

MODEL MHN2 NIBBLER

MAXIMUM DUTY 1/4" CAPACITY



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SPECIFICATIONS

MAXIMUM MATERIAL THICKNESS (CUTTING CAPACITY)

MILD STEEL 1/4 inches (.25 in. / 6.35 mm)
 STAINLESS STEEL 3/16 inches (.1875 in. / 4.7625 mm)
 NON-FERROUS 3/8 inches (.375 in. / 9.525 mm)

MAXIMUM CUTTING SPEED

60 INCHES PER MINUTE (1.5 meters per minute)

MINIMUM CUTTING RADIUS*

10 inches (254 mm)
 (*Primarily designed for straight cutting)

PHYSICAL SIZE

13-1/4 inches (336 mm) Long, 5-1/4 inches (133 mm) wide

HEIGHT

10-1/2 inches (267 mm)

WEIGHT

24 lbs. (10.9 kgs.)

MOTOR

2 H.P. (1800 watts) 120 volts 15 amp

STARTING HOLE SIZE

2-1/2 inches (63.5 mm) in diameter

SIZE OF CUT WIDTH

1/4 inches (6.35 mm)

IMPORTANT OPERATING HINTS

1. Always disconnect power cord before attempting adjustment or maintenance.
2. Minimize air gap between stripper foot and material with the appropriate shim provided.
3. Tighten all screws and check punch and die clearance at least once daily.
4. Keep punch and die sharp and a spare 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 increase the life of the punch and die.
7. Stop machine immediately, if it should jam. Never force tool. Back out punch by inserting screw driver in operating slot at rear of motor and turning motor shaft counter clockwise.
8. Let nibbler do the work as guiding tool is all that is necessary and 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. Always make frequent checks on motor brushes, replacing if worn.

FOR PORTABLE ELECTRIC TOOLS

REPLACEMENT PARTS

When servicing, use only original KETT replacement parts.

GENERAL SAFETY RULES FOR ALL TOOLS GROUNDED AND DOUBLE INSULATED

1. **KEEP WORK AREA CLEAN**
Cluttered areas and benches invite accidents.
2. **AVOID DANGEROUS ENVIRONMENT**
Keep work area well lit.
3. **KEEP CHILDREN AWAY**
All visitors should be kept a safe distance from work area.
4. **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.
5. **DON'T FORCE TOOL**
It will do the job better and safer at the rate for which it was designed.
6. **USE RIGHT TOOL**
Don't force small tool or attachment to do the job of heavy-duty tool.
7. **WEAR PROPER APPAREL**
No loose clothing or jewelry to get caught in moving parts.
8. **USE SAFETY GLASSES**
Use safety glasses with all tools. Also face or dust mask if cutting operation is dusty.
9. **DON'T ABUSE CORD**
Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil, and sharp edges.
10. **SECURE WORK**
Use clamps or vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
11. **DON'T OVERREACH**
Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE**
Keep tools sharp and clean for best and safest performance. Follow operating instructions for adjustments, lubricating and changing accessories.
13. **DISCONNECT TOOLS**
When not in use and before servicing or when changing accessories such as punch, die, brushes, etc.
14. **REMOVE ADJUSTING KEYS AND WRENCHES**
Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
15. **AVOID ACCIDENTAL STARTING**
Don't carry plugged in tool with finger on switch. Be sure switch is off when plugging in.
16. **OUTDOOR USE EXTENSION CORDS**
When tool is used outdoors, use only extension cords marked "suitable for use with outdoor appliances."
Store indoors when not in use.

SERVICING INSTRUCTIONS:

All repairs and maintenance of the electrical components, armature, field, switches and cords of either double insulated or grounded tools must be performed by KETT TOOL COMPANY.

