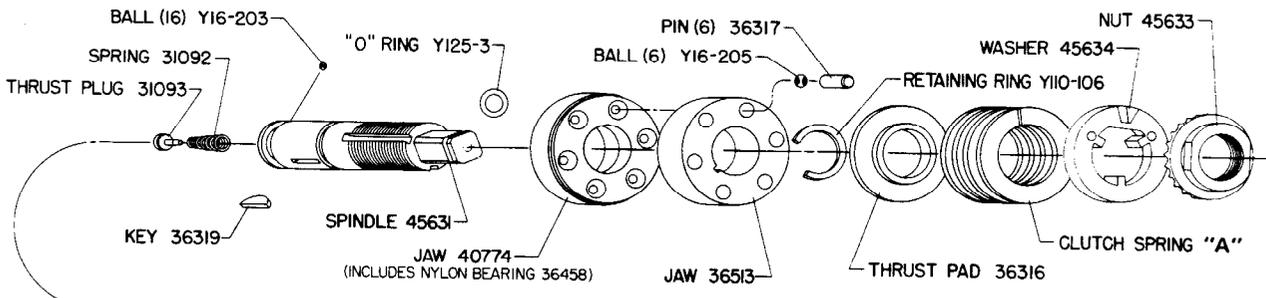
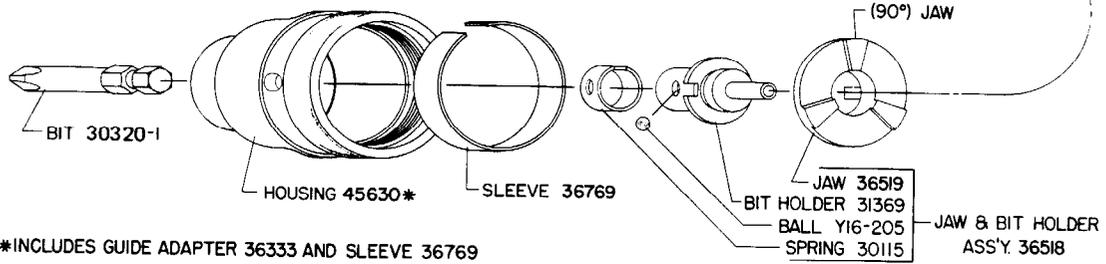


45629-() "000" SERIES EXTERNAL ADJUSTABLE CLUTCH ASSEMBLY



PARTS SHOWN BELOW THIS LINE ARE NOT INCLUDED IN 45629-() CLUTCH ASS'Y.



*INCLUDES GUIDE ADAPTER 36333 AND SLEEVE 36769

ASS'Y. NO.	TYPE	SPRING IDENTIFICATION		"A"
		TYPE WIRE	WIRE THICKNESS	
45629-1	STANDARD DUTY	ROUND	.080	36512
45629-2	HEAVY DUTY	FLAT	.062 x .156	36315

EXTERNAL CLUTCH ADJUSTMENT: Rotate Sleeve (36769) and align open portion of Sleeve with slot in Housing (45630). Depress Bit to engage Clutch Jaws and rotate Bit until notch in side of Adjusting Washer (45634) aligns with slot in Housing. Insert No. 2 Phillips Screwdriver thru slot in Housing and into Notch in Adjustment Washer and gear teeth in Nut. Turn screwdriver counter-clockwise to increase torque/clockwise to decrease torque.

DISASSEMBLY

- a. Remove Clutch Housing (L.H. threads) and Bit Holder Assembly (36518) from tool. Grasp Clutch Assembly and pull from gearing.
- b. Remove Adjusting Nut (45633), Washer (45634), and Clutch Spring "A".
- c. Remove Thrust Pad (36316), Pins (36317), and Balls (Y16-205).
- d. Remove Retaining (Y110-106), releasing Jaw (36513), Key (36319), Jaw (40774), and Balls (Y16-203).

REASSEMBLY

NOTE: Lubricate Balls, Jaw faces, and Bit Holder Shaft when assembling clutch, using grease 40036-1, or equivalent. Clutch assembly should contain approximately 1/8 oz. grease.

- a. Assemble Jaw (40774) to Spindle (45631) aligning face of Jaw with center of bearing groove in Spindle. Assemble Balls (Y16-203) into groove and slide Jaw ahead to retain balls in groove.
- b. Assemble Key (36319) and Jaw (36513) to Spindle and secure with Retaining Ring (Y110-106). **NOTE:** assemble Jaw (36513) to Spindle with small hole in face of Jaw, facing Jaw (40774).
- c. Assemble Balls (Y16-205), Pins (36317), Thrust Pad (36316), Clutch Spring, Washer (45634) and Nut (45633). Adjust to desired tension – see Clutch Adjustment.
- d. Assemble Spring (31092), Plug (31093), Bit Holder Assembly (36518) and Bit to Spindle and assemble to tool. Assemble Clutch Housing to tool.

INDUSTRIAL AIR TOOLS
THE ARO CORPORATION
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