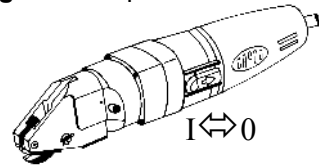


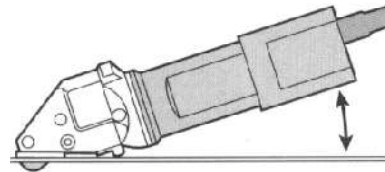
Operating instructions

- Intended use.** This Power Tool is intended for industrial applications, for cutting sheet metal (maximum capacity is indicated in the Specifications), for use with cutting jaws and cutting blades which are indicated in these operating instructions or recommended by DRÄCO.
- Do NOT cut sheet metal along welding points. Do NOT cut multi layer sheets, which exceed the maximum cutting capacity.
- Switching ON/OFF the power tool.** First check cable and plug for damage. Slide the switch pad (5) **FORWARD** for switching **ON** the power tool. Slide the switch pad (5) **BACKWARD** for switching **OFF** the power tool.



- For inside cutting, the shortest curve possible has a radius of 200 mm (± 8). If cutting a radius with the right hand, cut from right to left. The outside radius is unlimited.

- For **cutting out** curved or circular inside patterns, a 14 mm ($\pm 1/2$ ") hole, or a punched slot should be made to insert the centre cutter.
- If after cutting, a **small strip** remains this can easily be trimmed off to the exact measurement, without leaving a burr or any distortion of the material. Just one side of the power tools can be used for cutting also (e.g. along a marked line). Lift the power tools out of the shavings while the motor is running. Cut off longer shavings.
- Both knife and jaws can be sharpened. After being sharpened or replaced, the knife at its lowest point should protrude the jaws by approximately 3 mm. The knife should have approximately 0,05 mm (0,005") play on each side of the jaws, centring the cutter with spacing shims supplied.
- Every 200 operating ours have the cutting blade and cutting jaws sharpened at a specialist workshop.
- Ensure that the material to be cut is free of oil and grease.**



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 knife pin and knife 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

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

Warranty

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. (e.g. blades/knives and jaws) In case of complaint please send the machine, **undismantled**, to your dealer or the DRÄCO Service Center for electric power tools.

CE-Declaration of conformity

We declare under our sole responsibility that this product is in conformity with the following standards. EC 98/37, EC 93/ 68 EWG, EC 04/108 EC und Normen DIN EN ISO 12100-1 , DIN EN ISO 12100-2 , EN 50 144, EN 55 014 entspricht.

CE 09 Max Draenert



Operating Instructions for the Stainless Steel Shear 3520-1 US

To avoid any disturbance please read the following instructions :



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 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.

