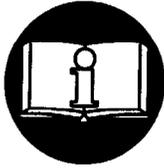


SLE01A-9-W, SLE04A-10-Q, SLE10A-7-Q, SLE04A-10-QC, AND SLE10A-7-QC ELECTRIC SCREWDRIVERS



⚠ WARNING

**IMPORTANT SAFETY INFORMATION ENCLOSED.
READ THIS MANUAL BEFORE OPERATING TOOL.**

FAILURE TO OBSERVE THE FOLLOWING WARNINGS COULD RESULT IN INJURY.

- **Always wear eye protection when operating or performing maintenance on this tool.**
- **Power 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.**
- **Keep work area clean.** Cluttered areas and benches invite injuries.
- **Consider work area environment.** Don't expose power tools and chargers to water. Keep work area well lighted. Do not use tool in presence of flammable liquids or gases.
- **Keep bystanders away.** Do not permit unauthorized personnel to operate this tool.
- **Store idle tools.** When not in use, tools should be stored in a dry and secured area.
- **Don't force tool.** It will do the job better and more safely at the rate for which it was intended.
- **Use the right tool.** Do not force a small tool or attachment to do the job of a heavy-duty tool.
- **Don't use tool for purpose not intended.**
For example – don't use screwdriver for a drill.
- **Dress properly.** Do not wear loose clothing or jewelry. They can be caught in moving parts. Rubber gloves and non-skid footwear are recommended when working outdoors. Wear protective hair covering to contain long hair.
- **Secure work.** Use clamps or a vise to hold work. Operators often need both hands to perform job functions.
- **Don't overreach.** Keep proper footing, balance, and a firm grip on the tool at all times.
- **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. Inspect tool cords periodically and if damaged, have them repaired by an authorized service facility. Inspect extension cords periodically and replace if damaged. Keep handles dry, clean, and free from oil and grease.
- **Remove adjusting keys and wrenches.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
- **Avoid unintentional starting.** Don't carry tool with finger on switch.

(continued on page 2)

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 Tool was not consulted.

Repairs should be made only by authorized trained personnel. Consult your nearest ARO Tool Authorized Servicenter.

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.

ARO Tool & Hoist Products

Ingersoll-Rand Company

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(Continued from page 1)

- **Stay alert.** Watch what you are doing. Use common sense. Do not operate tool when you are tired.
- **Check damaged parts.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced by

an authorized service center unless otherwise indicated elsewhere in this operation manual.

- **Have defective switches replaced by an authorized service center.**
- **Do not use the tool if the switch does not turn it on and off.**

WARNING

These tools can be used with SEC24N Electric Screwdriver controller. Disconnect the Controller power cord before performing and maintenance on these tools.

PLACING TOOL IN SERVICE

OPERATIONS CAUTIONS

- Whenever changing a bit, make certain the Forward/Reverse Switch is in the “OFF” position and the tool is unplugged.
- Do not allow chemicals such as acetone, benzene, thinner, ketone, trichloroethylene or other similar chemicals to come in contact with the screwdriver housing as damage will result.
- Do not drop or abuse the screwdriver.
- Do not adjust the torque setting higher than 5 on the Torque Scale.

Duty cycle:

MAX 0.5 sec. “ON”

MIN 3.5 SEC. “OFF”

- Do not tighten more than 900 tapping screws (size: 2 mm, length: 4 mm) per hour.
- Do not use this screwdriver for tightening wood screws.
- Do not operate the Forward/Reverse Switch when the motor is running.
- Whenever a tool is not being used, move the Forward/Reverse Switch to the “OFF” position and unplug the screwdriver.

MAINTENANCE SECTION

TORQUE ADJUSTMENT

To adjust the torque on these screwdrivers, proceed as follows:

1. Determine the torque output of the tool by checking a tightened fastener with a torque wrench.
2. Increase or decrease the torque output by rotating the Spring Adjusting Ring (37 or 39). Rotating the Ring **clockwise** to a higher number on the Torque Scale increase torque output while rotating the Ring **counterclockwise** to a lower number decreases the torque output.

NOTICE

The numbers from zero to seven on the Torque Scale are reference numbers only and are not an indication of actual torque output.

3. Check the adjustment with a torque wrench. A number of factors will affect torque output from one job to another. Final torque adjustment should be made at the job through a series of gradual increase. Always start below the desired torque and work upward.

CAUTION

- **Do not drop or abuse the tool.**
- **Whenever a tool is not being used, position the Power Switch to the “OFF” position and unplug the power cord.**

DO NOT ATTEMPT TO REPAIR THIS TOOL.

All repairs and maintenance of this tool and its cord must be performed by a qualified technician. Contact your local ARO distributor.

NOTICE

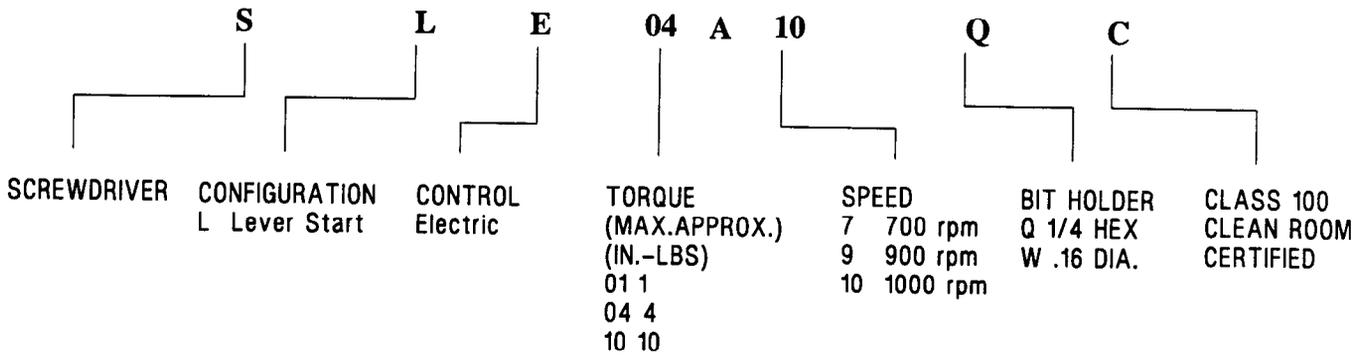
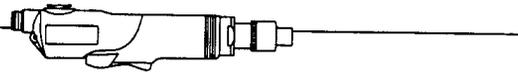
SAVE THESE INSTRUCTIONS. DO NOT DESTROY.

