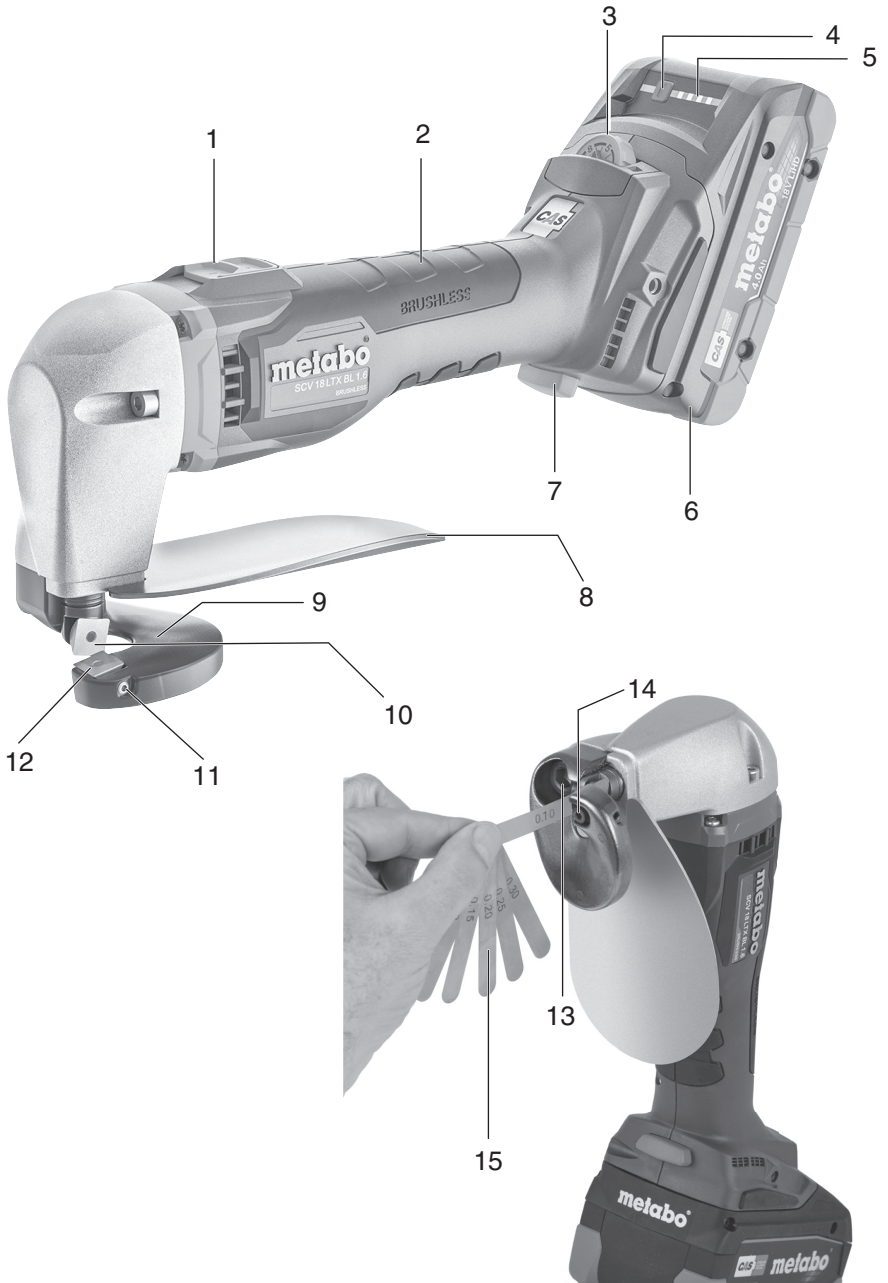




## SCV 18 LTX BL 1.6

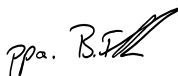


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		<b>SCV 18 LTX BL 1.6</b> *1) Serial Number: 01615	
<b>U</b>	<b>V</b>	18	
<b>B<sub>St</sub></b>	mm (in)	400 N/mm <sup>2</sup> 600 N/mm <sup>2</sup> 800 N/mm <sup>2</sup>	1,6 1,2 0,7
<b>B<sub>Al</sub></b>	mm (in)	250 N/mm <sup>2</sup>	2,0
<b>h<sub>0</sub></b>	min <sup>-1</sup> (spm)	1350 - 4840	
<b>h<sub>1</sub></b>	min <sup>-1</sup> (spm)	1240 - 4450	
<b>r<sub>min</sub></b>	mm (in)	15 ( <sup>19</sup> / <sub>32</sub> "	
<b>m</b>	kg (lbs)	1,33 (2.9)	
<b>a<sub>h</sub>/K</b>	m/s <sup>2</sup>	7,6 / 1,5	
<b>L<sub>pA</sub>/K<sub>pA</sub></b>	dB(A)	74 / 3	
<b>L<sub>WA</sub>/K<sub>WA</sub></b>	dB(A)	85 / 3	


\*2) 2014/30/EU,2006/42/EC, 2011/65/EU  
\*3) EN 62841-1:2015,EN 62841-2-8:2016, EN IEC 63000:2018

ppa. 

2021-06-18, Bernd Fleischmann  
Direktor Produktentstehung & Qualität (Vice President Product Engineering & Quality)  
\*4) Metabowerke GmbH - Metabo-Allee 1 - 72622 Nuertingen, Germany

# Original instructions

## 1. Conformity Declaration

We, being solely responsible, hereby declare that these cordless curve shears, identified by type and serial number \*1), meets all relevant requirements of directives \*2) and standards \*3). Technical documentation at \*4).

### For UK only:

**UK** We as manufacturer and authorized person to  
**CA** compile the technical file, see \*4) on page 3, hereby declare under sole responsibility that these cordless curve shears, identified by type and serial number \*1) on page 3, fulfill all relevant provisions of following UK Regulations S.I. 2016/1091, S.I. 2008/1597, S.I. 2012/3032 and Designated Standards EN 62841-1:2015, EN 62841-2-8:2016, EN IEC 63000:2018.

## 2. Specified Use

The machine is designed for cutting through and trimming flat workpieces made from steel, aluminium, and cuttable plastics. It is suited for curved and straight cuts without material loss.

The user bears sole responsibility for any damage caused by inappropriate use.

Generally accepted accident prevention regulations and the enclosed safety information must be observed.

