

STANLEY®

WS10 HYDRAULIC WELD SHEAR



USER MANUAL Safety, Operation and Maintenance



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New Britain, CT 06053
U.S.A.
28860 2/2015 Ver. 13

DECLARATION OF CONFORMITY

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ÜBEREINSTIMMUNGS-ERKLÄRUNG
DECLARATION DE CONFORMITE CEE
DECLARACION DE CONFORMIDAD
DICHIARAZIONE DI CONFORMITA

STANLEY.
Hydraulic Tools



I, the undersigned:
Ich, der Unterzeichnende:
Je soussigné:
El abajo firmante:
Io sottoscritto:

Weisbeck, Andy

Surname and First names/Familienname und Vornamen/Nom et prénom/Nombre y apellido/Cognome e nome

hereby declare that the equipment specified hereunder:
bestätige hiermit, daß erklaren Produkt genannten Werk oder Gerät:
déclare que l'équipement visé ci-dessous:
Por la presente declaro que el equipo se especifica a continuación:
Dichiaro che le apparecchiature specificate di seguito:

- Category: **Weld Shear, Hydraulic**
Kategorie:
Catégorie:
Categoria:
Categoría:
- Make/Marke/Marque/Marca/Marca **Stanley**
- Type/Typ/Type/Tipo/Tipo: **WS1032101A, WS1022001A**
- Serial number of equipment:
Seriennummer des Geräts:
Numéro de série de l'équipement:
Numero de serie del equipo:
Matricola dell'attrezzatura: **All**

Has been manufactured in conformity with
Wurde hergestellt in Übereinstimmung mit
Est fabriqué conformément
Ha sido fabricado de acuerdo con
E' stata costruita in conformità con

Directive/Standards Richtlinie/Standards Directives/Normes Directriz/Los Normas Direttiva/Norme	No. Nr Numéro No n.	Approved body Prüfung durch Organisme agréé Aprobado Collaudato
Machinery Directive EN ISO	2006/42/EC:2006 12100:2010	Self Self

- Special Provisions: **None**
Spezielle Bestimmungen:
Dispositions particulières:
Provisiones especiales:
Disposizioni speciali:
- Representative in the Union: **Patrick Vervier, Stanley Dubuis 17-19, rue Jules Berthonneau-BP 3406 41034 Blois Cedex, France.**
Vertreter in der Union/Représentant dans l'union/Representante en la Union/Rappresentante presso l'Unione

Done at/Ort/Fait à/Dado en/Fatto a Stanley Hydraulic Tools, Milwaukie, Oregon USA Date/Datum/le/Fecha/Data 1-10-11

Signature/Unterschrift/Signature/Firma/Firma

Position/Position/Fonction/Cargo/Posizione Director of Product Development

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IMPORTANT

To fill out a Product Warranty Validation form, and for information on your warranty, visit Stanleyhydraulics.com and select the Company tab, Warranty.
(NOTE: The warranty Validation record must be submitted to validate the warranty).

SERVICING: This manual contains safety, operation, and routine maintenance instructions. Stanley Hydraulic Tools recommends that servicing of hydraulic tools, other than routine maintenance, must be performed by an authorized and certified dealer. Please read the following warning.

⚠ WARNING

SERIOUS INJURY OR DEATH COULD RESULT FROM THE IMPROPER REPAIR OR SERVICE OF THIS TOOL.

REPAIRS AND / OR SERVICE TO THIS TOOL MUST ONLY BE DONE BY AN AUTHORIZED AND CERTIFIED DEALER.

For the nearest authorized and certified dealer, call Stanley Hydraulic Tools at the number listed on the back of this manual and ask for a Customer Service Representative.

SAFETY SYMBOLS

Safety symbols and signal words, as shown below, are used to emphasize all operator, maintenance and repair actions which, if not strictly followed, could result in a life-threatening situation, bodily injury or damage to equipment.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.



This safety alert and signal word indicate an imminently hazardous situation which, if not avoided, will result in death or serious injury.



This safety alert and signal word indicate a potentially hazardous situation which, if not avoided, could result in death or serious injury.



This safety alert and signal word indicate a potentially hazardous situation which, if not avoided, could result in death or serious injury.



This signal word indicates a potentially hazardous situation which, if not avoided, may result in property damage.



This signal word indicates a situation which, if not avoided, will result in damage to the equipment.

This signal word indicates a situation which, if not avoided, may result in damage to the equipment.

Always observe safety symbols. They are included for your safety and for the protection of the tool.

LOCAL SAFETY REGULATIONS

Enter any local safety regulations here. Keep these instructions in an area accessible to the operator and maintenance personnel.

SAFETY PRECAUTIONS

Tool operators and maintenance personnel must always comply with the safety precautions given in this manual and on the stickers and tags attached to the tool and hose.

These safety precautions are given for your safety. Review them carefully before operating the tool and before performing general maintenance or repairs.

Supervising personnel should develop additional precautions relating to the specific work area and local safety regulations. If so, place the added precautions in the space provided in this manual.

The model WS10 Hydraulic Weld Shear will provide safe and dependable service if operated in accordance with the instructions given in this manual. Read and understand this manual and any stickers and tags attached to the pressure washer and hose before operation. Failure to do so could result in personal injury or equipment damage.

The operator must start in a work area without bystanders. Flying debris can cause serious injury.