MAINTENANCE SECTION

MODEL IDENTIFICATION

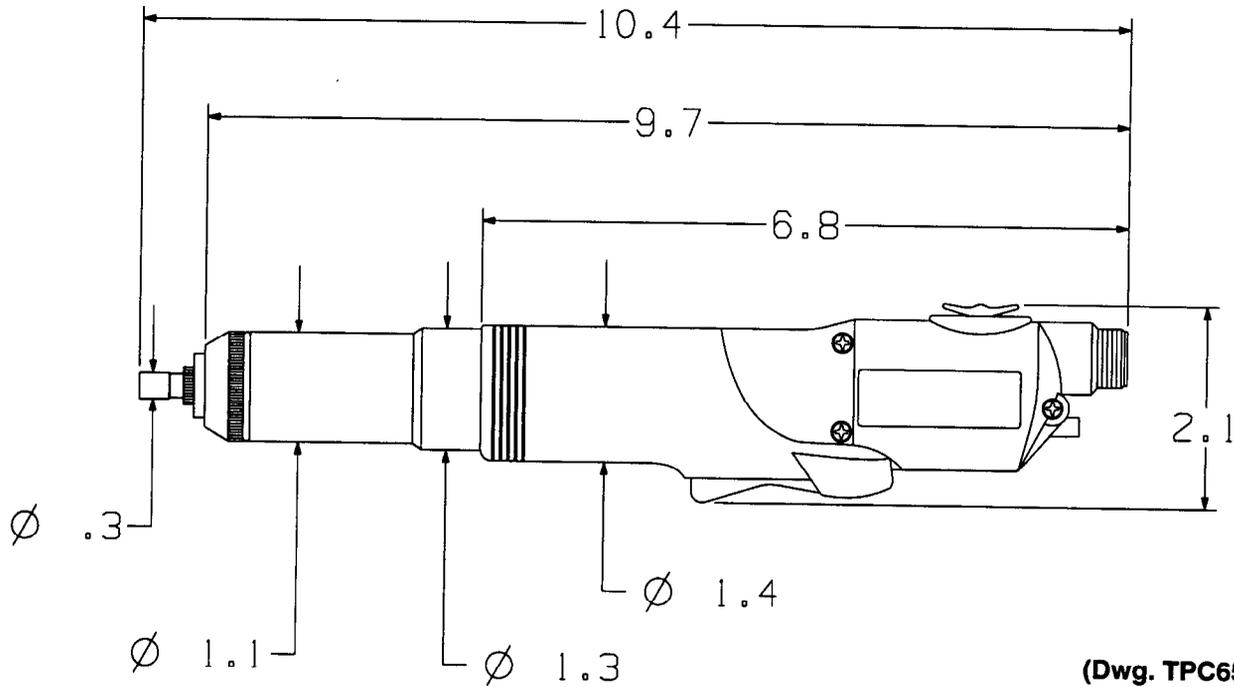
Low Torque (Requires Controller)

- Power: 24V DC From Controller
- Cable Length: 5 ft. Straight
- Sound: 65 dBA
- Reversible: Yes



(Dwg. TPD1859-1)

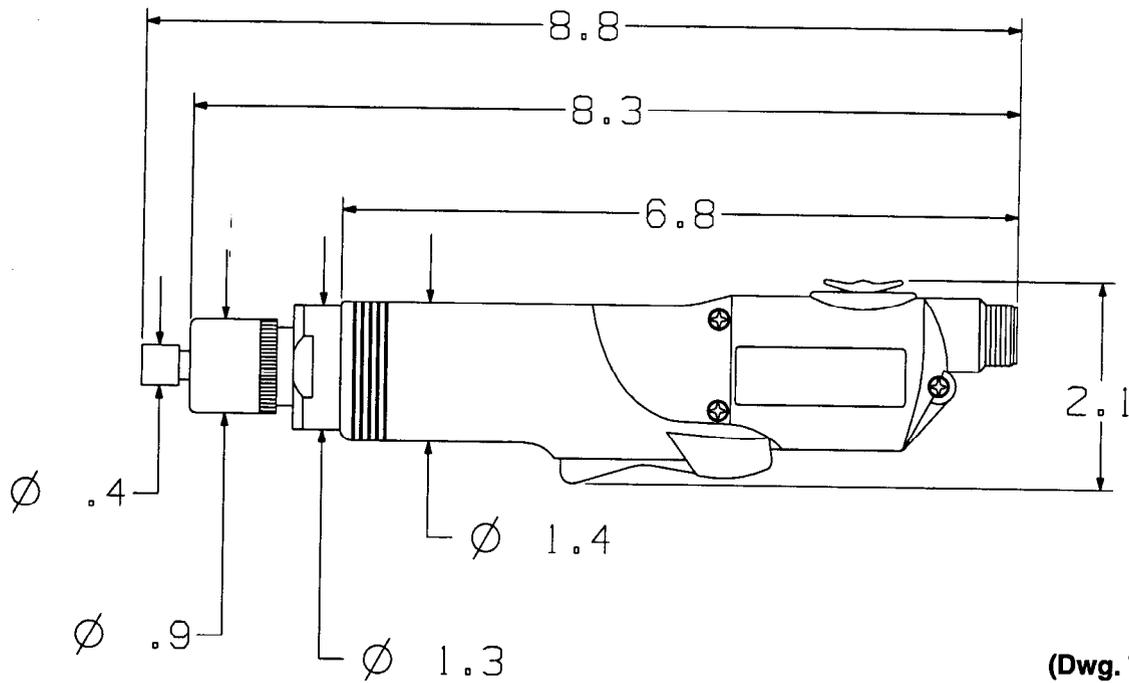
Dimensions for Models SLE04A-10-QC and SLE10A-7-QC Electric Screwdrivers (Trigger)



