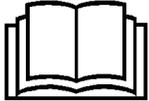


50 SERIES SCREWDRIVERS

SG052B-17-QFT
1700 R.P.M.
20° POSITIVE CLUTCH

**⚠ WARNING**

**READ THIS MANUAL CAREFULLY BEFORE INSTALLING,
OPERATING OR SERVICING THIS EQUIPMENT.**

FAILURE TO OBSERVE THE FOLLOWING WARNINGS COULD RESULT IN INJURY.

Pneumatic tools should always be installed and used in accordance with A.N.S.I. B186.1 "Safety Code For Portable Air Tools."

⚠ WARNING

- Operate this tool at 90 p.s.i.g. (6.2 bar) maximum air pressure at the air inlet of the tool.
- Disconnect air supply from tool before removing/installing bit, socket or device attached to tool or performing maintenance procedures.
- Keep hands, clothing and long hair away from rotating end of tool.
- Anticipate and be alert for sudden changes in motion during start up and operation of any power tool.
- Never exceed rated r.p.m. of tool.
- Wear suitable eye and hearing protection while operating tool.
- Tool shaft can continue to rotate briefly after throttle is released.
- Do not lubricate tools with flammable or volatile liquids such as kerosene, diesel or jet fuel.
- Do not remove any labels. Replace any damaged label.
- Use only accessories recommended by ARO.

⚠ WARNING

Repeated prolonged operator exposure to vibrations which may be generated in the use of certain hand-held tools may produce Raynaud's phenomenon, commonly referred to as Whitefinger disease. The phenomenon produces numbness and burning sensations in the hand and may cause circulation and nerve damage as well as tissue necrosis. Repetitive users of hand-held tools who experience vibrations should closely monitor duration of use and their physical condition.

NOTICE

- The use of other than genuine ARO replacement parts may result in safety hazards, decreased tool performance and increased maintenance and may invalidate all warranties.
- ARO is not responsible for customer modification of tools for applications on which ARO was not consulted.
- Tool maintenance and repair should be performed by authorized, trained, competent personnel. Consult your nearest ARO authorized servicer.
- It is the responsibility of the employer to place the information in this manual into the hands of the operator.

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) 672-0601.

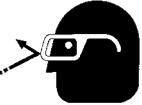
ARO Tool Products

Ingersoll-Rand Company
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FAILURE TO OBSERVE THE FOLLOWING WARNINGS COULD RESULT IN INJURY.

⚠ WARNING



Wear eye protection when operating or performing maintenance on this tool.

⚠ WARNING



Wear hearing protection when operating this tool.

⚠ WARNING



Turn off air supply and disconnect air supply hose before installing, removing or adjusting any accessory on this tool, or before performing any maintenance on this tool.

⚠ WARNING



Air powered tools can vibrate in use. Vibration, repetitive motions or uncomfortable positions may be harmful to your hands and arms. Stop using any tool if discomfort, tingling feeling or pain occurs. Seek medical advice before resuming use.

⚠ WARNING



Do not carry the tool by the hose.

⚠ WARNING



Do not use damaged, frayed or deteriorated air hoses and fittings.

⚠ WARNING



Do not overreach when operating this tool. Keep body stance balanced and firm.

⚠ WARNING



Operate at 90 p.s.i.g. (6.2 bar/620 kPa) maximum air pressure.

NOTICE

⚠ WARNING

Read the manual before operating this tool.
Operate at 90 psig/6.2 bar max.

PN 48176-1 LABEL

This label must appear on the tool at all times. If it is lost or damaged, a replacement label is available at no cost.

WARNING = Hazards or unsafe practices which could result in severe personal injury, death or substantial property damage.

CAUTION = Hazards or unsafe practices which could result in minor personal injury or product or property damage.

NOTICE = Important installation, operation or maintenance information.

ROUTINE LUBRICATION REQUIREMENTS

Lack of or an excessive amount of lubrication will affect the performance and life of this tool. Use only recommended lubricants at below time intervals:

EVERY 8 HOURS OF TOOL OPERATION - Fill lubricator reservoir of recommended F.R.L. with spindle oil (29665). If an in line or air line lubricator is not used, apply several drops of spindle oil (29665) in air inlet.

EVERY 160 HOURS OF TOOL OPERATION - Lubricate clutch parts with molybdenum grease (40036-1). Lubricate gearing. Pack bearings, coat shafts and lubricate gears with NLGI #1 "EP" grease (33153). Gearing should contain approximately 1/16 oz. (1.8 g) for double reduction. Positive clutch should contain approximately 1/32 oz. (.9 g) of grease.

