

SAFETY RULES  
MODEL 2020  
NIBBLER ATTACHMENT



The 2020 fits all KETT Shear motors and is also interchangeable with other compatible shear heads.

*Read all instructions.  
Save these instructions.*

**For 2020:**

When servicing, use only identical replacement parts.

**SPECIFIC SAFETY RULES**

**Keep Work Area Clean**

Cluttered areas and benches invite accidents. Keep work area well lit.

**Avoid Dangerous Environment** Don't expose power tools to rain or snow. Don't use power tools in damp or wet locations. The symbol on the Caution Label is mean to convey this message. Ne pas exposer a la pluie et ne pas utiliser dans les emplacements humides.

**Keep Children Away**

Do not let visitors contact tool or extension cord. All visitors should be kept away from work area.

**Store Idle Tools**

When not in use, tools should be stored in dry, high or locked-up place out of reach of children.

**Don't Force Tool**

It will do the job better and safer at the rate for which it was designed.

**Use Right Tool**

Don't force a small tool to do the job of a heavy duty tool. Don't use tool for on purpose not intended, for example-don't use a circular saw for cutting tree limbs or logs.

**Dress Properly**

Do not wear loose clothing or jewelry. They can be caught in moving parts. Rubber gloves and footwear are recommended when working out doors. Wear protective hair covering to contain long hair.

**Use Safety Glasses**

Use safety equipment. Always wear eye proteccion.

**Don't Abuse Cord**

Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil, and sharp edges. Replace damaged cords immediately.

**Secure Work**

Use clamps or vise to hold work. It's safer than using your hand and it frees both hands to operate tool.

**Don't Overreach.**

Keep proper footing and balance at all times.

**Maintain Tools with Care**

Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing punch and die. Inspect tool cords periodically and if damaged, have repaired by authorized service facility. Inspect extension cords periodically and if damaged or replace. Keep handles dry, clean, and be free from oil and grease.

**Disconnect Tools**

When not in use; before servicing; when changing punches, dies, brushes, etc.

**Remove Adjusting keys and Wrenches**

Form Habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

**Avoid Accidental Starting**

Don't carry plugged-in tool with finger on switch. Be sure switch is OFF when plugging in. Use of any accessory with this power unit might increase the hazard. The tool should be used only for the purpose for which it is designed.

**Outdoor Use Extension Cords**

When tool is used outdoors, use only extension cords marked W-A or W.

**Stay Alert**

Watch what you are doing, use common sense when operating a power tool. Do not use tool while tired or under the influence of drugs, alcohol or medication.

### **Check Damaged Parts**

Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment if moving parts, binding or moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by an authorized service center unless otherwise indicated elsewhere in this instruction manual. Have defective switches replaced by authorized service center. Do not use tool if switch does not turn it on or off. **DO NOT OPERATE** power tools in explosive atmospheres such as in the presence of flammable liquids, gases, or dust. Motors in these tools normally spark and sparks can possibly ignite fumes.

*Read all instruction.*

*Save these instructions.*

### **FUNCTIONAL DESCRIPTION**

Please read carefully all safety rules and operating instructions. The Model 2020 Nibbler is recommended for CR sheet steel up to 14 gauge. Secure work piece. To start cut, place die opening onto the edge of the work piece to steady the tool and ready it for the cut. Depress the trigger switch and guide nibbler into the work. Do not force it. Avoid double thicknesses of material which exceed the 14 gauge recommended capacity. For cutting within perimeter of work piece, drill a 9/16" diameter starting hole and follow instructions above. If resistance to tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication; thickness of material; sharpness of cutting blades.

### **ASSEMBLY**

To assemble Nibbler Head (2020) onto drive motor.

1. Insert spacer (see part sheet for correct spacer) onto shaft of motor.
2. Turn eccentric nut (41-24-1) onto shaft with hex side toward motor and against spacer.
3. Lubricate bearing surface of eccentric nut (41-24-1) with a good grade of bearing grease.
4. Place nibbler head onto motor unit. Eccentric nut must engage with connecting link (2024-3) as head is placed onto motor unit.
5. Tighten clamping screw (M133-36) snugly to lock head assembly in place.

