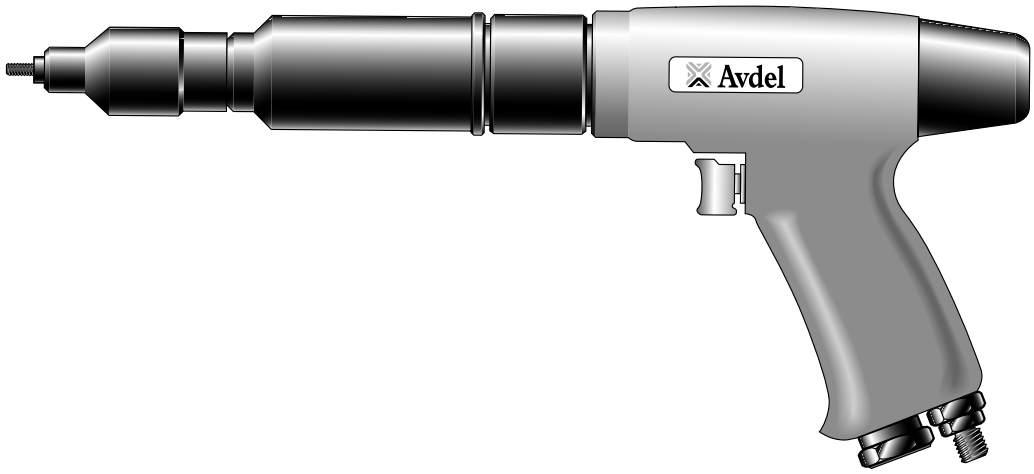
Avdel®

An Acument™ Global Technologies Company

Instruction Manual

Pass onto user to read and keep for reference



Threaded Insert Power Tool

07557

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 07557 TYPE TOOL

AIR PRESSURE	Minimum - Maximum	**5 - 8 bar**	75 - 120 lbf/in²
FREE AIR VOLUME REQUIRED	@ 5 bar / 75 lbf/in²	**510 litres**	18 ft³/min
MOTOR SPEED	@ 75 lb/in²	**550 RPM min.**	(clockwise)
CYCLE TIME	Approximately	**3 seconds**	
NOISE LEVEL		**75 dB(A)**	
WEIGHT	Without nose equipment	**1.65 kg**	3.64 lb
VIBRATION	Less than	**2.5 m/s²**	8 ft/s²

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

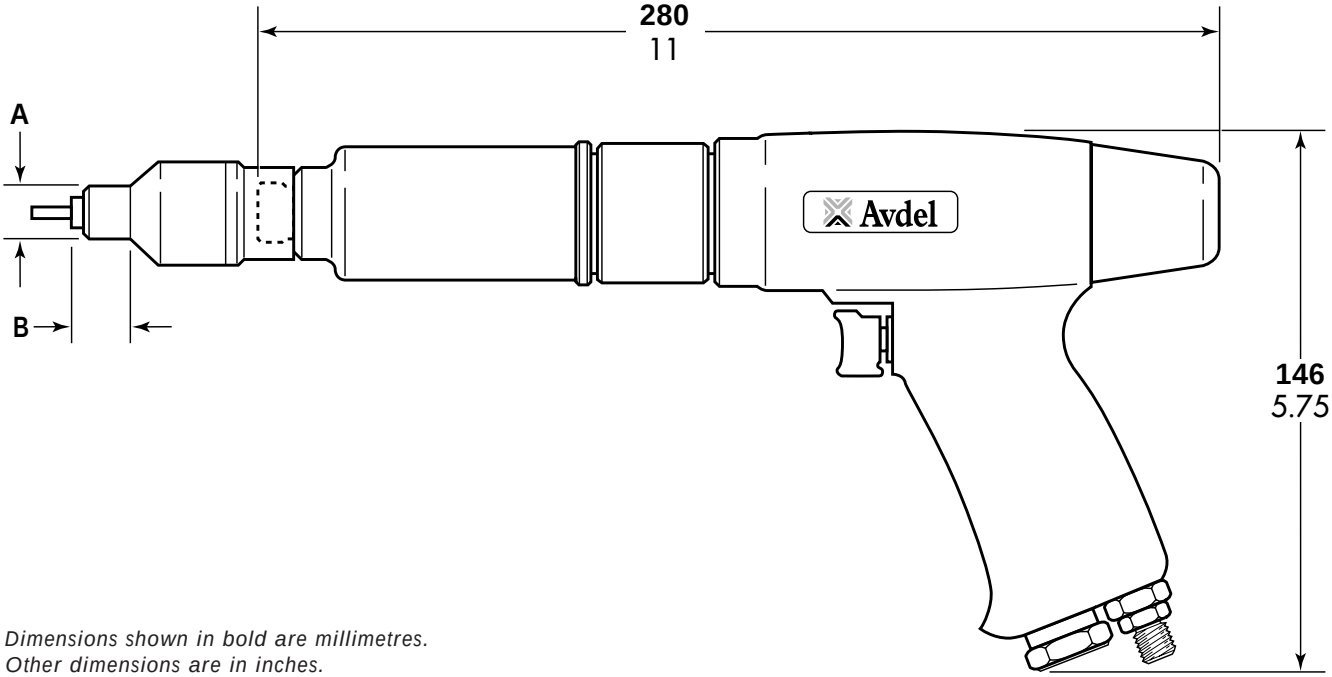
The pneumatic 07557 type tool is designed to place Avdel threaded inserts at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

Use the selection tables below and opposite to select a complete tool.