AIR SUPPLY REQUIREMENTS

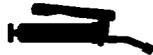
For maximum operating efficiency, the following air supply specifications should be maintained to this air tool:

- AIR PRESSURE - 90 p.s.i.g. (6.2 bar)
- AIR FILTRATION - 50 micron
- LUBRICATED AIR SUPPLY
- HOSE SIZE - 5/16" (8 mm) I.D.

An ARO® model C28231-810 air line FILTER/REGULATOR/LUBRICATOR (F.R.L.) is recommended to maintain the above air supply specifications.

RECOMMENDED LUBRICANTS

After disassembly is complete, all parts, except sealed or shielded bearings, should be washed with solvent. To relubricate parts, or for routine lubrication, use the following recommended lubricants:



<u>Where Used</u>	<u>ARO Part #</u>	<u>Description</u>
Air Motor	29665	1 qt Spindle Oil
"O" Rings & Lip Seals	36460	4 oz. Stringy Lubricant
Gears and Bearings	33153	5 lb. "EP" - NLGI #1 Grease
Clutches	40036-1	1 lb. "EP" Molybdenum Disulfide

INSPECTION, MAINTENANCE AND INSTALLATION

Disconnect air supply from the tool or shut off air supply and exhaust (drain) line of compressed air before performing maintenance or service to the tool.

It is important that the tools be serviced and inspected at regular intervals for maintaining safe, trouble-free operation of the tool.

Be sure the tool is receiving adequate lubrication, as failure to lubricate can create hazardous operating conditions resulting from excessive wear.

Be sure that the air supply lines and connectors are of proper size to provide a sufficient quantity of air to the tool.

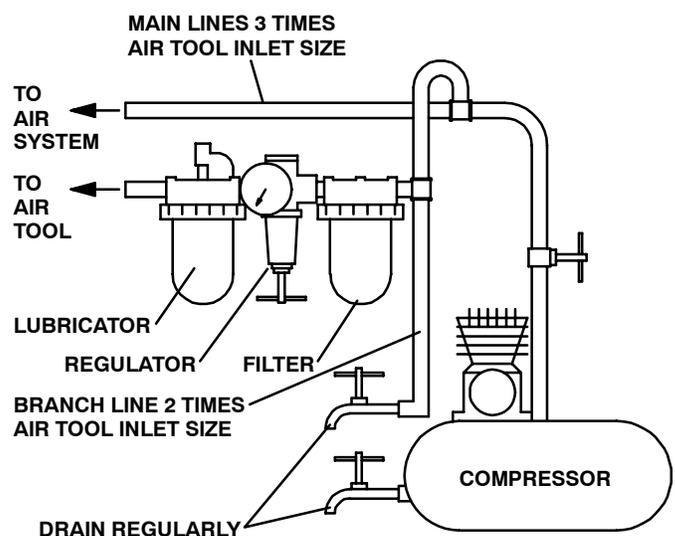
Tool maintenance and repair shall be performed by authorized, trained, competent personnel. Tools, hose and fittings shall be replaced if unsuitable for safe operation and responsibility should be assigned to be sure that all tools requiring guards or other safety devices shall be kept in legible condition. Maintenance and repair records should be maintained on all tools. Frequency of repair and the nature of the repairs can reveal unsafe application. Scheduled maintenance by competent authorized personnel should detect any mistreatment or abuse of the tool and worn parts. Corrective action should be taken before returning the tool for use.

