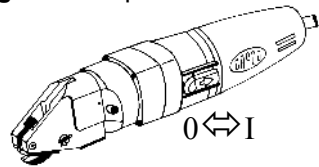


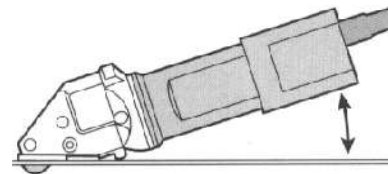
Operating instructions

- Intended use.** This Power Tool is intended for industrial applications, for cutting plastics (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 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) **BACKWARD** for switching **ON** the power tool. Slide the switch pad (5) **FORWARD** for switching **OFF** the power tool.



- For inside cutting, the shortest curve possible has a radius of 175 mm (± 7). 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 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. 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

CE 95 Max Draenert



Operating Instructions for the Plastic Shear 3550

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 plastic material 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.

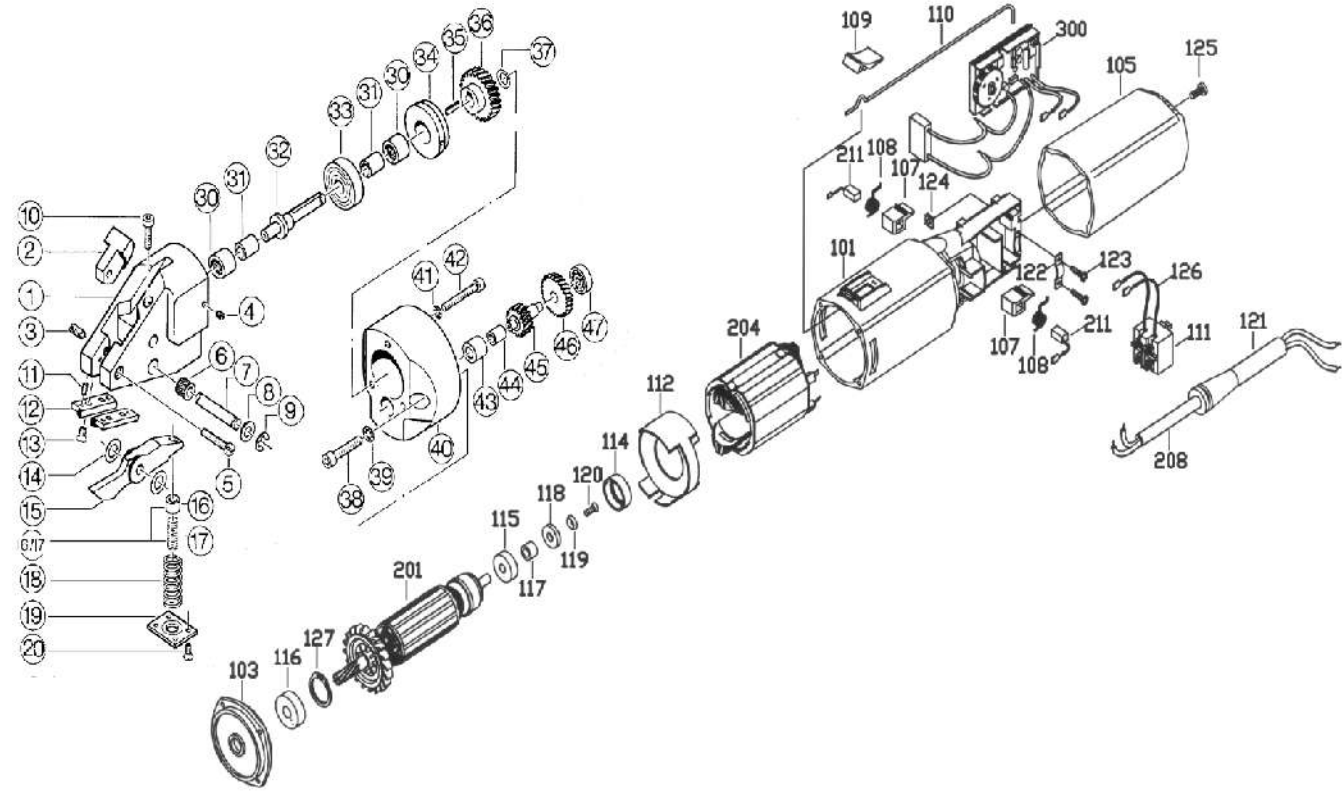


For further notes on safety , we refer to the enclosed red print, safety instruction sheet.

DRÄCO Plastic Shears		3550
max. cutting capacity	Art.no.	61320
Board etc.	mm	5,0
PVC, ABS, PP, etc.	mm/ga.	3,5 / 9
Polyester, GFK, Formica, etc.	mm/ga.	3,0 / 10
tightest radius	mm	175
working speed	m/min	4
strokes	min ⁻¹	2400
motor capacity	Watt	500
weight	kg	2

