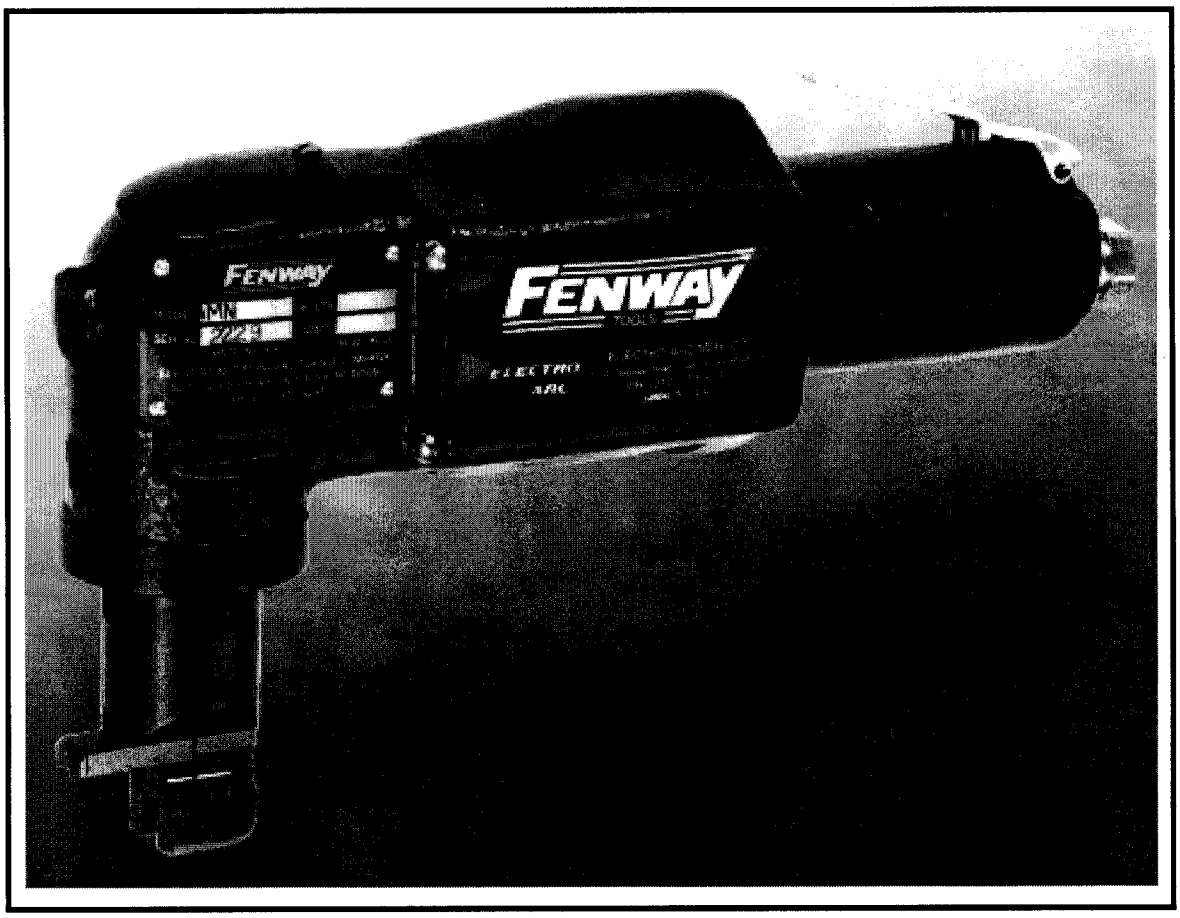
INSTRUCTION MANUAL

MODEL **AMN** NIBBLER

MEDIUM DUTY 14 Ga. MILD STEEL CAPACITY



KETT
FENWAY TOOLS

KETT TOOL COMPANY 5055 MADISON ROAD CINCINNATI, OHIO 45227-1494
513-271-0333
FAX 513-271-5318

MADE IN U.S.A.

KETT AMN NIBBLER

SPECIFICATIONS

MAXIMUM MATERIAL THICKNESS (CUTTING CAPACITY)
MILD STEEL 14 Ga. *(.075 in./2,1 mm)*
STAINLESS STEEL 16 Ga. *(.059 in./4,65 mm)*
NON-FERROUS 14 Ga. *(.075 in./ 2,1 mm)*

MAXIMUM CUTTING SPEED
60" INCHES PER MINUTE
(1.5 meters per minute.)