(Dwg. TPC652)

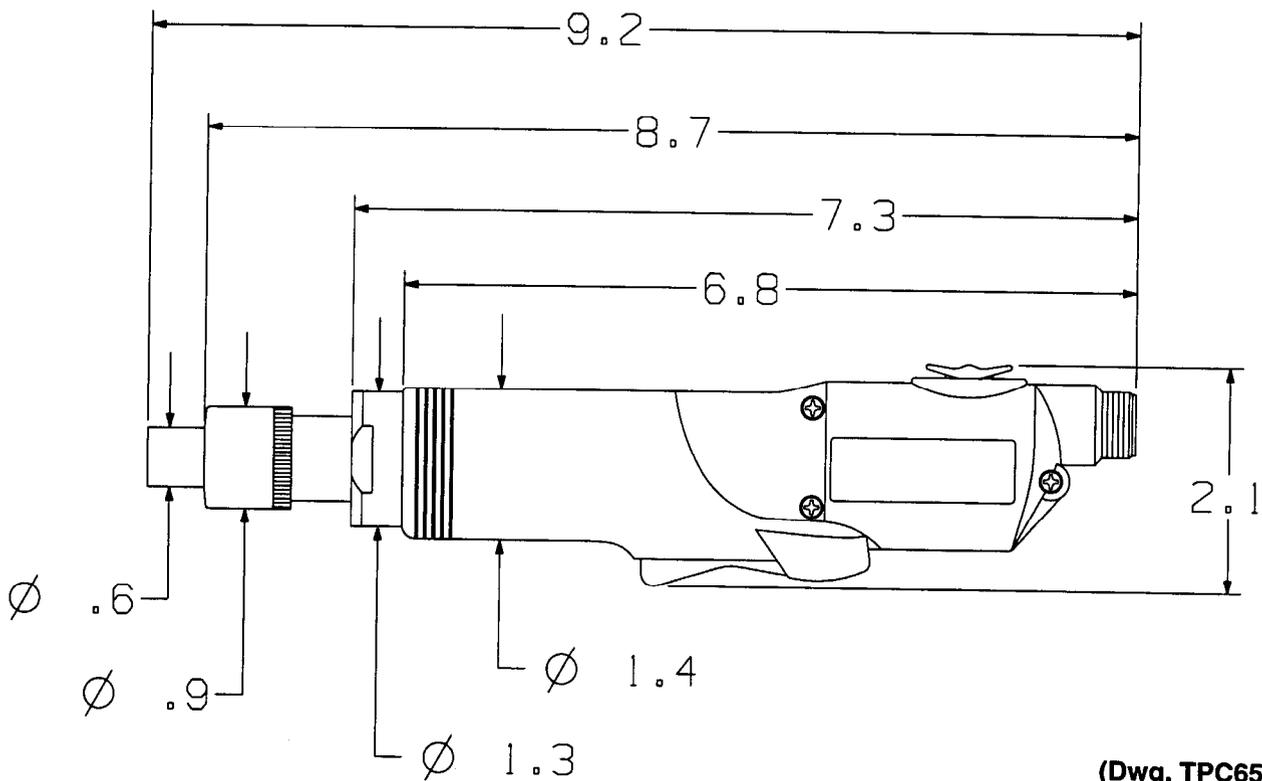
MAINTENANCE SECTION

Dimensions for Model SLE01A-9-W Electric Screwdriver (Trigger)

