



# INSTRUCTIONS AND PARTS LIST FOR 2 1/2 SERIES "AP" TOOLS Serial B

## 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. 289.

### 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.

## 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.

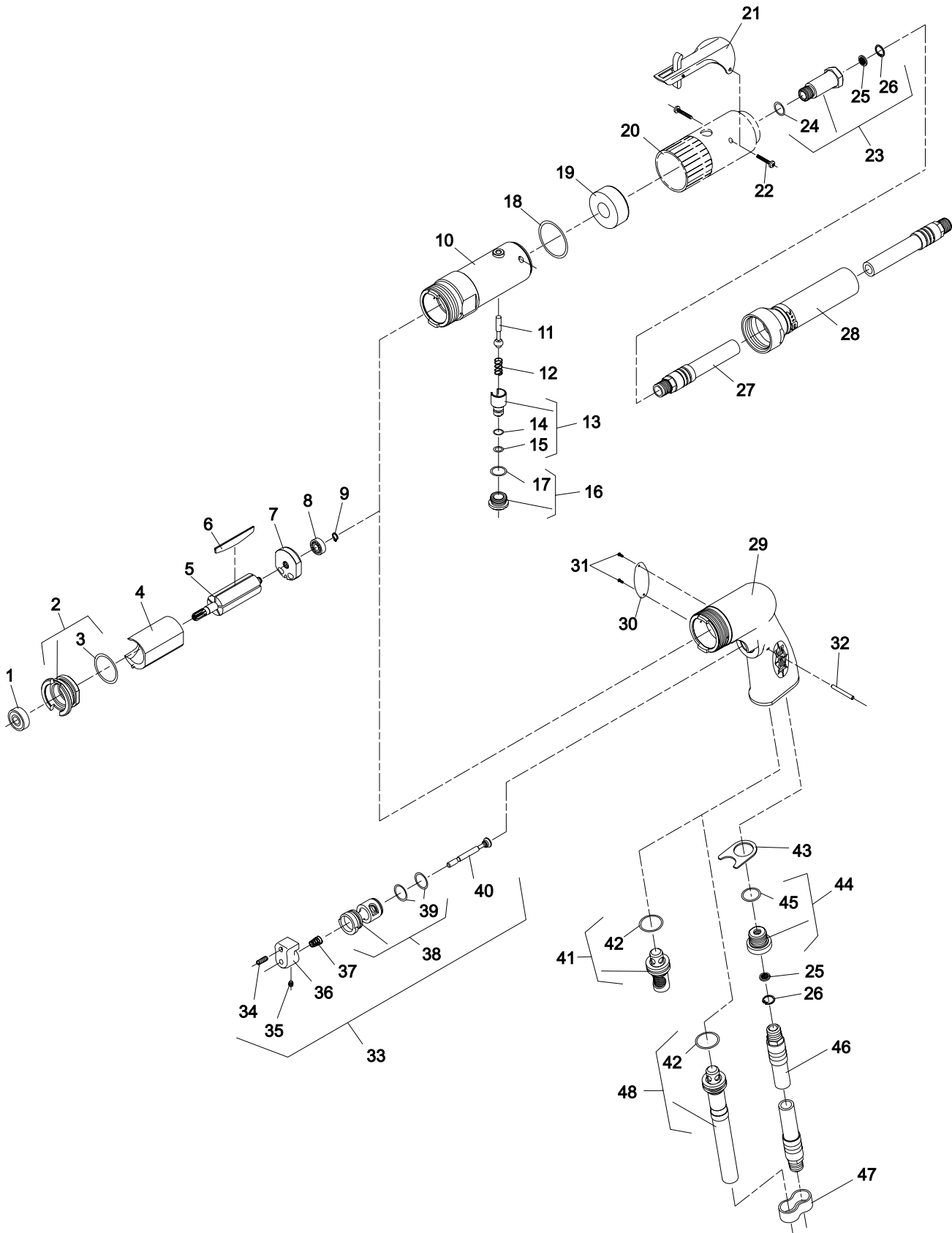
## SAFETY PRECAUTIONS

1. Keep Work Area Clean: Cluttered areas and benches invite accidents.
2. Wear Proper Apparel: No loose clothing or jewelry to get caught in moving parts.
3. Use Safety Glasses: Protect your eyes.
4. Secure Work: Use clamps or vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
5. Don't Overreach: Keep proper footing and balance at all times.
6. Maintain Tools With Care: Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
7. Disconnect Tools: When not in use, before servicing, or when changing accessories such as blades, bits and etc.
8. Remove Adjusting Key and Wrenches: Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
9. Caution: The use of an accessory with this tool not provided or specified by SIOUX TOOLS INC. may be hazardous.