MINIMUM CUTTING RADIUS
1" inches *(25,4 mm.)*

STARTING HOLE SIZE
1-1/4 inches *(31,75 mm)* in diameter

LENGTH
10" *(250 mm)* Long

WIDTH
3" *(76 mm)* wide

HEIGHT
6 1/2" *(165 mm)*

WEIGHT
7 lbs. *(3.17 Kg)*

MOTOR
1 HP Pneumatic motor

SIZE OF CUT
1/4" *(6,35 mm)* x 1-1/16" *(1,59 mm)*

OPERATING INSTRUCTIONS

The AMN Nibbler is designed to operate on 90 lbs. air pressure. It will operate satisfactorily on a 3/8" hose, 10' long. If a longer hose is necessary, the remaining portion should be 1/2" or larger.

It is **very important** that a line oiler be used for motor lubrication. The oiler should be filled with a good grade of No. 10W Machine oil. The gear train should be disassembled periodically and regreased with moly-grease. See the following pages for disassembly instructions.

IMPORTANT OPERATING HINTS

1. **CAUTION: Always disconnect air supply before attempting adjustment or maintenance.**
2. Adjust stripper to 1/64 inch above metal thickness being cut.
3. Tighten all screws and check punch and die clearance at least once daily.
4. Keep punch and die sharp and a spare in stock.
5. Turn nibbler on before engaging material.
6. When possible, spread a thin film of oil on surfaces being cut as this will greatly extend punch and die life.
7. Stop machine immediately if it should jam. Never force tool. Disconnect air, thenback out punch by inserting screwdriver in operating slot at front of gear box, and turning.
8. Let nibbler do the work. Guiding tool is all that is necessary. Forcing will only cause it to operate improperly.
9. Only cut the gauge metal that is recommended or servicing and expensive part damage will occur.
10. Observe lubrication instructions.
11. M ake frequent checks on the punch and die, replacing if worn.

SERVICE • SAFETY FOR PORTABLE PNEUMATIC TOOLS

REPLACEMENT PARTS

When servicing, use only original KETT replacement parts.

PNEUMATIC MOTOR SERVICE

All repairs and maintenance of the pneumatic motor must be performed by an authorized service center.

FOR SAFETY AND EFFICIENCY:

1. Disconnect air supply before attempting adjustment or maintenance.
2. ***KEEP WORK AREA CLEAN***
   Cluttered areas and benches invite accidents.
3. ***WHAT YOU CAN'T SEE CAN HURT YOU***
   Keep work area well lit.
4. ***KEEP CHILDREN AWAY***
   All visitors should be kept a safe distance from work area.
5. ***STORE IDLE TOOLS WHEN NOT IN USE***
   Tools should be stored in a dry, high, or locked-up place out of the reach of children.
6. ***DON'T FORCE TOOL***
   It will do the job better and safer at the rate for which it was designed.
7. ***USE RIGHT TOOL***
   Don't force small tool or attachment to do the job of heavy-duty tool.
8. ***WEAR PROPER APPAREL***
   Loose clothing or jewelry may get caught in moving parts.
9. ***USE SAFETY GLASSES***
   Use safety glasses with all tools. Also face or dust mask if cutting operation is dusty.
10. ***DON'T ABUSE AIR SUPPLY HOSE***
    Never carry tool by hose or yank it to disconnect. Keep hose from heat, oil, and sharp edges.
11. ***SECURE WORK***
    Use clamps or vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
12. ***DON'T OVERREACH***
    Keep proper footing and balance at all times.
13. ***MAINTAIN TOOLS WITH CARE***
    Keep tools sharp and clean for best and safest performance. Follow operating instructions for adjustments, lubricating and changing accessories.
14. ***REMOVE ADJUSTING KEYS AND WRENCHES***
    Form habit of checking to see that keys and adjusting wrenches are removed from tool before connecting to air supply or turning it on.
14. ***AVOID ACCIDENTAL STARTING***
    Don't carry connected tool around with thumb on throttle lever.

