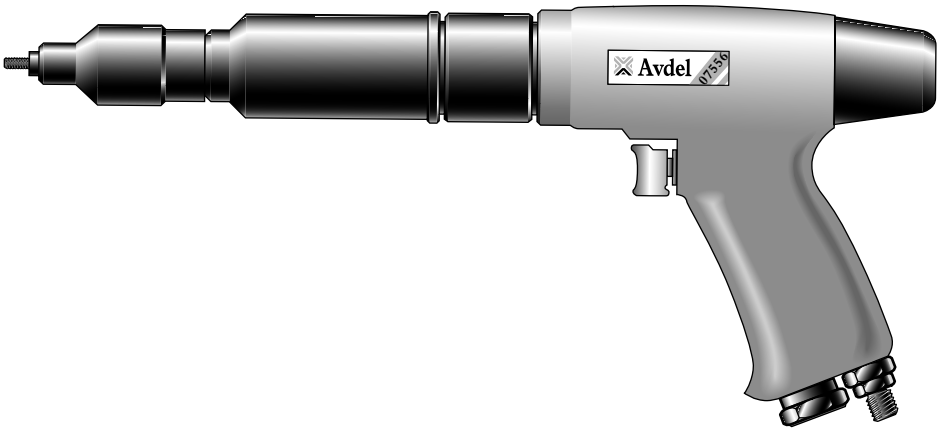
Avdel®

An Acument™ Global Technologies Company

Instruction Manual

Pass onto user to read and keep for reference



Threaded Insert Power Tool

07556

AVDEL policy is one of continuous development. Specifications shown in this document may be subject to changes which may be introduced after publication. For the latest information always consult Avdel.

SPECIFICATIONS FOR 07556 TOOL

AIR PRESSURE	Minimum - Maximum	**5 - 8 bar**	75 - 120 lbf/in^2
FREE AIR VOLUME REQUIRED	@ 5 bar / 75 lbf/in^2	**510 litres/min**	18 ft^3/min
MOTOR SPEED	@ 75 lb/in^2	**1000 RPM**	(clockwise)
CYCLE TIME	Approximately	**3 seconds**	
NOISE LEVEL		**80 dB(A)**	
WEIGHT	Without nose equipment	**1.76 kg**	3.9 lb
VIBRATION	Less than	**2.5 m/s^2**	8 ft/s^2

CONTENTS

SAFETY

This instruction manual must be read with particular attention to the following safety rules, by any person installing, operating or servicing this tool.

DO NOT USE OUTSIDE THE DESIGN INTENT.

DO NOT USE EQUIPMENT WITH THIS TOOL/MACHINE OTHER THAN THAT RECOMMENDED AND SUPPLIED BY AVDEL.

ANY MODIFICATION UNDERTAKEN BY THE CUSTOMER TO THE TOOL/MACHINE, NOSE ASSEMBLIES, ACCESSORIES OR ANY EQUIPMENT SUPPLIED BY AVDEL OR THEIR REPRESENTATIVES, SHALL BE THE CUSTOMER'S ENTIRE RESPONSIBILITY. AVDEL WILL BE PLEASED TO ADVISE UPON ANY PROPOSED MODIFICATION.

THE TOOL/MACHINE MUST BE MAINTAINED IN A SAFE WORKING CONDITION AT ALL TIMES AND EXAMINED AT REGULAR INTERVALS FOR DAMAGE AND FUNCTION BY TRAINED COMPETENT PERSONNEL. ANY DISMANTLING PROCEDURE SHALL BE UNDERTAKEN ONLY BY PERSONNEL TRAINED IN AVDEL PROCEDURES. DO NOT DISMANTLE THIS TOOL/MACHINE WITHOUT PRIOR REFERENCE TO THE MAINTENANCE INSTRUCTIONS. CONTACT AVDEL WITH YOUR TRAINING REQUIREMENTS.

THE TOOL/MACHINE SHALL AT ALL TIMES BE OPERATED IN ACCORDANCE WITH RELEVANT HEALTH AND SAFETY LEGISLATION. IN THE U.K. THE “HEALTH AND SAFETY AT WORK ETC. ACT 1974” APPLIES. ANY QUESTION REGARDING THE CORRECT OPERATION OF THE TOOL/MACHINE AND OPERATOR SAFETY SHOULD BE DIRECTED TO AVDEL.

THE PRECAUTIONS TO BE OBSERVED WHEN USING THIS TOOL/MACHINE MUST BE EXPLAINED BY THE CUSTOMER TO ALL OPERATORS.

ALWAYS DISCONNECT THE AIRLINE FROM THE TOOL/MACHINE INLET BEFORE ATTEMPTING TO ADJUST, FIT OR REMOVE A NOSE ASSEMBLY.

DO NOT OPERATE A TOOL/MACHINE THAT IS DIRECTED TOWARDS ANY PERSON(S).

ENSURE THAT VENT HOLES DO NOT BECOME BLOCKED OR COVERED AND THAT HOSES ARE ALWAYS IN GOOD CONDITION.

In addition to the general safety rules opposite, the following specific safety points must also be observed:

(!) THE OPERATING PRESSURE SHALL NOT EXCEED 8 BAR - 120 LBF/IN^2.

(!) DO NOT OPERATE THE TOOL WITHOUT FULL NOSE EQUIPMENT IN PLACE.

(!) WHEN USING THE TOOL, THE WEARING OF SAFETY GLASSES IS REQUIRED BOTH BY THE OPERATOR AND OTHERS IN THE VICINITY TO PROTECT AGAINST FASTENER PROJECTION, SHOULD A FASTENER BE PLACED 'IN AIR'. WE RECOMMEND WEARING GLOVES IF THERE ARE SHARP EDGES OR CORNERS ON THE APPLICATION.

(!) TAKE CARE TO AVOID ENTANGLEMENT OF LOOSE CLOTHES, TIES, LONG HAIR, CLEANING RAGS ETC. IN THE MOVING PARTS OF THE TOOL WHICH SHOULD BE KEPT DRY AND CLEAN FOR BEST POSSIBLE GRIP.

(!) WHEN CARRYING THE TOOL FROM PLACE TO PLACE KEEP HANDS AWAY FROM THE TRIGGER/LEVER TO AVOID INADVERTENT START UP.

(!) ALWAYS ADOPT A FIRM FOOTING OR A STABLE POSITION BEFORE OPERATING THE TOOL AND BE AWARE OF A TORQUE REACTION ON THE HANDS WHEN THE TOOL IS OPERATING, PARTICULARLY DURING THE REVERSING SEQUENCE. GRIP THE TOOL FIRMLY TO BE ABLE TO COUNTER THE TORQUE REACTION, BUT NOT TOO TIGHTLY.

(!) KEEP HANDS AWAY FROM THE ROTATING DRIVE SCREW AND THE NOSE END OF THE TOOL. IF A FASTENER BECOMES JAMMED ON THE DRIVE SCREW, SHUT OFF THE AIR SUPPLY AND DRAIN THE SUPPLY LINE TO THE TOOL BEFORE ATTEMPTING TO DISLODGE IT.

(!) THE TOOL IS NOT ELECTRICALLY INSULATED.

(!) THIS TOOL IS NOT DESIGNED FOR USE IN COMBUSTIBLE OR EXPLOSIVE ATMOSPHERES.

