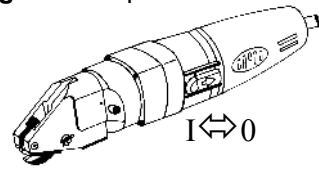


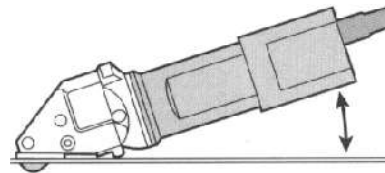
## Operating instructions

- 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 ( $\pm 8''$ ). 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. 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 Seam Metal Shear 3514-1 USA

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	3514-1
<b>max. thickness</b>		
steel	400 N/mm <sup>2</sup>	mm/ga <b>2,3 / 13</b>
stainl. steel	600N/mm <sup>2</sup>	mm/ga <b>2,0 / 14</b>
stainl. steel	800 N/mm <sup>2</sup>	mm/ga <b>1,5 / 16</b>
aluminium	250 N/mm <sup>2</sup>	mm/ga <b>3,0 / 10</b>
shortest curve radius	mm/inch	<b>45 / 1<sup>1/3</sup></b>
working speed max. ca.	m/min	<b>5</b>
strokes	min <sup>-1</sup>	<b>2400</b>
power consumption	Watt	<b>500</b>
weight	kg	<b>2</b>

## 3514-1 USA spareparts

knife	035141
set of jaws	BG35146
knifepin-set	BG35055

optional accessories	
metal box	18000

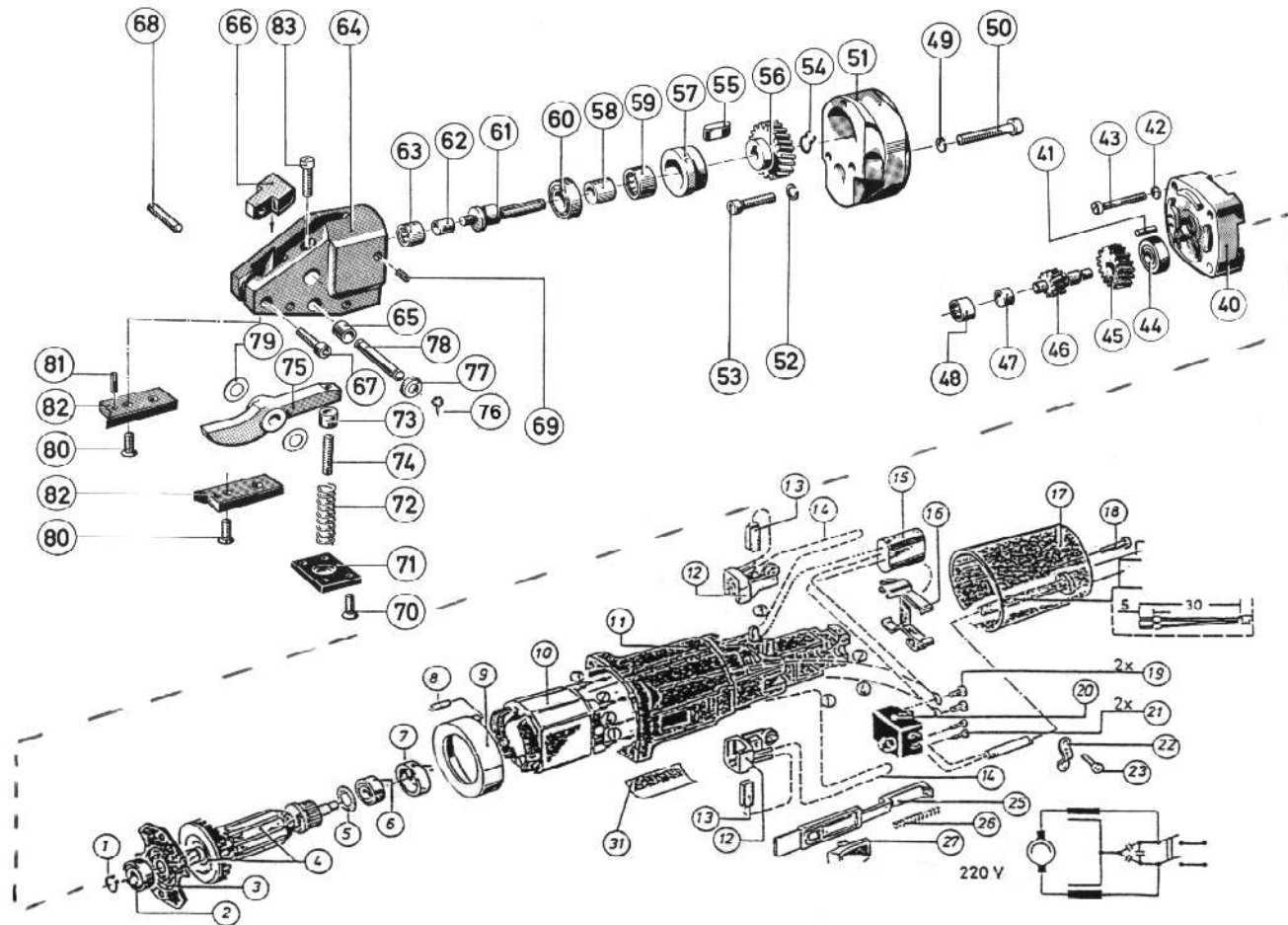
## Spare Parts List for DRÄCO Seam Metal Shear 3514-1 USA

