



Operating Instructions and Parts Manual Pneumatic Sheet Metal Notcher

Model PMN-11



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1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. This pneumatic sheet metal notcher is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a sheet metal notcher, do not use it until proper training and knowledge have been obtained.
5. Do not use this sheet metal notcher for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. Always wear ANSI Z87.1 approved safety glasses or face shield while using this machine. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
7. Wear ear protectors (plugs or muffs) if noise exceeds safe levels.
8. Before operating the machine, remove tie, rings, watches, other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair.
9. Keep the floor around the machine clean and free of scrap material, oil and grease.
10. Keep machine guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately upon completion of maintenance.
11. Check damaged parts. Before further use of the machine, 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 of moving parts, binding of 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.
12. Make all machine adjustments or maintenance with machine unplugged from power source.
13. Use the right tool. Do not force a tool or attachment to do a job that it was not designed to do.
14. Make certain the switch is in the **OFF** position before connecting the machine to the air or power supply.
15. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
16. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
17. Keep visitors a safe distance from the work area. Keep children away.
18. Make your workshop child proof with padlocks, master switches or by removing starter keys.
19. Do not overreach. Failure to maintain proper working position can cause you to fall into the machine or allow clothing to get caught, pulling you into the machine.
20. Keep the floor around the machine clean and free of scrap material, oil and grease.
21. Use recommended accessories; improper accessories may be hazardous.
22. **CALIFORNIA PROPOSITION 65 WARNING:** This product contains chemicals known to the State of California to cause cancer, or birth defects or other reproductive harm.
23. This product, when used for welding, cutting, or working with metal, produces fumes, gases, or dusts which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health and Safety Code Section 25249.5 et seq.)
24. Do not operate this machine while under the influence of drugs, alcohol or any medication.
25. Keep tools sharp and clean for safe and best performance.
26. Keep hands away from the blade area during operation.
27. Provide for adequate space surrounding work area and non-glare, overhead lighting.
28. Don't use in dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain.
29. Do not stand on the machine. Serious injury could occur if the machine tips over.

30. Never leave the machine running unattended. Disconnect machine from air supply before leaving the area.
31. Do not step on the foot pedal control before or during connection of air supply.
32. Use only JET factory authorized replacement parts and accessories; otherwise, the warranty and guarantee are null and void.
33. Do not attempt to cut material greater than the listed capacity of the notcher.
34. Do not use combustible gases, carbon dioxide, oxygen or any bottled gas as an air source for the tool. These can present risk of explosion and serious injury.
35. Compressed air can be harmful if directed toward sensitive areas of the body, and may propel small particles caught in the air stream. Exercise proper caution.
36. Shut off air supply and discharge any residual pressure from machine before removing hose, making adjustments, changing accessories, or storing.

Familiarize yourself with the following safety notices used in this manual:

⚠CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING This means that if precautions are not heeded, it may result in serious, or possibly even fatal, injury.

SAVE THESE INSTRUCTIONS

2.0 About this manual

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model PMN-11 Pneumatic Sheet Metal Notcher. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠WARNING Read and understand the entire contents of this manual before attempting assembly or operation! Failure to comply may cause serious injury!

Register your product online -

<http://www.jettools.com/us/en/service-and-support/warranty/registration/>

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4.0 Specifications

Model number **PMN-11**
Stock number 754405

Air supply:

Working pressure..... 115 PSI (8 kg/cm²)
Average air consumption 154.6 CFM
Air intake connector..... 3/8 in. NPT
Air system lubrication required lubricator bowl, ISO VG32 (SAE #10)
Foot switch..... satellite foot pedal with E-stop
Foot switch cable length (approx..) 4-1/2 ft. (137 cm)

Capacities:

Blade length..... 130 x 130 mm (5.2 x 5.2 in.)
Strokes per minute..... 50
Working force..... 2.2 tons
Maximum cutting thickness (mild steel) 2mm/14 ga. (R=60 kg/mm²); 3mm/11 ga. (R=42 kg/mm²)
Notching angle..... 90-degree fixed
Workpiece positioning..... up to 45-deg. L and R
Maximum blade travel..... 25mm (0.98 in.)

