



## INSTRUCTIONS AND PARTS LIST FOR NO. 2 1/2 SERIES 90 DEGREE ANGLE DRILL

### BE SURE TO LUBRICATE

All Sioux Air Tools are manufactured to extremely close tolerances. Reasonable care and preventative maintenance will greatly prolong their service life.

This line of tools is designed for a long life of continuous duty on assembly lines, with a minimum of service and maintenance. Rotating parts are mounted on extra-capacity ball bearings, rotors and spindles are finished to extreme accuracy for power and low air consumption, gears and pinions are oversize and correctly hardened for quietness and long life.

Special attention has been given to ease of servicing. These tools can be disassembled and reassembled with ease.

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

### LUBRICATION

#### GEARS

The gears are lubricated at the factory. Every 100 hours of operation add 1/4 oz. of Sioux Grease No. 1198.

#### AIR MOTORS

Sioux Air line lubricators are recommended. When used adjust lubricator to deliver 2 to 4 drops of Sioux Air Motor Oil No. 288 per minute to the air tool. If tool is not used with a lubricator, place 10 to 15 drops of Sioux No. 288 oil into air inlet twice daily.

### OPERATION

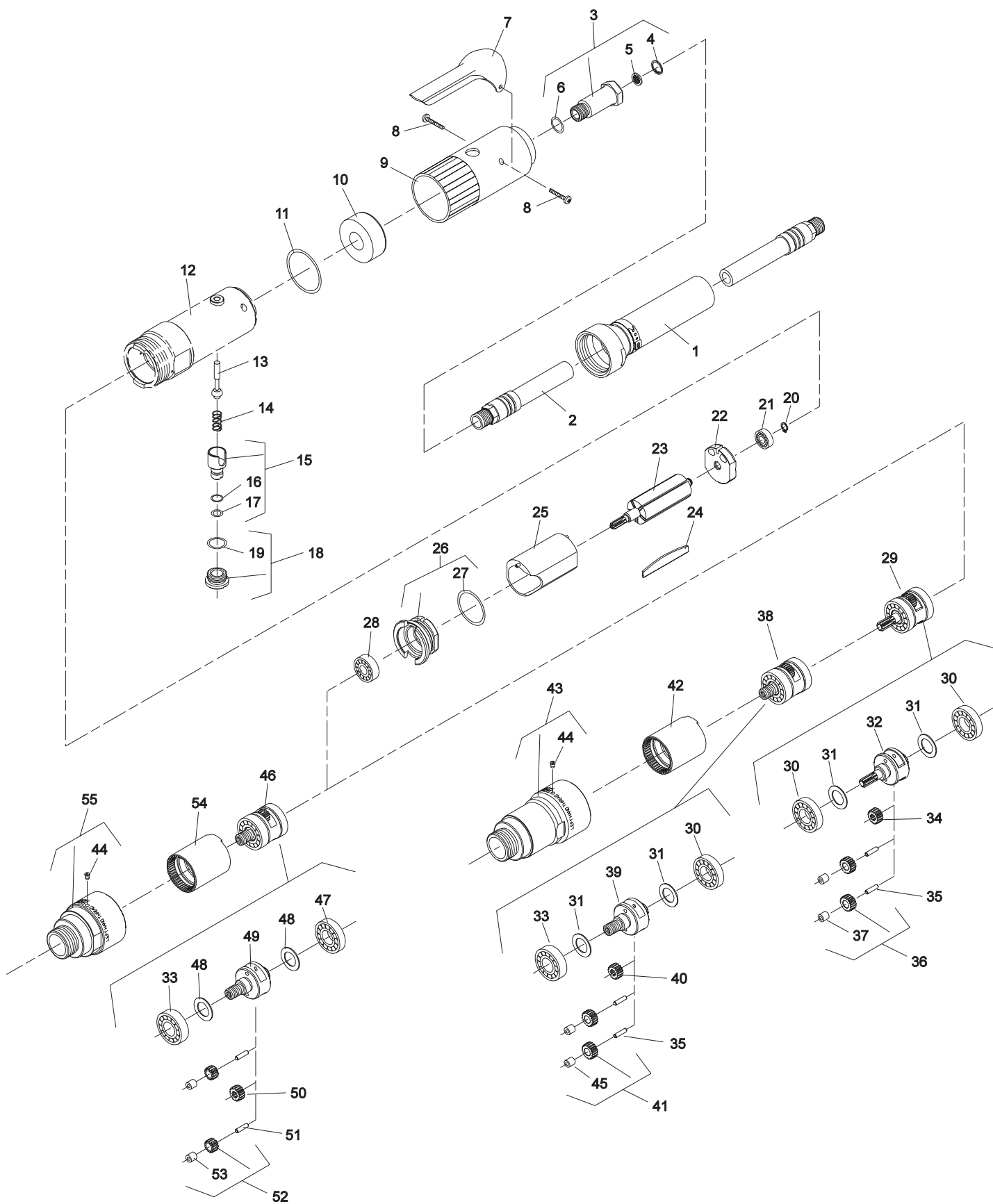
The air motor is started by depressing the operating lever or trigger. Motor speed may be controlled by adjusting the slotted head control which is located on the tool housing or on some models on the trigger surface.