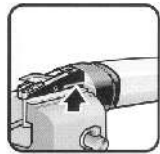
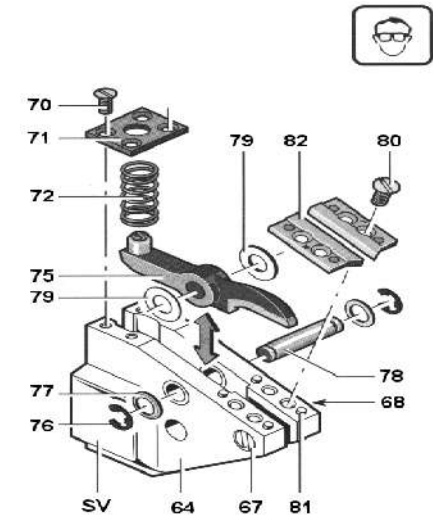
3550		
spare parts		
knife	01002	
set of jaws	BG20601	
knife-pin set	BG12555	
optional accessories		
metal-box	18000	
adjustable guide S/02	up to 100 mm	20062
adjustable guide S/02	up to 250 mm	20063
adjustable guide S/02	up to 500 mm	20064
set of blocks for corrugated plastics	BG20065	

Spareparts for Plastic Shears 3550

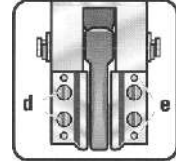
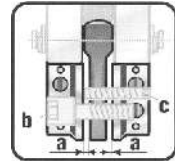


SERVICE TIPS

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



- One drop of oil between knife (11) and head-casting (1) keeps the spacing shims (15) in place.
- Dismantle Spring cover (20) and take spring out (19)
- Take circlip (16) and washer (17) off.
- Push knife pin (18) out of casting.
- Take knife out of housing.
- ⚠ Attention, do not exchange the spacing shims (15).
- Place the knife inside the housing feed shims on one side and push knife pin (18) into housing up to the middle of the knife.
- Feed the shims on the other of the knife.
- Push knife pin in completely, and secure washer (17) and circlip (16) again.
- Assemble spring (19) and spring cover (20).
- Between the knife (11) and the jaws (10) should be some distance, approximately 0,05 mm on each side. Knife (11) must be placed tight in the head casting.
- Adjustment for the play between the jaws. (a): 0,1 - 0,15 mm.



*Optional

- If knife has contact with the jaws on both sides, adjust with screws in the head casting. If a burr is on the material, adjust the space between the knife and the jaws
- Replace jaws with a new set, loosen 4 screws (8) take jaws (10) and pins (9) off, assemble again and tighten with the screws.

Spare Parts List for DRÄCO Plastic Shears 3550

Pos.	Description	Qty.	Order-No.	Pos.	Description	Qty.	Order-No.
	Shearhead 3550 cpl. without Motor		27302	48	Needle bearing	1	13043
54-62	Drive shaft assembled		13277	49	Securing Washer	3	81249
44-47	Pinion with gear cpl. Pos.39,44-47		BG31541	50	Flat Fillister Head Screw	3	81262
	Motor cpl. 230 V, 60 Hz	1	32229	51	Gear Case Cover Seri F	1	BG13046
	Motor cpl. 115 V, 60 Hz	1	32129	52	Spring washer	2	81243
1	Motor housing	1	32040	53	Hex Socket Screw	2	81031
2	Housing Cap	1	32047	54	Circlip	1	10009
3	Switch	1	32050	55	Key	1	10006
4	Guide Piece	1	32054	56	Gear 36 teeth	1	13051
5	Switch Pad	1	32056	57	Cap for Needle Bearing	1	10450
6	Pressure Spring	1	32055	58	Sleeve	1	10005
7	Wire	2	32044	59	Needle Bearing	1	10300
8	Carbon Brush Set	2	32042	60	Ball bearing	1	10200
9	Carbon Brush Holder	2	32041	61	Excentric Drive Shaft	1	10004
10	Condensator	1	32045	62	Sleeve	1	10005
11	Cable with Plug Europe	1	32046	63	Needle Bearing	1	10300
12	Connection Cable	1	32522	64	Head Casting	1	20500
13	Screw	2	32048	65	Pinbush	2	17900
14	Screw	2	32053	67	Flat Fillister Head Screw	1	81272
15	Cable Collar	1	32052	68	Spacing setscrew	1	21600
16	Field 230 Volt, 60 Hz	1	32039	69	Tap Screw with ISK	2	81239
16	Field 115 Volt, 60 Hz	1	32139	70	Flat Head Screw	4	81271
17	Air Deflector Ring	1	32038	71	Spring Cover	1	12300
18	Rubber Sleeve	1	32036	72	Spring	1	12200
19	Ball Bearing	1	32030	73	Knife Lock ring	1	12100
20	Washer	1	32037	73-74	Knife adjusting screw with adjusting screw	1	35566
21	Armature 230 Volt, 60 Hz	1	32033	74	Knife adjusting screw	1	35067
21	Armature 115 Volt, 60 Hz	1	32133	75	Knife	1	01002
23	Bearing Cover	1	32032	76-79	Knife pin set	1	BG12555
24	Ball Bearing	1	10038	76	Circlip	2	81275
25	Securing Ring	1	32034	77	Washer	2	81072
27	Bearing End Plate	1	32014	78	Spacing Shims	1	12500
28	Screw	4	32010	79	Spacing Shims Set	1	BG12400
29	Pin	1	81132	80	Spacing Shims	4	81286
30	Screw	2	32012	81	Pin	4	81248
31	Label	1	32057	82	Set of jaws	1	20601
39	Washer	3	81059	95	Aluminium Cover Plate	1	18610
44	Ball Bearing	1	13039	96	Washer	1	81035
45	Gear	1	13540	97	Flat Head Screw	2	81039
46	Pinion	1	13041	98	Top Angle Guide	1	13000
47	Sleeve	1	13042	99	Wing Screw	2	13200
				100	Side Angle Guide	1	13100

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