

INSTRUCTIONS and PARTS LIST MANUAL

FOR

Modern Nibblers

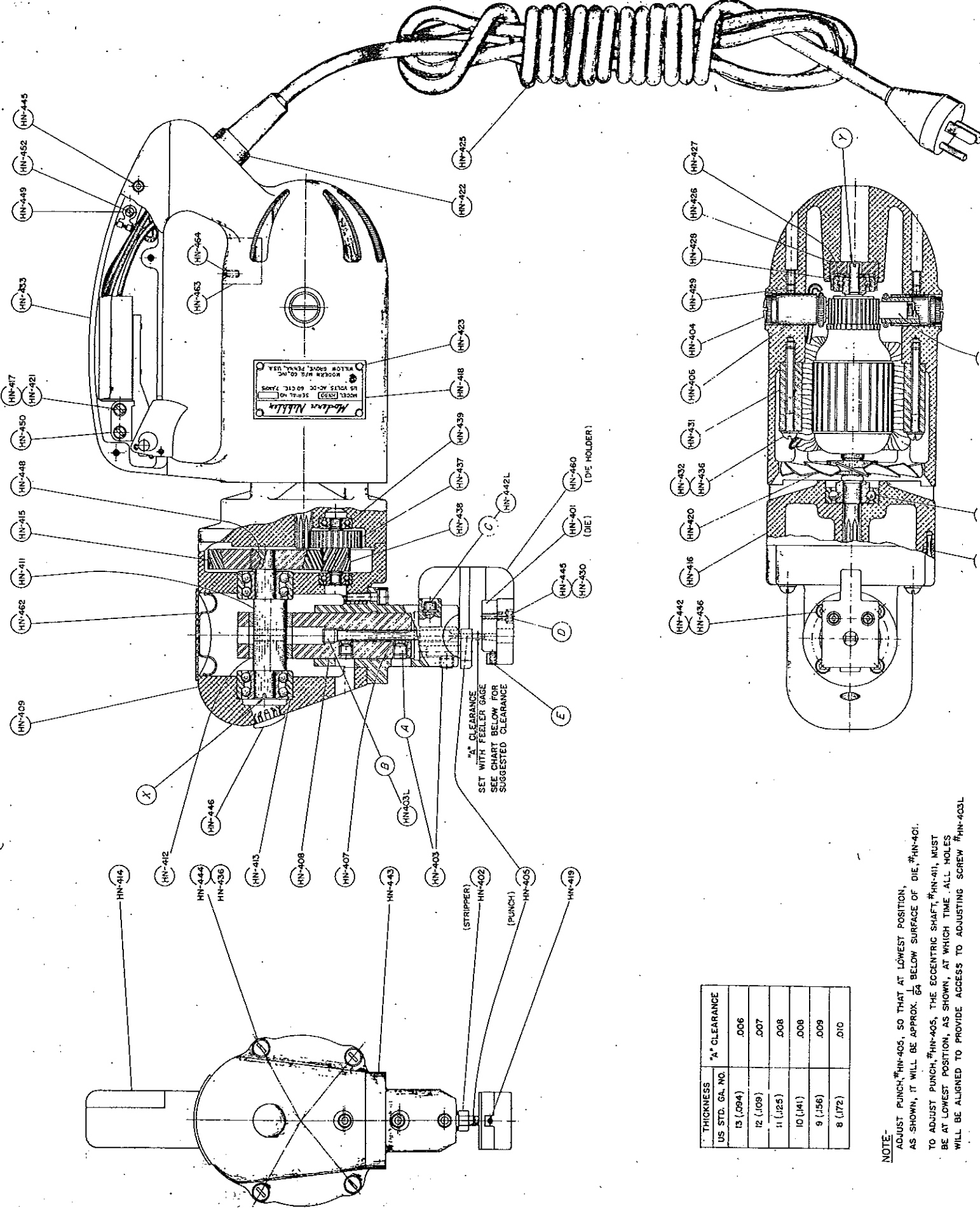
MODEL HN - 90 and HNC - 92



- Presses & Coil Handling Equipment
- Metal Fabricating Machinery
- Sheet Metal Equipment

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THICKNESS	"A" CLEARANCE
US STD. GA. NO.	.006
13 (.094)	.007
12 (.109)	.008
11 (.125)	.008
10 (.141)	.009
9 (.156)	.010
8 (.172)	

NOTE-
 ADJUST PUNCH, #HN-405, SO THAT AT LOWEST POSITION, AS SHOWN, IT WILL BE APPROX. $\frac{.01}{2}$ BELOW SURFACE OF DIE, #HN-401. TO ADJUST PUNCH, #HN-405, THE ECCENTRIC SHAFT, #HN-411, MUST BE AT LOWEST POSITION, AS SHOWN, AT WHICH TIME ALL HOLES WILL BE ALIGNED TO PROVIDE ACCESS TO ADJUSTING SCREW #HN-403L

OPERATING INSTRUCTIONS

WARNING Read operating instructions carefully before attempting to operate your MODERN NIBBLER. Instructions are concise and simple, and by carefully following these instructions, your MODERN NIBBLER will serve efficiently and cut your metal cutting cost tremendously.