**SIOUX<sup>TM</sup>**  
**TOOLS INC.**



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Fig. No.	Part No.	Name	Fig. No.	Part No.	Name
1.	10220	Bearing—Ball	24.	14312	Ring—"O"
2.	13550	End Plate—Front	25.	30463	Screen
3.	14342	Ring—"O"	26.	21541	Ring—Retaining
4.	64057	Cylinder	27.	63355	Ass'y—Hose Exhaust
5.	54860	Rotor (900, 1600, 2600, 5800RPM)	28.	1317	Hose—Leader
	54861	Rotor (540, 3350RPM)	29.	12660	Housing
6.	63192	Ass'y—Rotor Vane (Set of 5)	30.	65359	Name Plate
7.	10552	End Plate—Rear	31.	09953	Screw—Drive (2 x 3/16)(2)*
8.	10230	Bearing—Ball	32.	40157	Pin—Dowel (1/8" x 1-1/8")
9.	21491	Ring—Retaining	33.	63359	Ass'y—Trigger (Non-Rev)
10.	64036	Housing	34.	06459	Screw—Set (#8-32 x 1/2")
11.	63241	Ass'y—Valve	35.	06458	Screw—Set (#8-32 x 3/16")
12.	21427	Spring	36.	12676	Trigger
13.	54843	Speed—Control	37.	21401	Spring
14.	14394	Ring—"O"	38.	11600	Body—Valve (Non-Rev)
15.	14291	Ring—"O"	39.	14378	Ring—"O" (2)*
16.	54844	Retainer—Speed Control	40.	54222	Valve
17.	14309	Ring—"O"	41.	63545	Ass'y—Silencer
18.	14313	Ring—"O"	42.	14366	Ring—"O"
19.	40116	Material—Exhaust	43.	54968	Retainer—Exhaust
20.	04042	Cover—Housing	44.	54955	Adaptor—Inlet
21.	63258	Lever	45.	14281	Ring—"O"
22.	65499	Screw—Pan Hd (Selftap) (#6-32 x 3/4 Long)(2)*	46.	1376	Ass'y—Leader Hose
23.	54837	Adaptor—Intake	47.	40153	Clip—Hose (3)
			48.	63546	Ass'y—Exhaust Tube

2362 Aux. Handle (Not Shown)

## Complete Assemblies:

- 63361 Ass'y—Pistol Handle (Non-Rev)  
(Includes Figs. 25, 26, 29-48)
- 63444 Ass'y—Lever Handle (Non-Rev)  
(Includes Figs. 10-28)