- Do not operate the tool unless thoroughly trained or under the supervision of an instructor. Establish a training program for all operators to ensure safe operation.
- Always wear safety equipment such as goggles, ear and head protection, and safety shoes at all times when operating the tool.
- The operator must be familiar with all prohibited work areas such as excessive slopes and dangerous terrain conditions.
- Do not inspect, clean or replace the shear blades while the hydraulic power source is connected. Do not inspect or clean the tool while the hydraulic power source is connected. Accidental engagement of the tool can cause serious injury.

- Always connect hoses to the tool hose couplers before energizing the hydraulic power source. Be sure all hose connections are tight and are in good condition.
- Do not operate the tool at oil temperatures above 140°F/60°C. Operation at higher temperatures can cause higher than normal temperatures at the tool which can result in operator discomfort.
- Never wear loose clothing that can get entangled in the working parts of the tool.
- To avoid personal injury or equipment damage, all tool repair, maintenance and service must only be performed by authorized and properly trained personnel.
- The hydraulic circuit control valve must be in the OFF position when coupling or uncoupling the tool. Wipe all couplers clean before connecting. Failure to do so may result in damage to the quick couplers and cause overheating. Use only lint-free cloths.
- Never transport or carry the tool with the unit energized.
- Keep all parts of your body away from the cylinders and shear blades. Long hair or loose clothing can become drawn into moving components.
- Do not use a shear blade that is cracked, chipped or otherwise damaged. Always inspect shear blades for possible damage before installation or use.
- Do not operate a damaged, improperly adjusted or incompletely assembled tool.
- Do not exceed the rated limits of the tool or use the tool for applications beyond its design capacity.
- Always keep critical tool markings, such as labels and warning stickers legible.
- Eye injury and cutting or severing of body parts is possible if proper procedures are not followed.

TOOL STICKERS & TAGS



11207
Circuit Type D Sticker



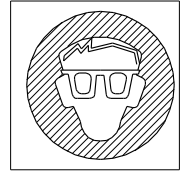
11206
Circuit Type C Sticker



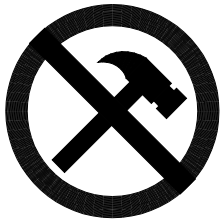
28322
CE Sticker



31064
Crushing Hazard
Warning Sticker



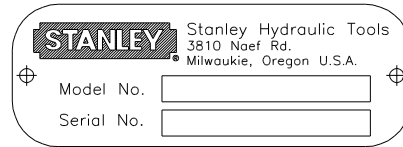
31049
Eye Protection
Sticker



35294
No Hammer Sticker



25610
Railroad Help Desk Sticker



372037
Serial Number Plate



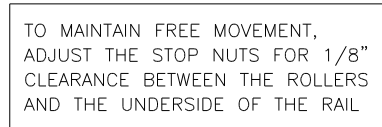
28788
Manual Sticker



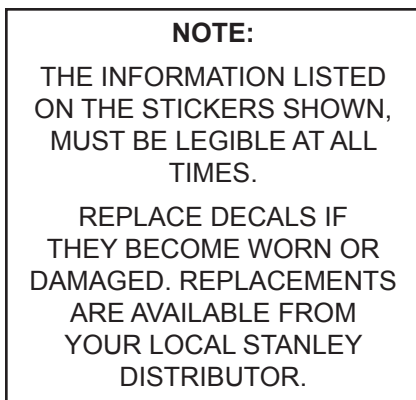
29188
GPM/Pressure Caution Sticker



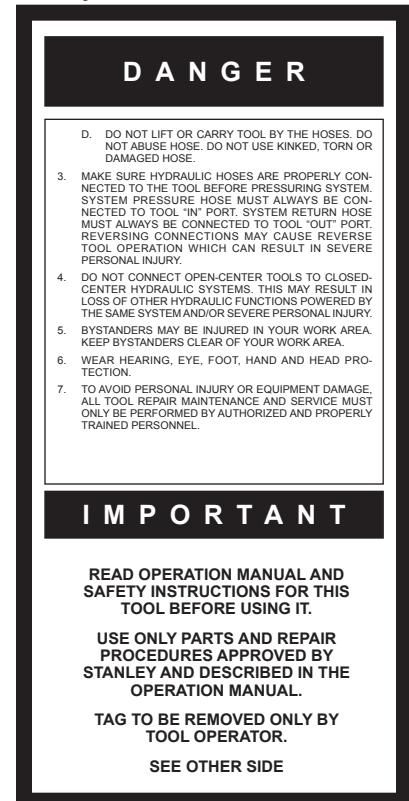
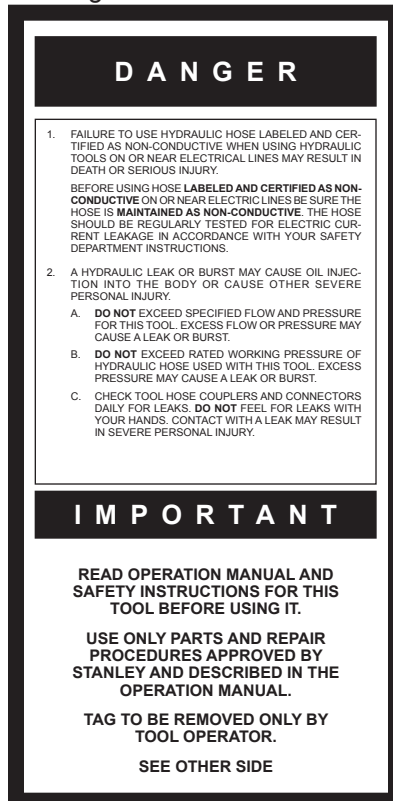
17572
Pinch Point Warning Sticker



35295
Roller Adjustment Sticker



The safety tag (P/N 15875) at right is attached to the tool when shipped from the factory. Read and understand the safety instructions listed on this tag before removal. We suggest you retain this tag and attach it to the tool when not in use.



