

### Intended use.

This power tool is intended: for commercial applications in industry and trade, for cutting sheet-metal (the maximum cutting thicknesses of the material are indicated in the Specifications), for use with dies and punches, which are indicated in these operating instructions or recommended by DRÄCO.

### Operating the power tool.

To ensure that the die and punch have a long service life, apply cutting paste or oil along the cutting path (on sheet steel), or petroleum (on aluminium sheet).

### Switching ON/OFF (1)

First check that the cable and plug are not damaged.

Switching the power tool ON:

- Slide switch (1) forward (I)

Switching the power tool OFF:

- Slide switch (1) backwards (0).

### Adjusting the cutting direction (3)

- Loosen the union nut (7a) by approx. 3 revolutions.
- Pull the die holder downwards.
- Rotate the die holder in the cutting direction, push up and notch it into the groove.
- Tighten the union nut.

### Changing the punch (5)

**Risk of injury** by switching the tool ON unintentionally. Before changing the tool, pull out the mains plug. Do not regrind the punch and dies. If increased feed is required to guide the power tool or if no-load strokes or excessive burr formation occur, the cutting tools are blunt.

For an optimum cut, change the die and punch at the same time!

- Loosen the union nut. (7a)
- Remove the die holder.
- Change the punch.
- Re-fit the die holder again.
- Tighten the union nut.

### Changing the die (6)

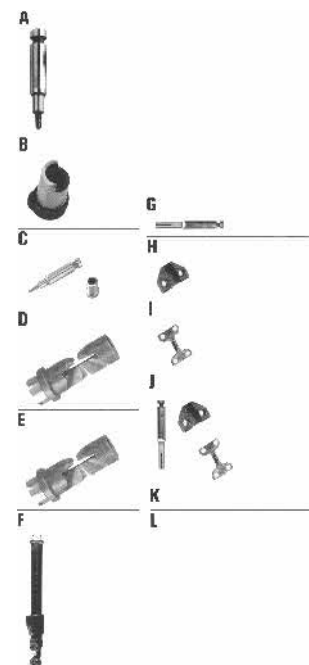
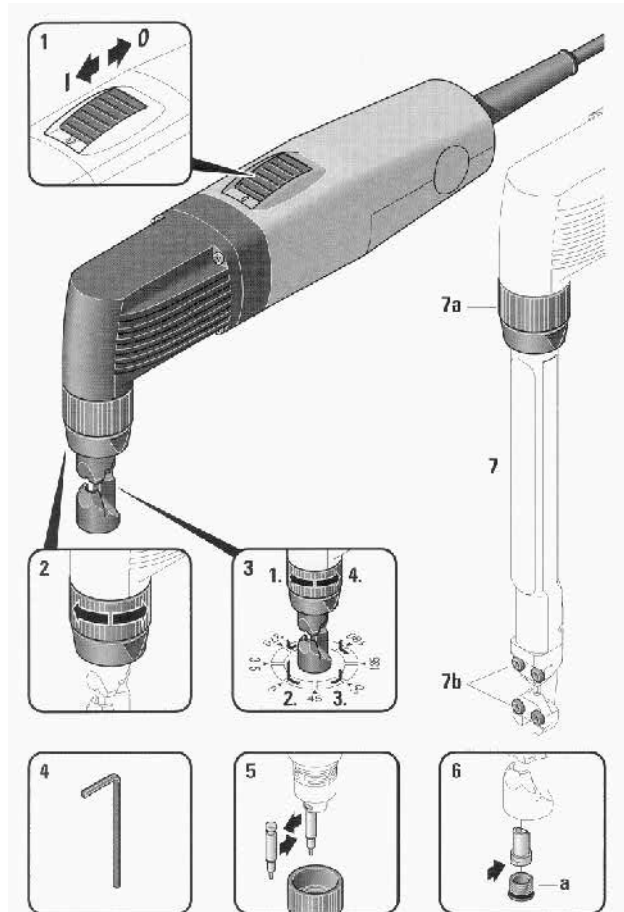
**Risk of injury** by switching the tool ON unintentionally. Before changing the tool, pull out the mains plug. For an optimum cut, change the die and the punch at the same time.