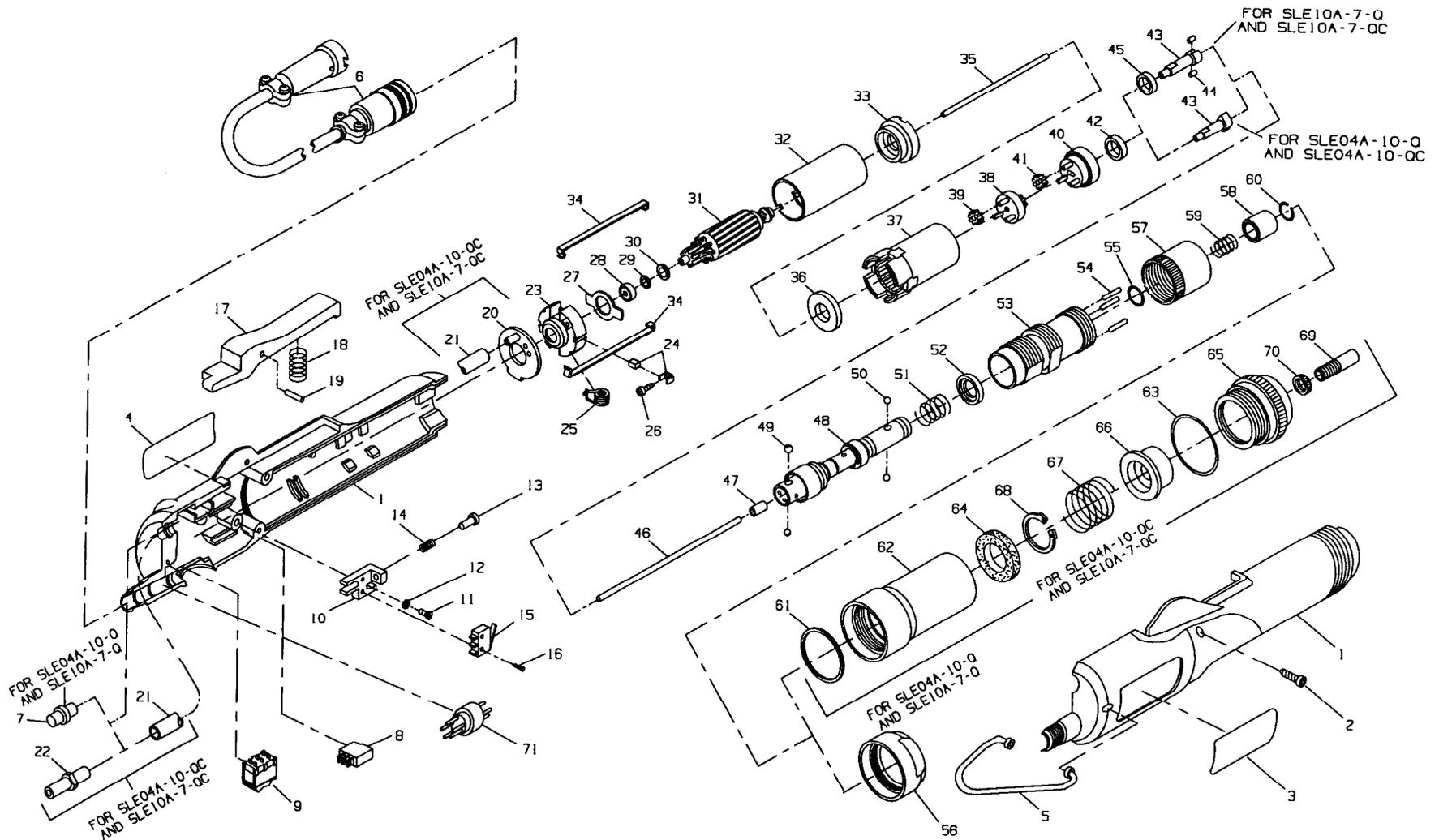


(Dwg. TPC653)

Dimensions for SLE04A-10-Q AND SLE10A-7-Q Electric Screwdriver (Trigger)



(Dwg. TPC654)



**MODELS SLE04A-10-Q, SLE04A-10-QC, SLE10A-7-Q
and SLE10A-7-QC ELECTRIC SCREWDRIVER**

(Dwg. TPA1539)

SLE04A-10-Q, SLE04A-10-QC, SLE10A-7-Q and SLE10A-7-QC ELECTRIC SCREWDRIVERS

PART NUMBER FOR ORDERING

PART NUMBER FOR ORDERING

	PART NUMBER FOR ORDERING		PART NUMBER FOR ORDERING
	Housing Package		Motor Assembly
	for SLE04A-10-Q	SLE04A-10-A40	for SLE04A-10-Q and SLE04A-10-QC ...
	for SLE10A-7-Q	SLE10A-7-A40	for SLE10A-7-Q and SLE10A-7-QC
	for SLE04A-10-Q	SLE04A-10-AC40	23 Rear End Plate
	for SLE10A-7-QC	SLE10A-7-AC40	24 Brush Assembly (2)
1	Housing	_____	25 Brush Spring
2	Housing Screw	_____	26 Brush Screw (2)
3	Nameplate		27 Motor Plate
	for SLE04A-10-Q	SLE04A-10-301	28 Rear Armature Bearing
	for SLE10A-7-Q	SLE10A-7-301	29 Shim (2) (.238" O.D. X .020" thick)
	for SLE04A-10-QC	SLE04A-10-C-301	30 Shim (.375" O.D. X .015" thick)
	for SLE10A-7-QC	SLE10A-7-C-301	31 Armature
4	Warning Label	EL0109B-99	for SLE04A-10-Q and SLE04A-10-QC ...
5	Suspension Bail	EL0109B-365	for SLE10A-7-Q and SLE10A-7-QC
6	Power Cord Assembly	EL0109B-239	32 Field
7	Housing Bushing	EL0109B-465	33 Front End Plate
8	Trigger Switch	EL0109B-222	34 Motor Assembly Spring (2)
9	Reverse Switch	EL0109B-329	35 Push Rod (1.403" long)
10	Switch Plate	EL0109B-221	36 Motor Clamp Spacer
11	Switch Plate Screw (2)	EL0109B-226	37 Gear Case
12	Switch Plate Screw Lock Washer (2)	EL0109B-227	for SLE04A-10-Q and SLE04A-10-QC ...
13	Plunger	EL0109B-593	for SLE10A-7-Q and SLE10A-7-QC
14	Plunger Spring	EL0410B-595	38 Gear Head Assembly
15	Brake Switch	EL0109B-223	for SLE04A-10-Q and SLE04A-10-QC ...
16	Microswitch Screw (2)	EL0109B-224	for SLE10A-7-Q and SLE10A-7-QC
17	Trigger	EL0109B-93	39 Gear Head Planet Gear (3)
18	Trigger Spring	EL0109B-274	for SLE04A-10-Q and SLE04A-10-QC ...
19	Trigger Pin	EL0109B-275	for SLE10A-7-Q and SLE10A-7-QC
20	Shield Plate (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-42	40 Spindle Assembly
21	Vacuum Tube (for SLE04A-10-QC and SLE10A-7-QC	EL0410BC-43	41 Spindle Planet Gear (3)
22	Vacuum Tube Nozzle (for SLE04A-10-QC and SLE10A-7-QC	EL0410BC-44	for SLE04A-10-Q and SLE04A-10-QC ...
			for SLE10A-7-Q and SLE10A-7-QC