PARTS LIST

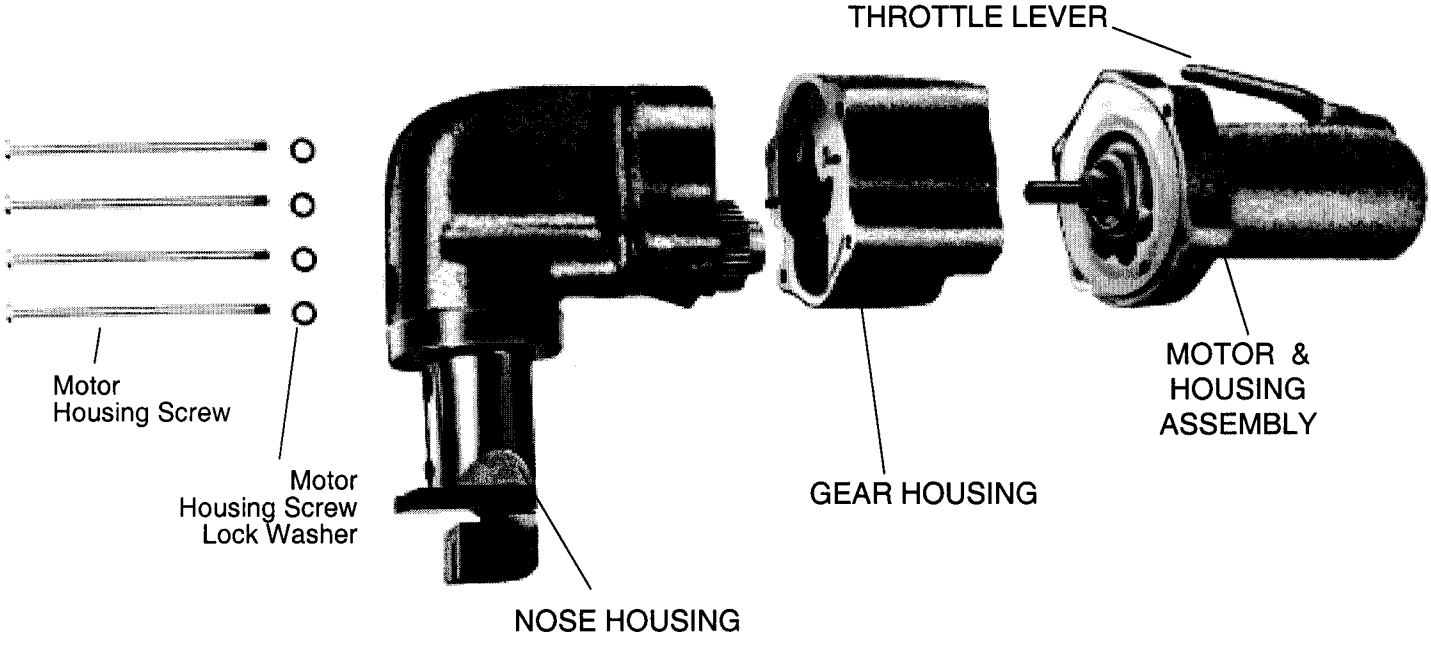
PARTS LIST

REFER TO DIAGRAMS BELOW AND ON NEXT PAGE

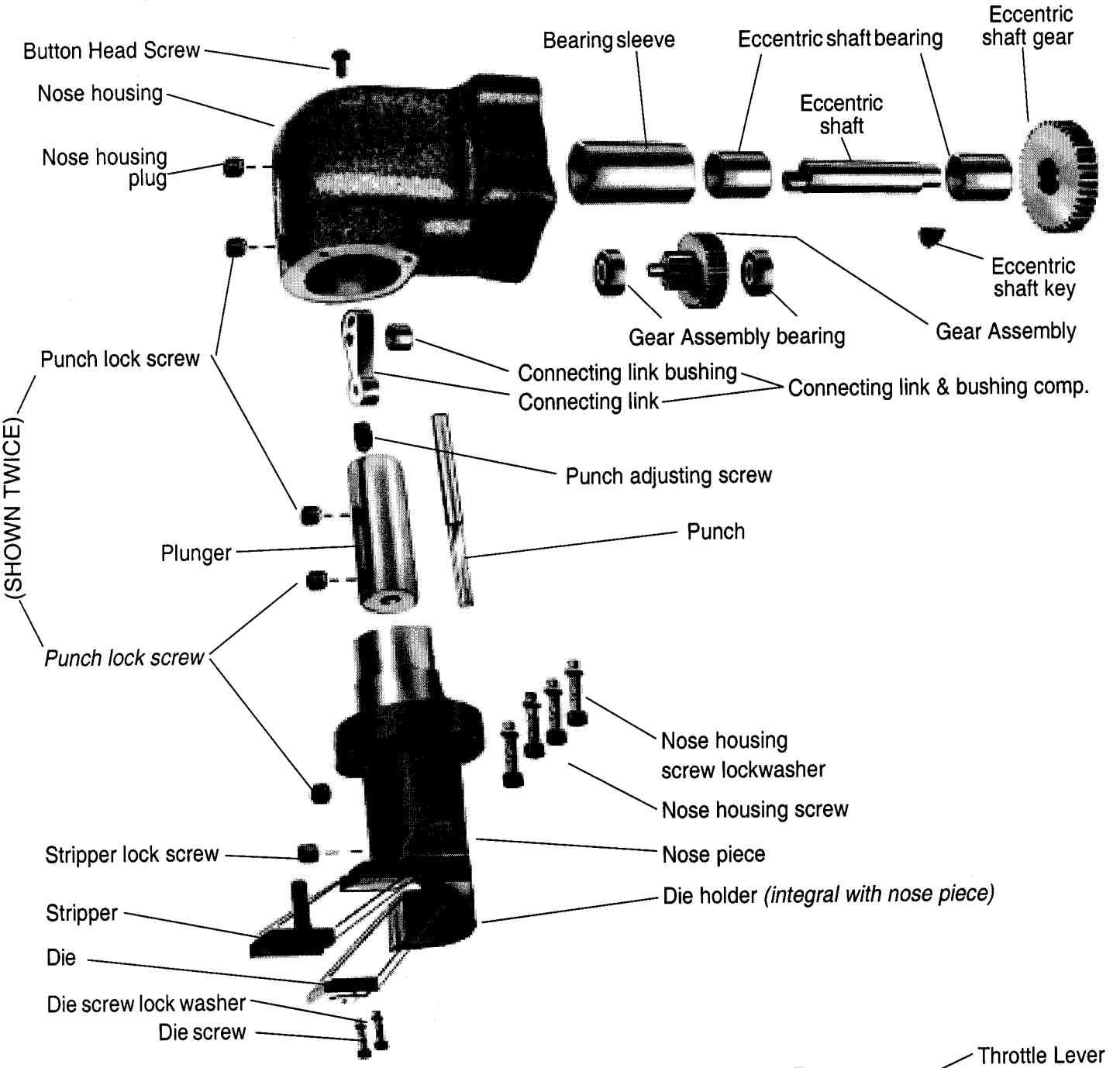
PART No.	NAME OF PART	QUAN.	PART No.	NAME OF PART	QUAN.
N2055	Nose housing screw	4	N2028	Die	1
N2068	Nose housing lockwasher	4	N2030	Stripper	1
N2031	Stripper lock screw	1	N2060	Eccentric shaft (Woodruff) key	1
N2054	Gear assembly bearing	2	N2058	Die screw	2
N2027	Punch adjusting screw	1	N2045	Die screw lock washer	2
N2027	Punch lock screw	2	N2039	Connecting link	1
N2033	Punch	1	N2046	Connecting link bushing (bronze)	1
N2037	Nose housing	1	AN2039	Connecting link & bushing comp.	1
