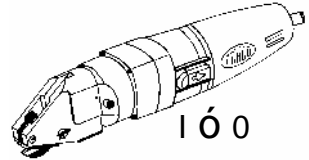


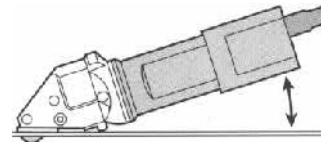
Operating Instructions

- 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 45 mm ($\pm 1\frac{3}{4}$ "). 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.
- Both knife and jaws can be sharpened. After being sharpened or replaced, the knife at it's 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.
- Knife and jaws can be sharpened. After being sharpened or replaced, the knife at it's lowest point, should protrude the jaws by about 2.5 mm. The gap between the knife and the jaws should be approximately 0.1 mm on both sides. For a burr free cutting adjust the cutting gap as follow: Loosen screw, adjust the gap with set screw, to the left narrow, to the right wide, and tighten screw again. Check gap with a feeler gauge.
- Ensure that the material to be cut is free of oil and grease.**



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

Noise/vibration information

Measured values determined according to EN 50 144. Typically the A-weighted sound pressure level of the tool is 83 dB(A). The noise level when working can exceed 85 db (A). Wear ear protection!
The typical hand-arm vibration is below 2,5 m/s².

CE-Declaration of conformity

We declare under our sole responsibility that this product is in conformity with the following standards.
EG 98/37, EG 93/ 68 EWG, EG 04/108 EG und Normen DIN EN ISO 12100-1 , DIN EN ISO 12100-2 , EN 50 144, EN 55 014, CISPR 14-1, CISPR 14-2, IEC61000-3-2, IEC61000-3-3, IEC 60745-1, IEC 60745-2, entspricht.

CE 09 Max Draenert



Operating Instructions for the Metal-Shear SD7-1

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. Have damage repaired by a qualified professional, only. Put the plug into the main socket only, when the machine is in off position.

4+5 Always wear 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.

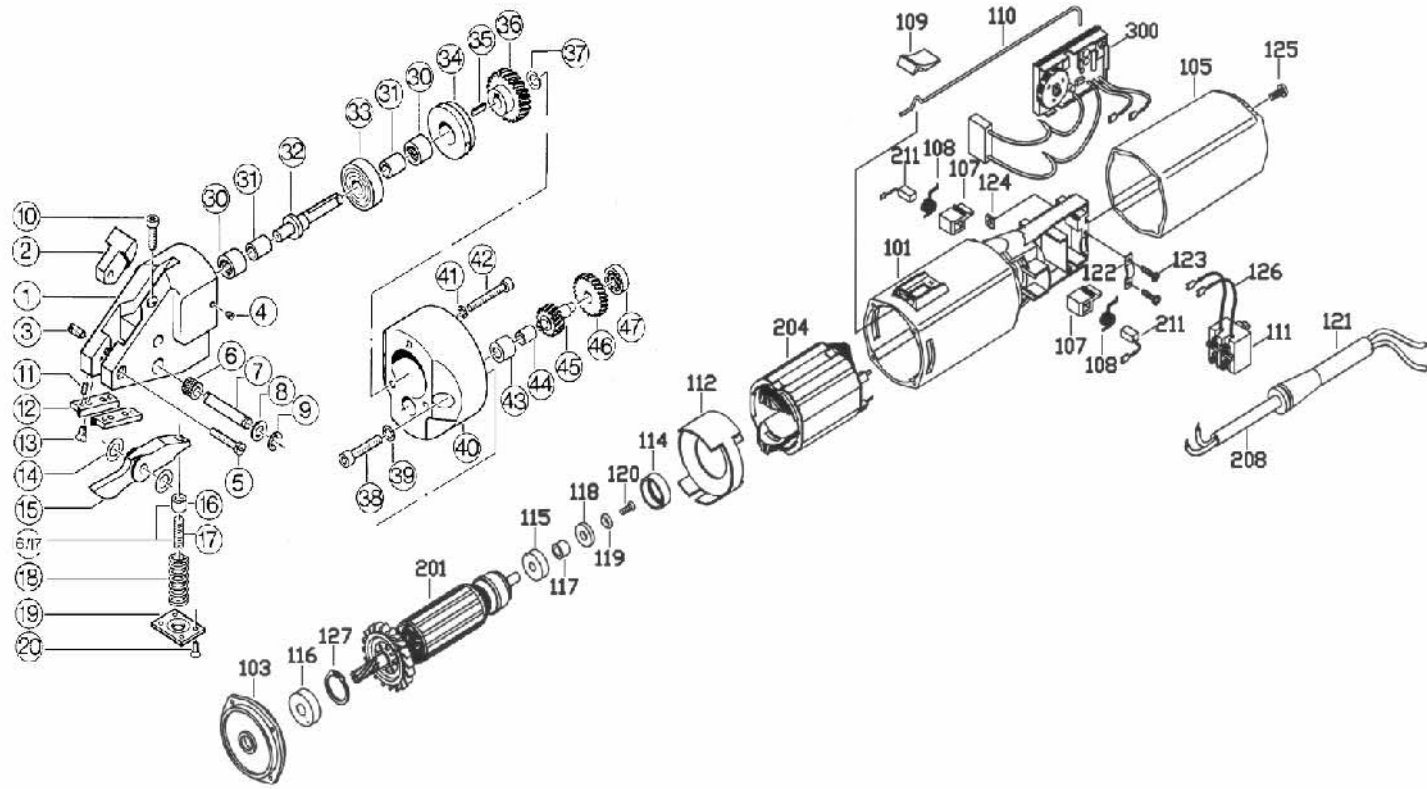
F For further notes on safety we refer to enclosed red safety instructions sheet