Main materials:

Cabinet sheet metal; steel plate
Cutting head cast steel
Blades..... hardened steel

Dimensions:

Table size 460 x 600 mm (18 x 24 in.)
Table height from floor..... 946 mm (37-1/4 in.)
Shipping dimensions (LxWxH)..... 754 x 706 x 1366 mm (30 x 28 x 53.8 in.)
Overall dimensions (LxWxH) 660 x 600 x 1260 mm (26 x 23.6 x 50 in.)

Weights:

Net 160 kg (352.7 lb)
Shipping..... 188 kg (414.5 lb)

L= length; W=width; H=height

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

⚠WARNING Read and understand the entire contents of this manual before attempting set-up or operation! Failure to comply may cause serious injury.

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5.0 Setup and assembly

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until machine is assembled and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

5.1 Shipping contents

- 1 Pneumatic Notcher
- 1 Angle gauge
- 1 0.3mm feeler gauge
- 1 14mm combination wrench
- 1 5mm hex key
- 1 Operating Instructions and Parts Manual
- 1 Warranty Card

5.2 Location and cleanup

1. Remove any fasteners holding machine to pallet.
2. Use forklift or hoist with straps to carefully move machine off pallet and into position. **Lifting equipment must be properly rated for weight of machine.** Position forks or straps below table as shown in Figure 5-1.

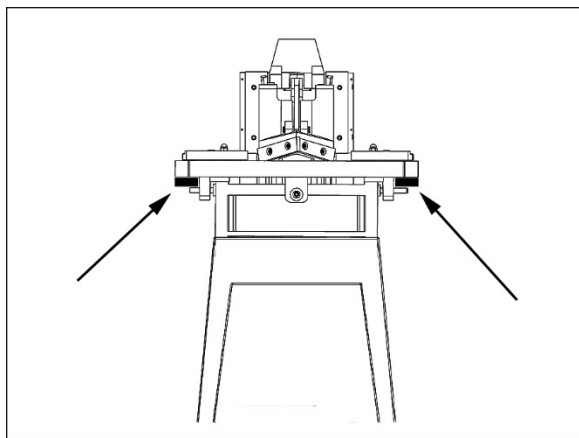


Figure 5-1: lifting the machine

3. Position notcher so there is enough room on all sides for general maintenance and feeding of materials. Level the machine; use shims if needed.

⚠WARNING If there is any tendency for machine to move or slide during operation, it must be anchored to floor using lag

screws or other appropriate fasteners through two holes in base (inside cabinet).

4. Exposed metal surfaces have been given a protective coating. Remove this with a soft cloth and a cleaner-degreaser. Do not use gasoline, paint thinner, acetone, etc., as these may damage painted surfaces. Do not use an abrasive pad, as it may scratch polished surfaces.

5.3 Air settings and lubrication

NOTE: Lubricator bowl (H, Figure 5-2) is not supplied with oil. Fill bowl to indicator line before operating notcher.

1. Make sure air compressor supplies clean, dry air at correct CFM for the machine. Blow out air supply line to remove any dirt or moisture, and connect hose to fitting (A, Figure 5-2) using a quick-connect coupling. Hose should be just long enough to serve the working area. Excessive hose length may cause pressure drop.

⚠CAUTION Excess air pressure and/or unclean air will reduce the machine's service life and may create a hazardous situation.

2. The sliding valve (B) is used to turn air flow on and off. ON: slide toward regulator, OFF: slide away from regulator.
3. Air pressure has been pre-set for 115 psi (8 kg/cm²). If adjustment is needed, turn on air and pull up on pressure regulator (C) and rotate. Check pressure gauge (D) to confirm setting, then push regulator down to lock setting. **Do not exceed 140 psi air pressure.**
4. Adjust oil flow by turning adjustment knob (E). Clockwise decreases oil flow, counterclockwise increases. A setting of 1 drop per every 5 cycles is sufficient for regular operation.