N2063	Nose piece/Die holder	1	N2059	Nose housing plug	1
N2038	Eccentric shaft	1	N2057	Body Screw	4
N2041	Eccentric shaft gear (large)	1	N2050	Body Screw Lock Washer	4
AN2053	Gear Assembly (small gears)	1			
N2036	Plunger	1	N2042	Gear Housing	1
N2040	Eccentric shaft (needle) bearing	2	AN2064	Motor & Housing Ass'y	1
N2047	Bearing sleeve	1	N2066	Button head screw	1

NOTE: The punch adjusting screw and the punch lock screw are identical, sharing part no.N2027. The stripper set screw (Part No. N2031) looks similar, but has a special coating.

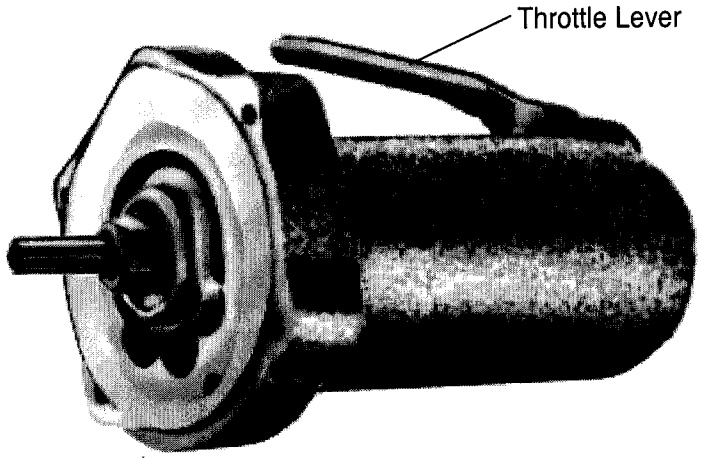
MODEL AMN PNEUMATIC NIBBLER – MAJOR COMPONENTS