It is also possible to order the base tool only (part number 07557-00400) which will not be fitted with a nose assembly.

7557 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
	3/16 BSW	30 - 35	08556-00380	13	10	1/2	13/32	07556-09916	07557-01016
STEEL	1/4 BSW	35 - 40	08557-00380	13	13 1/2	1/2	17/32	07566-09918	07557-01018
THIN	5/16 BSW	50 - 55	08557-00380	14	14	9/16	9/16	07443-09910	07557-01010
SHEET	1/4 BSF	35 - 40	08557-00380	13	13 1/2	1/2	17/32	07556-09928	07557-01028
NUTSERT	5/16 BSF	50 - 55	08557-00380	14	14	9/16	9/16	07443-09920	07557-01020
(9650)	4 UNC	7 - 9	08556-00390	13	11	1/2	7/16	07556-09954	07557-01054
	6 UNC	16 - 18	08556-00380	13	11	1/2	7/16	07556-09956	07557-01056
	8 UNC	16 - 18	08556-00380	13	12	1/2	15/32	07556-09958	07557-01058
	10 UNC	30 - 35	08556-00380	13	10	1/2	13/32	07556-09950	07557-01050
	4 UNF	7 - 9	08556-00390	13	11	1/2	7/16	07556-09974	07557-01074
	6 UNF	16 - 18	08556-00380	13	11	1/2	7/16	07556-09976	07557-01076
	8 UNF	16 - 18	08556-00380	13	12	1/2	15/32	07556-09978	07557-01078
	10 UNF	30 - 35	08556-00380	13	10	1/2	13/32	07556-09970	07557-01070
	1/4 UNC	35 - 40	08557-00380	13	13 1/2	1/2	17/32	07556-09948	07557-01048
	5/16 UNC	50 - 55	08557-00380	14	14	9/16	9/16	07443-09940	07557-01040
	1/4 UNF	35 - 40	08557-00380	13	13 1/2	1/2	17/32	07556-09968	07557-01068
	5/16 UNF	50 - 55	08557-00380	14	14	9/16	9/16	07443-09960	07557-01060
	6 BA	7 - 9	08556-00390	13	13 1/2	1/2	17/32	07556-09936	07557-01036
	4 BA	16 - 18	08556-00380	13	11	1/2	7/16	07556-09934	07557-01034
	2 BA	30 - 35	08556-00380	13	17	1/2	21/32	07556-09932	07557-01032
	0 BA	35 - 40	08557-00380	13	11	1/2	7/16	07556-09930	07557-01030
	M3	7 - 9	08556-00390	13	11	1/2	7/16	07556-09983	07557-01083
	M4	16 - 18	08556-00380	13	11	1/2	7/16	07556-09984	07557-01084
	M5	30 - 35	08556-00380	13	10	1/2	13/32	07556-09985	07557-01085
	M6	35 - 40	08557-00380	13	13 1/2	1/2	17/32	07556-09986	07557-01086
	M8	50 - 55	08557-00380	14	14	9/16	9/16	07443-09988	07557-01088
	8 UNC	16 - 18	08556-00380	13	10	1/2	13/32	07552-09558	07557-02058
SUPERSERT	10 UNC	30 - 35	08556-00380	13	12	1/2	15/32	07552-09550	07557-02050
(FB00)	8 UNF	16 - 18	08556-00380	13	10	1/2	13/32	07552-09578	07557-02078
	10 UNF	30 - 35	08556-00380	13	12	1/2	15/32	07552-09570	07557-02070
	1/4 UNC	45 - 50	08557-00380	13	15	1/2	19/32	07552-09548	07557-02048
	1/4 UNF	45 - 50	08557-00380	13	15	1/2	19/32	07552-09568	07557-02068
	M3	16 - 18	08556-00380	13	19	1/2	3/4	07552-09583	07557-02083
	M4	16 - 18	08556-00380	13	10	1/2	13/32	07552-09584	07557-02084
	M5	30 - 35	08556-00380	13	11	1/2	7/16	07552-09585	07557-02085
	M6	45 - 50	08557-00380	13	15	1/2	19/32	07552-09586	07557-02086
LGE FLANGE	M4	16 - 18	08556-00380	13	10	1/2	13/32	07556-09184	07557-04084
HEXSERT	M5	30 - 35	08556-00380	13	10	1/2	13/32	07557-09285	07557-03085
(9498)	M6	35 - 40	08557-00380	14	12	9/16	15/32	07556-09186	07557-04086