MAINTENANCE SECTION

SLE04A-10-Q, SLE04A-10-QC, SLE10A-7-Q and SLE10A-7-QC ELECTRIC SCREWDRIVERS

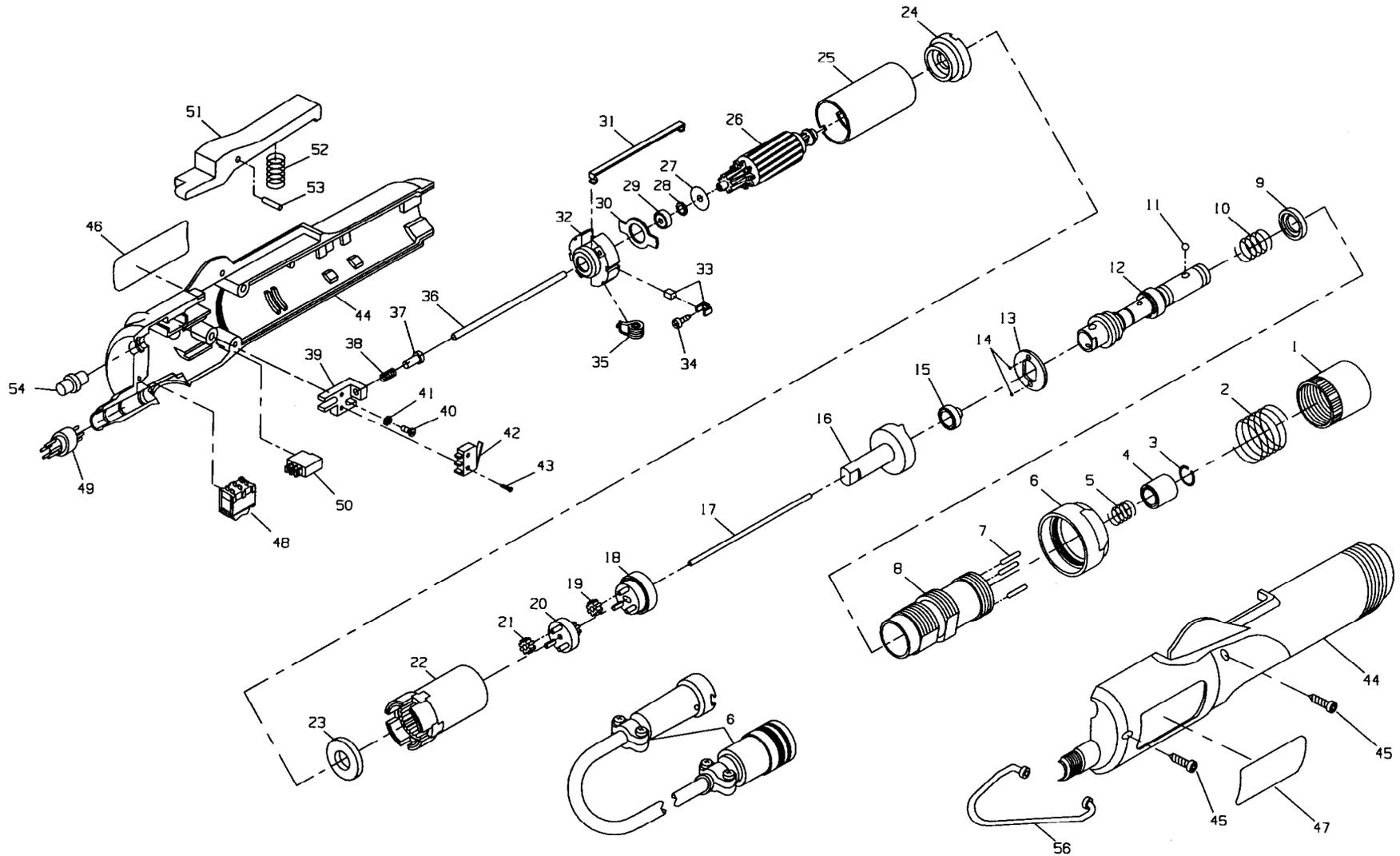
PART NUMBER FOR ORDERING

PART NUMBER FOR ORDERING

42	Thrust Washer	EL0410B-109		62	Nose Collar (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-46
43	Cam for SLE04A-10-Q and SLE04A-10-QC ... for SLE10A-7-Q and SLE10A-7-QC	EL0410B-581 EL1007B-581		63	O-ring (for SLE04A-10-QC and SLE10A-7-QC) ...	EL0410BC-47
44	Cam Pin (2) SLE10A-7-Q and SLE10A-7-QC	EL1007B-587		64	Filter (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-48
45	Cam Collar (for SLE10A-7-Q and SLE10A-7-QC ...	EL1007B-588		65	Front Cap (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-49
46	Push Rod (1.650" long)	EL0109B-435		66	Sleeve Holder (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-50
47	Cam Guide Sleeve	EL0410B-408		67	Holder Spring (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-51
48	Bit Holder Assembly	EL1007B-586		68	Holder Retaining Ring (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-52
49	Cam Guide Ball (2)	EL1007B-933		69	Vacuum Sleeve (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-53
50	Bit Retaining Ball (2) (.094" dia.)	R000B-263		70	Vacuum Sleeve Lockout (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-54
51	Clutch Spring for SLE04A-10-Q and SLE04A-10-QC ... for SLE10A-7-Q and SLE10A-7-QC	EL0410B-583 EL1007B-583		71	Insulator	EL0109B-330
+				*	Switch Adjusting Gauge	EL0410B-SG
52	Clutch Spring Plate	EL0410B-623		*	Gear Case Fixture	EL0410B-J37
53	Clutch Housing	EL0410B-580		*	Brush Package (10 pieces)	EL0109B-BP
54	Clutch Adjusting Pin (3) for SLE04A-10-Q and SLE04A-10-QC ... for SLE10A-7-Q and SLE10A-7-QC	EL0410B-416 EL1007B-416		*	Hardware Package (includes illustrated items 2[3], 11[2], 12[2], 13, 16[2], 18, 19, 25, 26[2], 34[2], and 60	EL0109B-HP
55	Bit Retainer Retaining Ring	EP4007N-584				
56	Coupling	EL0109B-125				
57	Clutch Adjusting Ring	EL0410B-582				
58	Bit Retainer Sleeve	EL0410B-930				
59	Bit Retainer Sleeve Spring	EL0410B-931				
60	Bit Retainer Retaining Ring (front)	EP4007N-683				
61	Packing Ring (for SLE04A-10-QC and SLE10A-7-QC)	EL0410BC-45				

* Not illustrated.