M H N 2 P A R T S L I S T

PARTS LIST			
Item #	Part #	Qty	Description
1	N5565	1	"T" Handle
2	N5520	4	Screw
3	N5537	1	Nose Housing
4	N5521	4	Screw
5	N5522	4	Lock Washer
6	N5523	4	Screw
7	N5530	2	Stripper Shim .060
	N5531	1	Stripper Shim .120
8	N5656	1	Nose Piece / Die Holder
9	N2050	2	Lock Washer
10	N5625	1	Die, Carbide
11	N5628	1	Punch HSS
12	N5629	1	Stripper
13	N5532	2	Screw, Stripper
14	N5636	1	Plunger
15	N5534	1	Dowel
16	N5535	1	Yoke
17	N5533	1	Bearing
18	N5538	1	Eccentric
19	N5539	2	Bearing
20	N5540	1	Screw
21	N5541	1	Gear #5
22	N3060	2	Key, Woodruff
23	N5542	1	Gear #3
24	N5543	2	Pin, Rolling
25	N5544	3	Bearing
26	N5545	1	Gear #4
27	N5546	1	Gear #2
28	N5547	1	Gear #1
	AN5553		Assy. incl. N5546 and N5547
29	N5549	1	Bearing
30	N3011	1	Screw, Ground, Slotted Hex Head
31	N3006	1	Ground Wire Assembly
32	N3007	1	Gropund Wire Retainer
33	N3008	2	Screw, Switch Mounting
34	N3009	1	Switch
35	N3011	1	Screw, Ground, Slotted Hex Head
36	N3012	2	Cord Clamp Screw
37	N3013	1	Cord Clamp
38	N6014	1	Cord Guard
39	N3002	1	Handle
40	N3003	1	Handle Cover
41	N3004	5	Screw, Handle Cover
42	N3017	2	Screw, Handle Locking
43	N3016	2	Self Locking Nut for Handle
44	N3015	1	Cord Assembly
45	N5001	1	Motor Housing*
	AN5001		Complete Motor Housing Assy.**
46	N5550	1	Dolly Assembly
47	N5551	2	Lock Washer
48	N5552	2	Screw, Dolly Support
49	N5553	1	Gear Housing
50	N5048	1	Bearing, Front Armature
51	N5068	1	Fan
52	N5047	2	Screw, Field
53	N5050	2	Lock Washer #10
54	N5619	1	Motor Field, 110 v
55	N5621	1	Armature, 110 v
56	N5032	2	Brush Holder Cap
57	N5026	2	Brush Holder
58	N5071	2	Spring, Garter (Field)
59	N5623	1	Bearing, Rear Armature
60	N5044	2	Carbon Brush Set
61	N5649	1	Load Spring
62	N5650	1	Spacer

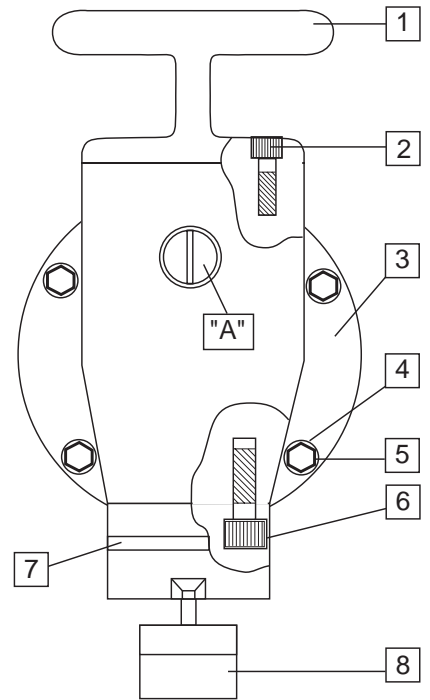


Figure 1

Accessories			
1/4" N0106	3/16" N0105	5/32" N0102	3/32" N0101
* Includes: N5026			
** Includes: N5001-1, N3002, N3003, N3004, N3016, N3017, N3012, N3013, N5032			