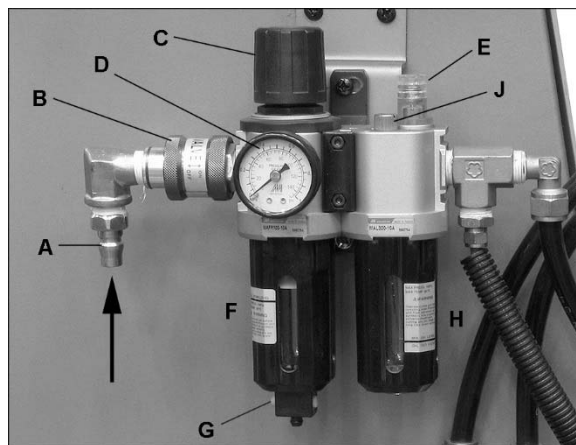


Figure 5-2: air adjustments

6.0 Operation

6.1 Controls

Press foot pedal to activate machine. Cutting head will descend and remain in down position until foot pedal is released.

An Emergency Stop switch (E-stop) is located atop the foot pedal post; push for immediate shut-down of machine. To restart, rotate E-stop clockwise until it disengages.

6.2 General operating procedure

1. Use scales (A, Figure 6-1) to help determine notching size.
2. Place angle indicator (B) against fence to help set angle for workpiece.
3. Position fences (C) to secure workpiece in place, and tighten handles.
4. Press foot pedal to operate. Cut pieces will drop into tray inside cabinet.

CAUTION Falling sheet metal pieces can cause foot injury. Use appropriate footwear when operating this machine.

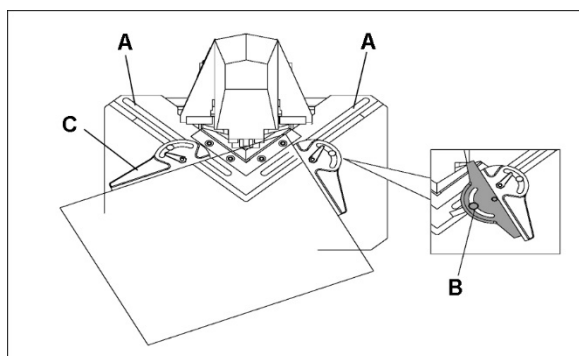


Figure 6-1

7.0 Adjustments

WARNING Disconnect machine from air supply before working with or near the blades. If head guard is removed for adjustments, reinstall guard before operating machine. Failure to comply may cause serious injury.

7.1 Blade gap tolerance

The notcher is pre-set for 3mm (12 ga.) workpiece thickness, with 0.3mm blade gap tolerance. A 0.3mm feeler gauge is provided to assist in checking this measurement. If notching workpieces 2mm (14ga.) or thinner, adjust blade gap to 0.1mm, as follows.

1. Press foot pedal to lower notching head; continue pressing it.

2. Turn off air with sliding valve (see B, Figure 5-2) and bleed residual air from system (see G, Figure 5-2).
3. Release foot pedal.
4. DISCONNECT air supply from machine.
5. Remove screws (D, Figure 8-1) and head guard (E).
6. Use feeler gauge to measure gap between upper and lower blades (Figure 8-2).
7. Make adjustments using hex nuts beneath table. Turn (F) to raise or lower blade, turn (G) to move in and out. Feeler gauge should be snug but can still be smoothly removed.
8. Make sure blades are flush against each other at the corners. See Figure 8-3.
9. Reinstall head guard and tighten screws.

