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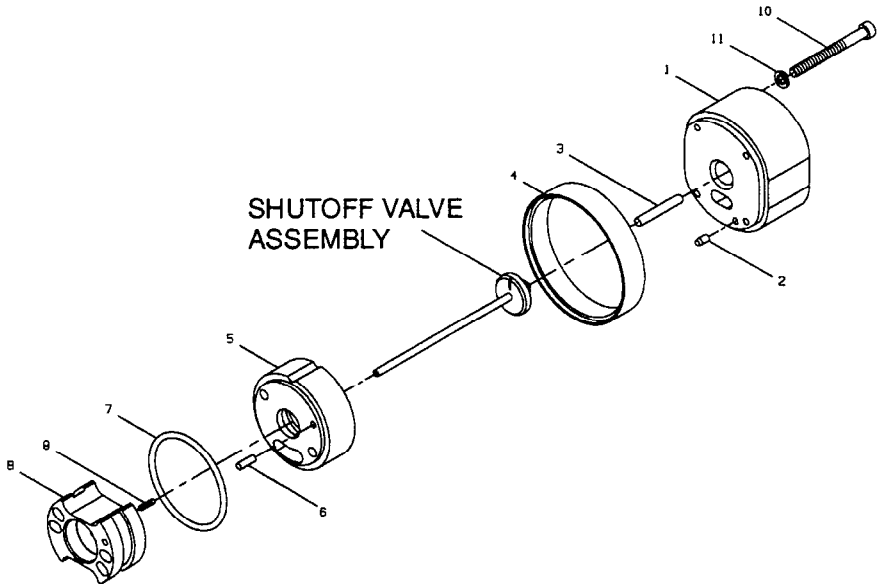
Form P7104
Edition 2
August, 1993

DAM–K25 BACKCAP KIT
for
SERIES DAA TORQUE CONTROL WRENCHES
(use this form in conjunction with Form P6976 or P7055)



(Dwg. TPC600–1)

PART NUMBER FOR ORDERING

		Backcap Kit	DAM–K25
		Backcap Assembly	DAM–A25
	1	Backcap	DAM–25
	2	Backcap Alignment Pin	7RL–56
	3	Valve Stop Pin	ST700–363–R
	4	Backcap Spacer	DAM–87
		Manifold Assembly	DAM–A86
	5	Manifold	DAM–86
	6	Manifold Alignment Pin	9DF5846–667
	7	Manifold Seal	WFS182–211
	8	Bearing Housing	DAM–203
+	9	Bearing Housing Plug	400–25–74–12
	10	Backcap Mounting Screw (4)	DAA40–68
	11	Mounting Screw Lock Washer (4)	DAA40–58

+ This Plug is only inserted into the Bearing Housing when the tool is NOT an automatic shutoff model. Models with an automatic shutoff will have the pushrod of the Shutoff Valve Assembly (Part No. DAA40–A435) passing through the Plug opening.

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PROFESSIONAL TOOLS

INSTALLATION OF THE BACKCAP KIT

1. Move the Adjustable Grip to the lowest position on the Handle.
2. Using a 2–1/2 mm hex wrench, unscrew and remove the four Handle Mounting Screws and Mounting Screw Lock Washers.
3. Pull the assembled motor away from the Handle.
4. Remove the Shutoff Valve Assembly, Reverse Valve and two Seals, Motor Clamp Spacer, Motor Clamp Seal and Rear Rotor Bearing Housing from the Motor Housing.
5. **For shutoff models**, remove or do not install the Bearing Housing Plug (9) in the threaded central opening of the Bearing Housing (8).
   For non–shutoff models, thread the Bearing Housing Plug (9) into the threaded central opening of the Bearing Housing (8).
6. Insert the two Rotor Bearing Springs into the central opening of the Bearing Housing and while holding the Motor Housing horizontal, slide the Bearing Housing, Bearing Springs leading, into the Housing. Make certain the Cylinder Dowel enters the hole in the Bearing Housing.
7. Install the Manifold Seal (7) on the small hub of the Manifold (5).
8. Slide the Manifold Assembly into the Housing making certain that the Manifold Alignment Pin (6) enters the hole in the Bearing Housing and the groove along the exterior of the manifold body engages the pin in the Housing.
9. **For shutoff models,** insert the shaft of the Shutoff Valve Assembly through the central opening of the Manifold and Bearing Housing.
10. Place the Backcap Spacer (4) on the Manifold and position the assembled Backcap (1), Alignment Pin (2) first, against the Spacer. Make certain the Pin enters the alignment hole in the Manifold.
11. Install the four Backcap Mounting Screws and Lock Washers and tighten the screws between 12 and 18 in–lb (1.4 and 2.0 Nm) torque.

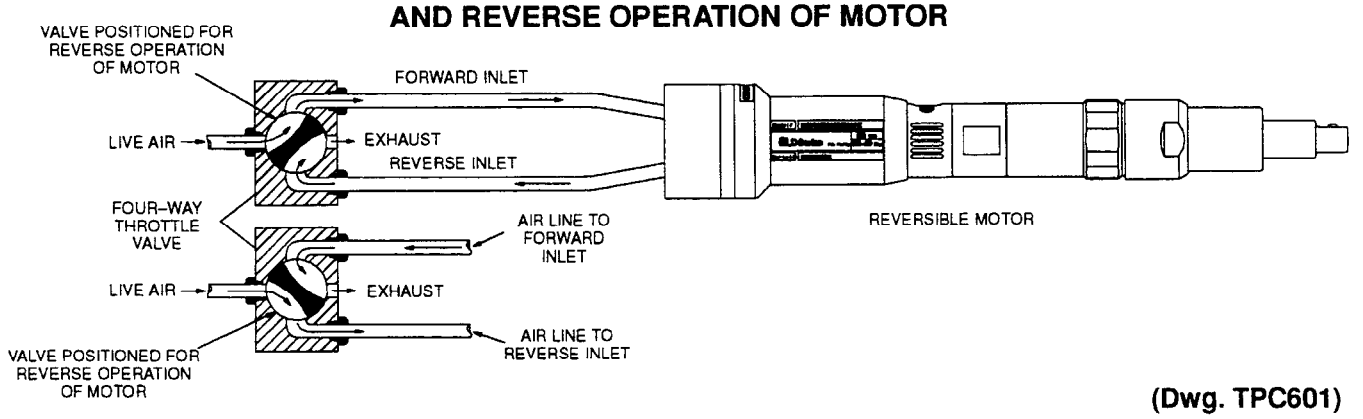
EXHAUST NOISE

Removing the Handle Assembly to install a Backcap eliminates all the noise suppression equipment located inside the Handle. To reduce exhaust noise to acceptable levels without reducing torque output, install one or two external Mufflers (Part No. MRV015–AC980). If the application requires the tool to operate in the forward and reverse modes, install one Muffler in the exhaust port, designated by the letter "E" and located at the rear of the Backcap. If the application requires the tool to operate only in direction, install one Muffler in the exhaust port and a second Muffler in the directional port ("F"–forward; "R"–reverse) that is not being used in the application.

CONTROL VALVE

For optimum performance, the air source and supply lines must be capable of maintaining 90 psig (6.2 bar/620 kPa) air pressure at the tool. A 3/8" (10 mm) diameter or larger hose is necessary for ample air flow to each tool.
When operating the tool in the reversible mode, it is necessary to put a four way valve in the air supply line because the reverse air inlet port becomes an auxiliary port when the tool operates in forward rotation. In reverse, the forward inlet becomes the auxiliary exhaust port.
A diagrammed example is shown in Drawing TPC601.

FOUR WAY VALVE FOR CONTROLLING FORWARD AND REVERSE OPERATION OF MOTOR



(Dwg. TPC601)