+ SLE10A-7 Screwdrivers are assembled with heavy Clutch Spring installed. A light Clutch Spring is also shipped and can be installed to meet varying torque requirements.



MAINTENANCE SECTION

MODEL SLE01A-9-W ELECTRIC SCREWDRIVER

(Dwg. TPA1540)

MODEL SLE01A-9-W ELECTRIC SCREWDRIVER

PART NUMBER FOR ORDERING

PART NUMBER FOR ORDERING

1	Clutch Adjusting Ring	EL0109B-582	36	Push Rod (1.403" long)	EL0109B-436
2	Bit Retainer Spring	EL0109B-931	37	Plunger	EL0109B-593
3	Bit Retainer Retaining Ring	EL0109B-683	38	Plunger Spring	EL0109B-595
4	Bit Retainer Sleeve	EL0109B-930	39	Shutoff Switch Plate	EL0109B-221
5	Bit Retainer Sleeve Spring	EL0109B-931	40	Switch Plate Screw (2)	—
6	Coupling	EL0109B-125	41	Switch Plate Screw Lock Washer (2)	—
7	Clutch Adjusting Pin (3)	EL0109B-275	42	Brake Microswitch	EL0109B-223
8	Clutch Housing	EL0109B-580	43	Microswitch Screw (2)	—
9	Clutch Spring Plate	EL0109B-623		Housing Package	SLE01-9-A40
10	Clutch Spring	EL0109B-583	44	Housing	—
11	Bit Retaining Ball (2mm dia.)	EL0109B-932	45	Housing Screw (3)	—
12	Bit Holder Assembly (2)	EL0109B-586	46	Warning Label	EL0109B-99
13	Cam Guide	EL0109B-681	47	Nameplate	SLE01-9-301
14	Cam Guide Ball (2) (3 mm dia.)	EL0109B-933	48	Reverse Switch	EL0109B-329
15	Cam Guide Sleeve Assembly	EL0109B-408	49	Insulator	EL0109B-330
16	Cam	EL0109B-581	50	Trigger Switch	EL0109B-222
17	Push Rod (1.650" long)	EL0109B-435	51	Trigger	EL0109B-93
18	Spindle Assembly	EL0109B-108	52	Trigger Spring	EL0109B-274
19	Spindle Planet Gear (3)	EL0109B-9	53	Trigger Pin	EL0109B-275
20	Gear Head Assembly	EL0109B-216	54	Housing Bushing	EL0109B-465
21	Gear Head Planet Gear (3)	EL0109B-10	55	Power Cord Assembly	EL0109B-239
22	Gear Case	EL0109B-37	56	Suspension Bail	EL0109B-365
23	Motor Clamp Spacer	EL0109B-207	*	Switch Adjusting Gauge	EL0410B-SG
	Motor Assembly	EL0109B-A53	*	Gear Case Fixture	EL0410B-J37
24	Front End Plate	EL0109B-11	*	Hardware Package (includes parts 3, 31[2], 34[2], 35, 37, 40[2], 41[2], 43[2], 45[3], 52 and 53)	EL0109B-HP
25	Field	EL0109B-54			
26	Armature	EL0109B-53			
27	Shim (.375" O.D. X .015 thick)	EL0109B-55			
28	Shim (.238" O.D. X .020 thick)	EL0109B-56			
29	Rear Armature Bearing	EL0109B-22			
30	Plate	EL0109B-13			
31	Motor Assembly Spring (2)	EL0109B-98			
32	Rear End Plate	EL0109B-12			
	Brush Package	EL0109B-BP			
33	Brush Assembly (2) (pkg. of 10)	—			
34	Brush Screw (2)	—			
35	Brush Spring	EL0109B-16			

* Not illustrated.

MAINTENANCE SECTION

DISASSEMBLY

⚠ WARNING

Always wear eye protection when operating or performing maintenance on this tool. Always turn off the electrical supply and disconnect the electrical cord before insalling, removing or adjusting any accessory on this tool, or before performing any maintenance on this tool.

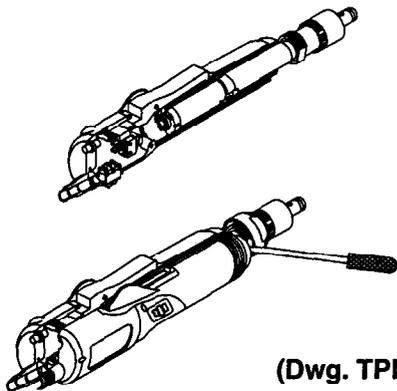
Disassembly of the Housing

1. To disassemble the Housing (1 or 44), begin by unscrewing the connection ring to remove the Power Cord (6 or 55).
2. Use a 29mm open end wrench to unscrew the Coupling (56 or 6).

NOTICE

This is a left-hand thread.

3. Using a #1 phillips screwdriver, remove the Housing Screws (2 or 45).
4. Separate the Housing by lifting the half with the three screw holes. If necessary, use a small screwdriver to pry the Housing apart. Refer to Dwg. TPD1816.



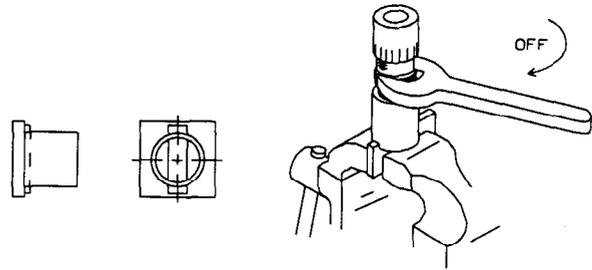
(Dwg. TPD1816)

5. Remove the Trigger (17 or 51), Trigger Spring (18 or 52) and the Trigger Pin (19 or 53).
6. Remove the Housing Bushing (7 or 54) from the back of the tool.