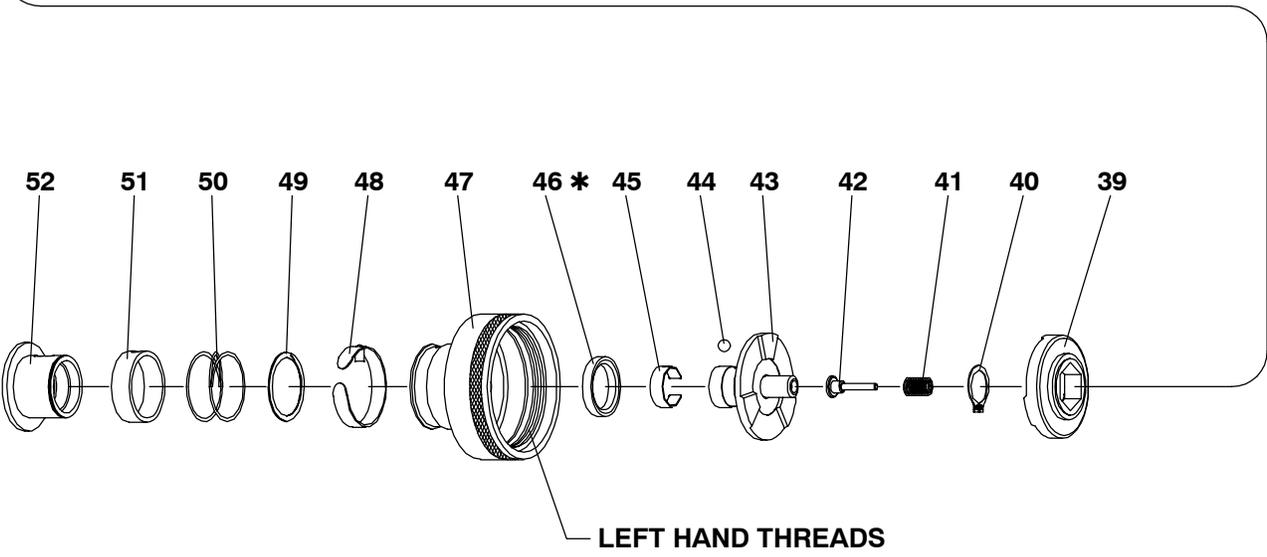
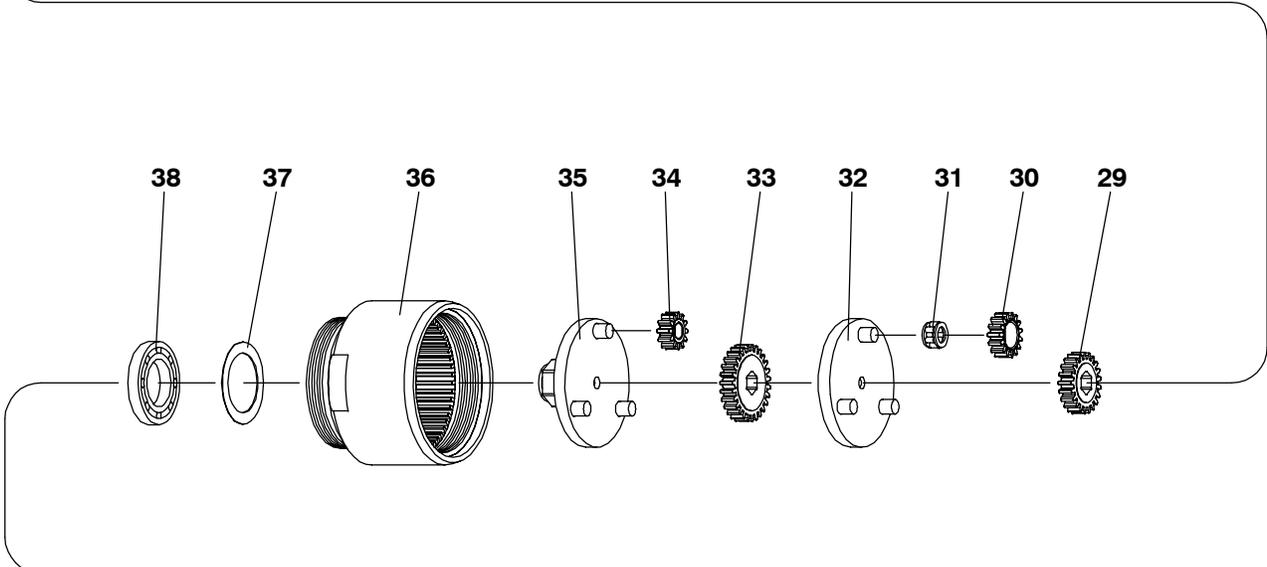
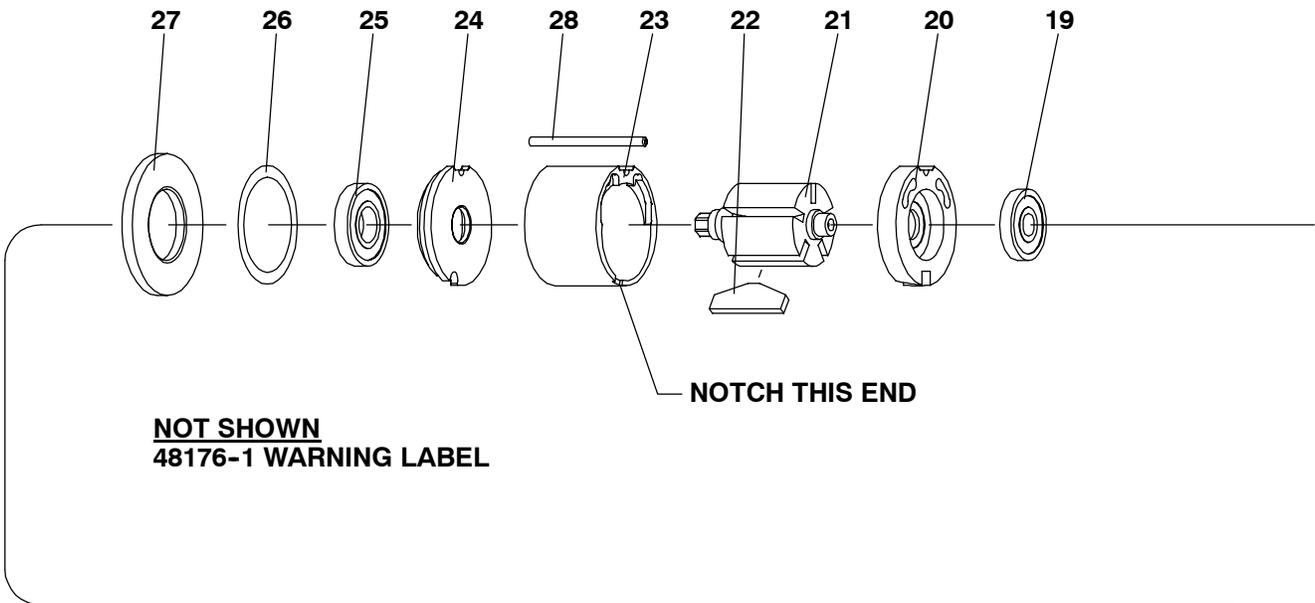
Disassembly should be done on a clean work bench with a clean cloth spread to prevent the loss of small parts. After disassembly is completed, all parts should be thoroughly washed in a clean solvent, blown dry with air and inspected for wear levels, abuse and contamination. Double sealed or shielded bearings should never be placed in solvent unless a good method of re-lubricating the bearing is available. Open bearings may be washed but should not be allowed to spin while being blown dry.