NOSE HOUSING SUBASSEMBLY

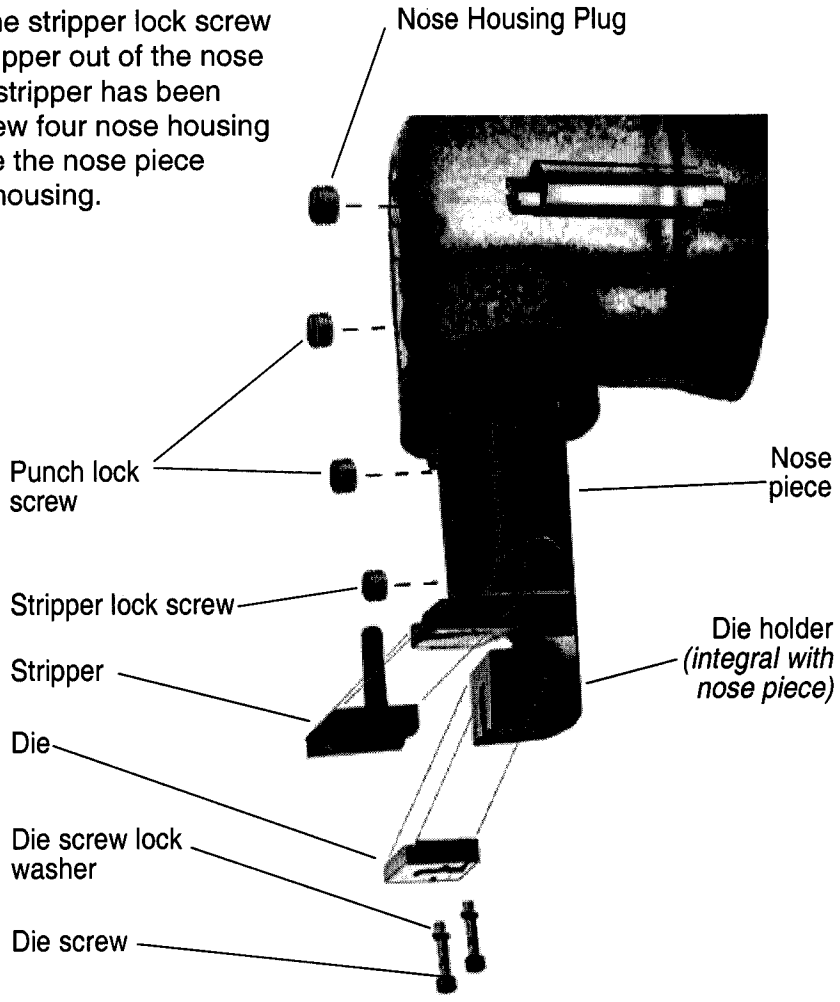


MOTOR & HOUSING SUBASSEMBLY

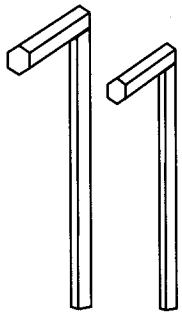


Nose Piece/Die Holder Subassembly

To disassemble the nose housing, unscrew two die screws and remove the die. After the die has been removed, unscrew two die holder screws and tap lightly on the die holder to separate it from the nose piece. Loosen the stripper lock screw and slide the stripper out of the nose piece. After the stripper has been removed, unscrew four nose housing screws and slide the nose piece out of the nose housing.



