	1
2	Oil filter	1
3	Air filter	1
4	Oil gauge	1
5	Motor	1
6	Pump	1
7	Pressure regulating valve	1
8	One way valve	1
9	Pressure indicator	1
10	Indicator switch	1
11	Magnetic exchange valve	1
12	Cylinder	2

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