\*Order Quantity As Needed

Furnish Catalog, Serial and Model Number When Ordering Parts



# INSTRUCTIONS AND PARTS LIST FOR 2 1/2 SERIES "AP" TOOLS Serial B

## Double Reduction Gear Case 540, 900, 1600 RPM Units)

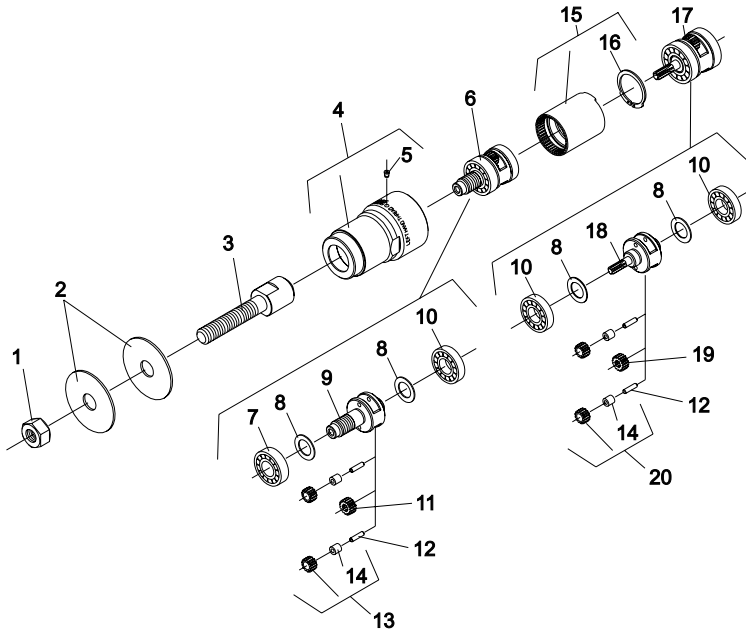


Fig. No.	Part No.	Name
1.	09622	Nut
2.	65497	Washer (2)*
3.	65881	Spindle—Adapter
4.	64003	Case—Gear
5.	30375	Fitting—Grease
6.	65884	Ass'y—Planetary Reduction (1600 RPM)
	63436	Ass'y—Planetary Reduction (540,900 RPM)
7.	10228	Bearing—Ball
8.	25439	Washer(2)*
9.	65883	Carrier—Gear(1600 RPM)
	22704	Carrier—Gear(540, 900RPM)
10.	10203	Bearing—Ball(3)*
11.	19267	Gear—Pinion(1600RPM)
12.	30062	Pin(4)*
13.	19314	Ass'y—Gear & Bearing(540, 900RPM)(2)*
	19331B	Ass'y—Gear & Bearing(1600RPM)(2)*
14.	10040	Bearing—Needle(4)*
15.	19266	Gear—Ring
16.	21510	Ring—Retaining
17.	63377	Ass'y—Planetary Reduction (900RPM)
	63386	Ass'y—Planetary Reduction (540RPM)
	63392	Ass'y—Planetary Reduction (1600RPM)
18.	22702	Carrier—Gear(1600RPM)
	64159	Carrier—Gear(900RPM)
	64160	Carrier—Gear(540RPM)
19.	19267	Gear—Pinion(900, 1600RPM)
20.	19314	Ass'y—Gear & Bearing(540RPM)(2)*
	19331	Ass'y—Gear & Bearing(900, 1600RPM)(2)*

## Single Reduction Gear Case (2600, 3350, 5800 RPM Units)

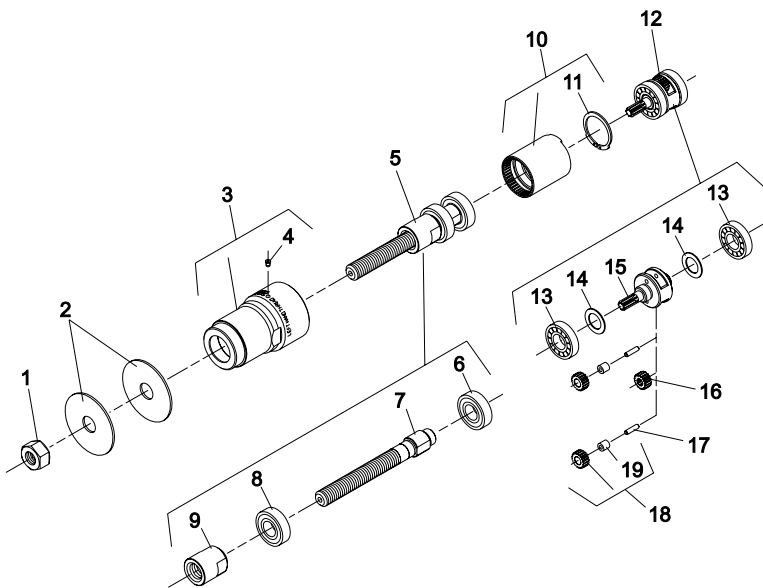


Fig. No.	Part No.	Name
1.	09622	Nut
2.	65497	Washer (2)*
3.	64003	Case—Gear
4.	30375	Fitting—Grease
5.	65887	Ass'y—Chuck Spindle
6.	10239	Bearing—Ball
7.	65846	Spindle—Chuck
8.	10929	Bearing—Ball
9.	65853	Nut—Spacer
10.	19266	Gear—Ring
11.	21510	Ring—Retaining
12.	63386	Ass'y—Planetary Reduction (3350RPM)
	63377	Ass'y—Planetary Reduction (5800RPM)
	63533	Ass'y—Planetary Reduction (2600RPM)
13.	10203	Bearing—Ball(2)*
14.	25439	Washer(2)*
15.	64101	Carrier—Gear (2600RPM)
	64159	Carrier—Gear(5800RPM)
	64160	Carrier—Gear(3350RPM)
16.	19267	Gear—Pinion(5800RPM)
17.	30062	Pin(2)*
18.	19314	Ass'y—Gear & Bearing(3350RPM)(2)*
	19317	Ass'y—Gear & Bearing(2600RPM)(2)*
	19331	Ass'y—Gear & Bearing(5800RPM)(2)*
19.	10040	Bearing—Needle(2)*

**SIoux<sup>TM</sup>**  
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