SAFETY TAG P/N 15875 (Shown smaller than actual size)

TOOL HOSE INFORMATION

The rated working pressure of the hydraulic hose must be equal to or higher than the relief valve setting on the hydraulic system. There are three types of hydraulic hose that meet this requirement and are authorized for use with Stanley Hydraulic Tools. They are:

Certified non-conductive — constructed of thermoplastic or synthetic rubber inner tube, synthetic fiber braid reinforcement, and weather resistant thermoplastic or synthetic rubber cover. *Hose labeled **certified non-conductive** is the only hose authorized for use near electrical conductors.*

Wire-braided (conductive) — constructed of synthetic rubber inner tube, single or double wire braid reinforcement, and weather resistant synthetic rubber cover. *This hose is **conductive** and must never be used near electrical conductors.*

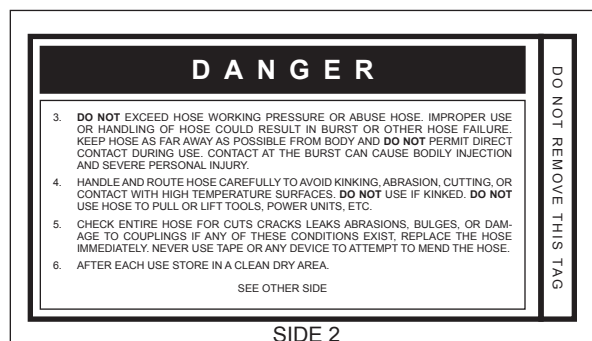
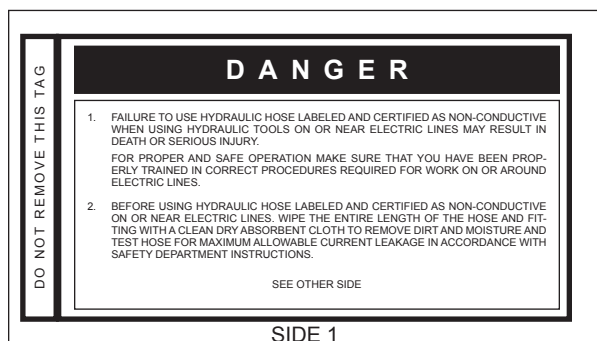
Fabric-braided (not certified or labeled non-conductive) — constructed of thermoplastic or synthetic rubber inner tube, synthetic fiber braid reinforcement, and weather resistant thermoplastic or synthetic rubber cover. *This hose is **not certified non-conductive** and must never be used near electrical conductors.*

HOSE SAFETY TAGS

To help ensure your safety, the following DANGER tags are attached to all hose purchased from Stanley Hydraulic Tools. **DO NOT REMOVE THESE TAGS.**

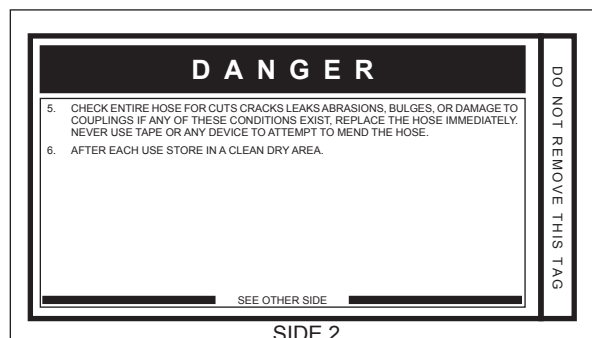
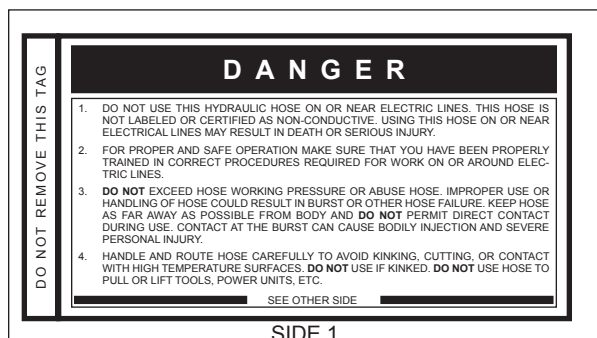
If the information on a tag is illegible because of wear or damage, replace the tag immediately. A new tag may be obtained from your Stanley Distributor.

THE TAG SHOWN BELOW IS ATTACHED TO “CERTIFIED NON-CONDUCTIVE” HOSE



(Shown smaller than actual size)

THE TAG SHOWN BELOW IS ATTACHED TO “CONDUCTIVE” HOSE.



(Shown smaller than actual size)

HOSE RECOMMENDATIONS

Tool to Hydraulic Circuit Hose Recommendations

The chart to the right shows recommended minimum hose diameters for various hose lengths based on gallons per minute (gpm)/liters per minute (lpm). These recommendations are intended to keep return line pressure (back pressure) to a minimum acceptable level to ensure maximum tool performance.