NTENT OF USE

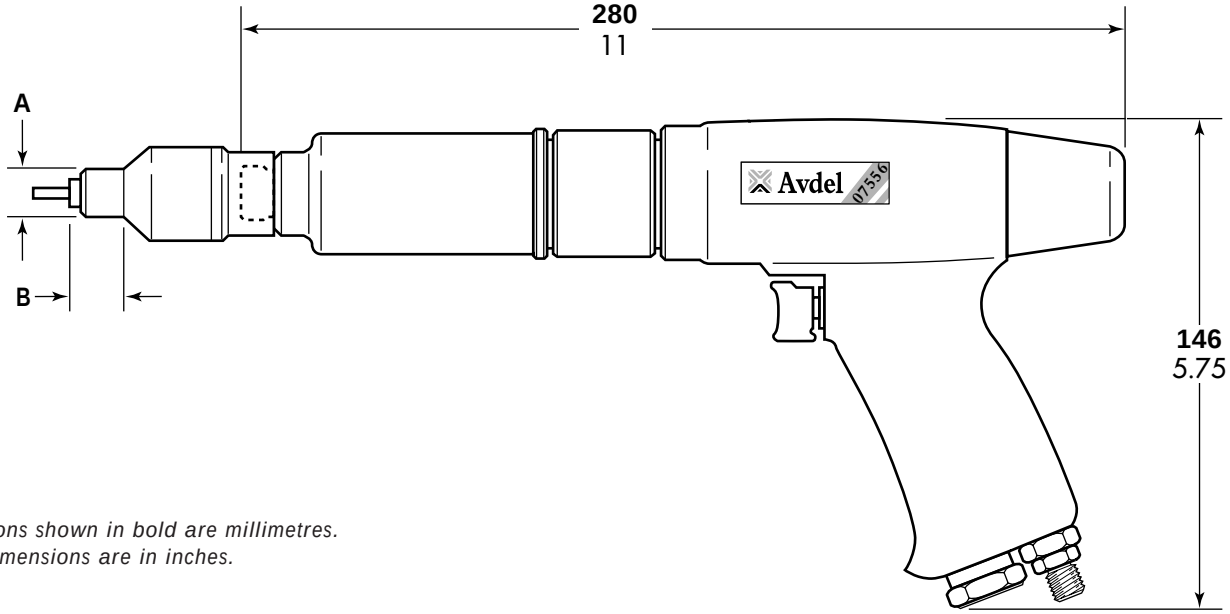
The pneumatic 07556 type tool is designed to place Avdel threaded inserts at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

Use the selection tables below and opposite to select a complete tool which will be fitted with the correct nose assembly for the threaded insert selected. `A' and `B' dimensions will help you assess the accessibility of your application.

It is also possible to order the base tool only (part number 07556-00400). For details of Nose Assemblies see pages 8 and 9.

7556 TOOL SELECTION

INSERT NAME & SERIES	Ø	TORQUE SETTING (lbf ins)	UNSET CLUTCH PART Nº	NOSE (see drawing opposite for A & B) A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART Nº	COMPLETE TOOL PART Nº
THIN SHEET NUTSERT (9650)	3/16 BSW	30 - 35	08556-00308	13	10	1/2	13/32	07556-09916	07556-01016
	1/4 BSW	35 - 40	08556-00309	13	13 1/2	1/2	17/32	07566-09918	07556-01018
	5/16 BSW	50 - 55	08556-00312	14	14	9/16	9/16	07443-09910	07556-01010
	1/4 BSF	35 - 40	08556-00309	13	13 1/2	1/2	17/32	07556-09928	07556-01028
	5/16 BSF	50 - 55	08556-00312	14	14	9/16	9/16	07443-09920	07556-01020
	4 UNC	7 - 9	08556-00302	13	11	1/2	7/16	07556-09954	07556-01054
	6 UNC	16 - 18	08556-00305	13	11	1/2	7/16	07556-09956	07556-01056
	8 UNC	16 - 18	08556-00305	13	12	1/2	15/32	07556-09958	07556-01058
	10 UNC	30 - 35	08556-00308	13	10	1/2	13/32	07556-09950	07556-01050
	4 UNF	7 - 9	08556-00302	13	11	1/2	7/16	07556-09974	07556-01074
	6 UNF	16 - 18	08556-00305	13	11	1/2	7/16	07556-09976	07556-01076
	8 UNF	16 - 18	08556-00305	13	12	1/2	15/32	07556-09978	07556-01078
	10 UNF	30 - 35	08556-00308	13	10	1/2	13/32	07556-09970	07556-01070
	1/4 UNC	35 - 40	08556-00309	13	13 1/2	1/2	17/32	07556-09948	07556-01048
	5/16 UNC	50 - 55	08556-00312	14	14	9/16	9/16	07443-09940	07556-01040
	1/4 UNF	35 - 40	08556-00309	13	13 1/2	1/2	17/32	07556-09968	07556-01068
	5/16 UNF	50 - 55	08556-00312	14	14	9/16	9/16	07443-09960	07556-01060
	6 BA	7 - 9	08556-00302	13	13 1/2	1/2	17/32	07556-09936	07556-01036
	4 BA	16 - 18	08556-00305	13	11	1/2	7/16	07556-09934	07556-01034
	2 BA	30 - 35	08556-00308	13	17	1/2	21/32	07556-09932	07556-01032
	0 BA	35 - 40	08556-00309	13	11	1/2	7/16	07556-09930	07556-01030
	M3	7 - 9	08556-00302	13	11	1/2	7/16	07556-09983	07556-01083
	M4	16 - 18	08556-00305	13	11	1/2	7/16	07556-09984	07556-01084
	M5	30 - 35	08556-00308	13	10	1/2	13/32	07556-09985	07556-01085
	M6	35 - 40	08556-00309	13	13 1/2	1/2	17/32	07556-09986	07556-01086
	M8	50 - 55	08556-00312	14	14	9/16	9/16	07443-09988	07556-01088
SUPERSERT (FB00)	8 UNC	16 - 18	08556-00305	13	10	1/2	13/32	07552-09558	07556-02058
	10 UNC	30 - 35	08556-00308	13	12	1/2	15/32	07552-09550	07556-02050
	8 UNF	16 - 18	08556-00305	13	10	1/2	13/32	07552-09578	07556-02078
	10 UNF	30 - 35	08556-00308	13	12	1/2	15/32	07552-09570	07556-02070
	1/4 UNC	45 - 50	08556-00311	13	15	1/2	19/32	07552-09548	07556-02048
	1/4 UNF	45 - 50	08556-00311	13	15	1/2	19/32	07552-09568	07556-02068
	M3	16 - 18	08556-00305	13	19	1/2	3/4	07552-09583	07556-02083
	M4	16 - 18	08556-00305	13	10	1/2	13/32	07552-09584	07556-02084
	M5	30 - 35	08556-00308	13	11	1/2	7/16	07552-09585	07556-02085
	M6	45 - 50	08556-00311	13	15	1/2	19/32	07552-09586	07556-02086
LARGE FLANGE HEXSERT (9498)	M4	16 - 18	08556-00305	13	10	1/2	13/32	07556-09184	07556-04084
	M5	30 - 35	08556-00308	13	10	1/2	13/32	07557-09285	07556-03085
	M6	35 - 40	08556-00309	14	12	9/16	15/32	07556-09186	07556-04086



Dimensions shown in bold are millimetres.
Other dimensions are in inches.

