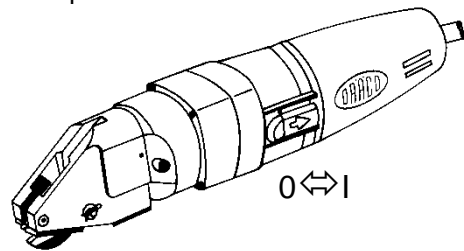
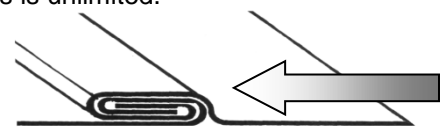


Operating instructions

- 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) **BACKWARD** for switching **ON** the power tool. Slide the switch pad (5) **FORWARD** for switching **OFF** the power tool.

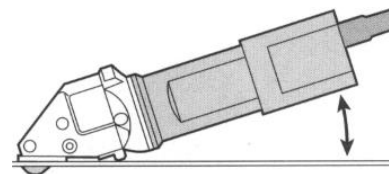


- For inside cutting, the shortest curve possible has a radius of 200 mm ($\pm 8^\circ$). If cutting a radius with the right hand, cut from right to left. The outside radius is unlimited.



Cutting Direction, when cutting Seams

- 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.

2006/42/EG, 2014/30/EU, EN 60745-2-8:2009, EN ISO 11688-1:2009, EN ISO 12100:2010

CE 2016 Susanne Draenert

Draenert



Operating Instructions for the Seam Metal Shear 3514-2

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 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.

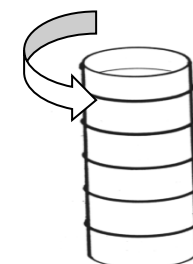
- Do not exceed the maximum allowable material thickness especially when cutting over double folded joints or welded seams.

For further notes on safety refer to enclosed sheet

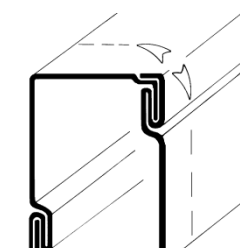
Technical Data:

| DRÄCO Seam Metal Shear | Type | 3514-2 |
|------------------------------------|------------------------------|----------------------|
| Max. Cutting Capacity | Art.no. | 61070 |
| Steel | 400 N/mm ² mm/ga. | 2,0 / 14 |
| Stainless steel | 600 N/mm ² mm/ga. | 1,5 / 16 |
| Stainless steel | 800 N/mm ² mm/ga. | 1,3 / 18 |
| Aluminium | 250 N/mm ² mm/ga. | 3,0 / 10 |
| Duct- & Pittsburgh Seam | 400 N/mm ² mm/ga. | 4 x 0,75 / 21 |
| Double Lock Seam | 250 N/mm ² mm/ga. | 6 x 0,75 / 21 |
| Tightest radius | mm/inch | 200 / 8 |
| Working speed \pm | m/min | 5-7 |
| Strokes | min ⁻¹ | 2400 |
| Motor capacity | W | 500 |
| Weight | kg | 2 |

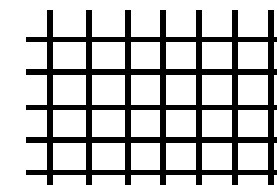
| 3514-2 Spare Parts | |
|----------------------|---------|
| Knife serrated | 035141 |
| Set of jaws | BG35146 |
| Knife-pin set | BG35055 |
| Optional accessories | |
| Metal Box | 18000 |