- Unscrew the screw (a).
- Press out and change the die.
- Tighten the screw (a).

### Assembling the profile set (7)

**Risk of injury** by switching the tool ON unintentionally. Before changing the tool, pull out the mains plug. Ideal for treating deep-profiled trapezoidal sheets. Loosen the union nut (7a) and remove die holder and punch. Pull the punch extension upwards a little out of the profile set and insert it from the side into the groove. Mount the profile set. Tighten the union nut (7a). For changing the punch pull it out completely, together with the punch extension.

**Attention!** Put in the die in from the side (Die groove has to match the groove at the wear plate).



### Description of the accessories:

- A Punch.
- B Die.
- C Set (punch and die).
- D Die holder for sheet with trapezoidal corrugations and corrugated sheet.
- E Die holder for profiled and corrugated sheet.
- F Profile Set 160.
- G Punch for Profile Set. Die for Profile Set.
- H Wear plate for Profile Set.
- J Profile Set with set consisting of punch, die, wear plate, 4 Torx screws and 1 screwdriver.
- L Metal Box (410 x 190 x 90 mm).



**Quick IN'OUT  
tool free**



## Operating Instructions for Electric Nibbler 1216

To avoid any disturbance please read the following instructions:

### For your safety:



**1** Safe operation of this machine is possible only when the operating instructions and the safety precautions are read completely and the instructions contained therein are strictly observed.

**2** The machine must not be used when damp and must not be operated in a wet environment.

**3** Always inspect cable and plug before using machine. Only have damage repaired by a qualified professional. Put the plug into the mains socket only when the machine is switched off.

**4+5** Always wears protective goggles, protective gloves and heavy-duty shoes when working.

● Do not carry the machine by the cable.

● Always remove the plug from the power supply socket before carrying out any work on the machine, when interrupting work and when not using the machine.

● Always place the cable to the rear away from the machine.

● Apply the machine to the sheet metal only when switched on.

● Always provide for secure footing when working.

● Firmly clamp the work piece if it does not remain stationary from its own weight.

● The knife should not rub on the jaws: Possible danger of cutting tool breakage.

● Do not exceed the maximum allowable material thickness especially when cutting over doublers, folded joints or welded seams.



For further notes on safety refer to enclosed sheet

**Risk of injury:** By switching the tool ON unintentionally. Before cleaning, pull out the mains plug. Carry out the following once a week, or more often if the power tool is used more frequently: Clean the venting openings. Blow out the motor space from outside with dry compressed air.