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

7557 TOOL SELECTION

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	08556-00380	13	12	1/2	15/32	07556-09816	07557-00016
	1/4 BSW	25 - 30	08556-00380	13	15	1/2	19/32	07566-09818	07557-00018
	5/16 BSW	40 - 45	08557-00380	14	14	9/16	9/16	07443-09810	07557-00010
	3/8 BSW	50 - 55	08557-00380	16	10	5/8	13/32	07443-09812	07557-00012
	1/4 BSF	25 - 30	08556-00380	13	15	1/2	19/32	07556-09828	07557-00028
	5/16 BSF	40 - 45	08557-00380	14	14	9/16	9/16	07443-09820	07557-00020
	3/8 BSF	50 - 55	08557-00380	16	10	5/8	13/32	07443-09822	07557-00022
	4 UNC	5 - 7	08556-00390	13	12	1/2	15/32	07556-09854	07557-00054
	6 UNC	9 - 11	08556-00390	13	12	1/2	15/32	07556-09856	07557-00056
	8 UNC	13 - 15	08556-00390	13	10	1/2	13/32	07556-09858	07557-00058
	10 UNC	20 - 25	08556-00380	13	12	1/2	15/32	07556-09850	07557-00050
	6 UNF	9 - 11	08556-00390	13	12	1/2	15/32	07556-09876	07557-00076
	8 UNF	13 - 15	08556-00390	13	10	1/2	13/32	07556-09878	07557-00078
	10 UNF	20 - 25	08556-00380	13	12	1/2	15/32	07556-09870	07557-00070
	1/4 UNC	25 - 30	08556-00380	13	15	1/2	19/32	07566-09848	07557-00048
	5/16 UNC	40 - 45	08557-00380	14	14	9/16	9/16	07443-09840	07557-00040
	3/8 UNC	50 - 55	08557-00380	16	10	5/8	13/32	07443-09842	07557-00042
	1/4 UNF	25 - 30	08556-00380	13	15	1/2	19/32	07566-09868	07557-00068
	5/16 UNF	40 - 45	08557-00380	14	14	9/16	9/16	07443-09860	07557-00060
	3/8 UNF	50 - 55	08557-00380	16	10	5/8	13/32	07443-09862	07557-00062
	6 BA	5 - 7	08556-00390	13	15	1/2	19/32	07556-09836	07557-00036
	4 BA	9 - 11	08556-00390	13	12	1/2	15/32	07556-09834	07557-00034
	2 BA	20 - 25	08556-00380	13	12	1/2	15/32	07556-09832	07557-00032
	0 BA	25 - 30	08556-00380	13	12	1/2	15/32	07556-09830	07557-00030
	M3	5 - 7	08556-00390	13	12	1/2	15/32	07556-09883	07557-00083
	M4	13 - 15	08556-00390	13	10	1/2	13/32	07556-09884	07557-00084
	M5	20 - 25	08556-00380	13	12	1/2	15/32	07556-09885	07557-00085
	M6	25 - 30	08556-00380	13	15	1/2	19/32	07566-09886	07557-00086
	M8	40 - 45	08557-00380	14	14	9/16	9/16	07443-09888	07557-00088
	M10	50 - 55	08557-00380	16	12	5/8	15/32	07443-09880	07557-00080
LGE FLANGE THIN SHEET NUTSERT(9698)	M4	16 - 18	08556-00380	13	10	1/2	13/32	07556-09184	07557-04084
	M5	30 - 35	08556-00380	13	12	1/2	15/32	07556-09185	07557-04085
	M6	35 - 40	08557-00380	13	15	1/2	19/32	07556-09186	07557-04086
HEXSERT (9498)	M4	16 - 18	08556-00380	13	12	1/2	15/32	07556-09284	07557-06084
	M5	30 - 35	08556-00380	13	12	1/2	15/32	07556-09285	07557-06085
	M6	40 - 45	08557-00380	16	14	5/8	9/16	07566-09286	07557-06086
	M8	50 - 55	08557-00380	16	15	5/8	19/32	07443-09288	07557-06088
NUTSERT SQ (GK08)	M5	30 - 35	08556-00380	10	13	13/32	1/2	07528-07085	07557-07085
	M6	40 - 45	08557-00380	13	15	1/2	19/32	07566-09186	07557-04086

