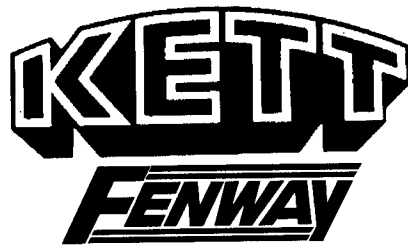


**I  
N  
S  
T  
R  
U  
C  
T  
I  
O  
N  
M  
A  
N  
U  
A  
L**

**MODEL  
AEHN  
NIBBLER  
HEAVY DUTY 3/16" Capacity**



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

**MADE IN U.S.A.**

A  
E  
H  
N

N  
-  
B  
B  
L  
E  
R

## SPECIFICATIONS

### MAXIMUM MATERIAL THICKNESS (CUTTING CAPACITY)

MILD STEEL 3/16" (.1875 in. / 4,762 mm)  
STAINLESS STEEL 10 Ga. (.1345 in. / 1,342 mm)  
NON-FERROUS 1/4" (.25 in. / 6,350 mm)

### MAXIMUM CUTTING SPEED

40-45" INCHES PER MINUTE (0.9 meters per minute)

### MINIMUM CUTTING RADIUS

8" inches (205 mm)

### PHYSICAL SIZE

12-3/4" (320 mm) long, 5" (127 mm) wide

### HEIGHT

12 inches (305 mm)

### WEIGHT

21 lbs. (9.5 kg)

### MOTOR

100 psi (30 CFM)

### STARTING HOLE SIZE

2-1/2" (64 mm) diameter

### SIZE OF CUT

3/16" (4,77 mm) wide

## 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. See Table 1.
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. Start nibbler 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. Always stop machine immediately if it should jam. Always disconnect air supply before attempting adjustment or maintenance. Never force tool. Back out punch by inserting screwdriver in operating slot in front of gearbox housing and turning shaft counter clockwise.
8. Let nibbler do the work. Guiding tool is all that is necessary. Forcing will only cause it to operate improperly.
9. Cut only sheet metal within gauges recommended. Exceeding specifications will result in damage to expensive parts, requiring service.
10. Keep nibbler in good condition. Follow lubrication instructions and frequently check air hose, replacing if worn.

## REPLACEMENT PARTS

When servicing, use only original KETT / FENWAY replacement parts.

## SERVICING INSTRUCTIONS

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

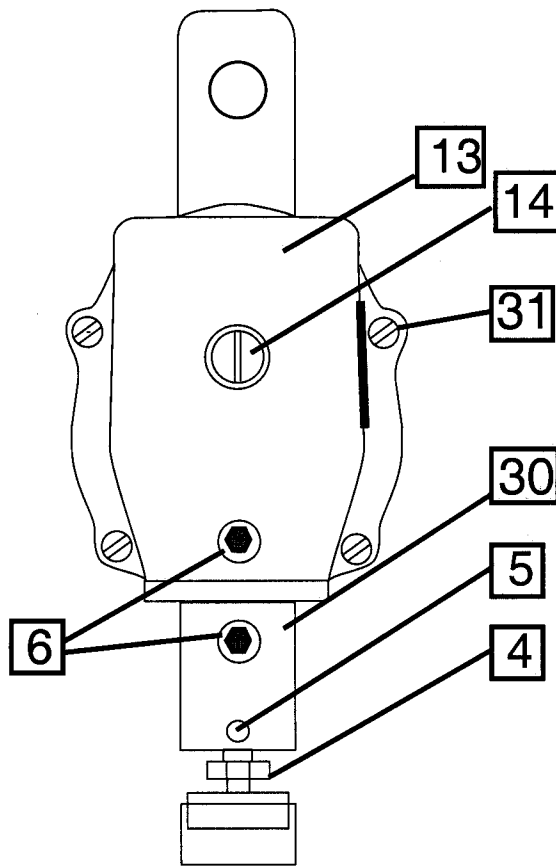
## WORK SMART -- WORK SAFE

1. **DISCONNECT TOOLS FROM AIR SUPPLY**  
when not in use; before servicing, when changing accessories such as punch, die, brushes, etc.
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 HOSES**  
Never carry tool by hose. Keep hose away 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 the 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, lubrication and changing accessories.
14. **REMOVE ALLEN WRENCHES AND TOOLS**  
Make a habit of checking to see that adjusting tools are removed from nibbler before turning it on.
15. **AVOID ACCIDENTAL STARTING**  
Don't carry tool with finger on trigger.