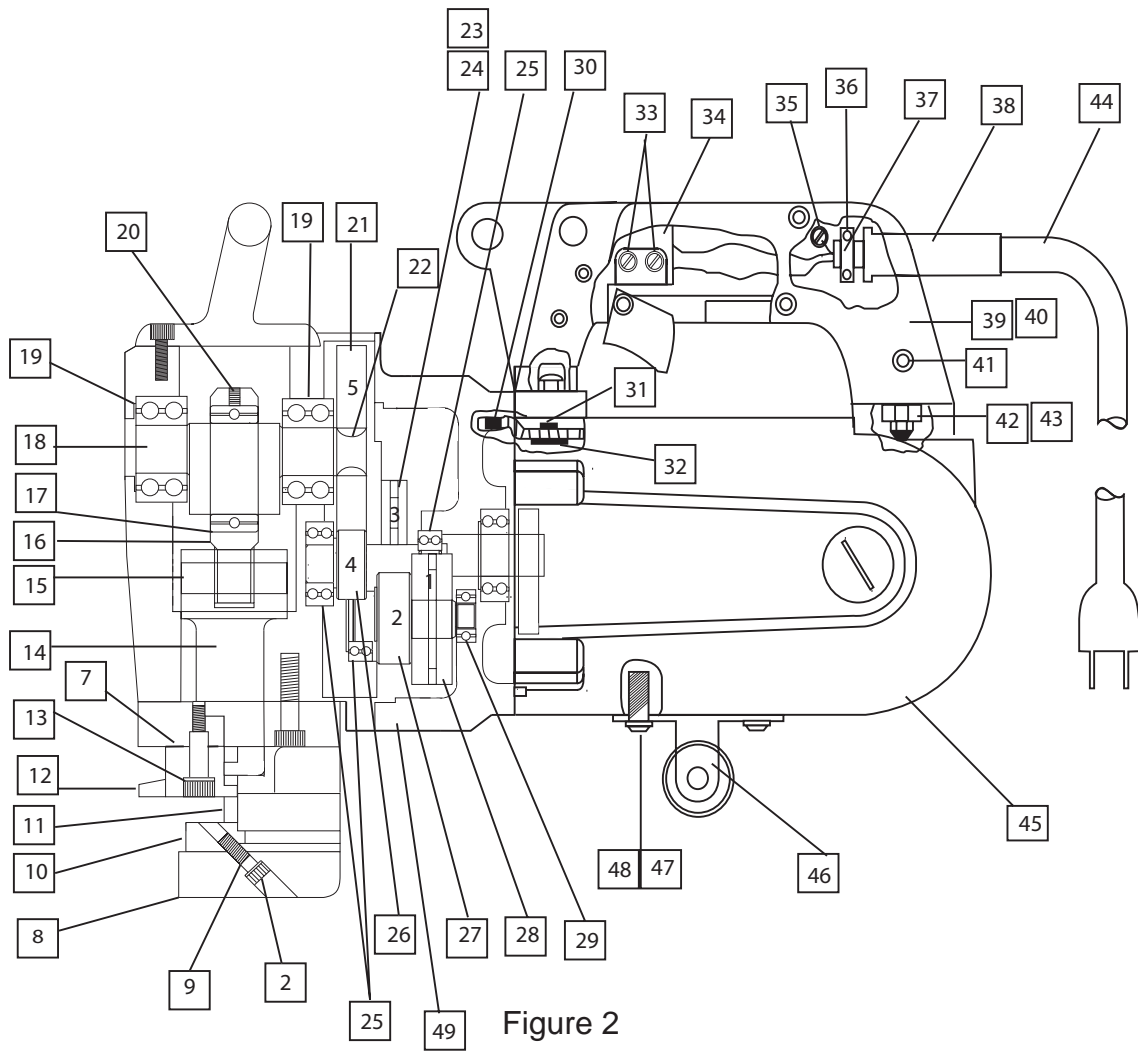


Figure 2

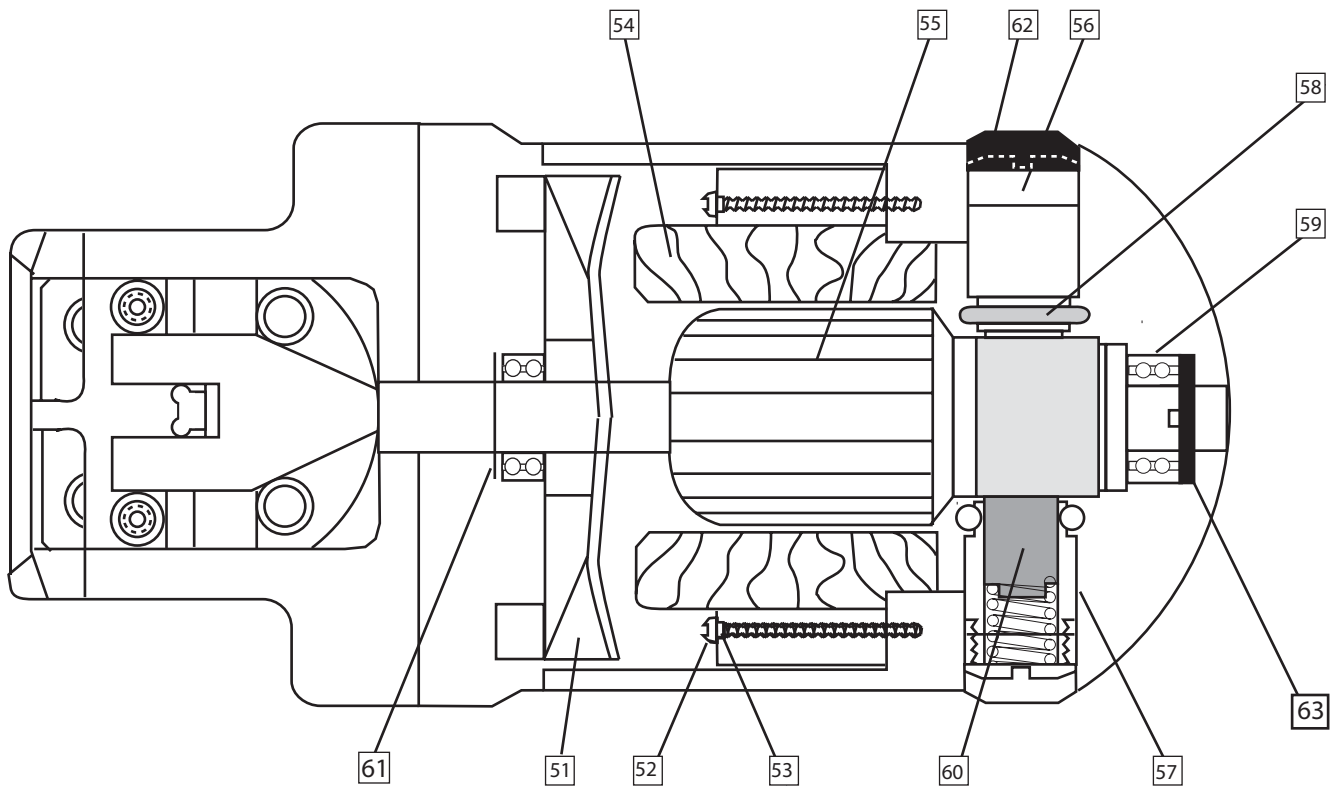
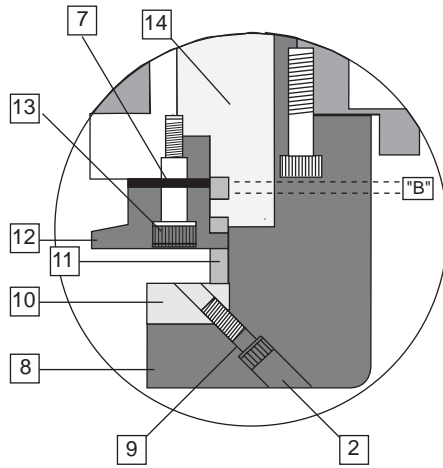


Figure 3



Reassemble stripper per illustration using required number of #7 shims for stock thickness being cut. (See table A)

TABLE A	
Stock Thickness	Shims required
3/8"	0
5/16"	1 (.060)
1/4"	1 (.120)
3/16"	2 (.120+.060)
1/8"	3([1] .120 + [2] .060)

PUNCH AND DIE DISSASSEMBLY

The punch and die in the Model MHN2 Nibbler are factory set for cutting 1/4" mild steel. Although not adjustable, the punch and die can be resharpened. **CAUTION:** When resharpening punch, care must be taken, so that the punch does not get hot when grinding the cutting edge. If the steel gets too hot, annealing may occur thereby reducing the effective life of the punch. The same care should be taken when resharpening the die.

To remove the punch, turn the eccentric shaft (18) by inserting a screwdriver in slot "A" at the front of the nibbler. (See Fig.1). Turn clockwise until plunger (14) is at the bottom of stroke. Slot "A" should be in a vertical position. Remove the two die screws (2) and lock washers (9). Remove die (10). Remove the two stripper screws (13). Remove stripper (12). Remove punch (11) from "T" slot in plunger (14). If necessary, drive the punch out of "T" slot by inserting a 1/8" diameter drive pin punch in hole "B" at the rear of nose piece die holder (8).

PUNCH AND DIE ASSEMBLY

To replace punch, insert punch (11) in "T" slot of plunger (14). Punch should fit snugly into "T" slot. Tapping punch firmly into "T" slot may be done with a piece of brass. Punch should fit flat. Replace stripper and any shims. Replace die.

CAUTION

Before reconnecting power cord, turn eccentric shaft using slot "A" one full revolution to insure proper punch and die alignment.

LUBRICATION/MAINTENANCE

Whenever possible, applying a thin film of cutting oil in the area of the steel to be cut will improve the cutting action and prolong the life of the punch and die.

After 100 hours of operation or every six months, the old grease in the nose housing and gear housing should be removed and relubricated with new lubricant. The motor brushes should be checked and replaced if worn. This can be performed by the customer or the tools can be sent to the factory as part of a routine maintenance program.