7556 TOOL SELECTION (continued)

INSERT NAME & SERIES	Ø	TORQUE SETTING (lbf ins)	UNSET CLUTCH PART Nº	NOSE (see drawing above for A & B) A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART Nº	COMPLETE TOOL PART Nº
STANDARD NUTSERTS (9500) (9538)	3/16 BSW	20 - 25	08556-00306	13	12	1/2	15/32	07556-09816	07556-00016
	1/4 BSW	25 - 30	08556-00307	13	15	1/2	19/32	07556-09818	07556-00018
	5/16 BSW	40 - 45	08556-00310	14	14	9/16	9/16	07443-09810	07556-00010
	3/8 BSW	50 - 55	08556-00312	16	10	5/8	13/32	07443-09812	07556-00012
	1/4 BSF	25 - 30	08556-00307	13	15	1/2	19/32	07556-09828	07556-00028
	5/16 BSF	40 - 45	08556-00310	14	14	9/16	9/16	07443-09820	07556-00020
	3/8 BSF	50 - 55	08556-00312	16	10	5/8	13/32	07443-09822	07556-00022
	4 UNC	5 - 7	08556-00301	13	12	1/2	15/32	07556-09854	07556-00054
	6 UNC	9 - 11	08556-00303	13	12	1/2	15/32	07556-09856	07556-00056
	8 UNC	13 - 15	08556-00304	13	10	1/2	13/32	07556-09858	07556-00058
	10 UNC	20 - 25	08556-00306	13	12	1/2	15/32	07556-09850	07556-00050
	6 UNF	9 - 11	08556-00303	13	12	1/2	15/32	07556-09876	07556-00076
	8 UNF	13 - 15	08556-00304	13	10	1/2	13/32	07556-09878	07556-00078
	10 UNF	20 - 25	08556-00306	13	12	1/2	15/32	07556-09870	07556-00070
	1/4 UNC	25 - 30	08556-00307	13	15	1/2	19/32	07556-09848	07556-00048
	5/16 UNC	40 - 45	08556-00310	14	14	9/16	9/16	07443-09840	07556-00040
	3/8 UNC	50 - 55	08556-00312	16	10	5/8	13/32	07443-09842	07556-00042
	1/4 UNF	25 - 30	08556-00307	13	15	1/2	19/32	07556-09868	07556-00068
	5/16 UNF	40 - 45	08556-00310	14	14	9/16	9/16	07443-09860	07556-00060
	3/8 UNF	50 - 55	08556-00312	16	10	5/8	13/32	07443-09862	07556-00062
	6 BA	5 - 7	08556-00301	13	15	1/2	19/32	07556-09836	07556-00036
	4 BA	9 - 11	08556-00303	13	12	1/2	15/32	07556-09834	07556-00034
	2 BA	20 - 25	08556-00306	13	12	1/2	15/32	07556-09832	07556-00032
	0 BA	25 - 30	08556-00307	13	12	1/2	15/32	07556-09830	07556-00030
	M3	5 - 7	08556-00301	13	12	1/2	15/32	07556-09883	07556-00083
	M4	13 - 15	08556-00304	13	10	1/2	13/32	07556-09884	07556-00084
	M5	20 - 25	08556-00306	13	12	1/2	15/32	07556-09885	07556-00085
	M6	25 - 30	08556-00307	13	15	1/2	19/32	07556-09886	07556-00086
	M8	40 - 45	08556-00310	14	14	9/16	9/16	07443-09888	07556-00088
	M10	50 - 55	08556-00312	16	12	5/8	15/32	07443-09880	07556-00080
LGE FLANGE THIN SHEET NUTSERT(9698)	M4	16 - 18	08556-00305	13	10	1/2	13/32	07556-09184	07556-04084
	M5	30 - 35	08556-00308	13	12	1/2	15/32	07556-09185	07556-04085
	M6	35 - 40	08556-00309	13	15	1/2	19/32	07556-09186	07556-04086
HEXSERT (9498)	M4	16 - 18	08556-00305	13	12	1/2	15/32	07556-09284	07556-06084
	M5	30 - 35	08556-00308	13	12	1/2	15/32	07556-09285	07556-06085
	M6	40 - 45	08556-00310	16	14	5/8	9/16	07556-09286	07556-06086
	M8	50 - 55	08556-00312	16	15	5/8	19/32	07443-09288	07556-06088
NUTSERT SQ (GK08)	M5	30 - 35	08556-00308	10	13	13/32	1/2	07528-07085	07556-07085
	M6	40 - 45	08556-00310	13	15	1/2	19/32	07556-09186	07556-04086

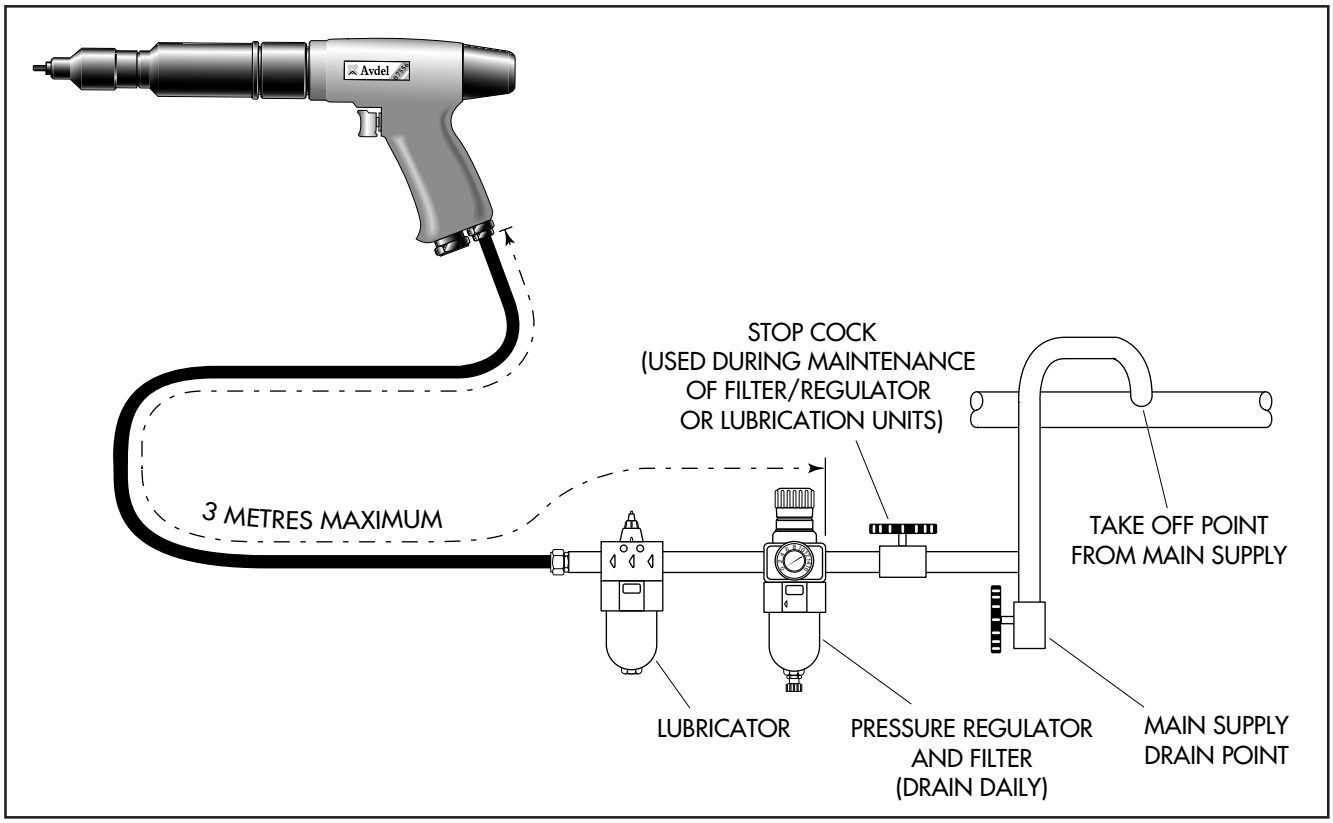
PUTTING INTO SERVICE

AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.5 bar. We recommend the use of pressure regulators and automatic oiling/filtering systems on the main air supply. These should be fitted within 3 metres of the tool (see diagram below) to ensure maximum tool life and minimum tool maintenance.