# AEHN NIBBLER PARTS LIST

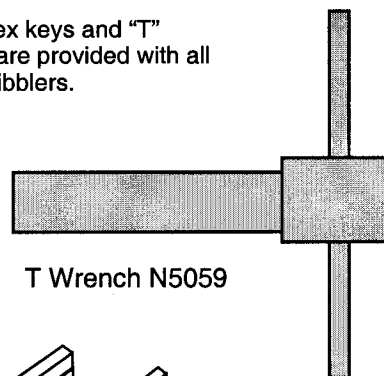
## MODEL AEHN PARTS LIST

Item No.	Part N <sup>o</sup>	Qty	Description
1	N5028	1	Die
3	N5028-1	1	Carbonized Die
4	N5030	1	Stripper
5	N3031	1	Stripper Screw
6	N5027	2	Punch Locking Screw
7	N5010	1	Slotted Adjustment Screw
8	N5009	1	Int. Locking Screw
9	N5033	1	Punch
10	N5033-1	1	Carbonized Punch
11	N5035	4	Stripper Shims
12	N5036	1	Plunger
13	N6037	1	Nose Housing
14	N5038	1	Eccentric Shaft
15	N5039	1	Slider
16	N5040	2	Eccentric Shaft Bearing
17	N6041	1	Large Gear
18	N6042	1	Gear Housing
19	N5018	2	Closing Cap Screw
21	N3043	2	Die Screw
22	N6020	1	Air Motor
23	N5045	2	Die Washer, Locking
24	N6001	1	Motor Housing
25	N3049	2	Dowel Pin
26	N5050	8	Lockwasher
27	AN6053	1	Small Gear Assembly
28	N5054	2	Bearing
29	N5055	4	Screw, socket head
31	N5057	4	Screw, round head
32	N5058	2	Die Screw
33	N5060	1	Woodruff Key
34	N3059	1	Button Plug
35	N6014	1	Throttle Valve Seal
36	N6015	1	Throttle Valve Spring
37	N6016	1	Throttle Valve Cap Seal
38	N6017	1	Throttle Valve Cap
39	N5062	1	Nose Piece/Die Holder
41	N6009	1	Trigger
42	N5065	1	Closing Cap
45	N6011	1	Trigger Shaft
46	N6012	1	Trigger Pin
47	N6020-5	1	Rotor Blades
48	N5059	1	T Wrench

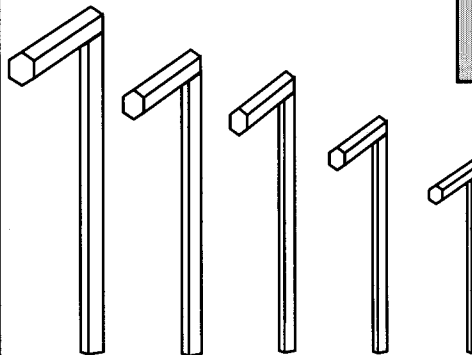


### MAINTENANCE KIT

These hex keys and "T" Wrench are provided with all AEHN Nibblers.



