ASWD317 AIR POWERED SPOT WELD DRILL

Features:

- **2 position trigger, first position sets the anvil the second position starts the drill.**
- **Exclusive 2 anvil kit with large and small anvils to cover nearly all needs.**
- **Kit comes with 6.5, 8.0 and 10.0 mm titanium coated drills to cover nearly all spot weld removal situations.**
- **Adjustable Vernier depth stop allows you to drill out just the spot weld and not the panel beneath.**
- **Drills out the entire spot weld, eliminates the need for grinding.**
- **Kit allows convenient storage no matter which anvil is on the drill.**
- **Assures accurate location, diameter and depth.**
- **High torque low speed for maximum power and control.**

Specifications:

Air Consumption	18 SCFM	Air Inlet	¼ in. NPT (F)
Free Speed	1,600 RPM	Recommended Hose Size	⅜ in. I.D.
Chuck Capacity	5/16 in.	Air Pressure	90 PSI

Model	Height (in.)	Length (in.)	Weight (lbs.)	Sound Level (dBA)
ASWD317 (with large anvil)	7⅝	12¾	6.4	80

WARNING

Always wear safety goggles to protect your eyes.

OIL DAILY

Oil daily for superior performance.

Operators Instructions

Includes – Product Highlights and Suggested Applications, Specifications, Please Read and Comply, Assembly Drawing of machine, Parts List, Putting the Tool into Service, Proper Use of Tool and Operating Instructions.

Important

Read these instructions carefully before installing, operating, servicing or repairing this tool. Keep these instructions in a safe accessible location.

Please Read and Comply With

1) General Industry Safety & Health Regulations, Part 1910, OSHA 2206, available from: Superintendent of Documents; Government Printing Office; Washington DC 20402

2) Safety Code for Portable Air Tools, ANSI B186.1 available from: American National Standards Institute, Inc.; 1430 Broadway; New York, NY 10018

3) State and Local Regulations.

Key parts of the above regulations are excerpted below. They are not intended to be inclusive. Study and comply with all regulations.

1) TOOL INTENT – Tool shall be used only for purposes intended in its design.

2) AIR SUPPLY – Test and operate tools at 90 PSIG (6.2 Bar) maximum unless tool is marked otherwise. Use recommended airline filters - regulators – lubricators (FRL).

3) UNUSUAL SOUND or VIBRATION – If tool vibrates or produces an unusual sound, repair immediately for correction.

4) OPERATOR PROTECTIVE EQUIPMENT – Wear goggles or face shield whenever tool is in operation. Other protective clothing shall be worn, if necessary.

5) SAFETY MAINTENANCE PROGRAM – Employ a safety program to provide inspection and maintenance of all phases of tool operation and air supply equipment in accordance with “Safety Code for Portable Air Tools.”

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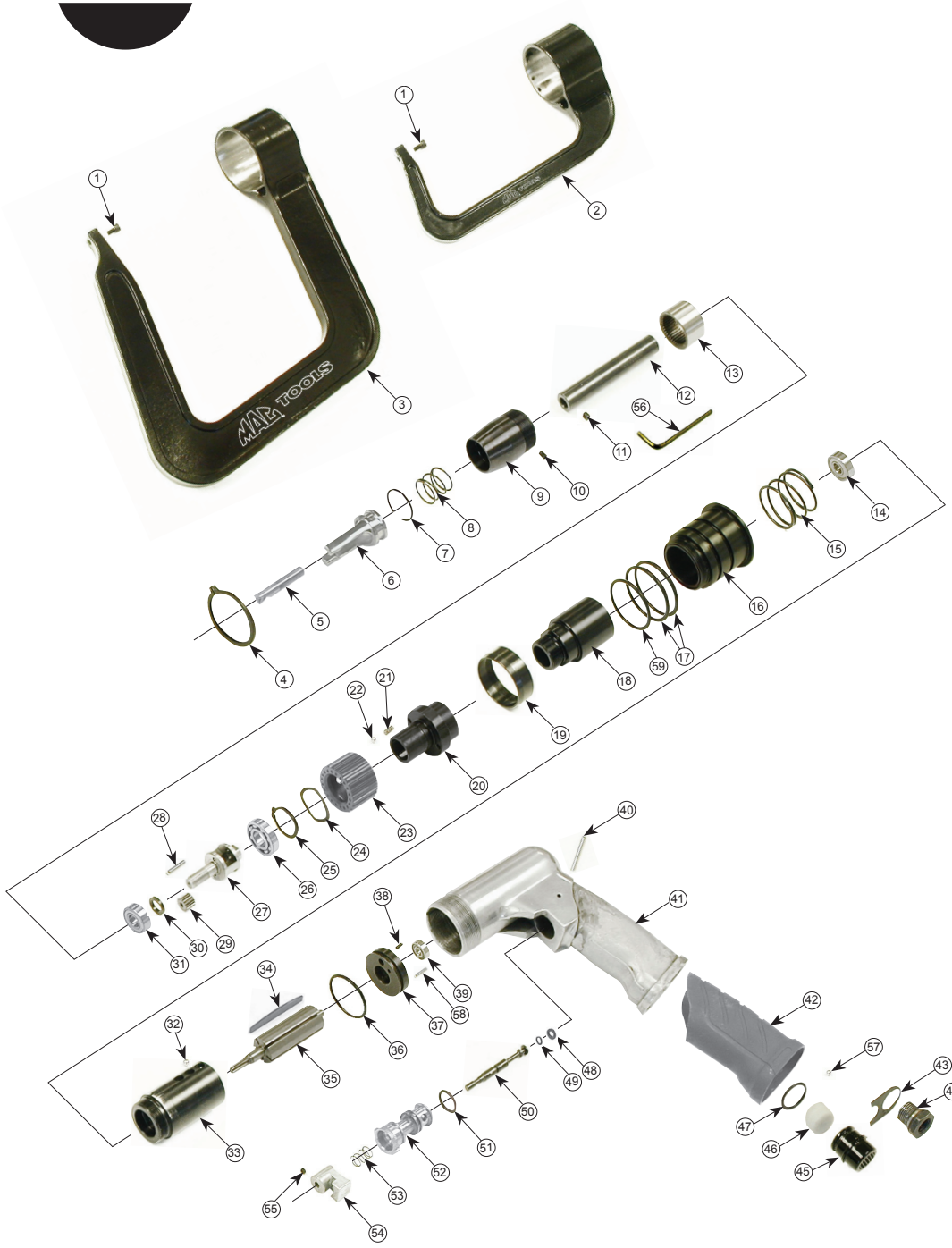