Air supply hoses should have a minimum working effective pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest. Air hoses should be oil resistant, have an abrasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged. All air hoses MUST have a minimum bore diameter of 6.4 millimetres or $^{1}/_{4}$ inch.

Read servicing daily details page 10.



OPERATING PROCEDURE

IMPORTANT

When placing Standard Nutserts, lubricate the drive screw of the tool every 25 placings. This is best achieved by wiping the drive screw with a sponge soaked with STP Lubricant part number 07992-00013

OPTION 1

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Place the insert into the prepared hole of the application.
- Locate the drivescrew of the tool into the insert.
- Operate the trigger. The drivescrew will screw into and collapse the insert, then automatically reverse out.

OPTION 2

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Screw the insert lip first onto the drive screw of the tool.
- With the insert on the tool, locate it into the prepared hole of the application
- Operate the trigger. The drivescrew will screw into and collapse the insert, then automatically reverse out.

CLUTCH AJUSTMENT

If you have ordered a complete tool the clutch will be set for the specified insert.

When purchased as a spare part the clutch is supplied unset.

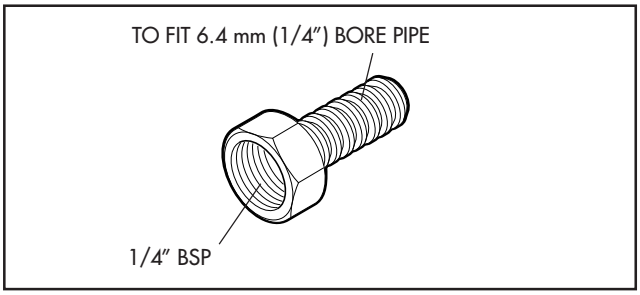
Correct clutch setting is necessary to ensure optimum deformation of the insert. If the deformation is insufficient (clutch torque too low) the insert will rotate in the application. If the deformation is excessive (clutch torque too high) thread distortion will occur and extensive wear on the drivescrew, may lead to fracture.

For details on how to adjust the clutch refer to the maintenance instructions referring to the clutch on page 11.

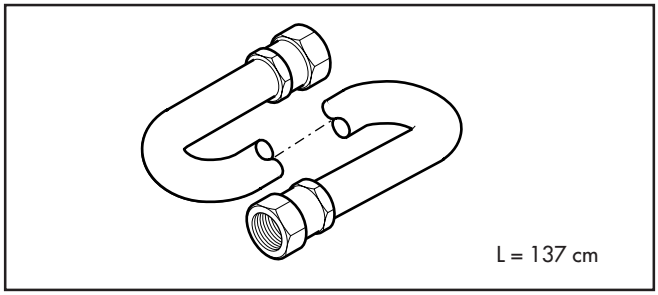
ACCESSORIES

Two different accessories are available to make the connection to your air supply:

Hose Connector
part nº 07005-00276



Hose Assembly
part nº 07008-000324



NOSE ASSEMBLIES

Nose assemblies are specifically designed for each size and type of insert used with the 07556 type of tooling. If you have purchased a complete tool, it will already be fitted with the correct nose assembly for your insert.

It is essential that the correct nose assembly is fitted prior to operating the tool. By knowing your original complete tool part number or the details of the insert to be placed, you will be able to order a new complete nose assembly using the selection tables pages 4 and 5.

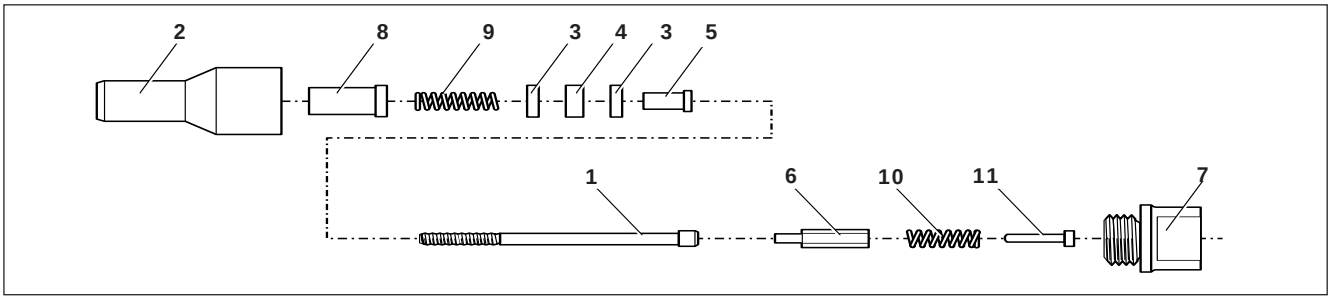
FITTING INSTRUCTIONS

IMPORTANT

The air supply must be disconnected when fitting or removing nose assemblies unless specifically instructed otherwise.

Before fitting the nose equipment, ensure the clutch on the tool is set to the correct torque for the insert being placed. (Torque values are on page 11.)

- Where applicable, insert sleeve **8** and thrust spring **9** into nose housing **2**.
- Coat thrust washers **3** and thrust bearing **4** with high pressure grease (eg. Shell Alvania E.P.I.) and locate them in the order shown below into the nose housing **2**.
- Where applicable, fit spacer **5** through thrust washers and thrust bearings.
- Insert drive screw **1** through the above assembly.
- Fit drive shaft **6** into the hexagon hole in the drive screw head.
- Insert stop **11** and spring **10** into the front of the base tool.
- Screw adaptor **7** into clutch housing of the base tool (left hand thread).
- Offer up the nose assembly to the adaptor. It will be necessary to rotate the drive screw by hand to line up the hexagon on the drive shaft **6** with the hexagonal hole in the front jaw of the base tool.
- Screw the nose housing **2** onto the adaptor **7** and tighten with a spanner (left hand thread).



SERVICING INSTRUCTIONS

Nose assemblies should be serviced at weekly intervals.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting Instructions'.
- Any worn or damaged part should be replaced.
- Particularly check wear on drivescrew, thrust washers and thrust bearing.
- Lubricate thrust washers and thrust bearings with high pressure grease (eg Shell Alvania E.P.I.)
- Check springs are not distorted.

- Assemble according to fitting instructions.

NOSE ASSEMBLY COMPONENTS

The table opposite lists all nose assemblies available. Each nose assembly represents a unique assembly of components which can be ordered individually. Components numbers refer to the text and illustration above. We recommend some stock as items will need regular replacement. Read the nose assemblies servicing instructions above carefully. All nose assemblies also include spring **10** part number 07430-08282 and stop **11** part number 07430-08203.