T Wrench N5059



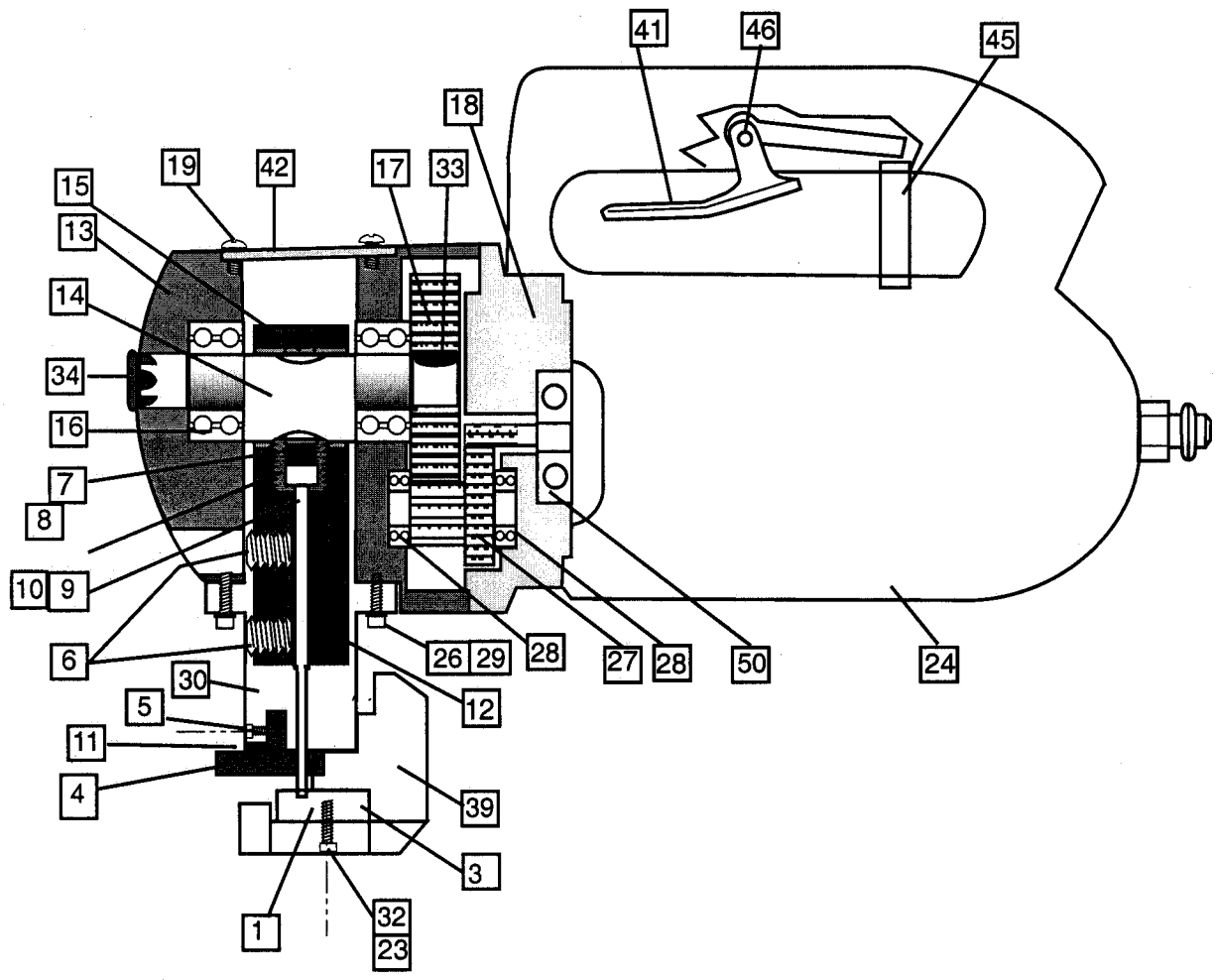
(3/16) (5/32) (7/32) (3/32) (1/16)  
(NO105) (NO105) (NO105) (NO105) (NO105)

