

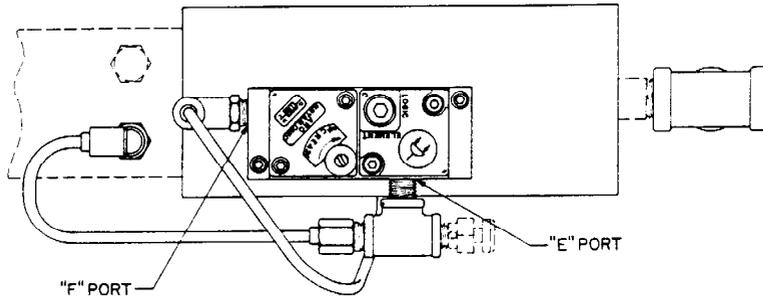
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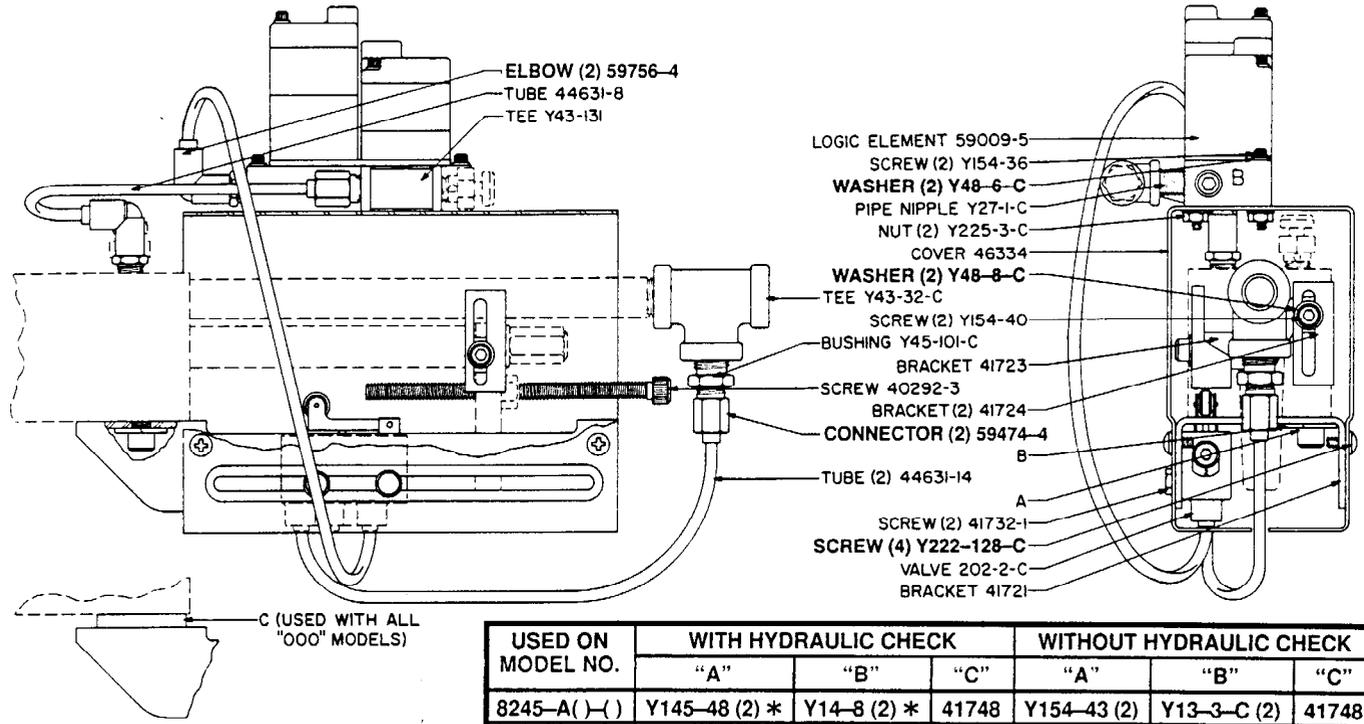
# SALES AND ENGINEERING DATA

## 41729 DWELL CONTROL KIT

SECTION: 100  
 PAGE NO.: 10  
 DATE: 6-26-98



NOT SHOWN  
 Y45-101-C BUSHING  
 (models 8245-A only)