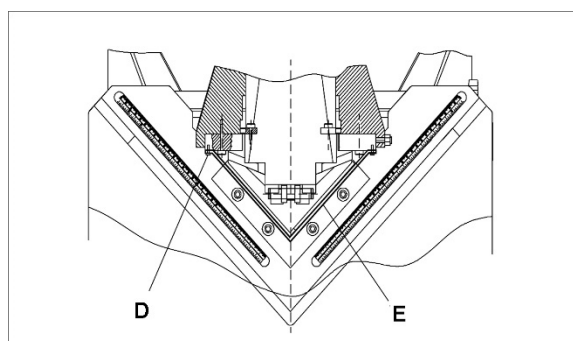


Figure 8-1

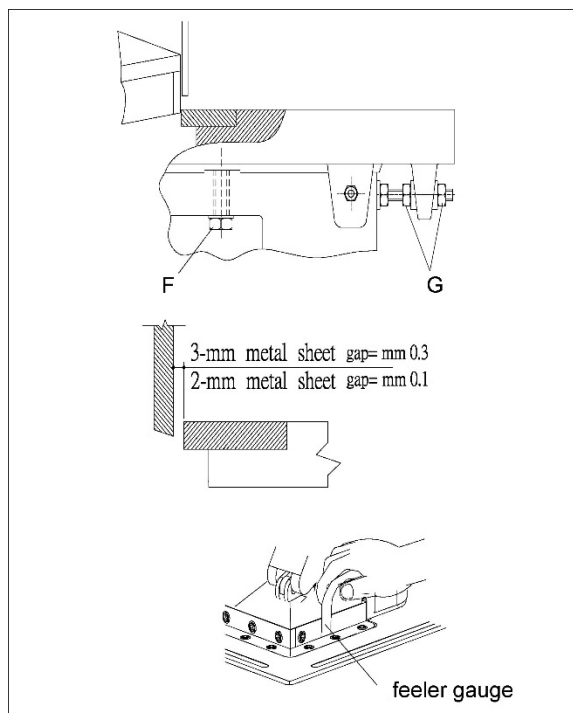


Figure 8-2: gap adjustment

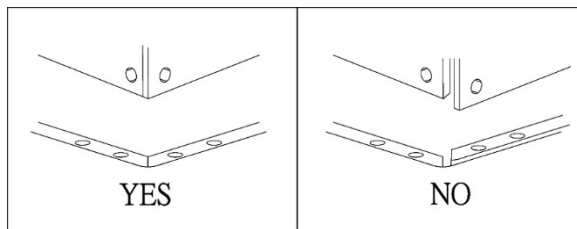


Figure 8-3

8.0 User-maintenance

⚠ WARNING Disconnect machine from air supply before performing any maintenance. If head guard is removed for servicing, reinstall guard before operating machine. Failure to comply may cause serious injury.

1. Periodically insert oil into two fittings (A, Figure 9-1)
2. Periodically apply oil to pivot areas of connection plate (B).