### KETT / FENWAY LUBRICANT



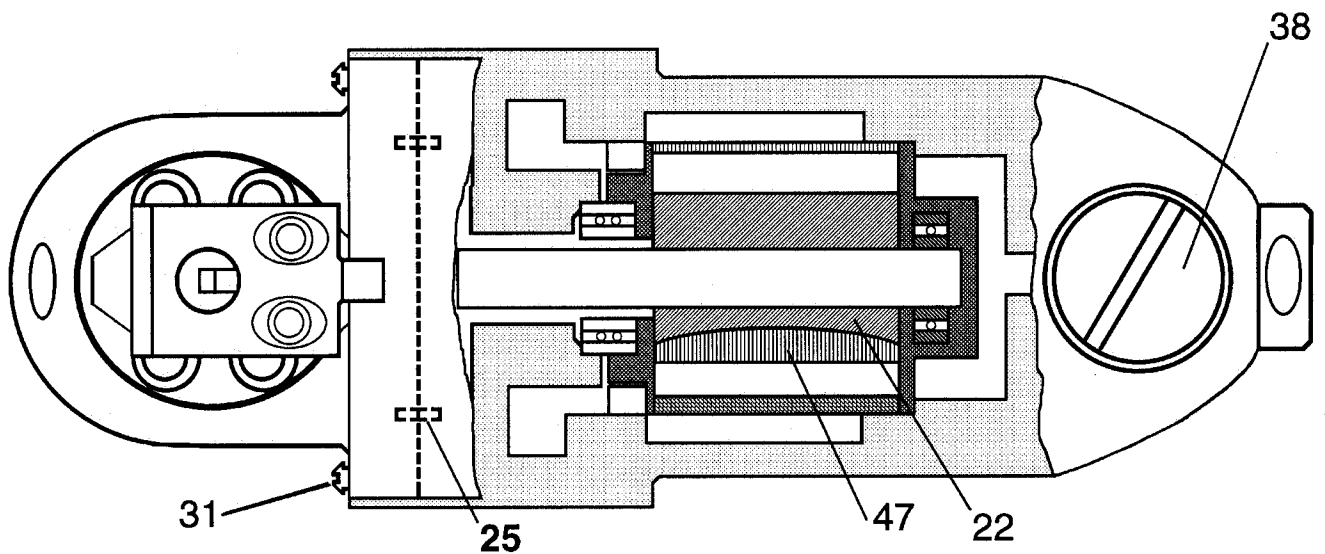
Part No. N0109

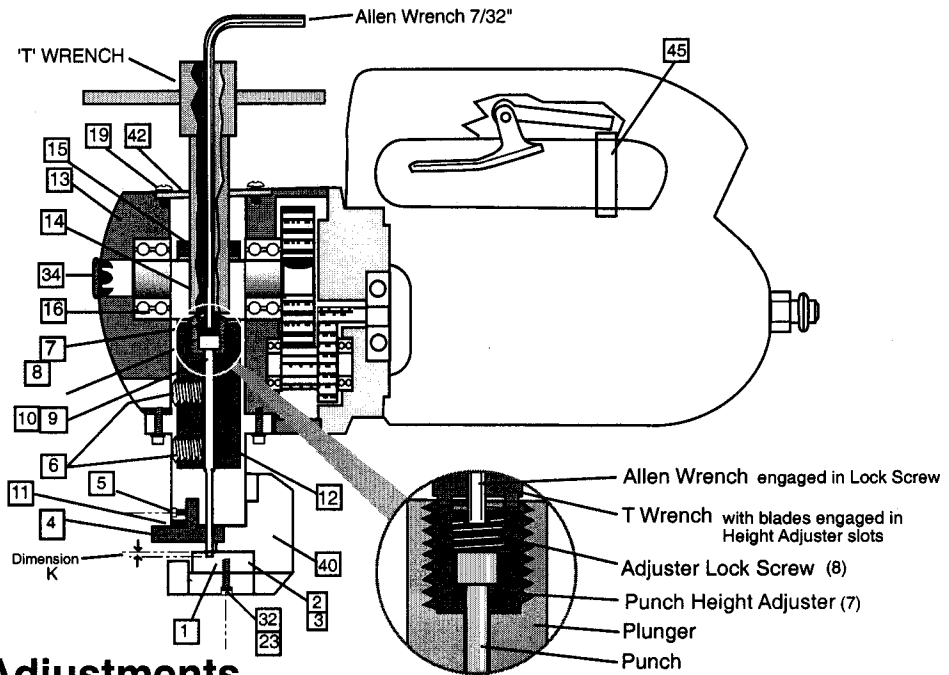
**Side view**



**Bottom view**

Not shown in this view:  
Items 35, 36, 37





## Basic Adjustments

**CAUTION: DISCONNECT FROM AIR SUPPLY BEFORE MAKING ANY ADJUSTMENTS OR REPAIRS. FAILURE TO DO SO CAN RESULT IN PERSONNEL INJURY OR TOOL DAMAGE.**  
**To adjust punch (9), the eccentric shaft (14) must be at lowest position, as shown, so that all holes will be aligned to provide access to adjusting screws (7) and (8).**