DRÄCO metal shears		SD7-1	
max. cutting capacity		Art.no.	61047
steel	400 N/mm ²	mm	2,0 / 14
stainless steel	600 N/mm ²	mm	1,5 / 16
stainless steel	800 N/mm ²	mm	1,3 / 18
aluminium	250 N/mm ²	mm	3,0 / 10
tightest radius		mm	50
working speed ±		m/min	5
strokes		min ⁻¹	2200
motor capacity		Watt	500
weight		kg	1,8
min. start hole diameter		Ø mm	14

SD7-1 spare parts	
knife	371401S7
set of jaws	BG37222
knife-pin set	BG35149
optional accessories	
metal-box	18000

Spare parts for DRÄCO Metal-Shear SD7-1

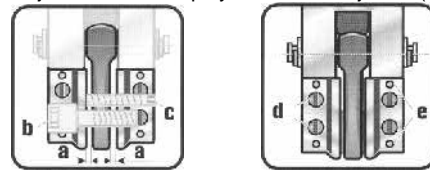
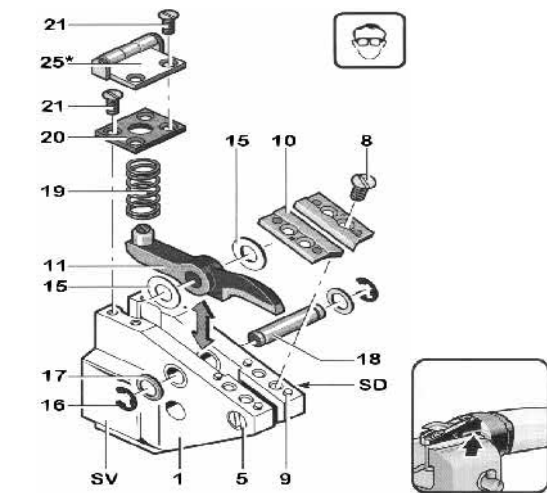
Spare parts for DRÄCO Metal-Shear SD7-1



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 in on one side and push knife pin (18) into housing up to the middle of the knife.
- Feed the shims on the other side 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 0,1 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.



- 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.

Position numbers used are valid
← for exploded view (knife mounting) only.

Pos.	Description	Pcs.	Order No.	Pos.	Description	Pcs.	Order No.	
1-43	Shear Head SD7-1	1	20236S7	42	Flat Fillister Head Screw	3	81262	
31-37	Drive Shaft cpl.	1	BG20202	43	Needle Bearing	1	13043	
44-47	Pinion with Gear cpl.	1	BG20203	44	Sleeve	1	13042	
103-208	Motor 500 W	230 V	16093	45	Pinion	1	13041	
103-208	Motor 500 W	115 V	16040	46	Gear	1	20231	
1,4,6,10,30	Head Casting, Serie F	1	BG20241	47	Ball Bearing	1	13039	
2,3,5	Spacing Block Serie F	1	BG37059	103	Gear Casing	1	16094	
3	Tap Screw	1	81120	116	Ball Bearing	1	10038	
4	Tap Screw with ISK	2	81239	127	Circlip	1	16014	
5	Screw	1	81176	201	Armature	230 V	16095	
6	Knife Pin Bushing	2	35542	201	Armature	120 V	16096	
6	Knife Pin Bushing	2	35542/11	115	Ball Bearing	1	10040	
7,8,9,14	Knife Pin Bushing	1	BG35149	117	Bushing	1	16026	
8	Washer	2	81072	118	Ring Magnet	1	16025	
9	Circlip	2	81275	119	Washer	1	16024	
10	Hex Socket Screw	1	81263	120	Screw	1	16023	
11	Pin	4	81248	114	Insulating Ring	1	16029	
11-13	Set of Jaws SD7-1	1	BG37222	112	Ventilation Cover	1	16030	
13	Screw Torx	4	81440	204	Field	230 V	16097	
14	Spacing Shims	Set	BG12400	204	Field	120 V	16098	
15-17	Special Alloyed Steel Knife SD7-1	1	371401S7	101	Housing for Motor, red	1	16039	
16	Knife Lockring	1	12100	107	Carbon Brush Holder	2	16035	
17	Knife Adjusting Screw	1	12000	108	Pressure Spring	2	16034	
16-17	Knife Adjusting Screw	1	12222	211	Carbon Brush for Shears	230 V	2	16002
18-20	Spring Cover	set	BG12300	211	Carbon Brush for Shears	120 V	2	16091
18	Spring	1	12200	109	Switch Knob	1	16033	
19	Spring Cover	1	12300	110	Switch Connection Lever	1	16032	
20	Screw Torx	4	81439	300	Electronic	230 V	1	16004
30	Needle Bearing	2	10300	300	Electronic	120 V	1	16099
31	Sleeve	2	10005	105	Switch Cover	1	16036	
31-33,35,37	Eccentric Drive Shaft	1	BG10004	125	Screw	1	16018	
32	Eccentric Drive Shaft	1	10004	124	Nut	1	16019	
33	Ball Bearing	1	10250	122	Cord-Clamp	1	16021	
34	Cap for Needle Bearing	1	10450	123	Screw	2	16020	
35	Key	1	10006	126	Connection Wire green	2	16017	
36	Gear 36	1	13051	111	Switch	1	16031	
37	Circlip	1	10009	121	Rubber-Sleeve	1	16022	
38	Hex Socket Screw	2	81031	208	Cable with Plug Europe (VDE)	1	32046	
39	Spring Washer	2	81243	208	Cable with Plug CH (SEV)	1	20260	
38-43	Gear Case Cover	1	BG13046	208	Cable with Plug (Italy)	1	20250	
41	Securing Washer	3	81249					

Specifications are subject to change for improvement without prior notice.
When ordering spares, please mention order number and voltage.

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