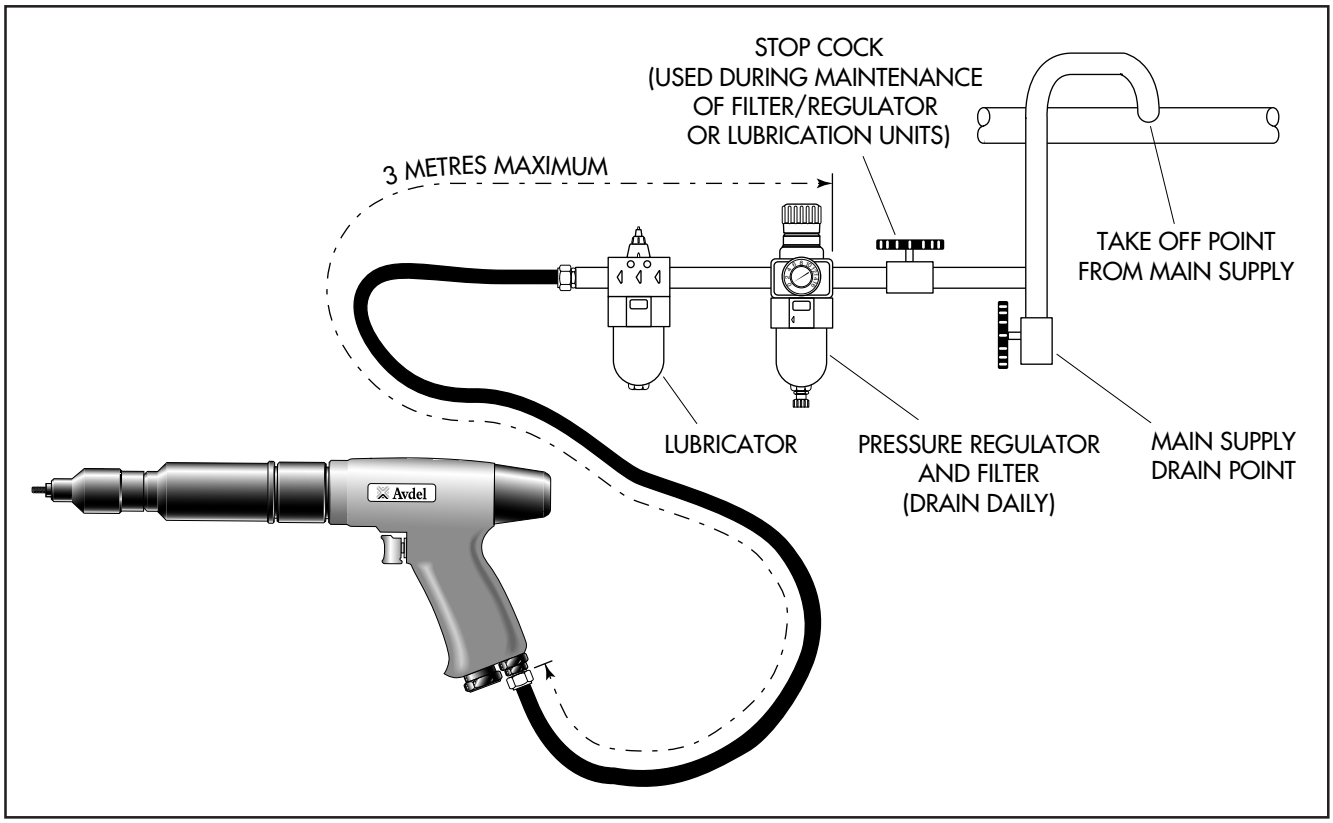
PUTTING INTO SERVICE

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 acheived 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 drive screw of the tool into the insert.
- Depress the trigger. The drive screw will screw into and collapse the insert, and 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
- Depress the trigger. The drive screw will screw into and collapse the insert, and then automatically reverse out.

CLUTCH ADJUSTMENT

This is necessary to ensure optimum insert deformation. If deformation is insufficient (clutch torque too low) the insert will rotate in the application. If deformation is excessive (clutch torque too high) thread distortion and possibly drive screw fracture will occour.
For details on how to adjust the clutch refer to the maintenance instructions referring to the clutch on page 12.

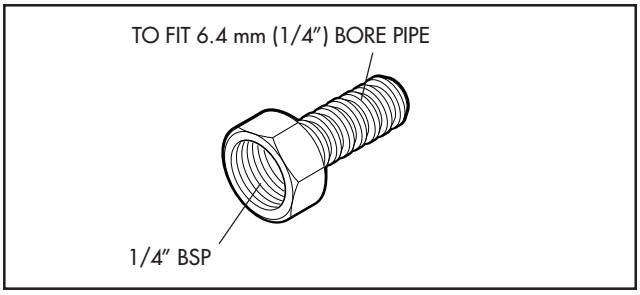
7557 CLUTCH DETAILS

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	-	-	-	-	-	-	-	-	-

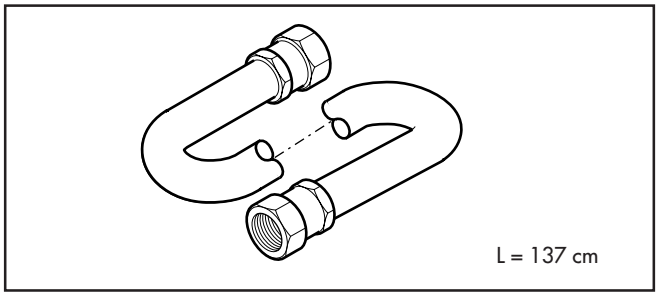
ACCESSORIES

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 07557 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.

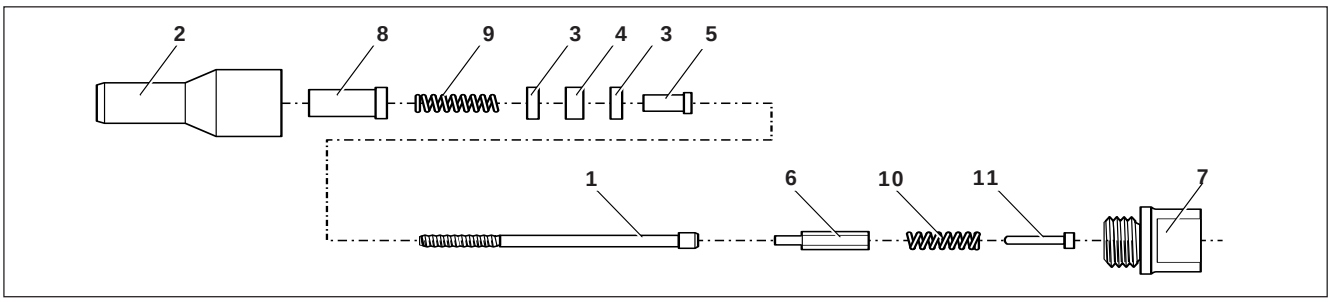
FITTING INSTRUCTIONS

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 quoted on pages 4 & 5.)

- 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 by a new part.
- Particularly check wear on drivescrew, thrust washers and thrust bearing.
- Check springs are not distorted.
- Check the clutch torque setting (see page 4 & 5 for details)
- Lubricate thrust washers and thrust bearings with high pressure grease (eg Shell Avania E.P.I.)
- Lubricate the clutch with high pressure grease.
- 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 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	-	-
07443-09940	07001-00078	07443-08805	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09960	07001-00079	07443-08805	07007-00081	07007-00078	07443-03110	07430-01110	07443-08002	-	-
07443-09988	07001-00084	07443-08805	07007-00081	07007-00078	07443-03110	07430-01808	07443-08002	-	-
07528-07085	07001-00256	07557-08985	07007-00080	07007-00077	07521-08808	07521-08806	07443-08001	-	-
07552-09180	07001-00100	07552-06810	07007-00082	07007-00079	-	07430-01810	07443-08003	07552-08810	03212-00800
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	-	-
07552-09558	07001-00318	07552-07701	07007-00080	07007-00077	07521-08809	07521-08804	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	-	-
07552-09578	07001-00319	07552-07701	07007-00080	07007-00077	07521-08809	07521-08804	07443-08001	-	-
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	-	-
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07556-09186	07001-00337	07552-06806	07007-00080	07007-00077	-	07522-08802	07443-08001	07552-08806	07150-00403
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07556-09828	07001-00333	07443-06108	07007-00080	07007-00077	-	07522-08801	07443-08001	-	-
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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