**Rotate the eccentric with a screwdriver. Access is at the front of the tool, marked "X" at right. Access is at the front of the tool under the button plug #34.**

**Adjust punch height so that at lowest position, shown at right, it will be 1/16" minimum below surface of die (9) (Clearance "K").**

**Adjust die clearance according to the material being cut. Follow the clearances recommended in column A in Table 1 below.**

**Step-by-step procedures below and on following page.**

## REMOVING PUNCH

1. Remove closing cap (42).
2. Insert screw driver in slot of armature shaft and rotate motor until hole in eccentric shaft (14) is lined up with hole in slider (15) as seen from top. Punch should be in full "down" position, clear of die in slot of eccentric shaft (14). **NOTE:** Slot in eccentric is in line with punch when punch is at full up or full down position.
3. Loosen two die holder screws (29) and lockwashers (26).
4. Loosen stripper set screw (5).
5. Remove Adjuster Lock Screw (8).
6. Loosen two set screws (6) and push punch upward and out of tool.

Thickness		"K"
Ga. No.	Thousandths"	Clearance
13	(.090)	.010
12	(.105)	.012
11	(.120)	.015
10	(.135)	.018
9	(.150)	.020
8	(.164)	.025

## REPLACING PUNCH

1. With the flat side facing front, insert punch downward into plunger until it touches adjusting screw (7).
2. Replace Adjuster Lock Screw (8).
3. Tighten set screws against flat of punch.
4. Using screwdriver, rotate the eccentric shaft until punch is in full "up" position.
5. Tighten die screws.
6. Tighten stripper set screw.
7. Replace dieholder, die assembly, and two die holder screws with lockwashers.
8. Using screwdriver, rotate eccentric shaft until punch is in the full "down" position.
9. Punch should enter die 1/16". Adjust punch height, if needed, (see below). After punch is properly adjusted, replace closing cap and button plug.

## ADJUSTING PUNCH

1. Remove closing cap (42) and button plug (34).
2. Using a screwdriver, rotate eccentric shaft until punch is in full "down" position. You should now be able to access the Punch Set Screws(6) from the front and the Punch Adjusting Screw (7) from the top.
3. Slightly loosen Punch Set Screws (6) and adjuster lock screw (8), holding punch firmly against the adjusting screw, turn adjusting screw enough so that punch enters die 1/16" at full "down" position.
4. Tighten set screws (6) and adjuster lock screw (8). Make sure screws are firmly against punch so adjustment cannot change.
5. **CAUTION:** Turn eccentric shaft several revolutions to make sure there is no binding.

## REMOVING DIE

1. Loosen stripper set screw (5), remove stripper shims and raise stripper (4) to widest opening.
2. Remove two die screws (32) and lockwashers (33).

## REPLACING DIE

1. Place die in die holder. Insert die screws and lockwashers.
2. Reset stripper as described below.

**CAUTION:** Turn eccentric shaft several revolutions to make sure there is no binding before connecting air supply.

## ADJUSTING STRIPPER

1. Loosen stripper screw (5) and adjust stripper clearance to approximately 1/64" above gauge of metal being cut.
2. Tighten stripper screw (5).

## LUBRICATION

After 30 hours of operation (or whenever either punch or die is removed):

Remove cap and add 6 - 8 drops of heavy gear oil (SAE 90 to SAE 140) into hole on top of plunger. With a screwdriver, turn eccentric shaft several revolutions to distribute oil. Repeat procedure three more times.

Drop 6 to 8 drops of the same lubricant into Punch Set Screw access hole. Replace cover, lay nibbler on its side and run it for several seconds to distribute the oil.

After 100 hours of operation or every 6 months:

Remove four nose housing bolts (see parts illustration), remove and separate nose housing and gear housing. Remove old grease and relubricate gears using the special Kett/Fenway Lubricant. Reassemble.

**CAUTION:** Rotate eccentric shaft with screwdriver to check for binding before connecting air supply.

**NOTE:** Further disassembly requires special tools and procedures, and may result in damage not covered by the warranty. Return tool to an authorized Kett / Fenway Service Facility if further disassembly is necessary.