Parts List

No.	Parts No.	Description	Qty.
1	ASWD317-1	Screw (M4x8)	1
2	ASWD317-2	Arm (2 inch)	1
3	ASWD317-3	Arm (5.5 inch)	1
4	ASWD317-4	Retaining Ring	1
5	ASWD65MM	Replacement Drill Bit 5 Pack (6.5 mm)	1
	ASWD80MM	Replacement Drill Bit 5 Pack (8.0 mm)	1
	ASWD10MM	Replacement Drill Bit 5 Pack (10.0 mm)	1
6	ASWD317-6	Supporter	1
7	ASWD317-7	Retainer	1
8	ASWD317-8	Spring	1
9	ASWD317-9	Attachment	1
10	ASWD317-10	Set Screw (M4x6)	1
11	ASWD317-11	Set Screw (M5x5)	1
12	ASWD317-12	Bit Holder	1
13	ASWD317-13	Internal Gear	1
14	ASWD317-14	Ball Bearing (608ZZ)	1
15	ASWD317-15	Spring	1
16	ASWD317-16	Clamp Nut	1
17	ASWD317-17	O-ring	2
18	ASWD317-18	Gear Case	1
19	ASWD317-19	Lock Nut	1
20	ASWD317-20	Gear Housing	1
21	ASWD317-21	Spring	2
22	ASWD317-22	Ball (Ø 4)	2
23	ASWD317-23	Adjusting Nut	1
24	ASWD317-24	Wave Washer	2
25	ASWD317-25	Retaining Ring (S22)	1
26	ASWD317-26	Ball Bearing (R8)	1
27	ASWD317-27	Gear Cage	1
28	ASWD317-28	Pin (3x17.8)	2
29	ASWD317-29	Gear	2
30	ASWD317-30	Washer	1
31	ASWD317-31	Ball Bearing	1
32	ASWD317-32	Ball (Ø 5)	1
33	ASWD317-33	Cylinder	1
34	ASWD317-34	Rotor Blades	5
35	ASWD317-35	Rotor	1
36	ASWD317-36	O-ring (31.5x2.4mm)	1
37	ASWD317-37	Rear End Plate	1
38	ASWD317-38	Set Screw (M3x12)	1
39	ASWD317-39	Ball Bearing	1
40	ASWD317-40	Pin (3x31.8mm)	1
41	ASWD317-41	Housing	1
42	ASWD317-42	Grip	1
43	ASWD317-43	Muffler Retainer	1
44	ASWD317-44	Air Inlet	1
45	ASWD317-45	Muffler	1
46	ASWD317-46	Muffler Insert	1
47	ASWD317-47	O-ring	1
48	ASWD317-48	O-ring (3.9x2.25x2mm)	1
49	ASWD317-49	O-ring (3.5x1.5mm)	1
50	ASWD317-50	Valve Stem	1
51	ASWD317-51	O-ring (P14)	3
52	ASWD317-52	Valve Bushing	1
53	ASWD317-53	Spring	1
54	ASWD317-54	Trigger	1
55	ASWD317-55	Set Screw (M4x4)	1
56	ASWD317-WR	Service Wrench (2.5 mm)	1
57	ASWD317-57	Ball	1
58	ASWD317-58	Spring pin	1
59	ASWD317-59	O-ring (32x1.5mm)	1