If the tool is equipped with reversing button, always depress the button fully to obtain maximum power.

### HOSE AND HOSE CONNECTION

Air supply hose should not be less than 3/8" I.D. If extension hose is necessary, use 1/2" I.D. hose with couplings not less than 3/8" I.D.

**SIoux™**  
**TOOLS INC.**



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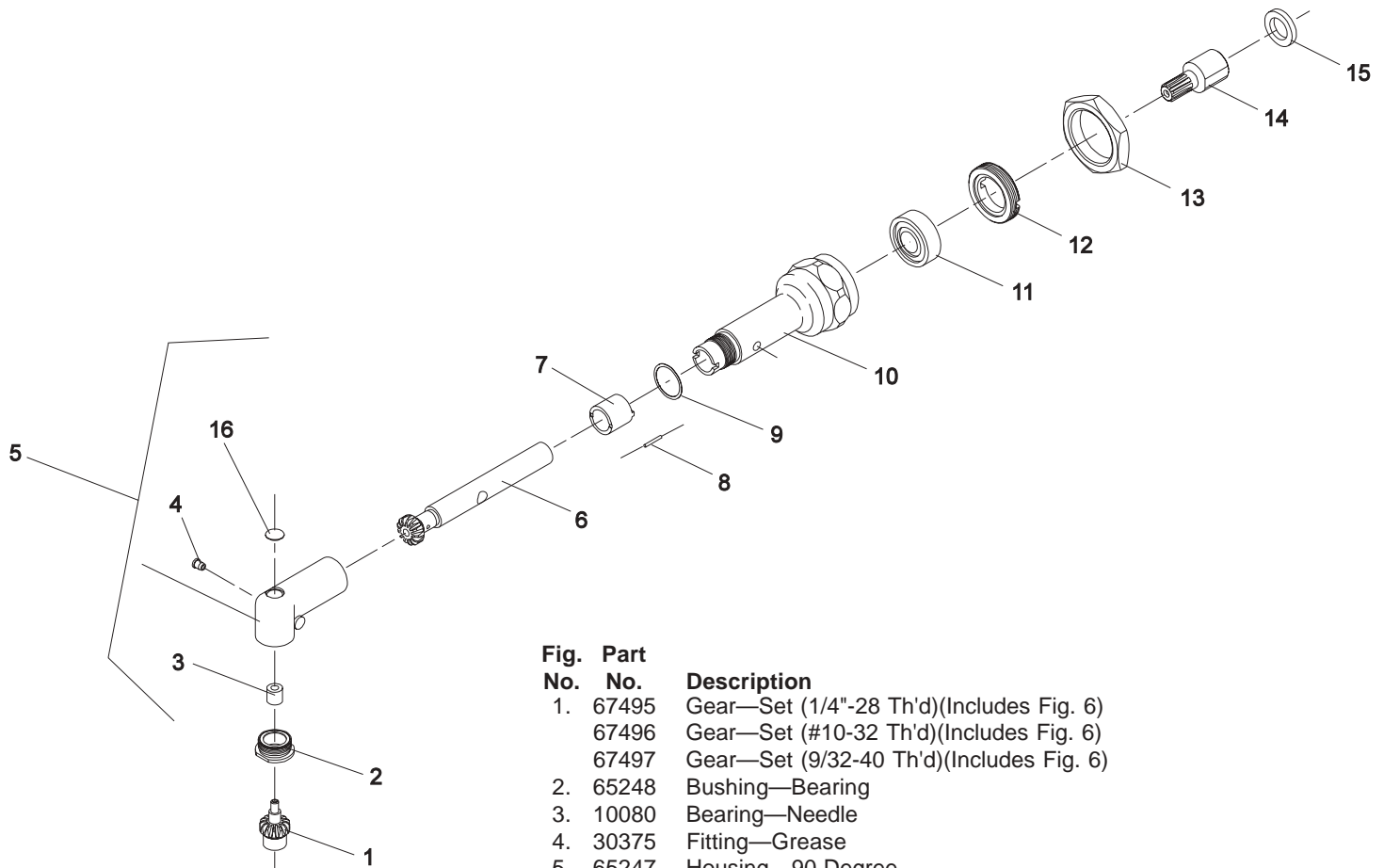
Fig. No.	Part No.	Name		Fig- no.	Part No.	Name
1.	63355	Ass'y—Hose Exhaust	Remote Exhaust		64159	Carrier—Gear (900 RPM)
2.	1317	Hose—Leader			22702	Carrier—Gear (1600 RPM)
3.	54837	Adaptor—Intake		33.	10228	Bearing—Ball
4.	21541	Ring—Retaining		34.	19267	Gear—Pinion (900, 1600 RPM)
5.	30463	Screen		35.	30062	Pin (4)*
6.	14312	Ring—"O"		36.	19314	Ass'y—Gear & Bearing (540 RPM)(2)*
7.	35737	Lever			19331	Ass'y—Gear & Bushing (900, 1600 RPM)(2)*
8.	65499	Screw—Pan Hd (Selftap) (#6—32 x 3/4 Long)(2)*		37.	10040	Bearing—Needle (2)*
9.	04042	Cover—Housing		38.	63379	Ass'y—Planetary Reduction (540, 900 RPM)
10.	40116	Material—Exhaust			63383B	Ass'y—Planetary Reduction (1600 RPM)
11.	14333	Ring—"O"		39.	64163	Carrier—Gear (540, 900 RPM)
12.	64036	Housing			64164	Carrier—Gear (1600 RPM)
13.	63241	Ass'y—Valve		40.	19267	Gear—Pinion (1600 RPM)
14.	21427	Spring		41.	19314	Ass'y—Gear & Bearing (540, 900 RPM)(2)*
15.	54843	Speed—Control			19331B	Ass'y—Gear & Bushing (1600 RPM)(2)*
16.	14394	Ring—"O"		42.	19266	Gear—Ring
17.	14291	Ring—"O"		43.	65145	Case—Gear
18.	54844	Retainer—Speed Control		44.	30375	Fitting—Grease
19.	14309	Ring—"O"		45.	10040	Bearing—Needle (540, 900RPM)(2)*
20.	21491	Ring—Retaining			10515	Bushing (1600RPM)(2)*
21.	10230	Bearing—Ball		46.	63390	Ass'y—Planetary Reduction (2600 RPM)
22.	10552	End Plate—Rear			63379	Ass'y—Planetary Reduction (3350 RPM)
23.	54860	Rotor (6 Tooth)(900, 1600, 2600, 5800 RPM)			63383	Ass'y—Planetary Reduction (5800 RPM)
	54861	Rotor (8 Tooth)(540, 3350 RPM)		47.	10203	Bearing—Ball
24.	63192	Ass'y—Rotor Vane (Set of 5)		48.	25439	Washer (2)*
25.	64057	Cylinder		49.	22699	Carrier—Gear (2600 RPM)
26.	13550	End Plate—Front			64163	Carrier—Gear (3350 RPM)
27.	14342	Ring—"O"			64164	Carrier—Gear (5800 RPM)
28.	10220	Bearing—Ball		50.	19267	Gear—Pinion (5800 RPM)
29.	63386	Ass'y—Planetary Reduction (540 RPM)		51.	30062	Pin (2)*
	63377	Ass'y—Planetary Reduction (900 RPM)		52.	19317	Ass'y—Gear and Bearing (2600 RPM)(2)*
	63392	Ass'y—Planetary Reduction (1600 RPM)			19314	Ass'y—Gear and Bearing (3350 RPM)(2)*
30.	10203	Bearing—Ball (3)*			19331	Ass'y—Gear and Bearing (5800 RPM)(2)*
31.	25439	Washer (4)*		53.	10040	Bearing—Needle (2)*
32.	64160	Carrier—Gear (540 RPM)		54.	19266	Gear—Ring
				55.	65144	Case—Gear