NOSE ASSY	1	2	3	4	5	6	7	8	9
07443-09288	07001-00084	07522-08988	07007-00081	07007-00078	07443-03110	07430-01808	07443-08002	07522-08902	07154-03092
07443-09810	07001-00076	07443-06110	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09812	07001-00099	07443-06112	07007-00081	07007-00078	-	07430-01112	07443-08002	-	-
07443-09820	07001-00077	07443-06110	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09822	07001-00098	07443-06112	07007-00081	07007-00078	-	07430-01112	07443-08002	-	-
07443-09840	07001-00078	07443-06110	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09842	07001-00106	07443-06112	07007-00081	07007-00078	-	07430-01112	07443-08002	-	-
07443-09860	07001-00079	07443-06110	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09862	07001-00105	07443-06112	07007-00081	07007-00078	-	07430-01112	07443-08002	-	-
07443-09880	07001-00100	07443-06810	07007-00082	07007-00079	-	07430-01810	07443-08003	-	-
07443-09888	07001-00084	07443-06110	07007-00081	07007-00078	07443-03110	07430-01808	07443-08002	-	-
07443-09910	07001-00076	07443-08805	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09920	07001-00077	07443-08805	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
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07528-07085	07001-00256	07557-08985	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	-	-
07552-09548	07001-00336	07552-07704	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
07552-09550	07001-00300	07552-07706	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
07552-09568	07001-00110	07552-07704	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
07552-09570	07001-00301	07552-07706	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
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07552-09583	07001-00325	07552-07709	07007-00080	07007-00077	07520-08803	07520-08802	07443-08001	-	-
07552-09584	07001-00326	07552-07705	07007-00080	07007-00077	07521-08810	07521-08805	07443-08001	-	-
07552-09585	07001-00256	07552-07702	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	-	-
07552-09586	07001-00337	07552-07703	07007-00080	07007-00077	-	07522-08802	07443-08001	-	-
07552-09588	07001-00084	07552-07710	07007-00081	07007-00078	07443-03110	07430-01808	07443-08002	-	-
07556-09184	07001-00326	07552-06804	07007-00080	07007-00077	07521-08810	07521-08805	07443-08001	07552-08804	07440-08002
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07556-09284	07001-00326	07521-08984	07007-00080	07007-00077	07521-08810	07521-08805	07443-08001	07521-08901	07440-08002
07556-09285	07001-00256	07521-08985	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	07521-08902	07440-08002
07556-09286	07001-00337	07522-08986	07007-00080	07007-00077	-	07522-08802	07443-08001	07522-08901	07150-00504
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07556-09828	07001-00333	07443-06108	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
07556-09830	07001-00335	07443-06108	07007-00080	07007-00077	07521-08801	07522-08801	07443-08001	-	-
07556-09832	07001-00321	07440-06805	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
07556-09834	07001-00315	07440-06304	07007-00080	07007-00077	07521-08807	07521-08802	07443-08001	-	-
07556-09836	07001-00276	07440-06306	07007-00080	07007-00077	07520-08803	07520-08801	07443-08001	-	-
07556-09848	07001-00336	07443-06108	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
07556-09850	07001-00300	07440-06805	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
07556-09854	07001-00313	07440-06306	07007-00080	07007-00077	07520-08803	07520-08801	07443-08001	-	-
07556-09856	07001-00316	07440-06304	07007-00080	07007-00077	07521-08807	07521-08802	07443-08001	-	-
07556-09868	07001-00318	07440-06508	07007-00080	07007-00077	07521-08809	07521-08804	07443-08001	-	-
07556-09870	07001-00301	07440-06805	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
07556-09876	07001-00317	07440-06304	07007-00080	07007-00077	07521-08807	07521-08802	07443-08001	-	-
07556-09878	07001-00319	07440-06508	07007-00080	07007-00077	07521-08809	07521-08804	07443-08001	-	-
07556-09883	07001-00325	07440-06308	07007-00080	07007-00077	07520-08803	07520-08802	07443-08001	-	-
07556-09884	07001-00326	07440-06508	07007-00080	07007-00077	07521-08810	07521-08805	07443-08001	-	-
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07556-09954	07001-00313	07440-08803	07007-00080	07007-00077	07520-08803	07521-08801	07443-08001	07440-08003	07440-08002
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07556-09968	07001-00110	07551-08803	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
07556-09970	07001-00301	07440-08805	07007-00080	07007-00077	07521-08808	07521-08803	07443-08001	-	-
07556-09974	07001-00314	07440-08803	07007-00080	07007-00077	07520-08803	07520-08801	07443-08001	07440-08003	07440-08002
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07556-09985	07001-00256	07440-08805	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	-	-
07556-09986	07001-00337	07551-08802	07007-00080	07007-00077	-	07522-08802	07443-08001	-	-
07557-09285	07001-00256	07557-08901	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	07557-08902	07440-08002

SERVICING THE TOOL

Regular servicing should be carried out and a comprehensive inspection performed annually or every 200000 cycles, whichever is soonest.

IMPORTANT

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel. The operator should not be involved in maintenance or repair of the tool unless properly trained.

DAILY

- Daily, before use or when first putting the tool into service, pour a few drops of clean, light lubricating oil into the air inlet of the tool if no lubricator is fitted on air supply. If the tool is in continuous use, the air hose should be disconnected from the main air supply and the tool lubricated every two to three hours.
- Check for air leaks. If damaged, hoses and couplings should be replaced by new items.
- If there is no filter on the pressure regulator, bleed the air line to clear it of accumulated dirt or water before connecting the air hose to the tool. If there is a filter fitted, drain it.
- Check that the nose assembly is correct.
- Inspect the drivescrew in the nose assembly for wear or damage. If there is any, renew.

WEEKLY

- Fully dismantle and service the nose assembly (see instructions page 8).
- Lubricate the clutch spring with high pressure grease (eg. Shell Alvania E.P.I.).
- Check the clutch torque setting (see clutch adjustment procedure page 11).
- Check for air leaks in the air supply hose and fittings.

For lubricating internal tool parts other than those described previously, use Moly Lithium Grease EP3753 (part number 07992-00020)

MOLY LITHIUM GREASE EP 3753 **SAFETY DATA**	
FIRST AID SKIN: As the grease is completely water resistant it is best removed with an approved emulsifying skin cleaner. INGESTION: Make the individual drink 30ml Milk of Magnesia, preferably in a cup of milk. EYES: Irritant but not harmful. Irrigate with water and seek medical attention. **ENVIRONMENT** Scrape up for burning or disposal on approved site.	**FIRE** FLASH POINT: Above 220°C. Not classified as flammable. Suitable extinguishing media: CO_2, Halon or water spray if applied by an experienced operator. **HANDLING** Use barrier cream or oil resistant gloves **STORAGE** Away from heat and oxidising agent.

MAINTENANCE

Every 200000 cycles the tool should be completely dismantled and components replaced where worn, damaged or when recommended. All 'O' rings and seals should be replaced with new ones and lubricated with Moly Lithium grease EP 3753 before assembling.

IMPORTANT

Safety Instructions appear on pages 2 & 3.

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel. The operator should not be involved in maintenance or repair of the tool unless properly trained.

The airline must be disconnected before any servicing or dismantling is attempted, unless specifically instructed not to.

It is recommended that any dismantling operation be carried out in clean conditions.