Disassembly of the Clutch Housing and Gear Case

1. Lift the Clutch Housing (53 or 8), Gear Case (37 or 22) and Motor Assembly from the Housing. While holding firmly, pull the Gear Case away.
2. Tap the end of the Gear Case on the work bench to remove the Motor Clamp Spacer (36 or 23) and the Gear Head Assembly (38 or 20).
3. Remove the Gear Head Planet Gears (39 or 21) from the Gear Head.
4. Remove the Push Rod (46 or 17) from the Gear Case. Fit the two notches at the rear end of the Gear Case

into the Gear Case Fixture part no. EL0410B-J37. Refer to Dwg. TPD1813.



(Dwg. TPD1813)

5. Using a slotted screwdriver, remove the Front Bit Retainer Retaining Ring (60 or 3) from the Bit Holder Assembly (48 or 12).
7. Remove the two Bit Retaining Balls (50) from the Bit Holder by tapping the Bit Holder on the work bench.
6. Remove the Bit Retainer Sleeve (58 or 4) and Bit Retainer Sleeve Spring (59 or 5).

NOTICE

Model SLE01A-9-W has only one Bit Retaining Ball (11).

8. Unscrew and remove the Clutch Adjusting Ring (57 or 1) from the Clutch Housing.
- For Model SLE01A-9-W, also remove the Bit Retainer Spring (2).**
9. Remove the three Clutch Adjusting Pins (54 or 7) from the Clutch Housing and the Bit Retainer Sleeve Spring.
10. Remove the Bit Retainer Retaining Ring (55) using external snap ring pliers.
11. Using a 21mm open end wrench on the flats of the Clutch Housing Assembly, unscrew and remove the Clutch Housing.

NOTICE

This is a left-hand thread.

12. Remove the Clutch Spring Plate (52 or 9) and the Clutch Spring (51 or 10).
13. Lift the Bit Holder Assembly from the Gear Case. **For Model SLE01A-9-W, remove the Cam Guide (13) and the two Cam Guide Balls (14) from the Bit Holder.** **For Models SLE04A10-Q and SLE10A-7-Q, remove the two Cam Guide Balls (49) and the Cam Guide Sleeve (47) from the Bit Holder Assembly (48).**
14. Remove the Gear Case from the Gear Case Fixture. Turn it over and push the Spindle Assembly (40 or 18) from the Case.

MAINTENANCE SECTION

15. Remove the Spindle Planet Gears (41 or 19) from the Spindle Assembly.
16. For Model SLE01A-9-W, remove the Cam (16) and Cam Guide Sleeve Assembly (15) from the bearing. For Model SLE10A-7-Q, remove the Cam Collar (45), the Cam (43), two Cam Pins (44) and the Thrust Washer (42).

Cleaning and Inspection of the Tool

1. Clean all mechanical parts you have disassembled in an approved safety solvent in a well-ventilated area. Inspect for damage or wear.
2. For all Models, inspect the Bit Holder Assembly. If the bearing does not rotate smoothly, replace the Bit Holder Assembly.
3. Inspect the Cam. If it is worn, replace it.
4. For Model SLE10A-7-Q, inspect the Cam Pins (44). If they are worn, replace them.
5. For Model SLE01A-9-W, inspect the Cam Guide Sleeve. If the bearing of the Cam Guide Sleeve does not rotate smoothly, replace it.
6. Inspect all the Gear Head Planet Gears. If the teeth are worn or damaged, replace them.
7. Inspect the Gear Case. If the inner gear teeth are worn or damaged, replace them.
8. Inspect the Spindle Assembly. If the bearing does not rotate smoothly, replace the Spindle Assembly.

Disassembly and Inspection of the Motor

1. Remove the Motor Assembly, the Plunger (13 or 37) and the Plunger Spring (14 or 38) from the Housing.
2. Using a thin slotted screwdriver, release the tension on the Brush Spring (25 or 35) and remove the two Brush Assemblies (24 or 33) from the Rear End Plate (23 or 32).
3. Carefully pull the copper wires to remove the Brush Assemblies from

NOTICE

Be careful not to damage the wires.

If the Brush Assemblies need to be replaced, desolder the blue and red Motor wires and remove the Brush Screws (26 or 34).

4. Using a thin blade screwdriver, remove the Motor Assembly Springs (34 or 31) by inserting the screwdriver between the Springs and the Rear End Plate and prying upward.
5. Remove the Front End Plate (33 or 24) from the Field (32 or 25).
6. Remove the Rear End Plate and the Motor Plate (27 or 30) by inserting a slotted screwdriver into the space between the Rear End Plate and the Field and prying upward.

7. While pushing the Rear Armature Bearing (28 or 29), pull the Armature (31 or 26) from the Field.

NOTICE

Do not damage the commutator or windings on the Armature. Hold the Armature body, not the commutator, when removing.

8. Remove the Push Rod (35 or 36) from the Armature.
9. Inspect the Push Rod. If it is worn, replace it.
10. Inspect the Rear Armature Bearing. If it does not rotate smoothly, replace it.
11. Inspect the gear teeth on the Armature. If they are worn or damaged, replace the Armature.
12. Inspect the front Armature Bearing. If it does not rotate smoothly, replace the Armature.
13. Inspect the commutator. If it is worn, replace the Armature.
14. Clean the Armature, Field, Motor Plate and the End Plates using a piece of fine cloth. For excess contamination, spray with contact cleaner and brush if necessary.

Disassembly and Inspection of the Electronics

1. To remove the Trigger Switch (8 or 50), Reverse Switch (9 or 48) or Brake Switch (15 or 42), remove any screws and pull the Switch from the Housing. Desolder and remove the lead wires.
2. To remove the Insulator (71 or 49), desolder the lead wires.

ASSEMBLY

Assembly of the Electronics

NOTICE

Before soldering any wire, slip a piece of heat shrinkable tubing over the wire.

1. To assemble the Electronic Components, resolder all wires to the Insulator (71 or 49). Also resolder all wires to the Brake Switch (15 or 42) and the Trigger Switch (8 or 50).
2. Reattach the Brake Switch to the Switch Plate (10 or 39) and screw the Plate into the Housing (1 or 44).
3. Insert all electronic components into their proper locations. Refer to Dwg. TPD1817 on page 13.