This chart is intended to be used for hydraulic tool applications only based on Stanley Hydraulic Tools tool operating requirements and should not be used for any other applications.

All hydraulic hose must have at least a rated minimum working pressure equal to the maximum hydraulic system relief valve setting.

All hydraulic hose must meet or exceed specifications as set forth by SAE J517.

Oil Flow		Hose Lengths		Inside Diameter		USE (Press/Return)	Min. Working Pressure	
GPM	LPM	FEET	METERS	INCH	MM		PSI	BAR
Certified Non-Conductive Hose - Fiber Braid - for Utility Bucket Trucks								
4-9	15-34	up to 10	up to 3	3/8	10	Both	2250	155
Conductive Hose - Wire Braid or Fiber Braid -DO NOT USE NEAR ELECTRICAL CONDUCTORS								
4-6	15-23	up to 25	up to 7.5	3/8	10	Both	2500	175
4-6	15-23	26-100	7.5-30	1/2	13	Both	2500	175
5-10.5	19-40	up to 50	up to 15	1/2	13	Both	2500	175
5-10.5	19-40	51-100	15-30	5/8	16	Both	2500	175
5-10.5	19-40	100-300	30-90	5/8	16	Pressure	2500	175
10-13	38-49	up to 50	up to 15	3/4	19	Return	2500	175
10-13	38-49	51-100	15-30	5/8	16	Both	2500	175
10-13	38-49	100-200	30-60	5/8	16	Pressure	2500	175
13-16	49-60	up to 25	up to 8	3/4	19	Return	2500	175
13-16	49-60	26-100	8-30	3/4	19	Pressure	2500	175

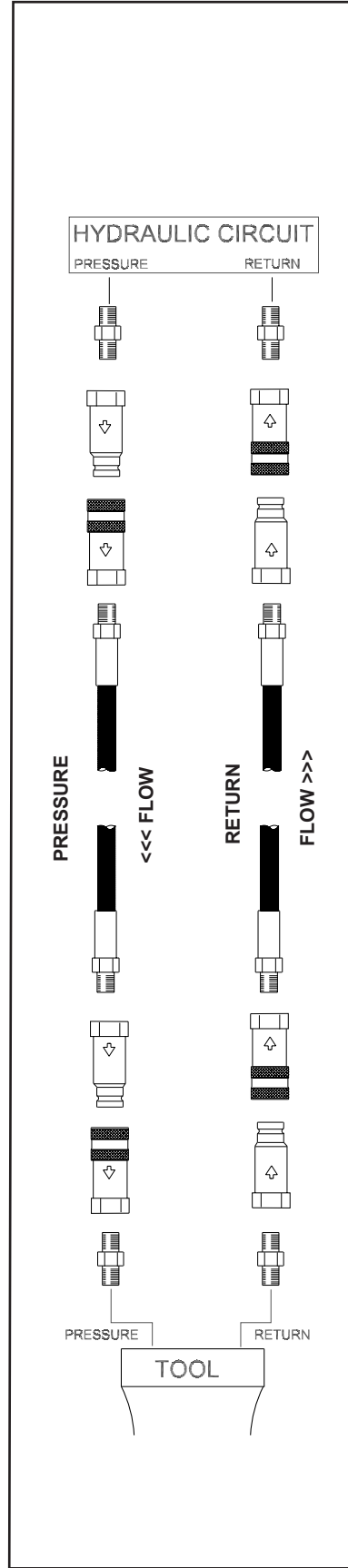


Figure 1. Typical Hose Connections

HTMA / EHTMA REQUIREMENTS

HTMA / EHTMA REQUIREMENTS

HTMA

HYDRAULIC SYSTEM REQUIREMENTS

TOOL TYPE

	TYPE I	TYPE II	TYPE RR	TYPE III
Flow Range	4-6 gpm (15-23 lpm)	7-9 gpm (26-34 lpm)	9-10.5 gpm (34-40 lpm)	11-13 gpm (42-49 lpm)
Nominal Operating Pressure (at the power supply outlet)	1500 psi (103 bar)	1500 psi (103 bar)	1500 psi (103 bar)	1500 psi (103 bar)
System relief valve setting (at the power supply outlet)	2100-2250 psi (145-155 bar)	2100-2250 psi (145-155 bar)	2200-2300 psi (152-159 bar)	2100-2250 psi (145-155 bar)
Maximum back pressure (at tool end of the return hose)	250 psi (17 bar)	250 psi (17 bar)	250 psi (17 bar)	250 psi (17 bar)
Measured at a max. fluid viscosity of: (at min. operating temperature)	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)
Temperature: Sufficient heat rejection capacity to limit max. fluid temperature to: (at max. expected ambient temperature)	140° F (60° C)	140° F (60° C)	140° F (60° C)	140° F (60° C)
Min. cooling capacity at a temperature difference of between ambient and fluid temps NOTE: Do not operate the tool at oil temperatures above 140° F (60° C). Operation at higher temperatures can cause operator discomfort at the tool.	3 hp (2.24 kW) 40° F (22° C)	5 hp (3.73 kW) 40° F (22° C)	6 hp (5.22 kW) 40° F (22° C)	7 hp (4.47 kW) 40° F (22° C)
Filter Min. full-flow filtration Sized for flow of at least: (For cold temp. startup and max. dirt-holding capacity)	25 microns 30 gpm (114 lpm)	25 microns 30 gpm (114 lpm)	25 microns 30 gpm (114 lpm)	25 microns 30 gpm (114 lpm)
Hydraulic fluid Petroleum based (premium grade, anti-wear, non-conductive) Viscosity (at min. and max. operating temps)	100-400 ssu*	100-400 ssu* (20-82 centistokes)	100-400 ssu*	100-400 ssu*
NOTE: When choosing hydraulic fluid, the expected oil temperature extremes that will be experienced in service determine the most suitable temperature viscosity characteristics. Hydraulic fluids with a viscosity index over 140 will meet the requirements over a wide range of operating temperatures.				
*SSU = Saybolt Seconds Universal				