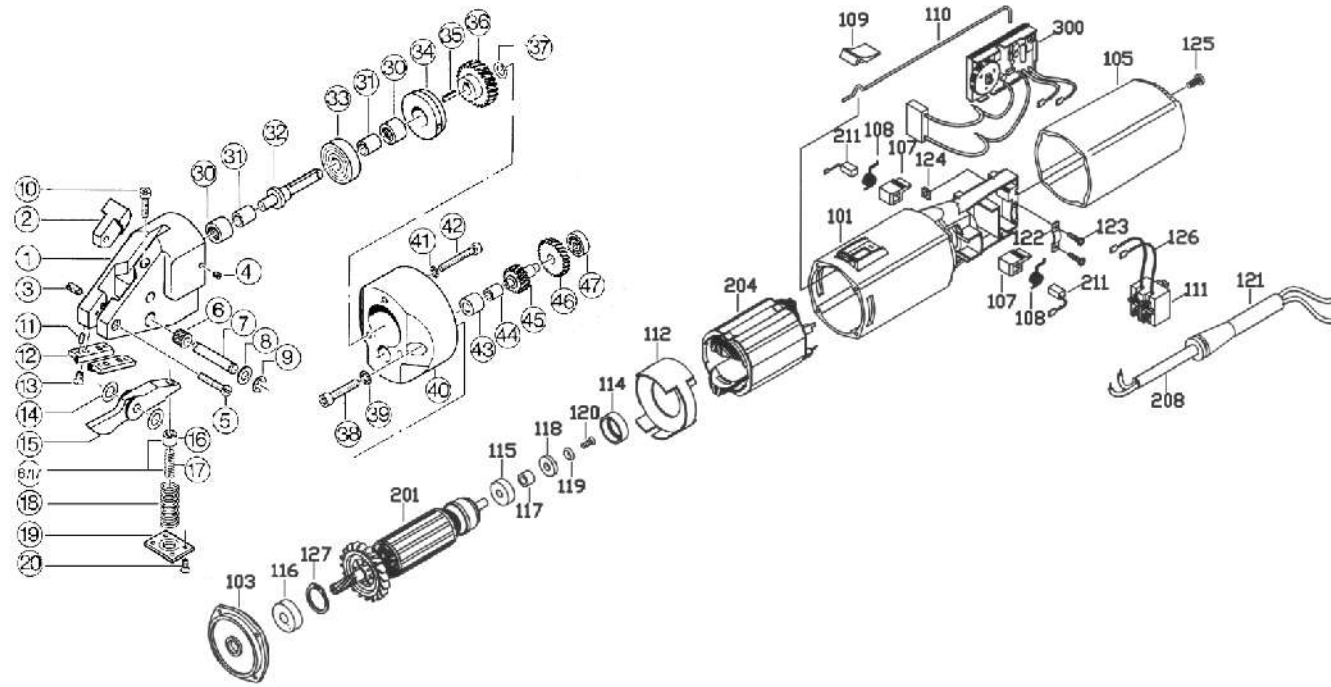
- Do not carry the machine by the cable.
- Always remove the plug from the power supply socket before carrying out any work on the machine, when interrupting work and when not using the machine.
- Always place the cable to the rear away from the machine.
- Apply the machine to the sheet metal only when switched on.
- Always provide for secure footing when working.
- Firmly clamp the work piece if it dose 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 double folded joints or welded seams.

1. Technical details:

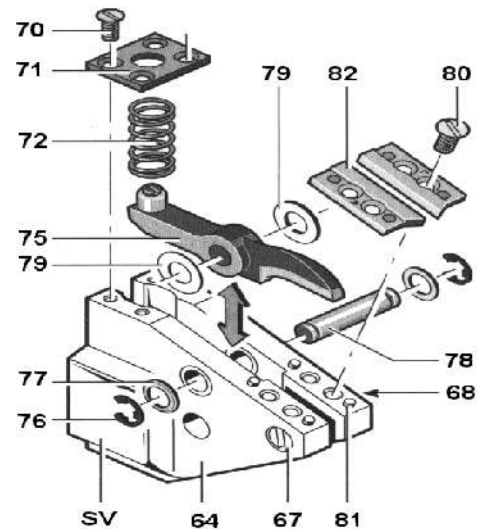
DRÄCO stainless steel shear		type	3520-1
max. thickness			61061-1S2
steel	400 N/mm ²	mm/ga	2,0 / 14
stainl. steel	600N/mm ²	mm/ga	1,5 / 16
stainl. steel	800 N/mm ²	mm/ga	1,3 / 18
aluminium	250 N/mm ²	mm/ga	3,0 / 10
shortest curve radius		mm/inch	200 / 8
working speed max. ca.		m/min	5-7
strokes		min ⁻¹	2400
power consumption		Watt	500
weight		kg	2

3520-1 spareparts	
knife	035201
set of jaws	BG35020
knifepin-set	BG35055
optional accessories	
metal box	18000

Exploded view DRÄCO Profile Metal Shear 3520-1 US



Before working on machine disconnect from power supply by removing plug from socket. Wear protective glasses!



Replacing the Knife

Clamp the machine in a vice on the clamping surfaces SV between aluminium protective jaws.

Unscrew the screws 70 and remove the spring plate 71. Remove the spring 72. Remove the Cotter Pin 76 and the Washer 77. Push back the knife pin 78.