### Technical Data:

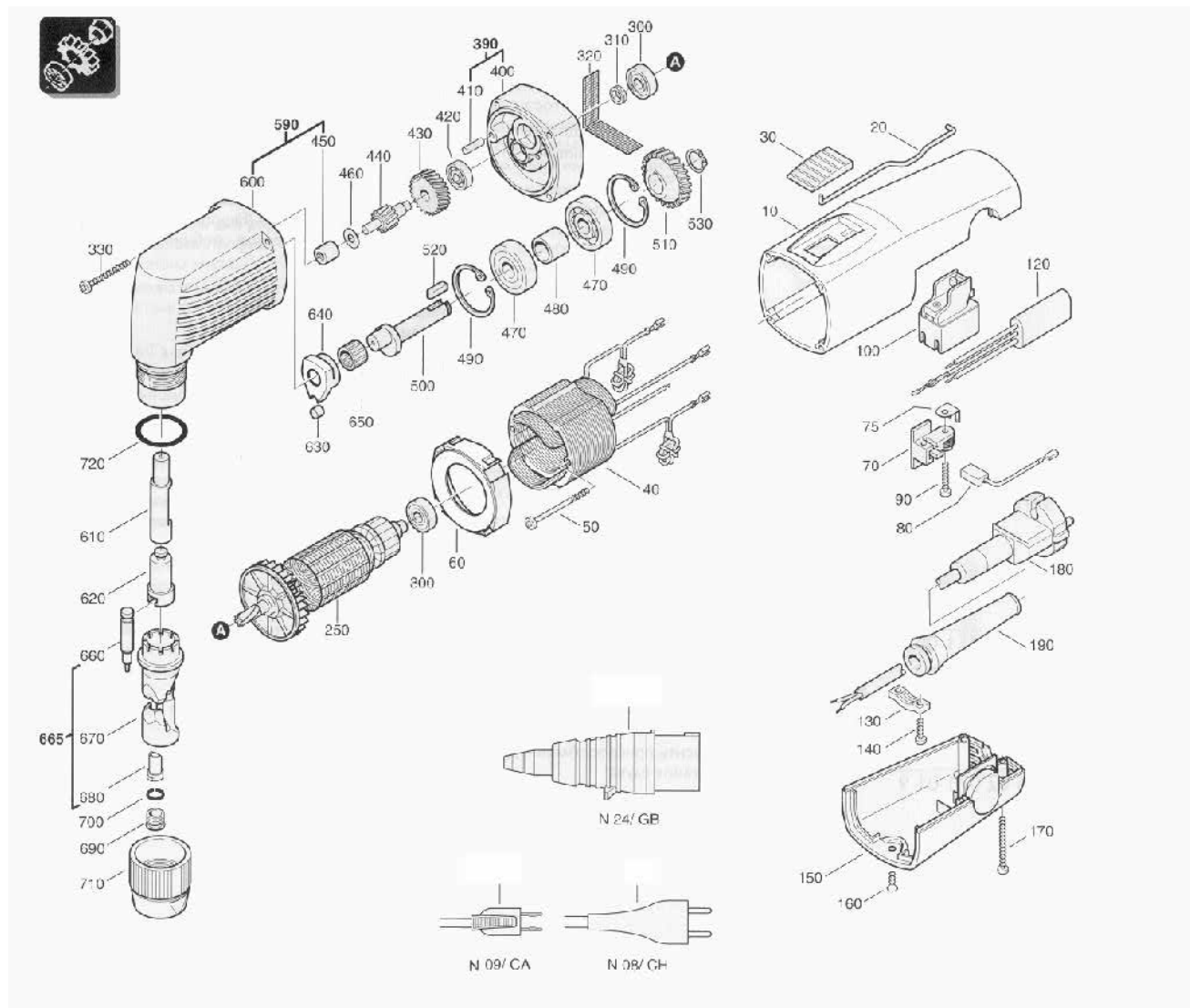
DRÄCO Corrugated Nibbler		1216	
<b>max. cutting capacity</b>		Art.no.	61207
steel	400 N/mm <sup>2</sup>	mm	1,6
stainless steel	600 N/mm <sup>2</sup>	mm	1,0
non ferro	250 N/mm <sup>2</sup>	mm	2,5
depth of profiles max.		mm	85/160
tightest radius		mm	35
working speed		m/min	1,9
strokes		min <sup>-1</sup>	1500
motor capacity		Watt	350
weight		kg	1,8

1216	
<b>spare parts</b>	
punch + die set	12160001
punch	12160002
die	12160003
<b>optional accessories</b>	
<b>profile set 160 mm</b>	<b>12160005</b>
metal-box	18000
nibbling oil (bottle 1,0 L)	20198
nibbling oil (spray 0,5 L)	20199



Profile set  
160 mm

# Exploded view DRÄCO Nibbler 1216



## Care and Maintenance



Before working on machine disconnect from power supply by removing plug from socket. Always keep the machine and the ventilation slots clean.

Oil the die and punch at regular intervals. If the machine should happen to fail despite the care taken in manufacture and testing, repair should be carried out by an authorised customer services agent for DRÄCO power tools

## General instructions

We recommend our customer service department, Dräco authorized service centers or agencies. Please hand these operating instructions to the repair center. An overview of spare parts can be found at the end of these operating instructions. Upon request a repair manual is sent to the electrical engineers. Only use original Dräco spare parts.