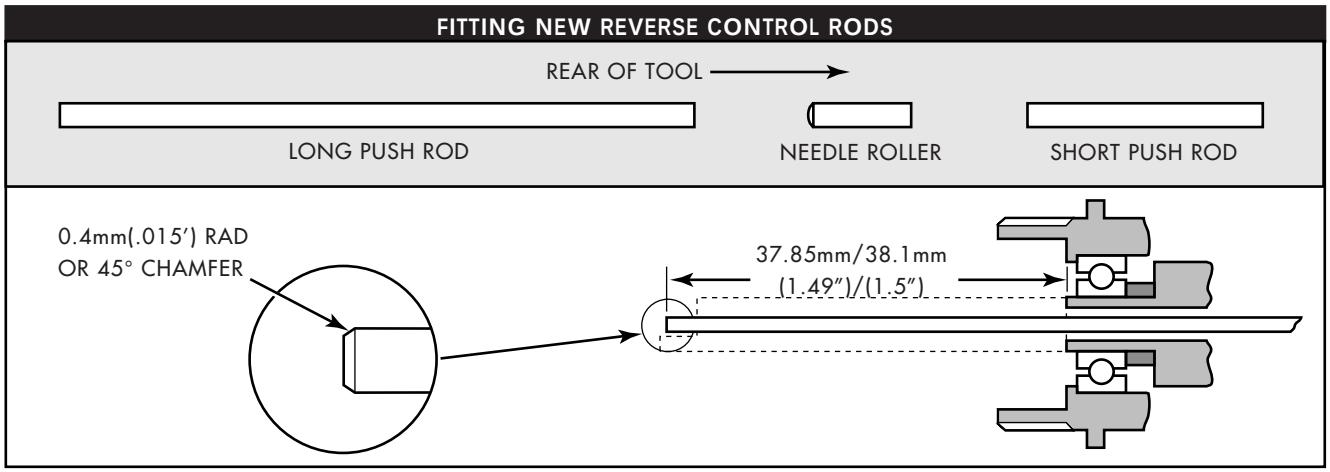
- Daily, before use or when first putting the tool into service, pour a few drops of clean, light lubricating oil into the air inlet of the tool if no lubricator is fitted on air supply. If the tool is in continuous use, the air hose should be disconnected from the main air supply and the tool lubricated 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

- Dismantle and clean the nose assembly with special attention to the thrust bearings and thrust washers. Lubricate with high pressure grease (eg. Shell Alvania EPI) before assembling.
- Check for air leaks in the air supply hose and fittings.
- Lubricate the clutch with high pressure grease (eg. Shell Alvania EPI) (see procedure in clutch section page 12)
- Check for wear on thrust bearings and thrust washers. If there is any, renew.

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.



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 nesessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, page 8 and 9.

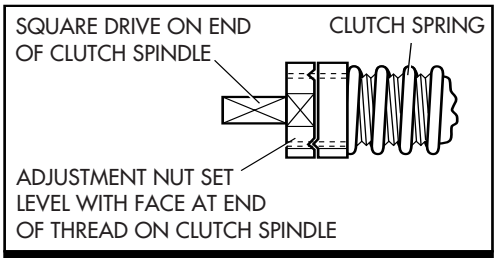
For total tool servicing we advise that you proceed with dismantling the sub-assemblies in the order shown on pages 12 and 13.

CLUTCH

- Place tool handle and bush assembly **1** in vice fitted with soft jaws.
- Unscrew clutch housing **35** (left hand thread) and remove bush **38** from clutch housing.
- Withdraw clutch assembly, taking care not to bend push rod **30**.
- Pull out push rod (long) **30**.
- Remove tool from vice and gently tap on front end of assembly to remove needle roller **59** and push rod (short) **64**.
- Holding square drive end of clutch spindle **43**, unscrew adjustment nut **28**.
- Pull off adjustment lock washer **29** and spring **41**.
- Depress spring **41** and remove pin **31**.
- Remove collar **40** and three balls **39**.
- Split retaining ring halves **32**.
- Move front jaw **34** relative to clutch spindle **43** until small hole in side of front jaw **34** is aligned with track of balls **37** in clutch spindle **43**.
- Ten balls **37** will become visible through small hole in front jaw **34**.
- Gently tap front jaw **34**, allowing ten balls to fall out of hole in front jaw **34** (as each ball is ejected, turn front jaw **34** on clutch spindle **43** to align next ball with hole).
- Insert small rod through centre of front jaw **34** and tap out clutch spindle **43**.
- Remove drive jaw **33**, key **36** and spring **41**.

- Clean and inspect components, renewing any worn or damaged items, paying special attention to condition of front jaw **34** and drive jaw **33**.

- Assemble in reverse order to dismantling.
- Reset clutch torque (dependant on clutch spring fitted : see page 7) in the following manner (see diagram)
- Place square drive on end of clutch spindle **43** in vice, engaging approximately 10mm in vice jaws. This allows for spanner entry.
- Using a 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 the fastener type and size by turning the adjustment nut clockwise/anticlockwise as appropriate.