EHTMA HYDRAULIC SYSTEM REQUIREMENTS

CLASSIFICATION

Flow Range	3.5-4.3 gpm (13.5-16.5 lpm)	4.7-5.8 gpm (18-22 lpm)	7.1-8.7 gpm (27-33 lpm)	9.5-11.6 gpm (36-44 lpm)	11.8-14.5 gpm (45-55 lpm)
Nominal Operating Pressure (at the power supply outlet)	1870 psi (129 bar)	1500 psi (103 bar)	1500 psi (103 bar)	1500 psi (103 bar)	1500 psi (103 bar)
System relief valve setting (at the power supply outlet)	2495 psi (172 bar)	2000 psi (138 bar)	2000 psi (138 bar)	2000 psi (138 bar)	2000 psi (138 bar)

NOTE: These are general hydraulic system requirements. See tool specification page for tool specific requirements

OPERATION

PREPARATION FOR INITIAL USE

On hand pump units, replace the plastic shipping plug on top of the pump assembly with the breather vent. No other special unpacking or assembly requirements are required on either unit prior to usage.

Each unit should be inspected to assure the unit was not damaged in shipping and does not contain packing debris.

CHECK HYDRAULIC POWER SOURCE (POWER UNIT MODEL ONLY)

1. Using a calibrated flowmeter and pressure gauge, check that the hydraulic power source develops a flow of 4-10 gpm/15-38 lpm Do Not exceed 140 bar/2000 psi.
2. Make certain the hydraulic power source is equipped with a relief valve set to open at 2200-2300 psi/151-158 bar.
3. Make certain that the power source return pressure does not exceed 250 psi/17 bar.
4. Check that the hydraulic circuit matches the tool for open-center (OC) operation.

CHECK TOOL

1. Make sure all tool accessories are correctly installed. Failure to install tool accessories properly can result in damage to the tool or personal injury.
2. There should be no signs of leaks.
3. The tool should be clean, with all fittings and fasteners tight.

CHECK CONTROL MECHANISM

Hand Pump Models

On hand pump models, check that the directional control valve operates freely from the neutral position to the forward position and then back to the neutral position and then to the rearward position. In each position work the lever to assure movement of the cylinders is free of binding and that the hydraulics are performing as intended.

Power Unit Models

On power unit models, check that the directional control valve operates freely from the neutral position to the forward position and then through the neutral and rearward positions.

CONNECT HOSES (Power Unit Model Only)

1. Wipe all hose couplers with a clean lint-free cloth before making connections.
2. Connect the hoses from the hydraulic power source

to the hose couplers on the weld shear. It is a good practice to connect the return hose first and disconnect it last to minimize or avoid trapped pressure within the cylinders.

3. Observe flow indicators stamped on hose couplers to be sure that oil will flow in the proper direction. The female coupler is the inlet coupler.

NOTE: The pressure increase in uncoupled hoses left in the sun may result in making them difficult to connect. When possible, connect the free ends of operating hoses together.

OPERATING PROCEDURES POWER UNIT AND HAND PUMP MODELS CHECKING OPERATION AND PERFORMANCE

1. Observe all safety precautions.
2. Remove any debris and burrs from the rail joint that will interfere with the weld shear cutters.
3. Place the weld shear on the rail over the location to be welded.
4. Adjust the height of the four roller pivots. The pivots must, once pivoted, be placed under the rail head with a minimum of clearance to avoid any forcing during the forward movement of the cutters. This adjustment is done with the 4 hex nuts.
5. On the power unit model, move the hydraulic circuit control valve to the "ON" position.
6. On the Weld Shear, move the directional control valve lever to the forward position so that the shear blade advances. (On hand pump versions, the shear blade will not advance or retract without pumping the lever) Check that the shear blade advances without binding. With the cylinders fully extended, there should be a gap of 1/32-1/16 inch between the two shear blades. If this gap is not correct, do not use the weld shear and have it serviced by an authorized and certified dealer. If the gap is correct, retract the shear blade to its most rearward position by moving the control lever to the rearward position. The shear blades should now be as far apart as the tool will permit.
7. Remove the weld shear from the rail.