Putting the Tool into Service

Use a clean lubricated air supply that will give a measured air pressure at the tool of 90 PSI (6.2 Bar) when the tool is running with the trigger fully depressed. It is recommended to use an approved 3/8 in. (10 mm) x 25 ft. (8 meter) maximum length airline. It is recommended that the tool be connected to the air supply as shown in Figure 1. Do not connect the tool to the airline system without incorporating an easy to reach and operate air shut off valve. The air supply should be lubricated. It is strongly recommended that an air filter, regulator and lubricator (FRL) be used as shown in Figure 1 as this will supply clean, lubricated air at the correct pressure to the tool. Details of such equipment can be obtained from your supplier. If such equipment is not used then the tool should be lubricated by shutting off the air supply to the tool, depressurizing the line by pressing the trigger on the tool. Disconnecting the airline and putting 2 to 3 drops of suitable pneumatic motor lubricating oil, preferably incorporating a rust inhibitor into the hose end (inlet) of the machine. Reconnect tool to air supply and run tool slowly for a few seconds to allow air to circulate the oil. If tool is used frequently lubricate on daily basis and if tool starts to slow or lose power.
It is recommended that the air pressure at the tool be 90 PSI (6.2 Bar) while the tool is running so the maximum RPM is not exceeded. The tool can be run at lower pressures but should never be run higher than 90 PSI (6.2 Bars). If run at lower pressure the performance of the tool is reduced.

Proper Use of Tool

This tool is to be used for removing spot welds from automotive panels only. Do not use this tool for any other purpose than specified.

This depth adjustable spot weld drill applies the cutting pressure for you. Be sure to release the trigger when the drill bit has stopped cutting.

Allow the drill to make gentle contact with the panel before pulling the trigger completely.

Read all instructions before using this tool. All operators must be fully trained in its use and aware of all safety rules. All service and repair must be carried out by trained personnel.

Make certain the tool is properly positioned before pulling trigger.

Always remove the air supply to the tool before fitting, adjusting or removing drill bits.

Always adopt a firm footing and/or position and be aware of torque reaction developed by the tool.
Use only correct spare parts.

Check hose and fittings regularly for wear.
Do not carry the tool by its hose and ensure that the hand is remote from the trigger when carrying the tool with the air supply connected.

Do not exceed maximum recommended air pressure.
Use safety equipment as recommended.

Operating Instructions

1) Depth adjustment is accomplished by turning the adjusting nut. Check the drilling depth by pulling back the supporter on the front of the drill. The amount of drill bit above the supporter indicates the drilling depth.
2) When used in conjunction with the arm, the drill will apply the cutting pressure against the spot weld.
   a. Hook the arm around the back of the panel.
   b. Pull the trigger half way to move the drill bit into position against the spot weld.
   c. Pull the trigger completely back to start the drill bit turning and to apply maximum pressure.
3) The arm is removable for applications on areas where the rear of the spot weld is inaccessible.
   a. When the arm is removed it is important that the technician pulls the trigger half way first to extend the drilling head.
   b. Place the opposite hand under the belly of the drill, then use the thumb and forefinger of that hand on the supporter to stabilize the drill.
   c. Once properly aligned with spot weld, pull the trigger completely to start drilling.

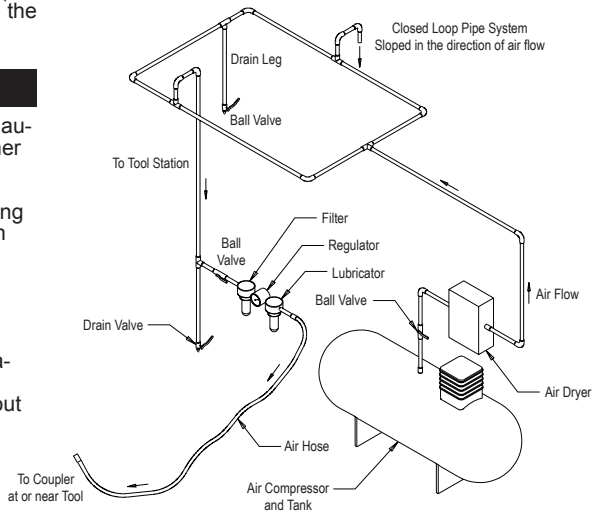

Figure 1