RESETTING CLUTCH TORQUE

HANDLE ASSEMBLY

- Replace handle and bush assembly **1** in soft jaw vice.
- Using spanner on ring gear **44**, remove front remove front gear assembly.
- Using spanner on housing **26**, remove inner gear assembly.
- Remove 'O' ring **19** and spacer **18** from handle and bush assembly **1** and pull out motor assembly. (It may be necessary to tap the front end of handle and bush assembly **1** on a wooden block until 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**.
- Unscrew adaptor **7** from handle and bush assembly **1** and remove filter **6**.
- Tap out pin **15** and carefully pull out trigger assembly, (take care not to damage 'O' 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 'O' ring **14**, three 'O' rings **2** from valve body **13** and 'O' rings **4** & **5** from valve **3**.
- Unscrew knob **75** and remove 'O' ring **67** from handle and bush assembly **1**.
- Remove screw **73** and washer **74**.
- Lightly tap end plate **70** to break Loctite seal between end plate **70** and valve assembly **65**.
- Remove end plate **70**, taking care not to damage pins **72**.
- Remove 'O' ring **71** and spring **69**.
- Push valve assembly **65** out of handle and bush assembly **1**.

IMPORTANT

Valve assembly 65 is a manufacturer supplied assembly and MUST NOT be dismantled.

- Remove 'O' ring **66** from valve assembly **65**.
- Remove 'O' ring **68** from valve bush but do not attempt to remove valve bushing from handle and bush assembly **1**.

- Assemble in reverse order to dismantling.
- When replacing screw **73** and washer **74** ensure thread sealant is used on screw threads.

FRONT GEAR ASSEMBLY (previously removed from handle assembly).

- Hold ring gear **44** and tap out internal assembly from front end.
- Remove two bearings **25** and spacer **46** from planet gear spindle **45**.
- Tap out two shafts **47** and remove two planet gears **48** and bearings **27** from planet gear **48**.
- Press out bearing **27** from planet gears **48**.

- Assemble in reverse order to dismantling.

REAR GEAR ASSEMBLY

- Pull off spacer **52**.
- Hold housing **26** and push out internal assembly from front end.
- Remove two bearings **25** and spacers **20** & **23** from planet gear spindle **24**.
- Push out two shafts **50** together with thirty needles **21**.
- Take out two planet gears **51** and drive gear **22**.
- Using circlip pliers remove circlip **49** from housing **26**.

- Assemble in reverse order to dismantling.

MOTOR ASSEMBLY (previously removed from handle assembly).

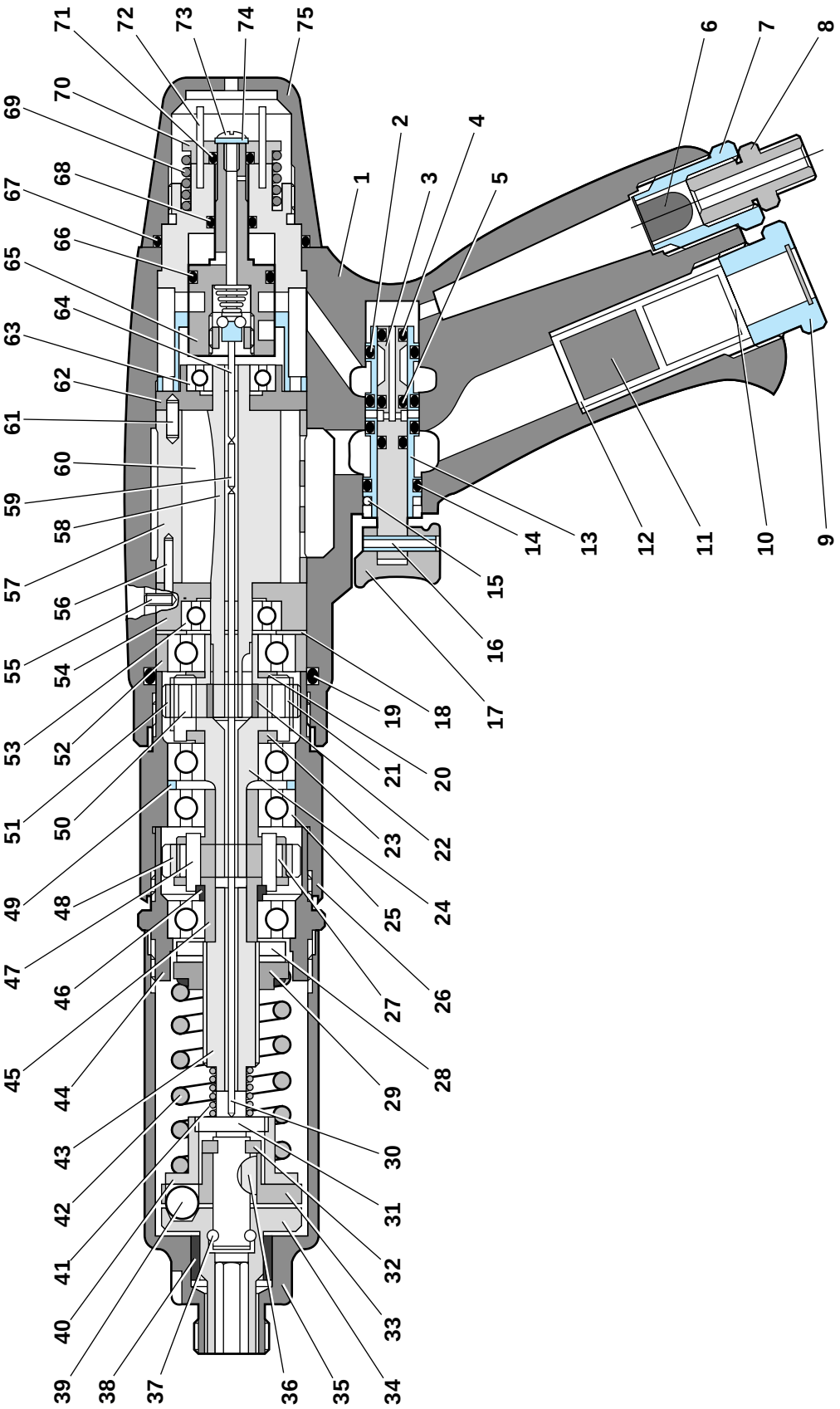
- Remove locating pin **55** from lower end plate **54**.
- Hold lower end plate **54** and tap splined end of rotor **58** with a soft hammer so as not to damage splines.
- Remove lower end plate **54** and bearing **53** from rotor **58**.
- Remove cylinder **57** complete with pin **56** and pin **61**.
- Remove five rotor blades **60** from rotor **58**.
- Support rear end plate **62** using a piece of tube with a bore diameter as close as possible to largest diameter of rotor **58**, then tap non-splined end of rotor **58** to remove it from rear end plate **62** and bearing **63**.
- Using a suitable punch, tap out bearing **53** from lower end plate **54**, bearing **63** and rear end plate **62**.