PREPARING TOOL FOR SERVICE

Model HN-90 and HNC-92 Nibblers are set to cut 10 gage metal. If other, than 10 gage will be cut, adjust stripper HN-402 or HNC-702 to 1/64" above thickness of material. More clearance than specified will cause tool to jump while cutting. Less clearance will prevent machine to cut with ease.

Also if other metal than 10 gage is being cut, adjust die HN-401 or HNC-701 to proper clearance "A" shown on chart by loosening screws "D", and adjusting screw "E"

Use a thin film of proper lubricant (shown on opposite page) to obtain best cutting, eliminate material from sticking to punch, and preserve sharp edge on punch and die.

Punch and die are made from special alloys and will keep sharp for approximately eight (8) hours or more of constant cutting, if above instructions are followed.

IMPORTANT

Before starting machine, insert screw driver in slot "X" or "Y" and turn motor manually to ascertain that punch enters die without interference. This precaution will eliminate breakage of punch, die, or die holder should the proper adjustment not be made.

ADJUSTING OR REPLACING PUNCH

For proper cutting, punch HN-405 should enter die HN-401, 1/64" to 1/32" deep. To accomplish this, turn motor manually at "X" or "Y" with screw driver until punch is at its lowest position and holes in shaft, HN-411 align with holes in HN-412 and HN-408 (shown on opposite page). Loosen two (2) screws "A", remove cap HN-462, and adjust screw "B" by turning with socket wrench provided.

To replace punch, turn motor manually until punch HN-405 is out of the die HN-401 completely. Remove lock screw "C" and pull die holder HN-460. Remove stripper HN-402, by loosening screw HN-403. Turn motor again manually until punch is in its lowest position, loosen screws "A" and remove punch from bottom.

To replace punch, reverse the above operations. Be sure that flat on punch is facing front.

CAUTION

Turn motor manually before starting with power to be sure there is no interference between functioning parts.

REMOVING AND SHARPENING DIE

To remove die HN-401, remove two (2) set screws "D" and raise stripper HN-402 to its maximum position. Raise die and pull out.

Sharpen die on surface grinder or by placing cutting face against a flat grinding wheel. Grind until all rounded edges of cutting portion are removed. Do not over heat in sharpening, as hardening temper will be lost.

After sharpening die, punch must be lowered so that it enters die 1/64" to 1/32". Be sure clearance "A" is set with feeler gage after replacing die.

CAUTION

Turn motor manually before starting with power to be sure there is no interference between functioning parts.

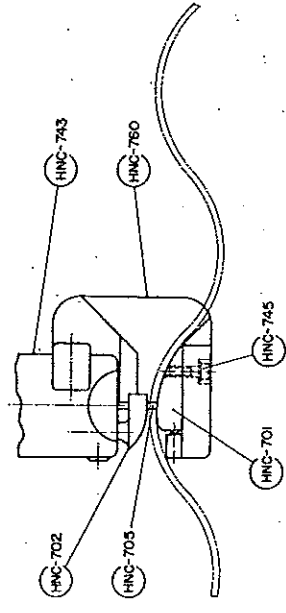
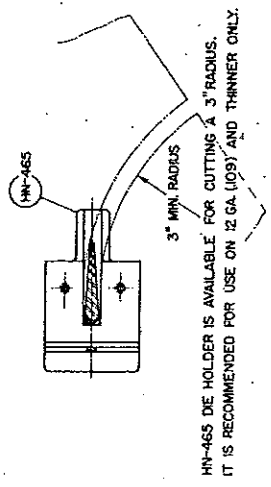
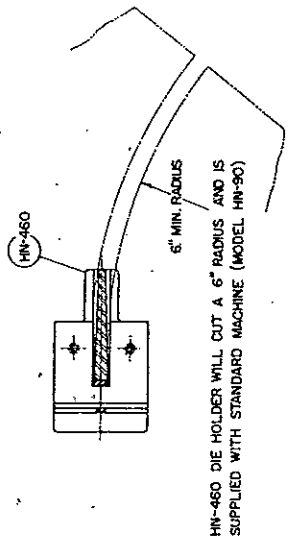
THE TEN COMMANDMENTS OF THE NIBBLER

1. Always adjust clearance "A" as per chart.
2. Adjust stripper to 1/64" above metal thickness being cut.
3. Use proper lubricant as prescribed.
4. Stop machine immediately if it should jam. Back out punch manually by turning motor at "X" or "Y".
5. When removing or replacing punch be sure brass plugs HN-407 are not lost. Loss of these plugs will cause punch to slip.
6. Always keep punch HN-405 and die HN-401, sharpened and a spare set on hand.
7. Tighten screws "A", "C", "D", and HN-403 with as much torque as manually possible to prevent slippage.
8. Be sure motor turns easily manually after any adjustment is made.
9. Have Nibblers checked and adjusted by factory every six (6) or eight (8) months, if continuously used.
10. Only use genuine MODERN replacement parts.