Item **numbers in bold** refer to the General Assembly drawing and parts list (pages 14 and 15).

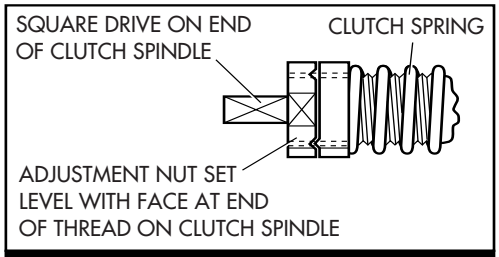
Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, page 8 and 9.

For total tool servicing we advise that you proceed with dismantling the sub-assemblies in the order shown on pages 12 and 13.

CLUTCH

- Place housing and bush assembly **1** in vice fitted with soft jaws.
- Unscrew clutch housing **34** (left hand thread) and remove bush **35** from clutch housing **34**.
- Withdraw the clutch assembly, taking care not to bend push rod **43**. Pull out push rod (long) **43**.
- Remove the tool from the vice and gently tap on the front end of assembly to remove needle roller **61** and push rod (short) **65**.
- Holding the square drive end of clutch spindle **31**, unscrew adjustment nut **28**.
- Pull off adjustment lock washer **29** and spring **30**.
- Depress spring **42** and remove pin **41**.
- Remove collar **40** and three balls **38**.
- Remove split retaining ring halves **39**.
- Move front jaw **33** relative to clutch spindle **31** until small hole in side of front jaw **33** is aligned with track of the balls in clutch spindle **31**.
- Ten balls **36** will become visible through small hole in front jaw **33**.
- Gently tap front jaw **33**, allowing the ten balls to fall out of hole in the front jaw, (as each ball is ejected, turn front jaw **33** on clutch spindle **31** to align next ball with hole).
- Insert small rod through centre of front jaw **33** and tap out clutch spindle **31**.
- Remove drive jaw **32**, key **37** and spring **42**.
- Assemble in reverse order to dismantling.

- Reset clutch torque in the following manner, (see diagram opposite):
- Place square drive on end of clutch spindle **31** in vice, engaging approximately 10 mm in vice jaws. This allows access for spanner entry.
- Using the spanner, unscrew adjustment nut **28** until it is level with the end of the thread of the clutch spindle. Torque can then be increased/ decreased as dictated by fastener type and size by turning the adjustment nut clockwise/anticlockwise as appropriate. Use the data in the table below to know how many turns to give a particular torque.



RESETTING CLUTCH TORQUE

Use the data in the table below to know how many turns give a particular torque.

7556 CLUTCH DETAILS

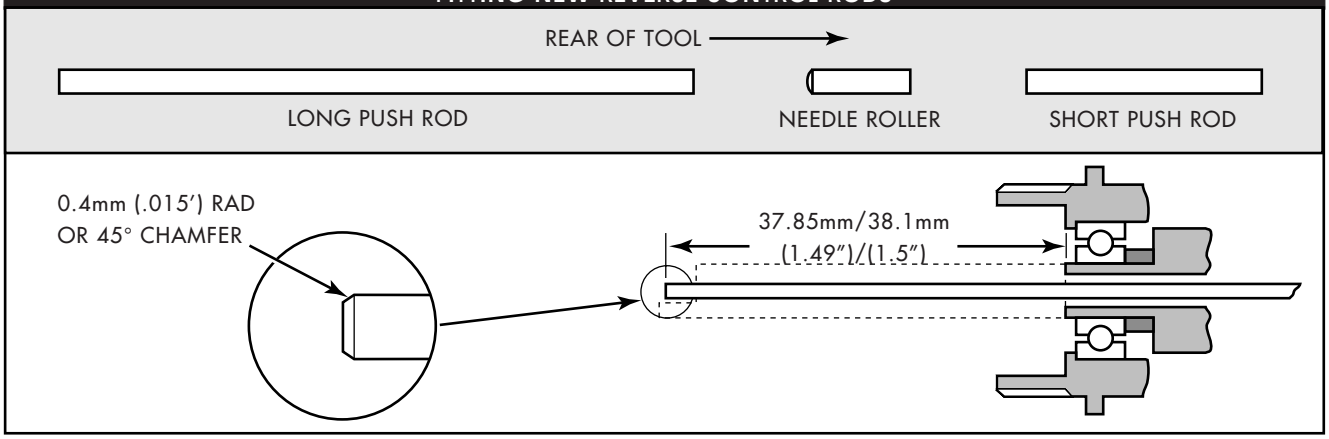
UNSET CLUTCH PART Nº	SPRING PART Nº	SPRING COLOUR	Nº OF TURNS/lb f ins													
			1	2	3	4	5	6	7	8	9	10	11	12	13	14
08556-00390	08572-00407	OXIDE BLACK	-	-	5	6	7	8	9	10	11	12	13	14	15	16
08556-00380	08556-00412	SILVER	5	7.5	10	12.5	15	17.5	20	22.5	25	28	31	34	-	-
08557-00380	08557-00202	COPPER	-	34	42	51	60	-	-	-	-	-	-	-	-	-

IMPORTANT

It is imperative that the reverse control rods are fitted in the correct sequence (see diagram opposite) to ensure correct tool function. When renewing the long push rod, it is necessary to trim the overall length to give a protrusion of 37.85mm (1.49")/38.1mm (1.5") of the push rod above the front face of the output square drive spindle of the final gearbox. A gauge (part number 07900-00424) is used to achieve this.

This operation should be carried out with the air supply connected to the tool. Do not operate the trigger during this operation. When the rod has been trimmed to the correct length, carefully remove the sharp edge left with either a 0.4mm(.015") radius or 45° chamfer. Take care not to bend or damage the new push rod.

FITTING NEW REVERSE CONTROL RODS



HANDLE ASSEMBLY

- Replace handle and brush assembly **1** in soft jaw vice.
- Using spanner on ring gear **45**, remove front gear assembly.
- Using spanner on housing **26**, remove inner gear assembly.
- Remove '0' ring **19** and spacer **18** from handle and brush assembly **1** and pull out the motor assembly. (It may be necessary to tap the front end of handle and bush assembly **1** on a wooden block until the motor assembly slides out).
- Unscrew silencer retainer assembly **9** and remove perforated washer **10**, silencer body **12** and silencer element **11**.
- Unscrew nipple **8** from adaptor **7**.
- Unsrew adaptor **7** from handle and brush assembly **1** and remove filter **6**.
- Tap out pin **15** and carefully pull out the trigger assembly, (take care not to damage '0" rings).
- Support trigger **17** and carefully drive out pin **16** taking care not to damage or bend valve **3**.
- Separate trigger **17** from valve **3** and remove '0" ring **14**, three '0' rings **2** from valve body **13** and 'o'rings **4** & **5** from valve **3**.
- Unscrew knob **76** and remove '0' ring **68** from handle and bush assembly **1**.
- Remove screw **74** and washer **75**.
- Lightly tap end plate **71** to break the Loctite seal between end plate **71** and valve assembly **66**.
- Remove end plate **71**, taking care not to damage pins **73**.
- Remove '0' ring **72** and spring **70**.
- Push valve assembly **66** out of hanfle and bush assembly **1**.

IMPORTANT

Valve assembly 66 is a manufacturer supplied assembly and MUST NOT be dismantled

- Remove '0' ring **67** from valve assembly **66**.
- Remove '0' ring **69** from valve bush but do not attempt to remove the valve bushing from handle and bush assembly **1**.