Upon reassembling, lubricate parts where required. Use 33153 grease, or equivalent, in bearings. Use 36460 lubricant for "O" ring assembly. When assembling "O" rings or parts adjacent "O" rings, care must be exercised to prevent damage to the rubber sealing surfaces. A small amount of grease will usually hold steel balls and other small parts in place while assembling.

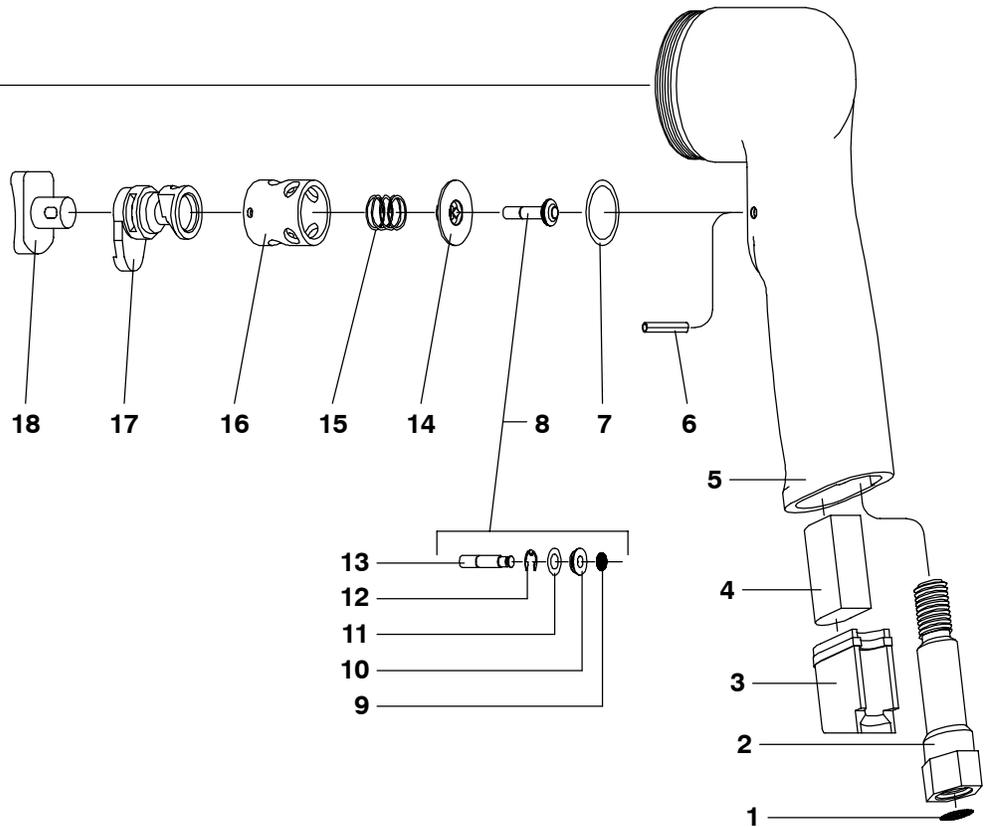
When replacement parts are necessary, consult drawing containing the part for identification.