OPERATION

CUTTING PROCEDURE

1. Proceed with the preparations for welding and put the molds and accessories in their place.
2. Pour the weld.
3. As soon as permitted by the mold manufacturer's instructions, remove the two side iron sheets of the mold. The bottom plate does not need to be removed.
4. Remove any excess sand from the railhead to prevent damage to the cutters.
5. Place the weld shear on the rail so that it straddles the mold.
6. Pivot the four roller pivots under the rail head by turning the handle assemblies.
7. Start cutting at the correct time based on the mold manufacturer's instructions by moving the directional control valve lever forward (*hand pump models require pumping of the lever*).
8. Cut to the end of the stroke and hold for approximately 1 to 2 seconds.
9. Move the valve handle to the rearward position for opening the cutters (*hand pump models require pumping of the lever*) and retract the shear blade to its most rearward position.
10. Pivot the four roller pivots away from the rail and remove the weld shear from the rail as soon as possible.
11. Quickly remove any excess weld material from the cutters to prevent overheating.

COLD WEATHER OPERATION

If a power unit model weld shear is to be used during cold weather, preheat the system hydraulic fluid at low engine speed.

Power unit models should use normally recommended fluids with fluid temperature at or above 50° F/10° C (400 ssu/82 centistokes) before use.

Hand pump models may be warmed by placing them in a heated compartment.

EQUIPMENT PROTECTION & CARE

NOTICE

In addition to the Safety Precautions found in this manual, observe the following for equipment protection and care.

- Make sure all couplers are wiped clean before connection.
- The hydraulic circuit control valve must be in the “OFF” position when coupling or uncoupling hydraulic tools. Failure to do so may result in damage to the quick couples and cause overheating of the hydraulic system.
- Always store the tool in a clean dry space, safe from damage or pilferage.
- Make sure the circuit PRESSURE hose (with male quick disconnect) is connected to the “IN” port. The circuit RETURN hose (with female quick disconnect) is connected to the opposite port. Do not reverse circuit flow. This can cause damage to internal seals.
- Always replace hoses, couplings and other parts with replacement parts recommended by Stanley Hydraulic Tools. Supply hoses must have a minimum working pressure rating of 2500 psi/172 bar.
- Do not exceed the rated flow (see Specifications) in this manual for correct flow rate and model number. Rapid failure of the internal seals may result.
- Always keep critical tool markings, such as warning stickers and tags legible.
- Tool repair should be performed by experienced personnel only.
- Make certain that the recommended relief valves are installed in the pressure side of the system.
- Do not use the tool for applications for which it was not intended.

TROUBLESHOOTING

If symptoms of poor performance develop, the following chart can be used as a guide to correct the problem.

When diagnosing problems with operation of the weld shear, always check that the hydraulic power source is supplying the correct hydraulic flow and pressure to the tool as listed in the specifications. Use a flow meter known to be accurate. Check the flow with the hydraulic oil temperature at least 80 ° F / 27° C.

SYMPTOM	CAUSE	SOLUTION
WELD SHEAR DOES NOT OPERATE.	HYDRAULIC POWER SOURCE NOT FUNCTIONING.	POWER UNIT MODELS, CHECK POWER SOURCE FOR PROPER FLOW AND PRESSURE (3-10 GPM/11-38 LPM AT 2000 PSI/140 BAR).
	POWER UNIT MODELS, COUPLERS OR HOSES BLOCKED	LOCATE AND REMOVE RESTRICTION.
	POWER UNIT MODELS, HYDRAULIC LINES NOT CONNECTED.	CONNECT LINES.
	HAND PUMP MODELS, HYDRAULIC PUMP FAILURE.	LOCATE AND REMOVE RESTRICTION.
	CYLINDER SEAL FAILURE.	HAVE INSPECTED AND REPAIRED AT AN AUTHORIZED STANLEY SERVICE CENTER.

SPECIFICATIONS

WS10 LIGHTWEIGHT MODELS

Capacity	20,000 lb / 89,000 N
Pressure Range	2000 psi / 140 bar
Maximum Back Pressure	250 psi / 17 bar
Flow Range	3-10 gpm / 11-38 lpm
Porting (power unit model)	-8 SAE O-ring
Couplers (power unit model only)	HTMA Flush Face Type Male & Female
Hose Whips	No (Hand Pump Model Yes)
Weight (hand pump model)	102 lb / 46.2
(power unit model)	90 lb / 41 kg
Overall Length (hand pump model).....	34.5 inches / 87.6 cm
(power unit model)	28 inches / 71 cm
Overall Width (hand pump & power unit models)	19.5 inches / 49.5 cm
Overall Height (hand pump model without pump handle)	12 inches / 30.4 cm
(power unit model)	14 inches / 35.5 cm
Maximum Fluid Temperature.....	140° F/60° C
Sound Pressure Level.....	Less Than 70 dBA @ 1 meter
Vibration Level.....	Less Than 2.5m/sec2
Blade Opening	6 in/15.2 cm

ACCESSORIES

Description	Part No.
Shear Blade Set A (105-155 lb / yd (47-70 kg / m Rail))*	27948
Shear Blade Set B (60-130 lb / yd (41-60 kg / m Rail))*	27989
* Rail Type & Size Determines The Correct Blade Size	
Seal kit (For Models WS1022001A, WS102200A, WS10321A, WS1032101A.....	73166
Seal Kit (Older Models WS10100, WS10200, WS10301, WS1030101, WS1020001	28586
Weld Shear Hold Down Kit.....	73394
Kit consists of the following items found on page 17: (Item 13, 34, 35, 40, 41, 55 and 56).	