- Assemble in reverse order of dismantling.
- When replacing screw **74** and washer **75** ensure thread sealant is used on screw threads.

FRONT GEAR ASSEMBLY (previously removed from handle assembly).

- Hold ring gear **45** and tap out internal asembly from front end.
- Remove two bearing **25** and spacers **50** and **47** from planet gear spindle **46**.
- Tap out two shafts **28** and thirty needles **27** and remove two planet gears **49** and drive gear **48**.

- Assemble in reverse order of dismantling.

REAR GEAR ASSEMBLY

- Pull off spacer **53**.
- Hold housing 26 and push out internal assembly from the front end.
- Remove two bearings **25** and spacers **20** & **23**. from planet gear spindle **24**.
- Push out two shafts **52** together with thirty needles **21**.
- Take out two planet gears **49** and drive gear **22**.
- Using circlip pilers, remove circlip **51** from housing **26**.

- Assemble in reverse order of dismantling.

MOTOR ASSEMBLY (previously removed from handle assembly).

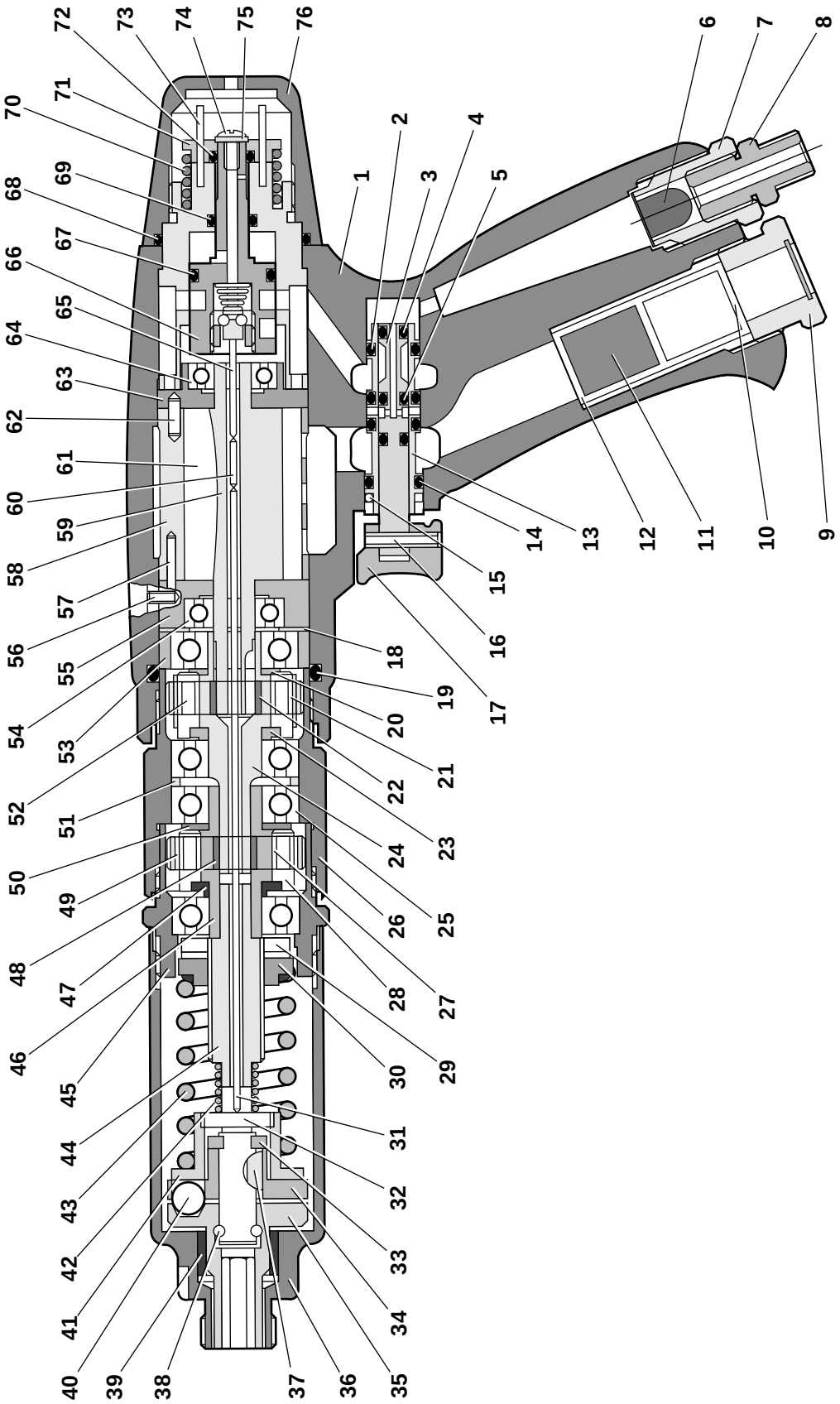
- Remove locating pin **56** from lower end plate **55**.
- Hold lower end plate **55** and tap splined end of rotor **59** with a soft hammer so as not to damage splines.
- Remove lower end plate **55** and bearing **54** from rotor **59**.
- Remove cylinder **58** complete with pin **57** and pin **62**.
- Remove five rotor blades **61** from rotor **59**.
- Support rear end plate **63** using a piece of tube with a bore diameter as close as possibl to largest diameter of rotor **59**, then tap the non-splined end of the rotor to remove it from rear end plate **63** and bearing **64**.
- Using a suitable punch, tap out bearing **54** from lower end plate**55**, bearing **64** and rear end plate **63**.

- When assembling, make sure that locating pin **58** in lower end plate **55** locates in keyway in the front end bore of the handle.
- Pay special attention to lower end plate **55** and rear end plate **63**, ensuring they are free from burrs and surface marking. If necessary, lap faces that abut cylinder **58** on a flat fine grade abrasive paper.
- Press fir bearings **54** & **64** into lower and rear end plates **55** & **63**.
- Support bearing **64** in rear end plate **63** on its inner ring and using a soft hammer, tap rotor **59** on its splined end until the rotor locates against rear end plate **63**.
- Support inner face of rear end plate **63** as close as possible to largest diameter of rotor **59**.
- Tap non-splined end of rotor **59** until a clearance of 0.040 mm (0.0015 in) to 0.065 mm (0.0025 in) is obtained between inner face of rear end plate **63** and rotor **59**.
- Check clearance by pulling rotor **59** away from rear end plate **63** and bearing **64**.
- Spin rotor **59** ensuring that it rotates freely in rear end plate bearing **64**.
- Locate cylinder **58** with locating pin **56** to rear end plate **63** and check ports in rear end plate **63** align with ports in cylinder **58**.
- Insert five rotor blades **60** into rotor **59**.
- Fit lower end plate **55** to cylinder **58** via locating pin **56**.
- Ensure rotor **59** spins freely.

- Fit motor in reverse order of removal (see handle assembly).