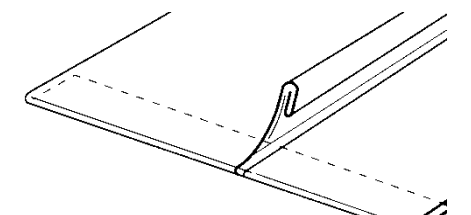
Spiral ducting



Pittsburgh-seam

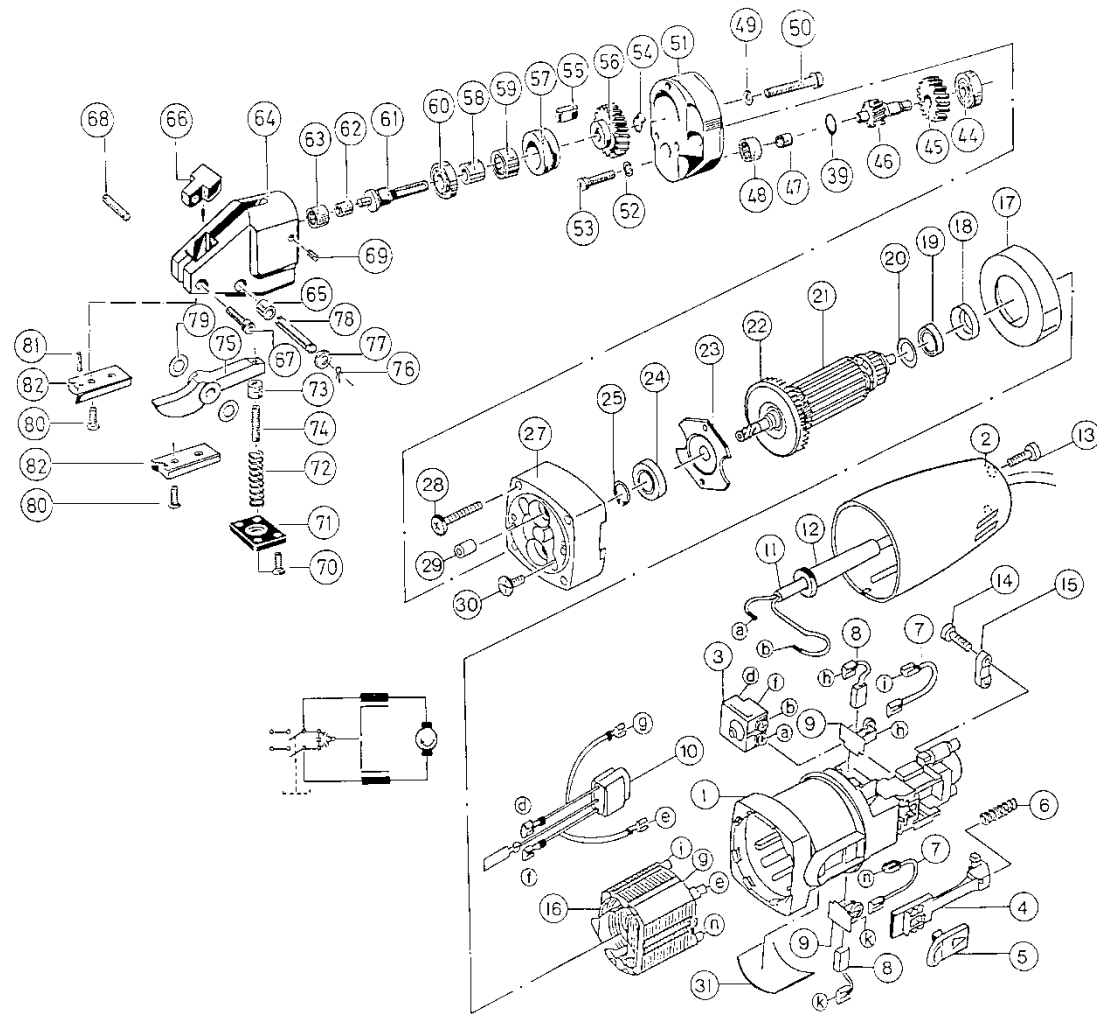


Mesh and Wire



Drop Edges

Spare part List DRÄCO Seam Metal Shear 3514-2



Replacing/Adjusting the Knife

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



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.

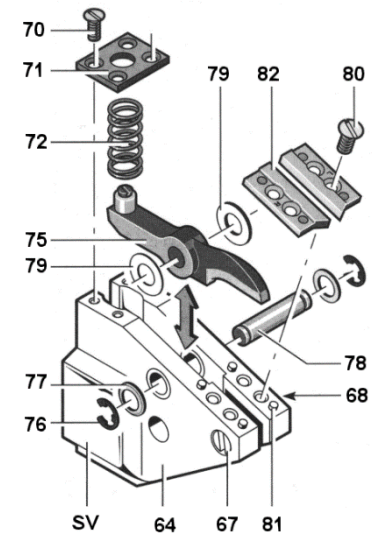
Adjusting the knife Clearance

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.