- When assembling, make sure that locating pin **55** in lower end plate **54** locates in keyway in front bore of handle.
- Pay special attention to lower end plate **54** and rear end plates **62**, ensuring they are free from burrs and surface marking. If necessary, lap faces that abut cylinder **57** on a flat fine grade abrasive paper.

- Press fit bearings **53** & **63** into lower and rear end plates **54** & **62**
- Support bearing **63** in rear end plate **62** on its inner ring and using a soft hammer, tap rotor **58** on its splined end until rotor **58** locates against rear end plate **62**.
- Support inner face of rear end plate **62** as close as possible to largest diameter of rotor **58**.
- Tap non-splined end of rotor **58** until a clearance of 0.0015" (0.040mm) to 0.0025" (0.065mm) is obtained between inner face of rear end plate **62** and rotor **58**.
- Check clearance by pulling rotor **58** away from rear end plate **62** and bearing **63**.
- Spin rotor **58** ensuring that it rotates freely in rear end plate bearing **63**.
- Locate cylinder **57** with locating pin **55** to rear end plate **62** and check ports in rear end plate **62** align with ports in cylinder **57**.
- Insert five rotor blades **60** into rotor **58**.
- Fit lower end plate **54** to cylinder **57** via locating pin **55**.
- Ensure rotor **58** spins freely.
- Refit motor into handle assembly in reverse order to removal (see handle assembly).

IMPORTANT

Check the tool against daily and weekly servicing.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07557-00200 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	08556-00406	COLLAR	1	-
02	08415-00207	'O' RING	3	3	41	08556-00411	SPRING	1	-
03	08556-00417	VALVE	1	1	42	08557-00202	CLUTCH SPRING 35-85lb. (COPPER)	1	-
04	08434-00202	'O' RING	1	1		08572-00407	CLUTCH SPRING 5-16lb. (OXIDE BLACK)	1	-
05	08441-00402	'O' RING	2	4		08556-00412	CLUTCH SPRING 12-35lb. (SILVER)	1	-
06	08415-00201	FILTER	1	2	43	08556-00408	CLUTCH SPINDLE	1	-
07	08415-00202	ADAPTOR	1	-	44	08430-00801	RING GEAR	1	-
08	08433-00221	NIPPLE	1	-	45	08430-00805	PLANET GEAR SPINDLE	1	-
09	08415-00203	SILENCER RETAINER ASSEMBLY	1	-	46	08430-00807	SPACER	1	-
10	08432-00201	PERFORATED WASHER	1	-	47	08430-00704	SHAFT	2	-
11	08415-00204	SILENCER ELEMENT	1	2	48	08430-00702	PLANET GEAR	2	-
12	08415-00205	SILENCER BODY	1	-	49	08430-00707	CIRCLIP	1	-
13	08520-00212	VALVE BODY	1	1	50	08434-00208	SHAFT	2	-
14	08520-00215	'O' RING	1	2	51	08434-00206	PLANET GEAR	2	-
15	08524-00207	PIN	1	2	52	08430-00706	SPACER	1	-
16	08433-00233	PIN	1	2	53	08430-00601	BEARING	1	-
17	08281-00405	TRIGGER	1	-	54	08430-00602	LOWER END PLATE	1	-
18	08430-00215	SPACER	1	-	55	08435-00202	LOCATING PIN	1	-
19	08522-00205	'O' RING	1	-	56	08433-00233	PIN	1	-
20	08434-00201	SPACER	1	-	57	08435-00214	CYLINDER	1	-
21	08434-00207	NEEDLE	30	-	58	08556-00415	ROTOR	1	-
22	08434-00203	DRIVE GEAR	1	-	59	08556-00418	NEEDLE ROLLER	1	3
23	08434-00205	SPACER	1	-	60	08430-00608	ROTOR BLADE	5	-
24	08556-00414	PLANET GEAR SPINDLE	1	-	61	08435-00203	PIN	1	-
25	08430-00705	BEARING	4	-	62	08433-00214	REAR END PLATE	1	-
26	08430-00708	HOUSING	1	-	63	08430-00606	BEARING	1	-
27	08434-00703	BEARING	2	-	64	08556-00416	PUSH ROD (SHORT)	1	3
28	08430-00229	ADJUSTMENT NUT	1	-	65	08556-00420	VALVE ASSEMBLY	1	-
29	08556-00409	ADJUSTMENT LOCK WASHER	1	-	66	08435-00209	'O' RING	1	-
30	08556-00413	PUSH ROD (LONG)	1	-	67	08435-00204	'O' RING	1	2
31	08556-00407	PIN	1	-	68	08415-00217	'O' RING	1	-
32	08556-00405	RETAINING RING HALF	2	-	69	08556-00425	SPRING	1	-
33	08556-00404	DRIVE JAW	1	-	70	08556-00422	END PLATE	1	-
34	08556-00401	FRONT JAW	1	-	71	08556-00424	'O' RING	1	-
35	08556-00402	CLUTCH HOUSING	1	-	72	08415-00209	PIN	2	-
36	08430-00223	KEY	1	-	73	08415-00221	SCREW	1	-
37	08430-00221	3/32 DIA. BALL	10	-	74	08415-00220	WASHER	1	-
38	08556-00403	BUSH	1	-	75	08415-00421	KNOB	1	-
39	08556-00410	5/16 DIA. BALL	3	-					