### **ADJUSTMENTS**

The die (2021) rotates a full 360 degrees. To change position, loosen clamp nut (2029), set die in desired position, tighten clamp nut. When cutting corrugated metal, set die at 90 degrees to the motor unit. This will allow the motor and head to roll with the corrugations.

### **TO CHANGE PUNCH AND/OR DIE**

1. Disconnect motor from power source.
2. Remove clamp nut (2029).
3. Remove retainer nut (2027) and the punch (2022) will slide out of the head.
4. Insert new punch (2022) into head and secure with retainer nut (2027).
5. Insert new die (2021) and secure with clamp nut (2029).

### **MAINTENANCE OF 2020 NIBBLER HEAD**

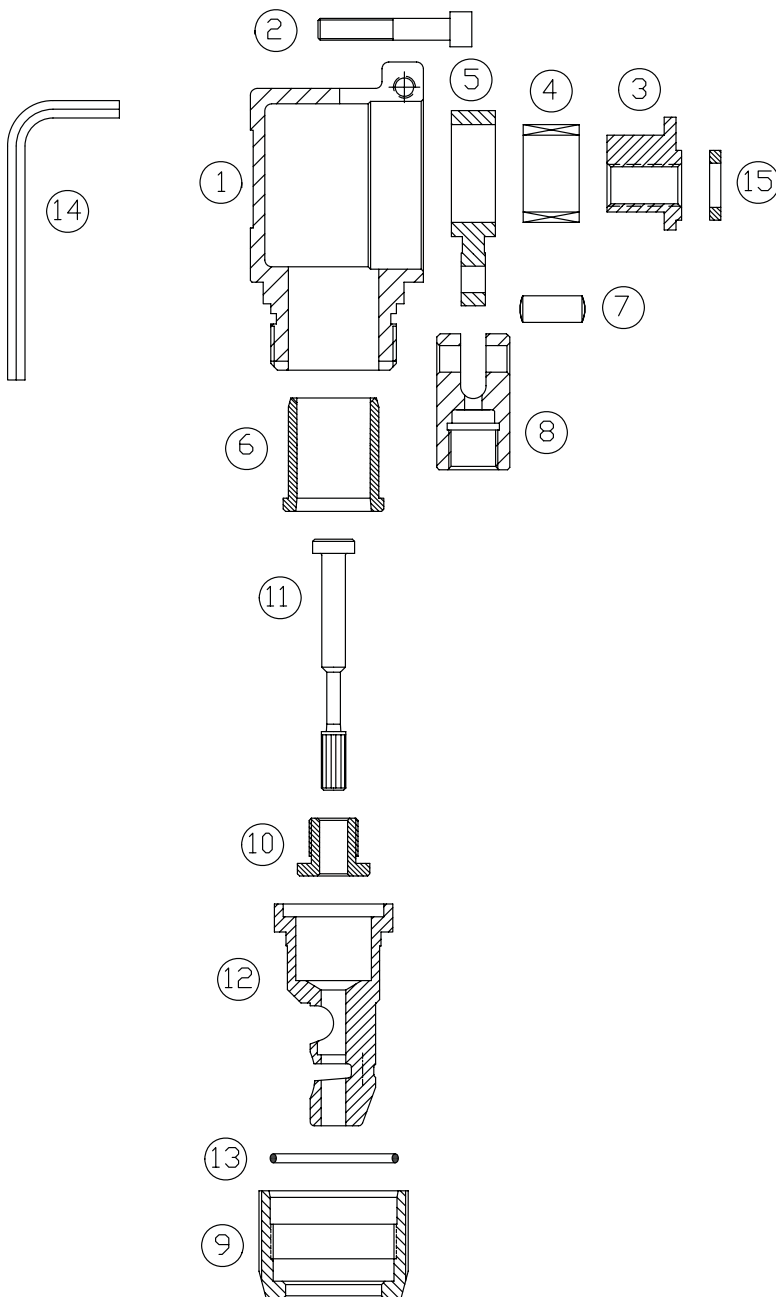
When servicing use only identical replacement parts. Once every three months, depending upon usage, remove the nibbler head from the power unit by loosening clamping screw (M133-36) and pull the head off with a twisting action. Lubricate bearing surface of the eccentric nut (41-24-1) with a good grade of bearing grease. Place nibbler head back onto motor unit. Eccentric nut must engage with the link assembly as head is placed onto motor. Tighten clamping screw snugly to lock head assembly in place.