\*Order Quantity As Needed

**FURNISH CATALOG, SERIAL, AND MODEL NUMBER  
WHEN ORDERING PARTS**



## PARTS LIST FOR 90 DEGREE ANGLE HEAD ASSEMBLY



**Fig. Part  
No. No.**

No.	Description
1. 67495	Gear—Set (1/4"-28 Th'd)(Includes Fig. 6)
67496	Gear—Set (#10-32 Th'd)(Includes Fig. 6)
67497	Gear—Set (9/32-40 Th'd)(Includes Fig. 6)
2. 65248	Bushing—Bearing
3. 10080	Bearing—Needle
4. 30375	Fitting—Grease
5. 65247	Housing—90 Degree
6.	Pinion (Not available individually, refer to Fig. 1 for proper gear set)
7. 65245	Retainer—Bearing
8. 65246	Pin (Set of 22)
9. 65240	Shim—.003"
65241	Shim—.004"
65242	Shim—.005"
10. 65244	Housing—Angle Drill
11. 10257	Bearing—Ball
12. 65243	Nut—Retaining
13. 65143	Nut—Jam
14. 65146	Adaptor—Spindle
15. 44122	Spacer
16. 65407	Plug—Expansion

Order Quantity  
As Needed

65214	Assembly—Complete (1/4-28 Th'd) (Includes Figs. 1-12)
65266	Assembly—Complete (#10-32 Th'd) (Includes Figs. 1-12)
65542	Assembly—Complete (9/32-40 Th'd) (Includes Figs. 1-12)

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