USED ON MODEL NO.	WITH HYDRAULIC CHECK			WITHOUT HYDRAULIC CHECK		
	"A"	"B"	"C"	"A"	"B"	"C"
8245-A(-)(-)	Y145-48 (2) *	Y14-8 (2) *	41748	Y154-43 (2)	Y13-3-C (2)	41748
8255-A(-)(-)	Y157-44 (2) *	30997 *	NONE	Y157-40 (2)	Y13-4-C (2)	NONE
8258-C(-)(-)	Y157-44 (2) *	30997 *	NONE	Y157-40 (2)	Y13-4-C (2)	NONE
8265-(-)(-)	Y157-44 (2) *	30997 *	NONE	Y157-40 (2)	Y13-4-C (2)	NONE
8266-A(-)(-)	Y157-44 (2) *	30997 *	NONE	Y157-40 (2)	Y13-4-C (2)	NONE
8268-A(-)(-)	Y157-44 (2) *	30997 *	NONE	Y157-40 (2)	Y13-4-C (2)	NONE

\* NOT PART OF 41729 KIT, INCLUDED WITH HYDRAULIC CHECK ASSEMBLY.

The 41729 dwell control kit is designed to provide ARO "valve-in-head" self-feed tools with an adjustable time delay or retraction. In operation, the tool advances to a pre-set depth, dwells and then retracts. The dwell time can be adjusted from 0.1 to 10.0 seconds. This dwell time is beneficial in countersinking and spotfacing operations, assuring bottom finish is accurate.

The 41729 dwell control kit may be mounted on any ARO "valve-in-head" self-feed tool in the 8245-, 8255-, 8258-, 8265-, 8266- or 8268- series.

**TO INSTALL:**

Remove two screws, washers and cover from valve housing. Remove the button bleed valve from the rear retract port (port R) of valve housing. Remove pipe plug (Y227-2-L) from retract port (port R) on top of valve housing and assemble to rear retract port (port R). Tighten pipe plug until secure and flush or below flush with housing. Assemble bracket (41721) to housing and secure with two washers ("B") and two screws ("A"). NOTE: Models 8245-(-) require the use of spacer (41748). Assemble valve (202-2-C) to bracket and secure with two screws (41732-1). Remove adapter (44883) and washer (Y14-616) from rear of piston rod. Assemble bracket (41723) to piston rod and secure with washer (Y14-616) and adapter (44883). Assemble two brackets (41724) to bracket (41723) and secure with two washers (Y48-8-C) and

two screws (Y154-40). Replace adjustment screw (40292-) with screw (40292-3) supplied with kit. Assemble elbow (59756-4) to "F" port of logic element (59009-5). Assemble pipe nipple (Y27-1-C) and tee (Y43-131) to "E" port of logic element and assemble logic element to cover (46334) securing with two washers (Y48-6-C), two screws (Y154-36) and two nuts (Y225-3-C). Assemble elbow (59756-4) to top retract port (port R) of valve housing. Assemble connector (59474-4) to tee (Y43-131). Assemble cover (46334) to bracket (41721) securing with four screws (Y222-128-C). Assemble tube (44631-8) to connector (59474-4) and elbow (59756-4) in top retract port (port R) of valve housing. Assemble tube (44631-14) to elbow (59756-4) at "F" port and to rear port of valve (202-2-C). Assemble tee (Y43-32-C), bushing (Y45-101-C) and connector (59474-4) to air inlet pipe nipple and position as shown. NOTE: Models 8245-(-) require the use of extra bushing (Y45-101-C) installed between the tee (Y43-32-C) and the air inlet pipe nipple. Assemble tube (44631-14) to connector (59474-4) and front port of valve (202-2-C). Assemble button bleed valve (24130), which was removed from valve housing, to tee (Y43-131) as shown. Depressing this bleed valve when tool is in operation will cause the tool to retract immediately, bypassing the dwell timer. If remote retraction is desired, replace the button bleed valve (24130) with pilot pressure bleed valve (9600). Valve (9600) is not supplied with kit.

For parts and service information, contact your local ARO distributor, or the Customer Service Dept. of the Ingersoll-Rand Distribution Center, White House, TN at PH: (615) 672-0321, FAX: (615) 672-0801.

**ARO Tool Products**

PN 49999-321

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