Any other use is considered to be not as specified and not allowed. The manufacturer assumes no liability for any damage caused by unspecified use.

Modification of the machine or use of parts not approved by the manufacturer can cause unforeseeable damage!

## 3. General Safety Instructions



For your own protection and for the protection of your electrical tool, pay attention to all parts of the text that are marked with this symbol!



**WARNING** – Reading the operating instructions will reduce the risk of injury.



**WARNING** – Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

**Save all warnings and instructions for future reference.** Pass on your electrical tool only together with these documents.

## 4. Special Safety Instructions

Remove the battery pack from the machine before any adjustments, conversions or servicing are performed.

Before fitting the battery pack, make sure that the machine is switched off.



Protect battery packs from water and moisture!



Do not expose battery packs to naked flame!



Do not use faulty or deformed battery packs!

Do not open battery packs!

Do not touch or short-circuit battery packs!



Slightly acidic, flammable fluid may leak from defective li-ion battery packs!



If battery fluid leaks out and comes into contact with your skin, rinse immediately with plenty of water. If battery fluid leaks out and comes into contact with your eyes, wash them with clean water and seek medical attention immediately.

Remove chips and similar material only when the machine is at a standstill.

Secure the workpiece to prevent slipping or rotation (e.g. by securing with screw clamps).

Always wear protective goggles, gloves, and sturdy shoes when working with this tool.

Keep hands away from the cutting area.

Always switch on the machine before offering up to the workpiece.

Always work with the chip deflector (8) attached.

### Transport of li-ion battery packs:

The shipping of li-ion battery pack is subject to laws related to the carriage of hazardous goods (UN 3480 and UN 3481). Inform yourself of the currently valid specifications when shipping li-ion battery packs. If necessary, consult your freight forwarder. Certified packaging is available from Metabo.

Only send the battery pack if the housing is intact and no fluid is leaking. Remove the battery pack from the machine for sending. Prevent the contacts from short-circuiting (e.g. by protecting them with adhesive tape).

If the machine is defective, remove the battery pack from the machine.

## 5. Overview


See page 2.


- 1 Slide switch
- 2 Handle
- 3 Thumbwheel for adjusting the speed
- 4 Button for capacity and signal indicator
- 5 Capacity and signal indicator
- 6 Battery pack\*
- 7 Battery pack release button
- 8 Chip deflector
- 9 Cutting base
- 10 Top blade
- 11 Adjustment screw

- 12 Bottom blade
- 13 Fixing screw top blade
- 14 Fixing screw bottom blade
- 15 Feeler gauge

\* not in scope of delivery


## 6. Commissioning

 Before plugging in, check to see that the rated mains voltage and mains frequency, as stated on the rating label, match your power supply.

 Australia: Always use a residual current device (RCD) protected supply with a rated residual current of 30 mA or less.

## 7. Use


### 7.1 Adjusting the Distance Between the Blades

 **The correct distance:**

The blade distance is set to a sheet thickness of 1 mm on delivery of the machine. Check the distance of the blades using the feeler gauge (15) (see P. 2). To obtain optimal cutting results, set the following values:

Sheet thickness in mm = blade distance in mm

0.3 - 0.6 mm	= 0.1 mm
0.7 - 1.2mm	= 0.2 mm
1.3 - 1.6 mm	= 0.3 mm

 The blades should not move.

#### Adjusting the distance:

- Tap the on/off switch several times until the top blade has reached the lower dead centre.
- Remove the battery pack
- Loosen the bottom blade (12).
- Set the blade with the adjustment screw (11) using the enclosed Allen key 3 mm to the required distance.
- Retighten the blade
- Lightly tighten the adjustment screw using the enclosed Allen key 3 mm.
- Check the distance with the feeler gauge (15).

### 7.2 Switching on and off

#### Switching on:

Push the sliding switch (1) forwards until it latches into position.

#### Switching off:

Push the sliding switch (1) backwards until it latches into position.

#### Working With the Machine

- Always switch on the machine before offering up to the workpiece.
- Hold the power tool at an angle of 80 to 90° to the sheet surface and do not jam it on the side.
- Uniformly guide the power tool in direction of

cutting while pushing it slightly. Excessive feed significantly reduces the tool life of the accessories.

- Do not cut sheets at welded points.
- Do not cut sheets of several layers, which exceed the maximum workpiece thickness.
- To increase the tool life of the blades we recommend to apply a lubricant along the planned cutting line:
  - for cuts in sheet steel: cutting paste or cutting oil
  - for cuts in aluminium: petroleum
- Switch off the power tool only after you have pulled it out of the cutting path.
- Cutting at the edge in overhead position. The cutting base (9) points upwards.
- Set the desired speed using the thumbwheel (3).
- When cutting radii, do not jam the machine and work only with little feed.

Note:


- Depending on the sheet thickness or tensile strength of the workpiece, two different blade types can be selected for the processing.
- Standard blade for sheets with a tensile strength  $\leq 400 \text{ N/mm}^2$  do not have any special marking. Chromium steel blades are marked with "Cr"\*
- For these reasons we recommend tools only according to the details in the table:


Aluminium	
250 N/mm <sup>2</sup>	= 0.3 - 2.0 = Standard
Construction steel	
400 N/mm <sup>2</sup>	= 0.3 - 1.6 = Standard
Stainless steel	
600 N/mm <sup>2</sup>	= 0.3 - 1.2 = Cr
Stainless steel	
800 N/mm <sup>2</sup>	= 0.3 - 1.0 = Cr

\* not in scope of delivery

## 8. Maintenance

### 8.1 The blade is characterized by the following points:

- The blades have four sharp cutting edges. If one edge becomes blunt, rotate the blades 90° to use the next sharp edge. The sign for blades is a significantly increased necessary feed force with slower work progress.
- Top blade and bottom blade have the same shape and are interchangeable (top or bottom).
-  The blades are not designed to be sharpened. Replace the blades when all four cutting edges are blunt.

 Never work with blunt blades!

#### Top blade:

- Remove the screw (13) using the enclosed Allen key 2 mm.
- Remove the blade (10), rotate 90° and insert again (so that the one cutting edge rests against the angled face of the ram).

## en ENGLISH

- Re-tighten the screw (13) with enclosed Allen key 2 mm.

### Bottom blade:

- Unscrew the screw (14).
- Remove the blade (12) with enclosed Allen key 2 mm, rotate 90° and insert again.
- Adjust the distance between the blades and secure the blade (12) again enclosed Allen key 2 mm

## 9. Troubleshooting

### Restart protection

The machine does not start, although it is switched on. Restart protection is active. The machine will not start if the battery pack is inserted while the machine is on. Switch the machine off and back on again.

### Overload protection

Electronic overload protection with integral temperature monitor protects the machine and the battery pack. If the temperature at the motor or electronics is too high, the tool will switch off. Leave the tool to cool down. Once the machine runs again, let the machine run idle so that it cools down faster.

## 10. Accessories

Use only original Metabo or CAS (Cordless Alliance System) battery packs and accessories.

Use only accessories that fulfil the requirements and specifications listed in these operating instructions.

Battery packs with different capacities:


Best.-Nr.: ..... 625596000 2,0 Ah (LiHD)  
Best.-Nr.: ..... 625367000 4,0 Ah (LiHD)  
etc.

Chargers:

Best.-Nr.: 627044000 ASC 55  
Best.-Nr.: 627378000 ASC 145  
etc.

For a complete range of accessories, see [www.metabo.com](http://www.metabo.com) or the main catalogue.

## 11. Repairs

 Repairs to electrical tools must be carried out by qualified electricians ONLY!

If you have Metabo electrical tools that require repairs, please contact your Metabo service centre. For addresses see [www.metabo.com](http://www.metabo.com).

You can download spare parts lists from [www.metabo.com](http://www.metabo.com).

## 12. Environmental Protection

The sanding dust generated may contain hazardous materials: do not dispose of with the

household waste, but at a special collection point for hazardous waste.

Observe national regulations on environmentally compatible disposal and on the recycling of disused machines, packaging and accessories.



Only for EU countries: Never dispose of power tools in your household waste! In accordance with European Guideline 2012/19/EU on used electronic and electric equipment and its implementation in national legal systems, used power tools must be collected separately and handed in for environmentally compatible recycling.

## 13. Technical Specifications

Explanatory notes on the specifications on page 3. Changes due to technological progress reserved.

U = Voltage of battery pack  
B<sub>St</sub> = Maximum sheet thickness (sheet steel)  
B<sub>Al</sub> = Maximum sheet thickness (aluminium)  
h<sub>0</sub> = Stroke rate at idle speed  
h<sub>1</sub> = Stroke rate at rated load  
r<sub>min</sub> = Smallest curve radius  
m = Weight without mains cable

Measured values determined in conformity with EN 62841.

Permitted ambient temperature during operation: -20 °C (-4°F) to 50 °C (120°F) (limited performance with temperatures below 0 °C (32°F)). Permitted ambient temperature for storage: 0 °C (32°F) to 30 °C (86°F).

=== Direct current (cordless machines)

The technical specifications quoted are subject to tolerances (in compliance with the relevant valid standards).



### Emission values

These values make it possible to assess the emissions from the power tool and to compare different power tools. Depending on the operating conditions, the condition of the power tool or the accessories, the actual load may be higher or lower. For assessment purposes, please allow for breaks and periods when the load is lower. Based on the adjusted estimates, arrange protective measures for the user e.g. organisational measures.

Vibration total value (vector sum of three directions) determined in accordance with EN 62841:

a<sub>h</sub> = Typical estimated acceleration in the hand/arm area (cutting sheet metal)

K<sub>h</sub> = Uncertainty (vibration)

Typical A-effective perceived sound levels:

L<sub>pA</sub> = Sound pressure level

L<sub>WA</sub> = Acoustic power level

K<sub>pA</sub>, K<sub>WA</sub> = Uncertainty

During operation the noise level can exceed 80 dB(A).



### Wear ear protectors!