MAINTENANCE KIT



Hex key set for Model AMN

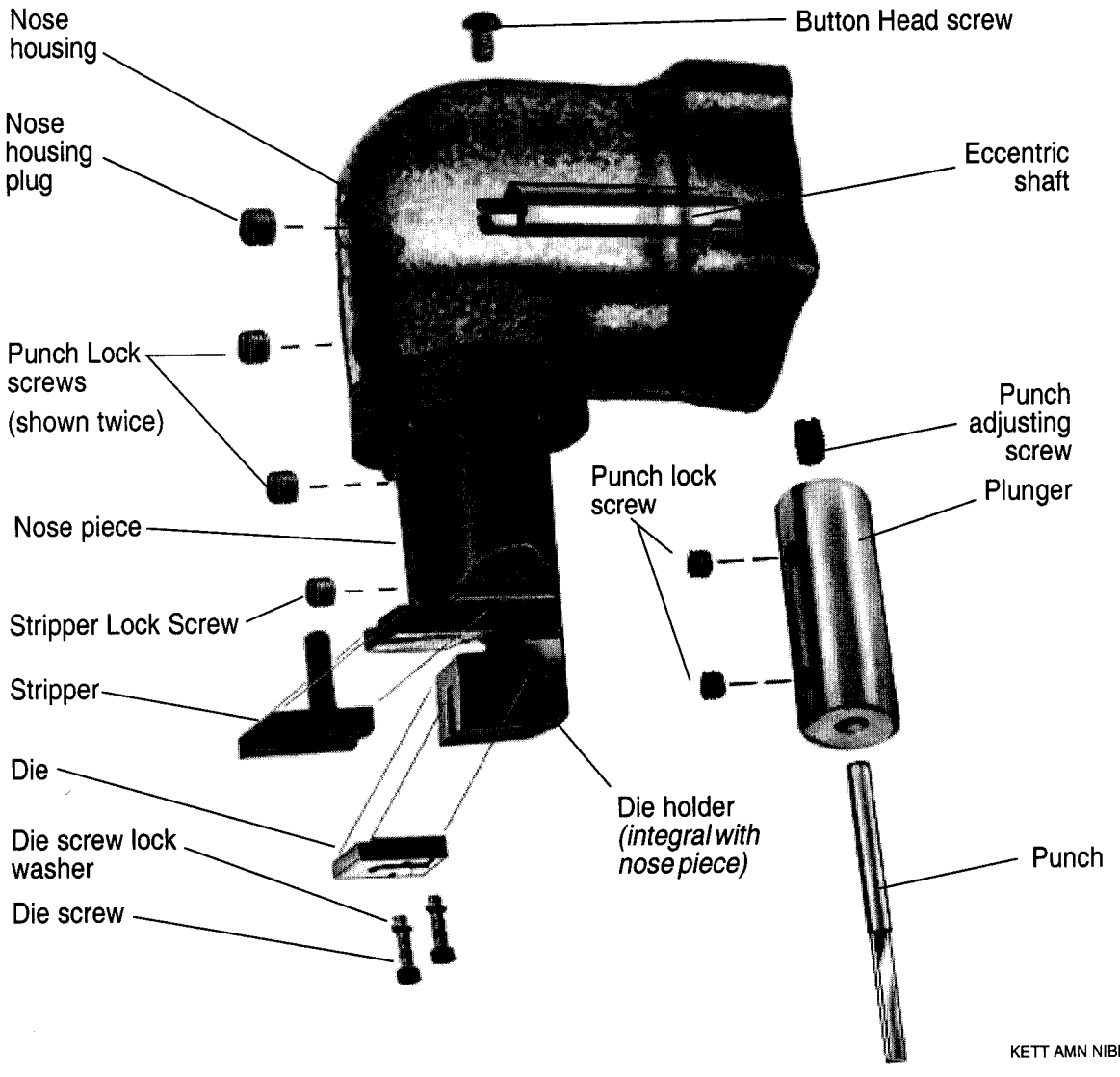
Part Nos. N0101 and N0102

Kett Lubricant 16 oz. Tube
Part No. N0109

Punch and Die Replacement

To remove the punch and die for sharpening, remove the nose housing plug and insert a screwdriver in the slot in the end of the eccentric shaft. Rotate the shaft until the punch is in the "up" position. Unscrew the two die holder screws and tap the die holder free of the nose piece. The die is attached to the die holder with two die screws. Remove these two screws and the die will come free of the die holder. Loosen the stripper lock screw and slide the stripper out of the nose piece. After the stripper has been removed, insert the screwdriver again in the slot in the end of the eccentric shaft and turn the shaft until the punch is in the full "down" position. With the punch in this position, loosen the two punch lock screws. The punch may then be pulled out of the plunger. In grinding the punch, grind only the square end of the punch and be sure that it is ground square with the body of the punch. The die should be surface ground for re-sharpening.

Reassembly is in the reverse order of disassembly. After the tool has been reassembled, remove the closing cap screws and the closing cap. This will allow access to the plunger adjusting screw. Turn the eccentric shaft until the plunger is in the extreme "down" position and slightly loosen the punch lock screws. Insert an Allen wrench into the punch adjusting screw and screw the punch adjusting screw down until the punch enters the die by 1/16". After this adjustment has been made, securely tighten the punch lock screws.



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