PARTS LIST

WS10321A, WS1032101A, WS10321AB & WS10321AS

ITEM	PART NO.	QTY	DESCRIPTION
1	00285	1	Roll Pin 1/8" OD
2	00757	1	Roll Pin 1/8" OD
3	00936	2	Adapter
4	01362	3	O-Ring
5	01758	4	Cap Screw 5/16-18
6	02004	2	# 4 x 3/8 Drive Screw
7	02177	1	O-Ring
8	02633	1	Ball Knob
9	02901	1	O-Ring
10	03061	8	LockWasher 1/2" ID
11	03972	1	Coupler, Female (Set 03971)
12	03973	1	Coupler, Male (Set 03971)
13	07492	4	Roll Pin 1/4" OD
14	07890	1	Roll Pin 3/16" OD
15	14090	2	Stanley Logo
16	17572	2	Pinch Point Warning Sticker
17	17924	1	O-Ring
18	20145	1	Steel Ball
19	20761	2	Bearing Race
20	20762	1	Bearing
21	21318	6	Washer 3/4" ID
22	22374	4	Cap Screw 1/2-13 UNC x 1-1/4
23	24231	3	Grommet
24	24233	1	Shaft
25	24291	1	Rod
26	24297	1	Torsion Spring
27	24300	1	Setscrew
28	24305	9	Spring Washer
29	24313	1	Housing
30	24877	1	Rotor Assy
31	25610	1	Railroad Help Desk Sticker
32	25912	1	Plug
33	25995	8	Hex Jam Nut 3/4-16UNF
34	26196	4	Hex Nut 3/4-10UNC
35	26247	4	Bearing 10FDU12
36	28911	2	Not Pictured, part of valve block assy
37	29188	1	GPM Sticker
38	35294	2	"NO" Hammer Sticker
39	35295	2	Roller Adjustment Sticker
40	67094	4	Roller Pivot
41	67107	4	Handle Assembly
42	67116	4	Elbow
43	67117	1	Tee
44	67124	1	Flow Control Valve
	72759	1	Flow Control Valve WS10321AS ONLY

ITEM	PART NO.	QTY	DESCRIPTION
45	-----	2	Shear Blade Set "A, or B" (See Accessories page or this page)
46	67305	8	Sheet Metal Screw
47	67996	2	45 Degree Elbow
48	68291	2	Cylinder
49	68296	1	Frame Weldment
50	68297	1	Slide Weldment
51	68306	1	Bottom Cover
52	68307	1	Top Cover
53	68309	2	Tube Assembly, Long
54	68311	2	45 Tube Assembly
55	68316	4	Shoulder Screw
56	69809	4	Roller
57	69810	1	Valve Block
58	69904	1	Valve Cap
59	372037	1	Serial Number Plate
60	02504	4	Cap Screw 1/2-13 x 1-1/2

SEAL KIT P/N-73166

SHEAR BLADES

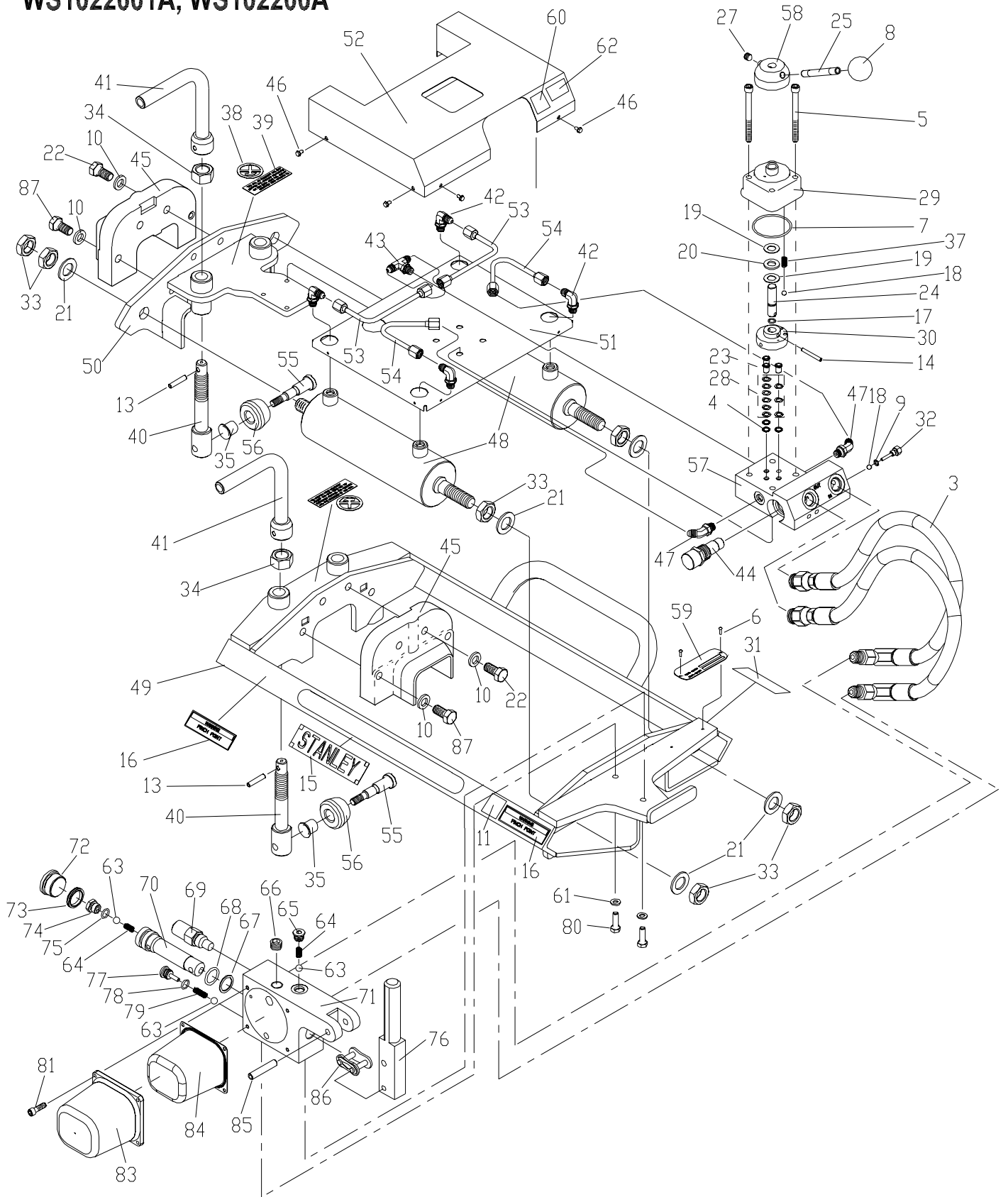
Shear Blade Set A
(105-155 lb / yd (47-70 kg / m Rail))* P/N-27948