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# Model 2020 Nibbler Attachment



## 2020 Parts List

| Item | Part No. | Description       |
|------|----------|-------------------|
| 1    | 2023     | Housing           |
| 2    | M133-36  | Screw             |
| 3    | 41-24-1  | Eccentric Bushing |
| 4    | 1024-2   | Needle Bearing    |
| 5    | 2024-3   | Connecting Link   |
| 6    | 2028     | Sleeve            |
| 7    | 1025     | Pin               |
| 8    | 2026     | Plunger           |
| 9    | 2029     | Nut               |
| 10   | 2027     | Retaining Nut     |
| 11   | 2022     | Punch             |
| 12   | 2021     | Die               |
| 13   | 2030     | O-Ring            |
| 14   | M150-9   | Wrench            |
| 15   | See Note | Spacer            |

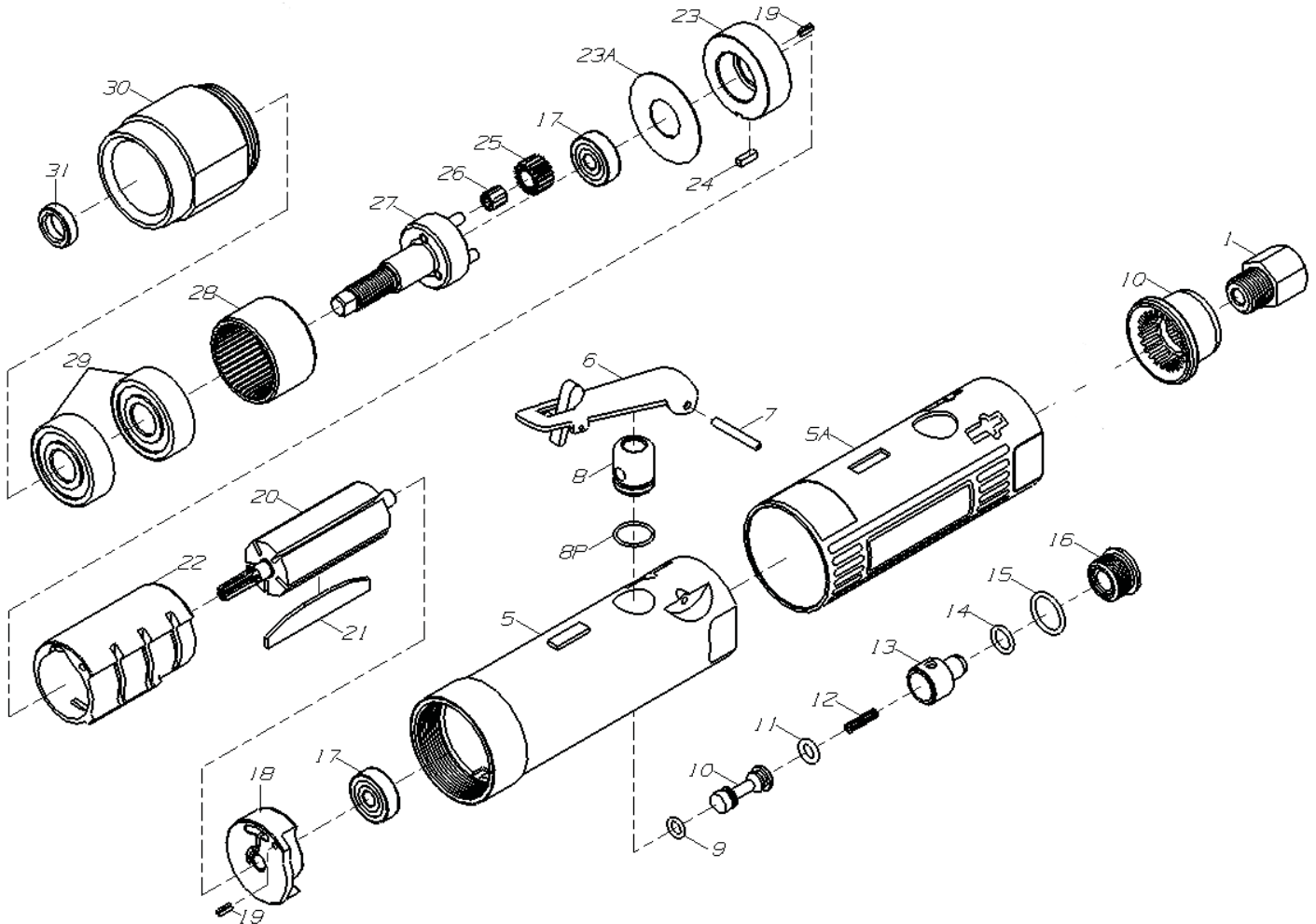
Note:

|         |        |
|---------|--------|
| Motor # | Spacer |
| 253-55  | 629815 |
| 253-59  | 449893 |
| 253-80  | 449893 |
| 253-68  | 449893 |
| 253-58  | 154-57 |

The use of Stick Cutting Wax (264-5) or a cutting oil will greatly improve the performance of the KETT Nibbler. Use stick cutting wax on the underside of the work piece for best results.



## 253-58 PNEUMATIC POWER UNIT PARTS LIST



| ITEM NO. | PART NO.   | DESCRIPTION       | REQ'D TOOL | ITEM NO. | PART NO.   | DESCRIPTION      | REQ'D TOOL |
|----------|------------|-------------------|------------|----------|------------|------------------|------------|
| 1        | 103132     | Inlet Bushing     | 1          | 17       | 0626-ZZ0A  | Ball Bearing     | 2          |
| 1Q       | 103129     | Exhaust Deflector | 1          | 18       | 103116     | Rear End Plate   | 1          |
| 5        | 303305     | Motor Housing     | 1          | 19       | P-0025-060 | Pin              | 2          |
| 5A       | 103118-S   | Housing Sleeve    | 1          | 20       | 303319     | Rotor            | 1          |
| 6        | 103127     | Lever             | 1          | 21       | 303115     | Rotor Blades     | 5          |
| 7        | P-0030-220 | Lever Pin         | 1          | 22       | 303112     | Cylinder         | 1          |
| 8        | 103126     | Valve Bushing     | 1          | 23       | 303323     | Front End Plate  | 1          |
| 8P       | O-1100-120 | O-Ring            | 1          | 23A      | 103322A    | Washer           | 1          |
| 9        | O-0500-150 | O-Ring            | 1          | 24       | 303324     | Key              | 1          |
| 10       | 103125     | Throttle Valve    | 1          | 25       | 103323     | Idler Gear       | 3          |
| 11       | O-0500-200 | O-Ring            | 1          | 26       | K477TN     | Needle Bearing   | 3          |
| 12       | 103123     | Spring            | 1          | 27       | 303327     | Idler Gear Plate | 1          |
| 13       | 103122     | Air Regulator     | 1          | 28       | 303328     | Ring Gear        | 1          |
| 14       | O-0700-180 | O-Ring            | 1          | 29       | 6201-Z00A  | Ball Bearing     | 2          |
| 15       | O-1100-250 | O-Ring            | 1          | 30       | 303330     | Gear Cap         | 1          |
| 16       | 103119     | Valve Screw       | 1          | 31       | 303331     | Washer           | 1          |