Replacing the Knife

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

| Pos. | Description | Qty. | Order-No. | Pos. | Description | Qty. | Order-No. |
|------|---|------|-----------|-------|---|------|-----------|
| | Shear Head 3514-2 cpl. assembl. Pos. 35, 39, 44-82 | 1 | BG35941 | 44 | Ball Bearing | 1 | 13039 |
| | | | | 45 | Gear | 1 | 13540 |
| | | | | 46 | Pinion | 1 | 13041 |
| | Drive Shaft cpl. Pos. 54-62 | 1 | BG31558 | 47 | Sleeve | 1 | 13042 |
| | Pinion with Gear cpl. Pos. 39, 44-47 | 1 | BG31541 | 48 | Needle Bearing | 1 | 13043 |
| | Motor cpl. 230 V | 1 | 32229 | 49 | Securing Washer | 3 | 81249 |
| | Motor cpl. 115 V | 1 | 32129 | 50 | Screw | 3 | 81262 |
| | | | | 51 | Gear Case Cover Pos. 48-53 | 1 | BG13046 |
| 1 | Motor Housing | 1 | 32040 | 52 | Securing Washer | 2 | 81243 |
| 2 | Housing Cap | 1 | 32047 | 53 | Hex Socket Screw | 2 | 81031 |
| 3 | Switch | 1 | 32050 | 54 | Circlip | 1 | 10009 |
| 4 | Guide Piece | 1 | 32054 | 55 | Key | 1 | 10006 |
| 5 | Switch Pad | 1 | 32056 | 56 | Gear | 1 | 13051 |
| 6 | Pressure Spring | 1 | 32055 | 57 | Cover for Needle Bearing Pos. 57+59 | 1 | BG10450 |
| 7 | Wire | 2 | 32044 | 58+62 | Sleeve | 1 | 10005 |
| 8 | Carbon Brush | 2 | 32042 | 59+63 | Needle Bearing | 1 | 10300 |
| 9 | Carbon Brush Holder | 2 | 32041 | 60 | Roller Bearing | 1 | 35285 |
| 10 | Condensator | 1 | 32045 | 61 | Eccentric Shaft assembled Pos. 54+55, 60-62 | 1 | BG35556 |
| 11 | Cable with Plug | 1 | 32046 | 64 | Head Casting Pos. 64-68 | 1 | BG35940 |
| 12 | Connection Cable | 1 | 32522 | 65 | Knife Pin Bushing | 2 | 35542 |
| 13 | Screw | 2 | 32048 | 66 | Spacing Block | 1 | 35810 |
| 14 | Screw | 2 | 32053 | 67 | Screw | 1 | 81176 |
| 15 | Cable Collar | 1 | 32052 | 68 | Tap Screw | 1 | 81120 |
| 16 | Field 230 V | 1 | 32039 | 70 | Screw | 4 | 81285 |
| 16 | Field 115 V | 1 | 32139 | 71 | Spring Cover Plate | 1 | 12300 |
| 17 | Air Deflector Ring | 1 | 32038 | 71 | Spring Cover Plate Pos. 70-72 | 1 | BG12300 |
| 18 | Rubber Sleeve | 1 | 32036 | 72 | Spring | 1 | 12200 |
| 19 | Ball Bearing | 1 | 32030 | 73/74 | Knife Adjust Screw with Locking | 1 | 35566 |
| 20 | Washer | 1 | 32037 | 75 | Knife 3514-2 Pos. 73-75 | 1 | 03514 |
| 21 | Armature 230 V | 1 | 32033 | 76+79 | Knife-pin set BG12400+BG35145 | 1 | BG35055 |
| 21 | Armature 115 V | 1 | 32133 | 76 | Safety Cotter Pin | 2 | 35054 |
| 23 | Bearing Cover | 1 | 32032 | 77 | Washer | 2 | 81072 |
| 24 | Ball Bearing | 1 | 10038 | 78 | Knife Pin cpl. Pos. 76-78 | 1 | BG35145 |
| 25 | Securing Ring | 1 | 32034 | 79 | Spacing Shims Set | 1 | BG12400 |
| 27 | Bearing End Plate | 1 | 32014 | 80 | Screw | 4 | 81440 |
| 28 | Screw | 4 | 32010 | 81 | Pin | 4 | 81248 |
| 29 | Pin | 1 | 81132 | 82 | Set of Jaws 3514-2 | 1 | 35146 |
| 30 | Screw | 2 | 32012 | 82 | Set of Jaws 3514-2 cpl. Pos. 80-82 | 1 | BG35146 |
| 31 | Rating Plate | 1 | 32057 | | | | |
| 39 | Washer | 3 | 81059 | | | | |

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