! Do NOT interchange the Spacing Shims 79: the wrong spacing could ruin the jaws and knife. Insert a new knife with the old spacing Shims 79. Insert the knife pin 8. Mount the washer 77 and the Cotter Pin 76. Insert the spring 72. Reassemble spring plate 71.

Replacing the Jaws

Loosen the screws 80 and remove the jaws 82. Press out the positioning pins 81. Mount new jaws and positioning pins. Tighten the screws 80.

Adjusting the knife Clearance

For clearance between knife and jaws that is too large, loosen the fillister head screw 67. Adjust the clearance with the setscrew 68. Retighten the fillister head screw 67.

! The knife must not rub on the jaws: Danger of breakage. Note: If heavy burring is produced while cutting, repeat the adjustment.

Sharpening the Knife/Jaws

The Knife and the Jaws must be sharpened and adjusted at the same time. This work should be performed by an authorised DRÄCO customer service location. Send in the complete machine for this purpose.

Spare Parts List for DRÄCO Profile Metal Shear 3520-1 US

Pos. no.	Order no.	Description	Qty./shear	Pos. no.	Order no.	Description	Qty./shear
101	16039	Motor Housing	1	49	81249	Securing washer A4	3
103	16079	Gear Casing	1	50	81262	Screw	3
105	16036	Switch Cover	1	48-53	BG13046	Gear case cover	1
107	16035	Carbon brush holder	2	52	81243	Securing washer	2
108	16034	Pressure Spring	2	53	81031	Hex socket screw	2
109	16033	Switch Knob	1	54	10009	Circlip	1
110	16032	Switch Connection Lever	1	55	10006	Key	1
111	16080	Switch	1	56	13051	Gear (36 teeth)	1
112	16030	Ventilation Cover	1	57	10450	Cover for needle bearing	1
114	16029	Insulating Ring	1	58,60-62	BG35556	Eccentric drive shaft cpl. ass.	1
115	10040	Ball Bearing	1	58	10005	Sleeve	1
116	16086	Ball Bearing	1	59	10300	Needlebearing	1
117	16026	Bushing	1	60	35285	Bearing	1
118	16025	Magnet	1	61	35556	Eccentric shaft	1
119	16024	Washer	1	62	10005	Sleeve	1
120	16023	Screw M3x8	1	63	10300	Needlebearing	1
121	16022	Rubber-Sleeve	1	63-68	BG37547	Head casting	1
122	16021	Cord-Clamp	1	65	35542	Knife pin bushing ø 10 mm	2
123	16020	Screw 3,5 x 12	2	66-68	BG37059	Spacing block	1
124	16019	Nut M4	1	67	81176	Flat fillister head screw	1
125	16018	Screw M4 x 10	1	68	81120	Tap screw	1
126	16016	Connection Wire	2	69	81239	Tap screw	1
127	16014	Circlip Ø 22 x 1V	1	70	81285	Flat head screw	4
201	16096	Armature 120 Volt	1	70-72	BG12300	Spring cover plate	1
204	16099	Stator/Field 120V Volt	1	72	12200	Spring	1
208	20242	Cable with plug USA	1	73/74	12222	Knife lockring	1
211	16091	Carbon Brush, 110 V	2	74	12000	Knife adjusting screw	1
101-211	16093	Motor 500W, 120V USA	1				
41	13036	Pin	1	73-75	035201	Knife 3520	1
42	81249	Circlip	4	76	35054	Split pin	2
43	31010	Screw	4	77	81072	Washer	2
44	13039	Ball bearing	1	76-78	35145	Knife pin ø 6x42mm	1
44-83	32236	Shearhead Cpl.	1	76-79	BG35055	Knife pin set ø 6x42mm	1
45	13540	Gear (30 teeth)	1	79	BG12400	Spacing shims (var. thick.)	1
44-47	BG31541	Drive shaft Cpl.	1	80	81286	Flat head screw	4
47	13042	Sleeve	1	81	81248	Pin	4
48	13043	Needle-bearing	1	80	35020	Set of jaws	1
				80-82	BG35055	Set of jaws cpl.	1

Please use order # to order.

Your dealer: