



# INSTRUCTIONS FOR NO. 3 SERIES TORQUE CONTROL ANGLE NUTRUNNERS

## OPERATION

These tools are automatic torque control tools. The air motor starts when the operating lever is depressed, and stops automatically when the applied load is tightened to a pre-set torque. (Note: Hold operating lever fully on to give proper tool operation.) After the tool has shut off it will be necessary to release the operating lever to reset the tool for the next cycle.

The torque is varied by placing the adjusting wrench (No. 53126) with the pin through the opening in the side of the angle attachment. Turn the output spindle square with a suitable wrench until the pin of the adjusting wrench falls into the slot of the adjusting nut on the torque control clutch. Turn the spindle clockwise to increase and counterclockwise to decrease torque.

To reverse the tool, turn the reversing ring fully counterclockwise against the stop. The tool has no clutch action in reverse but is a stall drive.

If the tool stalls in the forward direction the torque setting should be decreased.

## AIR SUPPLY

The efficiency of this tool depends on the proper supply of clean, dry, lubricated air at about 90 p.s.i. The use of a line filter, pressure regulator, and lubricator will insure maximum output and service of this tool.

Before connecting the tool, blow the air line to remove water & dirt which may have accumulated. This is especially important for a new line or when the line has not been used for some time.

## HOSE CONNECTIONS

Supply hose should not be less than 3/8" I.D. If extension hose is used, use next larger size hose. Use couplings and fittings with at least 9/32" I.D.

## LUBRICATION

### GEARS

The gearing is lubricated with Sioux #1232A grease in the following quantities: double reduction gear case—1/2 oz.; single reduction gear case—1/4 oz.; angle gearing—1/8 oz.

Replace the grease if necessary after 100 hours of operation.

### AIR MOTOR

An air line lubricator, set to deliver 1 to 2 drops per minute, is recommended. If a lubricator is not used, remove the plug from the handle and fill the chamber with oil. Refill every four hours of operation. Sioux #288 air motor oil, which contains a moisture absorbent and rust preventative, is recommended.

### CLUTCH

Lubricate all moving parts with light weight oil every 40 hours of operation.

## MAINTENANCE

Remove the air hose and look at the screen inside the air fitting in the tool. Remove and clean the screen if necessary. Add grease to the gear case and angle gearing as required through their grease fittings. Remove the clutch, lubricate with light oil, and replace clutch.

# SIoux TOOLS INC.

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