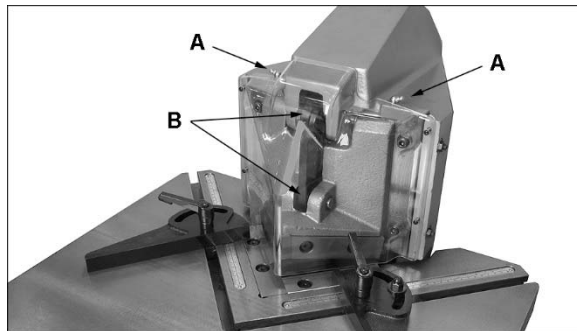


Figure 9-1

3. Drain water from air compressor tank daily, as well as any condensation from air lines. Change filters on the air system on a regular basis.
4. Periodically check filter/regulator bowl (F, Figure 5-2) for fluids or sediment accumulation, and empty if needed. Bowl should be emptied before fluid reaches maximum drain level as indicated on bowl. To remove a bowl, shut off air supply and push pin (G, Figure 5-2) to bleed excess air. Then press tab, rotate bowl to the left, and pull bowl down. Reverse procedure to reinstall bowl. *Make sure bowl is locked in position before applying air to the system!*
5. Maintain oil level in lubricator bowl (H, Figure 5-2); top off as needed with ISO 32 (SAE 10) non-detergent, non-additive oil. Remove screw (J, Figure 5-2) with screwdriver to fill.
6. Keep table and T-slots clean and free of rust. Periodically apply a light coat of SAE 30 oil or equivalent to exposed metal surfaces, such as table, fences and blades.
7. Check air connections; replace components if leakage is found.
8. Keep blade area free of deposits or shavings, which can impede cut quality and hasten blade wear.
9. Maintain sharp blades. If they become dull, remove and re-sharpen.

8.1 Additional servicing

Any additional servicing should be performed by authorized service personnel.

9.0 Troubleshooting PMN-11 Pneumatic Notcher

Table 2

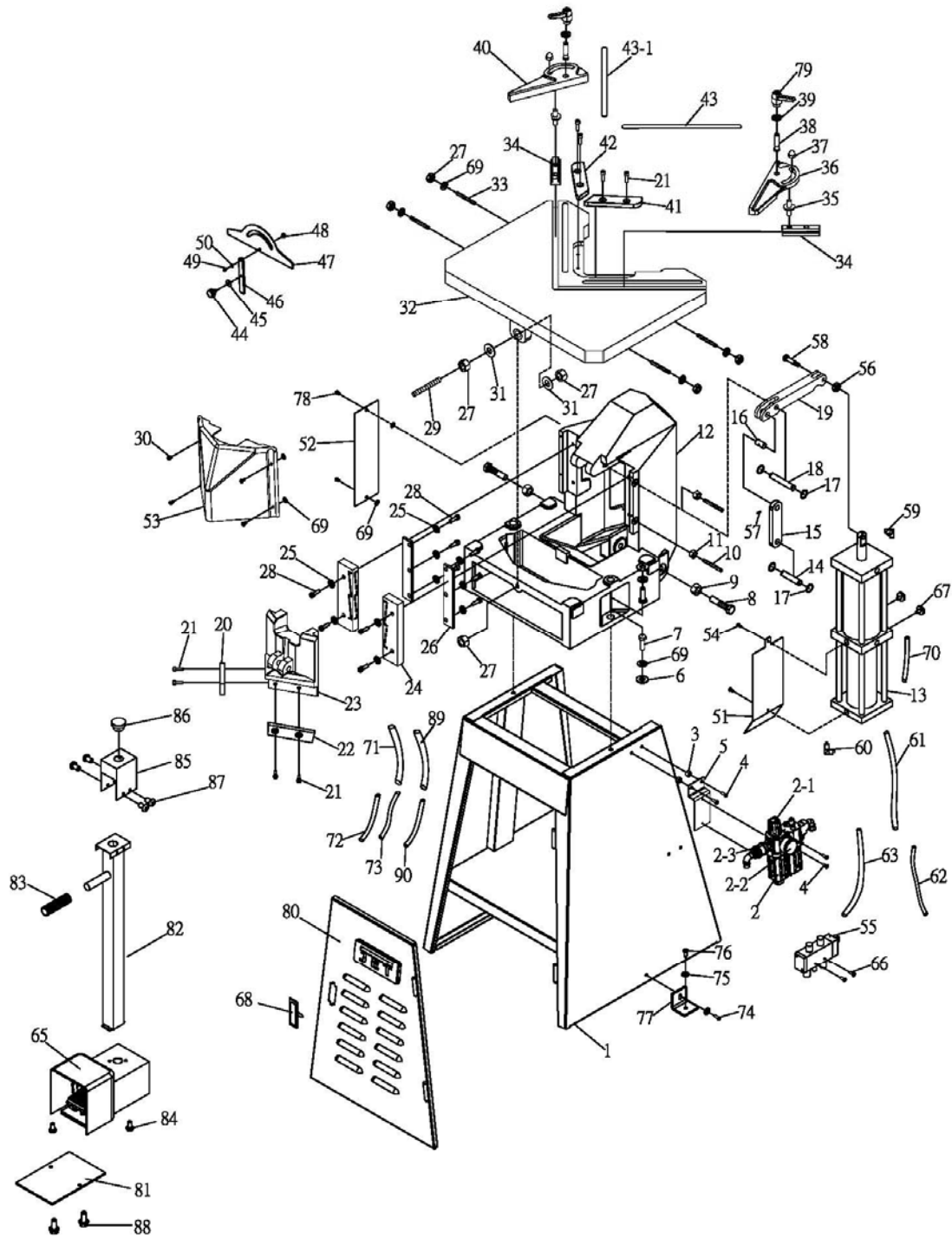
Symptom	Possible Cause	Correction
Machine will not start.	Air valve closed or obstructed.	Open valve; clear any obstructions.
	Foot pedal malfunction.	Inspect and replace if needed.
Loss of power; erratic action	Low air pressure.	Verify compressor has proper CFM rating for tool. Check regulator setting; set air pressure to 115 psi. Check for loose connections.
	Moisture or obstruction in air hose.	Air supply must be clean and dry. Clean out air hose and remove any kinks or bends.
Machine appears to labor during cutting.	Machine capacity exceeded.	Use materials within rated capacity.
	Improper lubrication.	Follow lubricating guidelines.
Edges of cut are rough or rolled.	Blade gap incorrect.	Adjust blade gap.
	Insufficient workpiece material on both sides of blade.	Make sure workpiece length on both sides of blades is approximately 8 times workpiece thickness.
Poor cut quality.	Machine capacity exceeded.	Use materials within rated capacity.
	Blades dry; improper lubrication.	Follow lubricating guidelines.
	Blades dull or damaged.	Resharpen or replace blades.
	Blades are loose.	Check all blades for tightness.