IMPORTANT

Check the tool against daily and weekly servicing.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07556-00200 PARTS LIST

ITEM	PART Nº	DESCRIPTION	QTY	REC. SPARES	ITEM	PART Nº	DESCRIPTION	QTY	REC. SPARES
01	08556-00423	HANDLE AND BUSH ASSEMBLY	1	-	40	08556-00410	5/16 DIA. BALL	3	-
02	08415-00207	'O' RING	3	3	41	08556-00406	COLLAR	1	-
03	08556-00417	VALVE	1	1	42	08556-00411	SPRING	1	-
04	08434-00202	'O' RING	1	1	43	08557-00202	CLUTCH SPRING 35-85lb. (COPPER)	1	-
05	08441-00402	'O' RING	2	4		08572-00407	CLUTCH SPRING 5-16lb. (OXIDE BLACK)	1	-
06	08415-00201	FILTER	1	2		08556-00412	CLUTCH SPRING 12-35lb. (SILVER)	1	-
07	08415-00202	ADAPTOR	1	-	44	08556-00408	CLUTCH SPINDLE	1	-
08	08433-00221	NIPPLE	1	-	45	08430-00801	RING GEAR	1	-
09	08415-00203	SILENCER RETAINER ASSEMBLY	1	-	46	08443-00401	PLANET GEAR SPINDLE	1	-
10	08432-00201	PERFORATED WASHER	1	-	47	08443-00402	SPACER	1	-
11	08415-00204	SILENCER ELEMENT	1	2	48	08434-00203	DRIVE GEAR	1	-
12	08415-00205	SILENCER BODY	1	-	49	08434-00206	PLANET GEAR	4	-
13	08520-00212	VALVE BODY	1	1	50	08434-00201	SPACER	1	-
14	08520-00215	'O' RING	1	2	51	08430-00707	CIRCLIP	1	-
15	08524-00207	PIN	1	2	52	08434-00208	SHAFT	1	-
16	08433-00233	PIN	1	2	53	08430-00706	SPACER	1	-
17	08281-00405	TRIGGER	1	-	54	08430-00601	BEARING	1	-
18	08430-00215	SPACER	1	-	55	08430-00602	LOWER END PLATE	1	-
19	08522-00205	'O' RING	1	-	56	08435-00202	LOCATING PIN	1	-
20	08434-00201	SPACER	1	-	57	08433-00233	PIN	1	-
21	08434-00207	NEEDLE	30	-	58	08435-00214	CYLINDER	1	-
22	08434-00203	DRIVE GEAR	1	-	59	08556-00415	ROTOR	1	-
23	08434-00205	SPACER	1	-	60	08556-00418	NEEDLE ROLLER	1	3
24	08556-00414	PLANET GEAR SPINDLE	1	-	61	08430-00608	ROTOR BLADE	5	-
25	08430-00705	BEARING	4	-	62	08435-00203	PIN	1	-
26	08430-00708	HOUSING	1	-	63	08433-00214	REAR END PLATE	1	-
27	08434-00207	NEEDLE	30	-	64	08430-00606	BEARING	1	-
28	08434-00208	SHAFT	2	-	65	08556-00416	PUSH ROD (SHORT)	1	3
29	08430-00229	ADJUSTMENT NUT	1	-	66	08556-00420	VALVE ASSEMBLY	1	-
30	08556-00409	ADJUSTMENT LOCK WASHER	1	-	67	08435-00209	'O' RING	1	-
31	08556-00413	PUSH ROD (LONG)	1	-	68	08435-00204	'O' RING	1	2
32	08556-00407	PIN	1	-	69	08415-00217	'O' RING	1	-
33	08556-00405	RETAINING RING HALF	2	-	70	08556-00425	SPRING	1	-
34	08556-00404	DRIVE JAW	1	-	71	08556-00422	END PLATE	1	-
35	08556-00401	FRONT JAW	1	-	72	08556-00424	'O' RING	1	-
36	08556-00402	CLUTCH HOUSING	1	-	73	08415-00209	PIN	2	-
37	08430-00223	KEY	1	-	74	08415-00221	SCREW	1	-
38	08430-00221	3/32 DIA. BALL	10	-	75	08415-00220	WASHER	1	-
39	08556-00403	BUSH	1	-	76	08415-00421	KNOB	1	-

FAULT DIAGNOSIS TABLE

SYMPTOM	POSSIBLE CAUSE	REMEDY
Tool reverses before Insert is Placed	→ Worn thrust bearing or thrust washers	→ Replace
	→ Dirty insert threads	→ Change batch of inserts
	→ Worn drive screw	→ Replace
	→ Lack of lubrication on drive screw (Standard Nutserts only)	→ Lubricate drive screw properly (see page 6)
	→ Thrust spring not fitted	→ Fit thrust spring
	→ Clutch torque setting too low	→ Adjust to correct setting
	→ Insufficient pressure/volume of air	→ Check air supply/fittings
Tool runs slowly	→ Insufficient air pressure	→ Adjust air pressure at base of handle. 5 - 8 bar maximum.
	→ Incorrect bore of hose	→ Ensure bore of hose is 6.4mm minimum
	→ Insufficient air volume	→ Ensure there is no restriction in the air supply or connections
	→ Tool not properly lubricated internally	→ Lubricate as per instructions
Tool fails to start	→ Tool not properly lubricated	→ Lubricate then depress trigger several times
	→ Restricted air pressure/volume	→ Ensure there is no restriction in the air supply
Tool runs permanently in reverse mode	→ Push rod too long	→ Replace with one of correct length
	→ Insufficient air supply	→ Adjust air pressure/volume
Tool runs permanently in forward mode	→ Push rods/needle roller missing	→ Replace where necessary
	→ Air leak around screw **73**	→ Seal with thread sealant
	→ Push rod too short	→ Replace
Inserts not pulling up	→ Torque setting too low	→ Adjust to correct setting
	→ Insufficient air pressure/volume	→ Adjust air pressure/volume
	→ Inserts out of grip	→ Select correct insert
	→ Lack of lubrication on insert	→ Change batch of inserts
	→ Lack of lubrication on drive screw (Standard Nutserts only)	→ Lubricate drive screw correctly (see page 6)
	→ Insert thread restricted	→ Change Inserts
	→ Drive screw thread worn	→ Replace drive screw
	→ Incorrect insert/drive screw	→ Replace with correct insert/drive screw
Standard Nutserts centres falling out	→ Dirty Nutserts	→ Clean Nutserts
	→ Clutch torque setting too low	→ Adjust to correct setting
	→ Application thickness below minimum recommended grip	→ Change to correct Insert
	→ Oversize hole in application	→ Correct hole size in application
Worn drive screws	→ Clutch torque setting too high	→ Adjust to correct setting
	→ Drive screw not lubricated	→ Lubricate drive screw regularly when using Standard Nutserts
	→ Inserts not lubricated	→ Change batch of inserts
	→ Tool not held correctly	→ Ensure tool is held square to application
	→ Incorrect insert/drive screw threads	→ Replace with correct insert/drive screw
	→ Restricted insert threads	→ Change batch of inserts

Engineered Fastening and Assembly Systems

CE

Declaration of Conformity

We, *Avdel UK Limited, Mundells, Welwyn Garden City, Herts, AL7 1EZ*

declare under our sole responsibility that the product

type 07556

Serial Nº ____

to which this declaration relates is in conformity with the following standards or other formative documents

EN292 part 1 and part 2

ISO 8662 part 1 and part 7

ISO 3744 and PNEUROP test code PN8TC1

ISO PREN792 part 6

following the provisions of the Machine Directive 98/37/EC
This box contains a power tool which is in conformity with Machines Directive 98/37/EC. The 'Declaration of Conformity' is contained within.

Welwyn Garden City - date of issue ____

A. Seewraj
Product Engineering Manager - Automation Tools

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