Pos. no.	Order no.	Description	Qty./shear	Pos. no.	Order no.	Description	Qty./shear
1-43	31060	Motor 500 W 115 V	1	48	13043	Needle-bearing	1
1	31030	Ring	1	49	81249	Securing washer A4	3
2	31031	Ball bearing	1	50	81262	Screw	3
3	31032	Cover	1	48-53	BG13046	Gear case cover	1
4	31133	Armature 115 V	1	52	81243	Securing washer	2
5	31034	Ring	1	53	81031	Hex socket screw	2
6	10038	Ball bearing	1	54	10009	Circlip	1
7	31036	Pin bushing	1	55	10006	Key	1
8	31037	Pin	1	56	13051	Gear (36 teeth)	1
9	31038	Ring	1	57	10450	Cover for needle bearing	1
10	31139	Field 115 V	1	58,60-62	BG35556	Eccentric drive shaft cpl. ass.	1
11	31040	Motorhousing	1	58	10005	Sleeve	1
12	31041	Carbon brush holder	2	59	10300	Needlebearing	1
13	31042	Carbon brush	2	60	35285	Bearing	1
14	31044	Cable	2	61	35556	Eccentric shaft	1
15	31045	Condensator	1	62	10005	Sleeve	1
16	31046	Holder	1	63	10300	Needlebearing	1
17	31047	Motorhousing cover	1	63-68	BG37547	Head casting	1
18	31048	Screw	1	65	35542	Knife pin bushing ø 10 mm	2
19	31049	Screw	2	66-68	BG37059	Spacing block	1
20	31050	Switch	1	67	81176	Flat fillister head screw	1
21	31051	Screw	2	68	81120	Tap screw	1
22	31052	Cord-Clamp	1	69	81239	Tap screw	1
23	31053	Screw ST 3	2	70	81285	Flat head screw	4
25	31054	Switch connect. lever	1	70-72	BG12300	Spring cover plate	1
26	31055	Spring	1	72	12200	Spring	1
27	31056	Switch lever	1	73/74	12222	Knife lockring	1
28	31522	Rubber-sleeve	1	74	12000	Knife adjusting screw	1
29	20242	Cable with plug	1	73-75	035141	Knife 3514-2	1
31	31057	Sticker	1	76	35054	Split pin	2
40	31014	Gear case cover	1	77	81072	Washer	2
41	13036	Pin	1	76-78	35145	Knife pin ø 6x42mm	1
42	81249	Circlip	4	76-79	BG35055	Knife pin set ø 6x42mm	1
43	31010	Screw	4	79	BG12400	Spacing shims (var. thick.)	1
44	13039	Ball bearing	1	80	81286	Flat head screw	4
44-83	32236	Shearhead Cpl.	1	81	81248	Pin	4
45	13540	Gear (30 teeth)	1	80	35146	Set of jaws	1
44-47	31541	Drive shaft Cpl.	1	80-82	BG35146	Set of jaws cpl.	1
47	13042	Sleeve	1				

Please use order # to order.

[www.dracotools.com](http://www.dracotools.com)

Your dealer:



### 3514-1 USA

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.

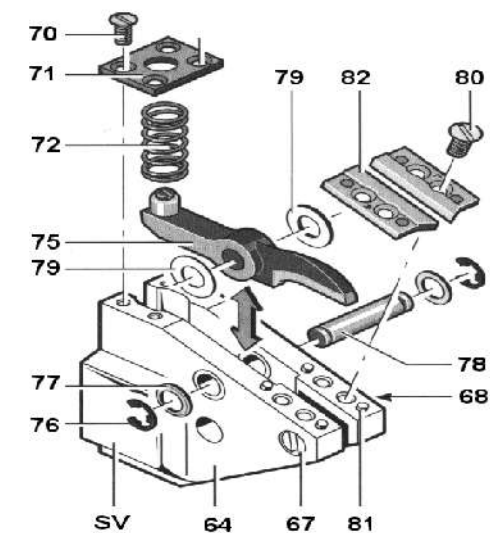
#### Adjusting the knife Clearance

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.