10.0 Replacement Parts

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

10.1.1 PMN-11 Pneumatic Notcher – Exploded View



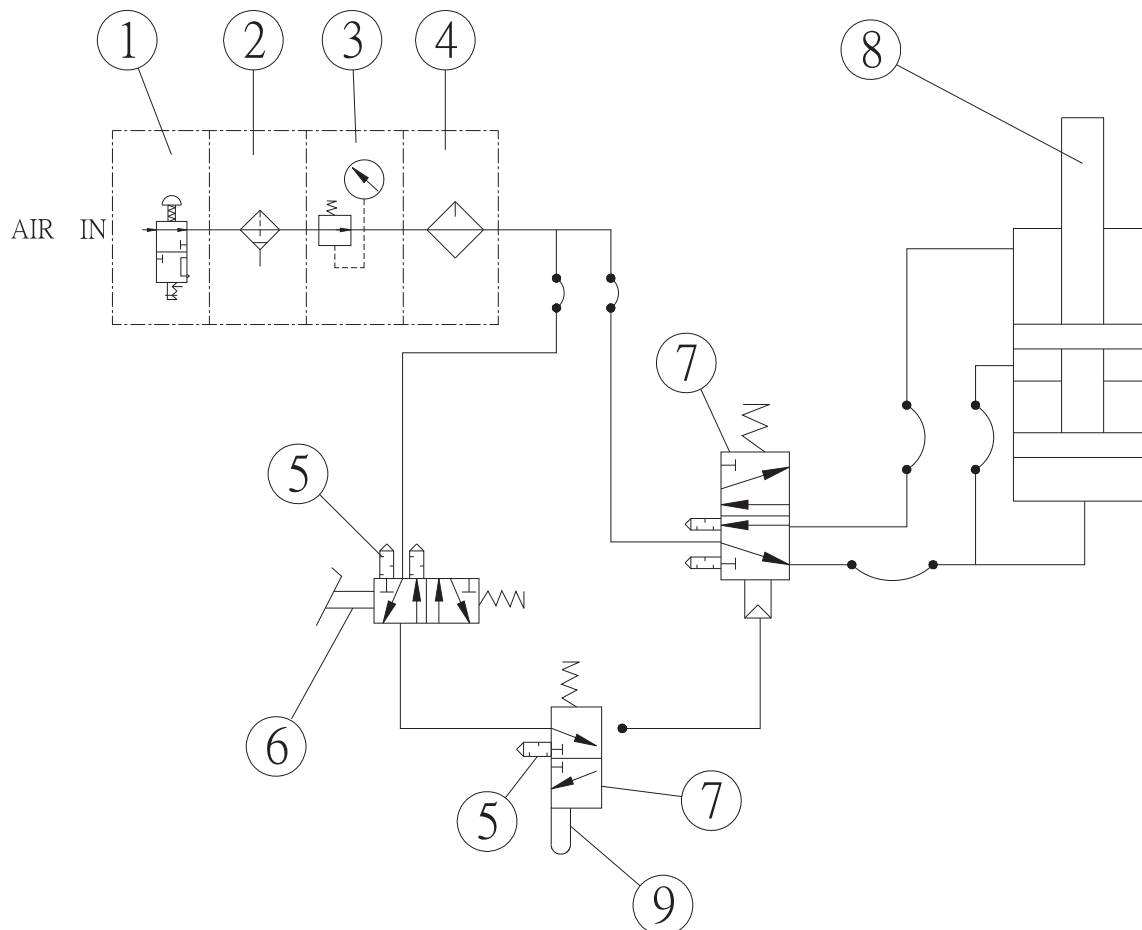
10.1.2 PMN-11 Pneumatic Notcher – Parts List