Shear Blade Set B
(60-130 lb / yd (41-60 kg / m Rail))* P/N-27989

*** Rail Type & Size Determines The Correct Blade Size**

PARTS ILLUSTRATION

WS1022001A, WS102200A



PARTS LIST

WS1022001A & WS102200A

ITEM	PART NO.	QTY	DESCRIPTION
3	71978	2	Hose Assy
4	01362	3	O-Ring
5	01758	4	Cap Screw 5/16-18
6	02004	2	# 4 x 3/8 Drive Screw
7	02177	1	O-Ring
8	02633	1	Ball Knob
9	02901	1	O-Ring
10	03061	8	LockWasher 1/2" ID
11	28322	--	CE Sticker
13	07492	4	Roll Pin 1/4" OD
14	07890	1	Roll Pin 3/16" OD
15	14090	2	Stanley Logo
16	31064	4	Crushing Hazard Sticker (CE)
17	17924	1	O-Ring
18	20145	2	Steel Ball
19	20761	2	Bearing Race
20	20762	1	Bearing
21	21318	6	Washer 3/4" ID
22	22374	4	Cap Screw 1/2-13 UNC x 1-1/4
23	24231	3	Grommet
24	24233	1	Shaft
25	24291	1	Rod
27	24300	1	Setscrew
28	24305	9	Spring Washer
29	24313	1	Housing
30	24877	1	Rotor Assy
31	25610	1	Railroad Help Desk Sticker
32	25912	1	Plug
33	25995	8	Hex Jam Nut 3/4-16UNF
34	26196	4	Hex Nut 3/4-10UNC
35	26247	4	Bearing 10FDU12
36	28911	2	Not Pictured, part of valve block assy
37	24876	1	Spring
38	35294	2	"NO" Hammer Sticker
39	35295	2	Roller Adjustment Sticker
40	67094	4	Roller Pivot
41	67107	4	Handle Assembly
42	67116	4	Elbow
43	67117	1	Tee
44	71979	1	Port Plug
45	----	1	Shear Blade Set "A, or B" (See Accessories page or this page)
46	67305	8	Sheet Metal Screw
47	67996	2	45 Degree Elbow
48	68291	2	Cylinder

ITEM	PART NO.	QTY	DESCRIPTION
49	70792	1	Frame Weldment
50	68297	1	Slide Weldment
51	68306	1	Bottom Cover
52	68307	1	Top Cover
53	68309	2	Tube Assembly, Long
54	68311	2	45 Tube Assembly
55	68316	4	Shoulder Screw
56	69809	4	Roller
57	69810	1	Valve Block
58	69904	1	Valve Cap
59	372037	1	Serial Number Plate
60	31049	1	Eye Protection Sticker (CE)
61	00283	2	Washer
62	28788	1	Manual Sticker (CE)
63	12100	3	Steel Ball
64	26073	2	Spring
65	08104	1	Hollow Hex Plug
66	01212	1	Pipe Plug
67	26074	1	Back-up Ring
68	23002	1	O-Ring
69	05043	1	Relief Valve
70	25915	1	Plunger
71	70745	1	Pump Block
72	04858	1	Hollow Hex Plug
73	26069	1	Piston Seal
74	25916	1	Plug
75	01411	1	O-Ring
76	25901	1	Lever
77	24289	1	Plug
78	01411	1	O-Ring
79	26071	1	Spring
80	370508	2	Capscrew
81	56521	4	Capscrew
83	52832	1	Reservoir
84	52831	1	Bladder
85	25292	1	Roll Pin
86	26005	1	Master Link
87	02504	4	Cap Screw 1/2-13 UNC x 1-1/2

SEAL KIT P/N-73166

SHEAR BLADES

Shear Blade Set A
(105-155 lb / yd (47-70 kg / m Rail))* P/N-27948
Shear Blade Set B
(60-130 lb / yd (41-60 kg / m) Rail)* P/N-27989

* Rail Type & Size Determines The Correct Blade Size

For Weld Shear Hold Down Kit See Page 14.

STANLEY®

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28860 1/2014 Ver 10