## Environmental protection



Recycling raw materials instead of waste disposal. Machine, accessories and packaging should be sorted for environment-friendly recycling. These instructions are printed on recycling paper manufactured without chlorine.

## Guarantee

Dräco tools carry a guarantee of 12 months from date of delivery. Damage attributable to normal wear and tear, overload or improper handling will be excluded from the guarantee. In case of complaint please send the machine, **undismantled**, to your dealer or the Dräco Service Center for electric power tools.

# Spare Part List DRÄCO Electric Nibbler 1216

Pos.	Order-No.	Description	Qty.	Pos.	Order-No.	Description	Qty.
10	20210	Motor housing	1	490	12160020	Securing ring	2
20	20211	Switch rod	1	500	12160021	Eccentric shaft	1
30	20212	Trigger	1	510	12160022	Spur wheel, 41 teeth	1
40	20209	Field 115 V	1	520	12160023	Fitting key	1
40	20206	Field 230 V	1	530	12160024	Securing ring	1
50	20225	Screw Ejot-PT	2	590	12160025	Outer bearing, assembled	1
60	20224	Air conducting ring	1	610	12160026	Plunger	1
70	20228	Carbon brush holder	1	620	12160027	Lower part of plunger	1
75	20227	Connector	2	630	12125	Roller	1
80	20230	Carbon brush	1	640	12160028	Connecting rod	1
90	20229	Screw Ejot-PT	2	650	12160029	Needle bearing	1
100	13017	Switch (2 pole)	1	660	12160002	Punch	1
120	20226	Capacitor	1	665	12160001	Set punch and die	1
130	20219	Cable clamping piece	1	670	12160004	Die holder, assembly for sheet with trapezoidal	1
140	20218	Screw Ejot-PT	2	12160034	Die holder, assembly for profiled and	1	
150	BG20214	Cover assembled	1	680	12160003	Die	1
160	20215	Screw Ejot-PT	1	690	12160030	Screw	1
170	20216	Screw Ejot-PT	2	700	12160031	Sealing ring	1
180	32046	Cable with plug Europe	1	710	12160032	Screw cap	1
	20242	Cable with plug US/CDN	1	720	12160033	Sealing ring	1
	20250	Cable with plug I	1	72025	Socket head wrench, opening 6 mm	1	
	20260	Cable with plug CH	1				
190	13022	Rubber-sleeve	1		<b>PROFILSET 160</b>		
250	12160006	Armature with winding 110-120 V	1	<b>12160005</b>	<b>Profile Set 160 for Nibbler 1216 complete</b>	<b>1</b>	
250	12160007	Armature with winding 230-240 V	1	12160101	Extension 160	1	
300	12160008	Grooved ball bearing	2	12160102	Punch for profile set 160	1	
310	20223	Spacer ring	1	41022	Raised head screw 160	4	
320	12160009	Protective grating	2	41171	Punch guide 160	1	
330	12160010	Screw Ejot-PT	4	41577	Die 160	1	
390	12160011	Intermediate bearing assembly	1	41579	Wearing plate 160	1	
410	12160012	Cylindrical pin	1	12160108	Socket head wrench ( Torx 20)	1	
420	12160013	Grooved ball bearing	1	12160120	Holder ass. (upper part)	1	
430	12160014	Spur wheel, 29 teeth	1	12160117	Die holder SET (under part)	1	
440	12160015	Spur wheel shaft 15 teeth	1				
450	12160016	Needle bearing	1		<b>Optimal accessories</b>		
460	12160017	Disc	1	18000	Metal Box		
470	12160018	Grooved ball bearing	2	20198	Nibbling Oil Bottle 1,0 L		
480	12160019	Spacer sleeve	1	20199	Nibbling Oil Spray 0,5L		

## CE-Declaration of conformity

We declare under our sole responsibility that this product is in conformity with the following standards.  
EG 98/37 EG, EG 73/ 23 EG, EG 89/336 EG, or standardisation documents EN 292 part I, EN 292 part II, EN 50 144, EN 55 014, EN 60 555, HD 400, HD 400.3 part II/H

Max Draenert

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