Index No.	Part No.	Description	Size	Qty
1	PMN11-1	Cabinet		1
2	PMN11-2	Air Control Unit		1
2-1	PMN11-2-1	Pressure Regulator		1
2-2	PMN11-2-2	Pressure Gauge		1
2-3	PMN11-2-3	Adaptor Set		1
3	TS-1540041	Hex Nut	FULL M6	2
4	TS-1534042	Mach Screw, Pan HD, Phillips	M6x12	4
5	PMN11-5	Air Control Bracket		1
6	TS-0680061	Flat Washer	M12	4
7	TS-1492041	Hex Cap Screw	M12x40	4
8	PMN11-8	Hex Cap Screw	M16	2
9	TS-2311161	Hex Nut	FULL M16	2
10	F010413	Socket Set Screw	M8x30	2
11	TS-1540061	Hex Nut	FULL M8	2
12	PMN11-12	Head Weldment		1
13	PMN11-13	Air Cylinder		1
14	PMN11-14	Pin (Short)		1
15	PMN11-15	Connection Plate		1
16	PMN11-16	Pin		1
17	PMN11-17	C-Ring	S-14	4
18	PMN11-18	Pin		1
19	PMN11-19	Link Bar		1
20	PMN11-20	Upper Left Blade		1
21	PMN11-21	Thin Socket HD Cap Screw	M8x20	8
22	PMN11-22	Upper Right Blade		1
23	PMN11-23	Cutting Head Weldment		1
24	PMN11-24	Block		2
25	TS-1550061	Flat Washer	M8	10
26	PMN11-26	Spacer Plate		2
27	TS-1540081	Hex Nut	FULL M12	7
28	TS-1504071	Socket HD Cap Screw	M8x35	10
29	PMN11-29	Full Thread Bolt	M12x120	1
30	TS-2244202	Socket HD Button Screw	M4X20	4
31	TS-2360121	Flat Washer	M12	2
32	PMN11-32	Table		1
33	F010434	Socket Set Screw	M12x60	4
34	PMN11-34	T-Type Key		2
35	PMN11-35	Connection Pin		2
36	PMN11-36	Right Fence		1
37	TS-2331101	Cap Nut	M10	2
38	PMN11-38	Fixing Pin		2
39	TS-0680041	Flat Washer	3/8	4
40	PMN11-40	Left Fence		1
41	PMN11-41	Lower Right Blade		1
42	PMN11-42	Lower Left Blade		1
43	PMN11-43	Right Scale		1
43-1	PMN11-43-1	Left Scale		1
	PMN11-AG	Angle Guide Assembly (#44-50)		1
44	PMN11-44	Knob	M6x10	1
45	TS-0680021	Flat Washer	1/4	1
46	PMN11-46	Guide Bar		1
47	PMN11-47	Angle Indicator		1
48	PMN11-48	Knob		1
49	TS-2284082	Mach Screw, Pan HD, Phillips	M4x8	1
50	PMN11-50	Flat Washer	M4	1
51	PMN11-51	Cover Plate		1
52	PMN11-52	Air Cylinder Cover		1
53	PMN11-53	Guard		1
54	TS-2244102	Socket HD Button Screw	M4X10	2
55	PMN11-55	Multipurpose Valve		1

