

A691R PORTABLE SHEAR CUTTER  
24", 36", 48", 60" INSTRUCTION SHEET

1. Attach the three hold down strips with two #10 x 1-3/4" round head bolts, two #10-24 keps hex nuts and two #10 acorn nuts, as shown in the exploded assembly drawing.
2. Attach the two uprights to the base assembly as shown in the exploded assembly drawing.
3. Attach the cross bar, two roller dowel clips and the 3/4" diameter roller dowel to the uprights as shown in the exploded assembly drawing. NOTE: Attach the first roller dowel clip to the cross bar and upright, insert one end of the roller dowel into that clip. Insert the other end of the dowel into the unattached clip before securing it to the crossbar and upright.
4. Attach the dowel sockets to the uprights as shown in the exploded assembly drawing.
5. Attach the handle to one of the uprights as shown in the exploded assembly drawing.
6. Attach the four casters using four 1/2-13 hex nuts as shown in the exploded assembly drawing.
7. Insert the 1-1/4" feed dowel through the core of the material to be dispensed. If core plugs are included with your material, use them. Insert the dowel onto the dowel sockets.
8. Feed the material over the top of the roller dowel and under one, two, or all three of the hold-downs if necessary to prevent rollback.
9. Your A691R Portable Shear Cutter is ready to dispense.



# A691R EXPLODED ASSEMBLY DRAWING

## ROTARY CUTTER ASSEMBLY

PART NO.	SIZE
691241	24
691361	36
691481	48
691601	60

RUBBER BUMPER #2772

1/4 X 5-1/2  
HEX BOLT #69026

CROSS BAR SIZE  
6912407 24  
6913607 36  
6914807 48  
6916007 60

1/4 X 5/8 ROUND  
HEAD BOLT (8) #393

1/4 KEPS NUT (8) #11860

#10 X 1/2 TRUSS  
HEAD SCREW (2)  
#396

HANDLE #1074

BASE ASSEMBLY FOR  
A691R-24, 36 & 48.  
A691R-60 HAS A KD  
BASE. SEE SEPARATE  
INSTRUCTION SHEET FOR  
ASSEMBLY INSTRUCTIONS.

1/2 NUT (4)  
#429

SWIVEL CASTER  
#376

FEED SIZE	ROLLER DOWEL	HOLD DWN STRIPS	BASE ASSY
24	6912415	6912414 6912411	6912401
36	6913615	6913614 6913611	6913601
48	6914815	6914714 6914811	6914801
60	6916015	6916014 6916011	6916001

ACORN NUT  
#6910009

HOLD DOWN STRIPS

#10 KEPS NUT (2) #3800

#10 X 1-3/4 ROUND  
HEAD BOLT (2) #379

#10 KEPS NUT (2) #3800

UPRIGHT  
#6910001H

ROLLER DOWEL

1/4 KEPS NUT #11860 (4)

DOWEL SOCKET  
#6910007

ROLLER DOWEL CLIP  
#6910010

#10 KEPS NUT #3800

1/4 X 5/8 ROUND  
HEAD BOLT (4) #393

1/4 X 1-3/4  
HEX HEAD  
BOLT (4)  
#1178

FEED DOWEL

1/4 FLAT  
WASHER (4)  
#1040

1/4 KEPS NUT (4)  
#11860

SWIVEL LOCKING  
CASTER #377

FASTENER PACK #691253  
CASTER PACK #397  
ROTARY KNIFE ASSEMBLY #69015  
ROTARY HEAD ASSEMBLY #69022  
ROTARY HEAD #69019

BULMAN PRODUCTS, INC. GRAND RAPIDS, MICHIGAN 49504-2043  
PHONE: 616-363-4416 FAX: 616-363-0380