FAULT DIAGNOSIS TABLE

SYMPTOM	POSSIBLE CAUSE	REMEDY
Tool reverses	→ Worn thrust bearing or thrust washers	→ Replace
before Insert	→ Dirty insert threads	→ Change batch of inserts
is Placed	→ 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 instuctions
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	→ Push rod too long	→ Replace with one of correct length
permanently	→ Insufficient air supply	→ Adjust air pressure/volume
in reverse mode		
Tool runs	→ Push rods/needle roller missing	→ Replace where necessary
permanently	→ Air leak around screw **73**	→ Seal with thread sealant
in forward mode	→ Push rod too short	→ Replace
Inserts not	→ Torque setting too low	→ Adjust to correct setting
pulling up	→ 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	→ Dirty Nutserts	→ Clean Nutserts
centres falling out	→ 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	→ Clutch torque setting too high	→ Adjust to correct setting
screws	→ 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 07557

Serial N° _____

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

Avdel®

An Acument™ Global Technologies Company

AUSTRALIA
Acument Australia Pty Ltd.
891 Wellington Road
Rowville, Victoria 3178
Tel: +61 3 9765 6400
Fax: +61 3 9765 6445
Email: info@acument.com.au

CANADA
Avdel Canada, a Division of Acument
Canada Limited
87 Disco Road
Rexdale
Ontario M9W 1M3
Tel: +1 416 679 0622
Fax: +1 416 679 0678
Email: infoAvdel-Canada@acument.com

CHINA
Acument China Ltd.
RM 1708, 17/F., Nanyang Plaza,
57 Hung To Rd., Kwun Tong
Hong Kong
Tel: +852 2950 0631
Fax: +852 2950 0022
Email: infochina@acument.com

FRANCE
Avdel France S.A.S.
33 bis, rue des Ardennes
BP4
75921 Paris Cedex 19
Tel: +33 (0) 1 4040 8000
Fax: +33 (0) 1 4208 2450
Email: AvdelFrance@acument.com

GERMANY
Avdel Deutschland GmbH
Klusriede 24
30851 Langenhagen
Tel: +49 (0) 511 7288 0
Fax: +49 (0) 511 7288 133
Email: AvdelDeutschland@acument.com

ITALY
Avdel Italia S.r.l.
Viale Lombardia 51/53
20047 Brugherio (MI)
Tel: +39 039 289911
Fax: +39 039 2873079
Email: vendite@acument.com

JAPAN
Acument Japan Kabushiki Kaisha
Center Minami SKY,
3-1 Chigasaki-Chuo, Tsuzuki-ku,
Yokohama-city, Kanagawa Prefecture
Japan 224-0032
Tel: +81 45 947 1200
Fax: +81 45 947 1205
Email: info@acument.co.jp

SINGAPORE
Acument Asia Pacific (Pte) Ltd.
#05-03/06 Techlink
31 Kaki Bukit Road 3
Singapore, 417818
Tel: +65 6840 7431
Fax: +65 6840 7409
Email: Tlim@acument.com

SOUTH KOREA
Acument Korea Ltd.
212-4, Suyang-Ri,
Silchon-Eup, Kwangju-City,
Kyunggi-Do, Korea, 464-874
Tel: +82 31 798 6340
Fax: +82 31 798 6342
Email: info@acumentkorea.com

SPAIN
Avdel Spain S.A.
C/ Puerto de la Morcuera, 14
Poligono Industrial Prado Overa
Ctra. de Toledo, km 7,8
28919 Leganés (Madrid)
Tel: +34 (0) 91 3416767
Fax: +34 (0) 91 3416740
Email: ventas@acument.com

UNITED KINGDOM
Avdel UK Limited
Pacific House
2 Swiftfields
Watchmead Industrial Estate
Welwyn Garden City
Hertfordshire
AL7 1LY
Tel: +44 (0) 1707 292000
Fax: +44 (0) 1707 292199
Email: enquiries@acument.com

USA
Avdel USA LLC
614 NC Highway 200 South
Stanfield,
North Carolina 28163
Tel: +1 704 888-7100
Fax: +1 704 888-0258
Email: infoAvdel-USA@acument.com

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