LIST OF PARTS

- HN-401 DIE
- HN-402 STRIPPER
- HN-403 SET SCREW, $\frac{5}{16}$ 24 (3 REQ'D)
- HN-403L SET SCREW, LOCK TYPE
- HN-404 BRUSH HOLDER CAP. (2 REQ'D)
- HN-405 PUNCH
- HN-406 BRUSH HOLDER. (2 REQ'D)
- HN-407 PLUG. (2 REQ'D)
- HN-408 PLUNGER
- HN-409 NOSE HOUSING
- HN-410 ALLEN WRENCH, $\frac{1}{16}$ HEX. (NOT SHOWN)
- HN-411 ECCENTRIC SHAFT
- HN-412 SLIDER
- HN-413 BALL BEARING. (2 REQ'D)
- HN-414 COVER
- HN-415 2.00 GEAR
- HN-416 GEAR HOUSING
- HN-417 ROUND HD. SCREW, #5 (125) 40 (2 REQ'D)
- HN-418 NAME PLATE
- HN-419 HDLESS. SET SCREW, #5 (125) 40
- HN-420 ARMATURE
- HN-421 LOCKWASHER, #5 (2 REQ'D)
- HN-422 CORD RESTRAINER
- HN-423 DRIVE SCREW, (2 REQ'D)
- HN-424 BRUSH, (2 REQ'D)
- HN-425 CORD SET
- HN-426 BEARING RETAINER
- HN-427 LOAD SPRING
- HN-428 BALL BEARING
- HN-429 HDLESS SET SCREW, #10 (190) 32, (2 REQ'D)

- HN-442L SOC. HD. CAP SCREW, LOCK TYPE, #10 (190) 24, (2 REQ'D)
- HN-430 LOCKWASHER, #6, (2 REQ'D)
- HN-431 MOTOR FIELD
- HN-432 ROUND HD. SCREW, #10 (190) 24, (2 REQ'D)
- HN-433 MOTOR HOUSING
- HN-434 BALL BEARING
- HN-435 DOWEL PIN
- HN-436 LOCKWASHER, #10, (12 REQ'D)
- HN-437 $\frac{1}{2}$ GEAR
- HN-438 PINION
- HN-439 BALL BEARING, (2 REQ'D)
- HN-442 SOC. HD. CAP SCREW, #10 (190) 24, (4 REQ'D)
- HN-443 NOSE
- HN-444 ROUND HD. SCREW, #10 (190) 24, (4 REQ'D)
- HN-445 SOC. HD. CAP SCREW, #6 (138) 32, (5 REQ'D)
- HN-446 PLUG BUTTON
- HN-448 WOODRUFF KEY
- HN-449 TERMINAL
- HN-450 SWITCH
- HN-452 ROUND HEAD SELF-TAPPING SCREW, #5 (125) 40
- HN-453 ALLEN WRENCH, $\frac{5}{32}$ HEX. (NOT SHOWN)
- HN-456 ALLEN WRENCH, $\frac{3}{32}$ HEX., (NOT SHOWN)
- HN-460 DIE HOLDER
- HN-462 CLOSURE CAP
- HN-463 RADIO INTERFERENCE SUPPRESSORS... WHEN REQUESTED. (2 REQ'D)
- HN-464 FLAT HD. SCREW, #5 (138) 32 (2 REQ'D)
- HN-465 DIE HOLDER, 3" RADIUS, (AVAILABLE UPON REQUEST)



CORRUGATED NIBBLER MODEL HNC-92
ALL PARTS SAME AS STANDARD MODEL HN-90 EXCEPT AS SHOWN

MODERN MFG. CO. INC.	
WILLOW GROVE, PA.	
HEAVY DUTY	
NIBBLER ASSEMBLY	
MODEL HN-90 & HNC-92	
DRAWN	J.A. PRITZ
APPROVED	(CHECKED)
SCALE	FULL
DATE	REVISED 10-24-53
	3-20-54

- HNC-701 DIE
- HNC-702 STRIPPER
- HNC-705 PUNCH
- HNC-743 NOSE
- HNC-745 SOC. HD. CAP SCREW (2 REQ'D)
- HNC-760 DIE HOLDER