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

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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.**
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) ¼” X 3 ½” 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 ¼” 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.
Step 3

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

B. Tighten ¼” 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.
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 Extension into Cam Receiver, aligning through hole, and insert a Hitch Pin.

C. Insert Handle into Handle Extension, 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.
**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.

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**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.
OPERATING THE MAGNUM SHEAR™

![Caution! Blade is Extremely SHARP!](image)

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)
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)

Figure 12
Narrow Anvil Setting
The MagnumShear is now assembled with this setting, which seems to produce higher quality cuts on most of the Laminate Flooring currently on the market.

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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.

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Fig. 11A

The Professional's Best Shot