Index No.	Part No.	Description	Size	Qty
56	TS-1541031	Hex Nut, Nylon Lock	M8	1
57	TS-1523021	Socket Set Screw	M6x8	1
58	PMN11-58	Hex Head Bolt	M8	1
59	PMN11-59	Hose Connector		1
60	PMN11-60	Hose Elbow Connector	90 deg	1
61		Hose A (RE: 63-1)	ø9 x Ø12 x 820 mm	1
62		Hose B (RE: 63-1)	ø9 x Ø12 x 620 mm	1
63		Hose C (RE: 63-1)	ø9 x Ø12 x 620 mm	1
63-1	PMN11-63-1	Hose *	ø9 x Ø12 ... (cut to length)	
65	PMN11-65	Foot Pedal Assembly		1
66	F001213	Mach Screw, Pan HD, Phillips	M5x40	2
67	PMN11-67	Noise Reducer		2
68	EMN9-90	Door Latch		1
69	TS-2361121	Lock Washer	M12	10
70	PMN11-70	Hose D	230MM	1
71	PMN11-71	Hose	3/8x1660MM	1
72	PMN11-72	PU Hose A	1985MM	1
73	PMN11-73	PU Hose B	2485MM	1
74	TS-1504021	Socket HD Cap Screw	M8x12	2
75	PMN11-75	Flat Washer	5/16x23x2	4
76	PMN11-76	Mach Screw, Pan HD, Phillips	5/16x1	2
77	PMN11-77	Shipping Bracket		2
78	TS-2245102	Socket HD Button Screw	M5X10	2
79	EMN9-17	Handle	M10	2
80	PMN11-80	Cabinet Door		1
81	PMN11-81	Foot Pedal Plate		1
82	PMN11-82	Post		1
83	PMN11-83	Plastic Grip		1
84	F001214	Mach Screw, Pan HD, Phillips	M6*8	2
85	PMN11-85	Emergency Stop Switch Box		1
86	PMN11-86	Emergency Stop Switch		1
87	TS-2246082	Socket HD Button Screw	M6x8	4
88	F001208	Mach Screw, Pan HD, Phillips	M5x8	2
89	PMN11-89	Hose	3/8x220MM	1
90	PMN11-90	PU Hose C	940MM	1
	JET-165	JET Logo (not shown)	165x68mm	1
	LM000225	ID Label, PMN-11 (not shown)		1
	LM000223	Warning Label (not shown)		1

* specify needed length when ordering

11.0 Pneumatic diagram for PMN-11 Notcher



Ref.	Description
1	Air drain valve switch
2	Condensate drain filter
3	Pressure reducer valve
4	Lubricator
5	Noise reducer
6	Foot control pedal with lock
7	Multipurpose valve
8	Air cylinder
9	Emergency stop

12.0 Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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