Always use clean, dry air. Dust, corrosive fumes and/or excessive moisture can damage the motor of an air tool. An air line filter can greatly increase the life of an air tool. The filter removes rust, scale, moisture and other debris from the air lines. Low air pressure (less than 90 p.s.i.g.) reduces the speed of the air tool. High air pressure (more than 90 p.s.i.g.) raises performance beyond the rated capacity of the tool and could cause injury. Shown below is a typical piping arrangement.





*** OIL IMPREGNATED BRONZE BUSHING. DO NOT WASH, WIPE CLEAN ONLY.**



PART NUMBER FOR ORDERING

PART NUMBER FOR ORDERING

1	Screen	33911	28	Locating Pin	47723-1
2	Inlet Adapter	46385	29	Sun Gear (21 teeth)	46465
3	Muffler Assembly	46857	30	Planet Gear (3 req'd) 15 teeth	46899
4	Filler	46851	31	Needle Bearing (3 req'd)	42315
5	Pistol Grip Housing	47367	32	Carrier Assembly	46521
6	Spiral Pin	46849	33	Sun Gear (27 teeth)	46464
7	"O" Ring	Y325-15	34	Planet Gear (3 req'd) 12 teeth	46460
8	Valve Stem Assembly	49993	35	Spindle Assembly	47797
9	"O" Ring	Y325-3	36	Ring Gear	46467
10	Valve	45473-1	37	Spacer	46496
11	"O" Ring	Y325-7	38	Ball Bearing	46243
12	Retaining Ring	Y180-13	39	Jaw	47176-1
13	Valve Stem	49992	40	Retaining Ring	Y145-3
14	Guide	49991	41	Spring	46854
15	Spring	41100	42	Pin Assembly	47182
16	Valve Bushing	46381	43	Bit Holder Assembly (includes items 44 and 45) ..	47272
17	Reverse Valve	46299-1	44	Ball	Y16-204
18	Trigger	46298	45	Retaining Clip	47695
19	Ball Bearing	47724	46	Bushing	46360
20	Rear End Plate	46312-1	47	Clutch Housing (includes item 46)	47792
21	Rotor	46454	48	Retaining Clip and Pin	47782
22	Blade (5 req'd)	46413	49	Retaining Ring	47779
23	Cylinder	46311	50	Spring	47778
24	Front End Plate	47722	51	Bushing	47775
25	Ball Bearing	Y65-13	52	Sleeve	47702-1
	Motor Assembly (includes items 19 thru 25)	47728		Quick-Change Sleeve Assembly (includes items 49 thru 52)	46884-1
26	"O" Ring	Y325-214			
27	Spacer	46412			

DISASSEMBLY/ASSEMBLY INSTRUCTIONS

NOTICE

- Never apply excessive pressure by a holding device which may cause distortion of a part.
- Apply pressure evenly to parts which have a press fit.
- Apply even pressure to the bearing race that will be press fitted to the mating part.
- Use correct tools and fixtures when servicing this tool.
- Don't damage "O" rings when servicing this tool.
- Use only genuine ARO replacement parts for this tool. When ordering, specify part number, description, tool model number and serial number.

CLUTCH DISASSEMBLY

- Clamp the tool in a smooth face vise, clamping on handle (5).
- Remove clutch housing (47), using a strap type wrench - LEFT HAND THREADS.
- Remove clutch assembly from tool.
- Remove pin assembly (42) and spring (41) from jaw.
- Remove retaining ring (40), releasing jaw (39).

CLUTCH ASSEMBLY

- Assemble jaw (39) to spindle (35) and secure with retaining ring (40).
- Coat pin assembly (42) with ARO 29665 spindle oil, then slide spring (41) over pin assembly.
- Install pin assembly (42) and spring (41) into spindle (35).
- Lubricate spindle, jaw face and ball (44) of bit holder (43) with ARO 40036-1 clutch lube and assemble to tool.
- Assemble clutch housing (47) to tool - LEFT HAND THREADS.

GEARING DISASSEMBLY

- Remove clutch from tool.
- Remove ring gear (36), using a wrench on flats.
- Remove retaining ring (40) from spindle (35).
- Remove spindles and gears from ring gear (36), keeping gears grouped with mating spindle.
- Do not remove bearing (38) or spacer (37) unless damage is evident.
- To remove bearing (38) and spacer (37) from ring gear, press on spacer (37) from inside splined end of ring gear.
- Do not remove gear (33) from carrier assembly (32) unless damage is evident. Gear is press fit onto carrier assembly.

GEARING ASSEMBLY

- Lubricate bearings with ARO 33153 grease upon assembly.
- Assemble spacer (37) into ring gear (36).
- Assemble bearing (38) into ring gear, pressing on outer race of bearing.
- Coat shafts of spindle (35) and carrier assembly (32) with ARO 33153 grease.
- Assemble gears to shafts of mating spindle.
- Assemble carrier assembly to spindle assembly.
- Assemble spindles and gearing into ring gear (36). Rotate spindle and gears to align gear teeth with splines of ring gear.
- Assemble jaw (39) and retaining ring (40) to spindle (35).
- Thread ring gear to tool and tighten, using a wrench on flats.
- Assemble clutch to tool.

MOTOR DISASSEMBLY

- Remove clutch and gearing from tool.
- Remove spacer (27) and "O" ring (26).
- Tap front edge of housing to remove motor assembly. Locating pin (28) should also come out.
- Grasp cylinder in one hand and tap drive end of rotor (21) with a soft face hammer; motor will come apart. NOTE: Bearings are press fit on rotor.
- Remove end plate (20) and bearing (19) from rotor.

MOTOR ASSEMBLY

- Lubricate bearing (19) with ARO 33153 grease and assemble to end plate (20), pressing on outer race of bearing.
- Assemble end plate (20) to rotor, pressing on inner race of bearing.
- Coat five rotor blades (22) with ARO 29665 spindle oil and assemble to rotor slots - straight side out.
- Coat i.d. of cylinder (23) with ARO 29665 spindle oil and assemble over rotor. NOTE: Air inlet slots in end of cylinder must be aligned with two air inlet slots in end plate (20).
- Assemble bearing (25) to end plate (24), pressing on outer race of bearing.
- Assemble end plate (24) to rotor, pressing on inner race of bearing. Be sure rotor turns without binding.
- Insert locating pin (28) into .096" diameter blind hole at bottom of motor cavity in housing.
- Align notches of end plates and cylinder and install motor into housing, aligning notches with locating pin (28).
- Lubricate "O" ring (26) and assemble to end plate.
- Assemble spacer (27) to motor.
- Assemble gearing and clutch to tool.

HOUSING DISASSEMBLY

- Remove spiral pin (6), driving it out the left side of the housing.
- Remove trigger (18), reverse valve (17), valve bushing (16), spring (15), guide (14), valve assembly (8) and "O" ring (7).
- Remove "O" ring (9), valve (10), "O" ring (11) and retaining ring (12).
- Remove inlet adapter (2) and screen (1).
- Remove muffler (3) and filler (4).

HOUSING ASSEMBLY

- Lubricate "O" ring (7) and assemble to housing.
- Assemble retaining ring (12) to valve stem (13).
- Lubricate "O" ring (11) and assemble to valve (10).
- Assemble valve (10) to valve stem, with smallest diameter of valve going on valve stem first.
- Lubricate "O" ring (9) and assemble to valve stem (13).
- Assemble guide (14) and spring (15) over valve stem (13).
- Assemble reverse valve (17) into valve bushing (16). NOTE: Position the .102" diameter hole thru bushing to align with slot thru side of reverse valve (17).
- Assemble valve stem (8) and components thru reverse valve (17) and bushing (16).
- Install valve bushing (16) with valve components and reverse valve (17) into pistol grip housing (5), aligning .102" diameter holes in housing and bushing.
- Assemble trigger (18) to reverse valve (17).
- Install spiral pin (6), pressing in from left side of housing.
- Install filler (4), muffler (3) and inlet adapter (2).
- Clean and install screen (1) in inlet adapter (2).