NOTICE

Be sure the notch in the Insulator fits with the tab in the Housing.

MAINTENANCE SECTION

Assembly of the Motor

1. Carefully insert the gear end of the Armature (31 or 26) into the notched side of the Field (32 or 25).

NOTICE

Be careful not to damage the commutator or windings.

2. Install the Front End Plate (33 or 24) onto the Field.
3. Place the Motor Plate (27 or 30) onto the Rear End Plate (23 or 32).

NOTICE

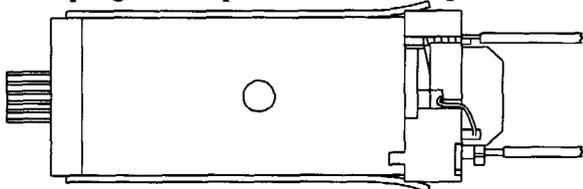
Be sure to install the Motor Plate correctly. The edge of the Motor Plate must be parallel to the step in the Rear End Plate.

4. Push the Rear End Plate into the notches of the Field.
5. Snap the Motor Assembly Springs (34 or 31) into the notches of the End Plates.
6. Insert the Brush Assembly (24 or 33) into the Rear End Plate. Be careful not to twist or damage the copper wire.

NOTICE

Make sure the Brush Assembly is positioned correctly. The connection point of the copper wire on the Brush Assembly should be closer to the rear end than the front end of the Motor Assembly.

7. Insert the Brush Spring (25 or 35) into the Rear End Plate. Using a small screwdriver to tension the Spring, insert the end of the Brush Spring into the notch on the End Plate.
8. Solder the blue and red Motor lead wires if the Brush Springs were replaced. Refer to Dwg. TPD1814.



(Dwg. TPD1814)

9. Apply grease to both ends of the Push Rod (35 or 36) and insert it into the center hole of the Motor Assembly.

Assembly of the Gear Case and Clutch Housing

1. Place the three Spindle Planet Gears (41 or 19) onto the Spindle Assembly (40 or 18).
2. Place the three Gear Head Planet Gears (39 or 21) onto the Gear Head Assembly (38 or 20).
3. Grease the gears.
4. Place the Gear Head Assembly onto the Spindle Assembly.
5. Grease both sides of the Thrust Washer (42) and place it on the Spindle bearing.
6. Insert the Cam (43 or 16) into the Spindle Assembly.
7. While rotating the Gear Case (37 or 22) and holding the Cam, insert all parts into the Gear Case.

8. Grease the Gear Case side of the Motor Clamp Spacer (36 or 23) and insert the Motor Clamp Spacer into the Gear Case.
9. For Model SLE10A-7-Q, grease the notches on the Cam and place the two Cam Pins (44) into the notches.
10. Grease the inside of the Bit Holder Assembly (48 or 12).
11. Insert the Cam Guide Sleeve (47 or 15) into the Bit Holder.
12. Grease the ball bearings under the spring support on the Bit Holder Assembly.
13. Grease the holes on the Bit Holder and insert the two Cam Guide Balls (49 or 14).
14. For Model SLE10A-7-Q, grease the inside of the Cam Collar (45) and place it onto the Bit Holder.
15. For Model SLE01A-9-W, grease the bottom end of the Bit Holder Assembly and place the Cam Guide (13) onto the Bit Holder. Grease the holes in the Cam Guide and insert the two Cam Guide Balls.
16. Fit the two notches at the rear of the Gear Case Assembly into the Gear Case Fixture part no. EL0410B-J37.
17. Place the Bit Holder Assembly into the Gear Case.
18. Place the Clutch Spring (51 or 10) and the Clutch Spring Plate (52 or 9) over the Bit Holder.
19. Place the Clutch Housing (53 or 8) partially into the Gear Case.

NOTICE

This is a left-hand thread.

At the middle of the Clutch Housing threads apply Loctite (R)* Thread Locker 3 Bond 1406 to three of the threads. Screw the Clutch Housing all the way into the Gear Case.

20. Using an open end torque wrench, tighten the Clutch Housing to 20 Nm torque.
21. Install the Bit Retainer Retaining Ring (55 or 3) into the groove of the Bit Holder. Place the side with the sharp edge first.
22. Apply grease to the holes of the Bit Holder and insert the two Bit Retaining Balls (50 or 11) into the Bit Holder.

NOTICE

Model SLE01A-9-W has only one Bit Retaining Ball.

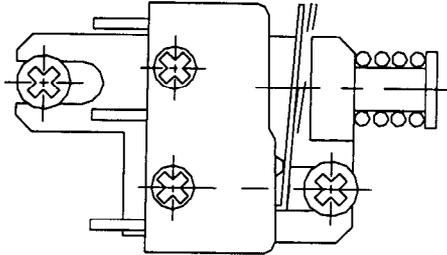
23. Apply grease to one end of each Clutch Adjusting Pin (54 or 7) and insert them into the Clutch Housing.
24. For Model SLE01A-9-W, place the Clutch Adjusting Ring (1) and Bit Retainer Spring (2) onto the Clutch Housing.
25. Grease the inside lip of the Clutch Adjusting Ring and thread it onto the Clutch Housing.
26. Install the Bit Retainer Sleeve Spring (59 or 5). Grease the inside of the Bit Retainer Sleeve (58 or 4) and place it onto the Bit Holder.

MAINTENANCE SECTION

27. Using a slotted screwdriver, install the Bit Retainer Retaining Ring into the groove of the Bit Holder.
28. Unclamp the Assembly Fixture from the vise and turn it over to remove the Clutch and Gear Case.
29. Grease both ends of the Push Rod (46 or 17) and insert it into the Gear Case.

Adjustment of the Brake Switch Timing

1. If the Brake Switch needs adjusting, loosen the Switch Plate Screws (11 or 40). Refer to Dwg. TPD1815.



(Dwg. TPD1815)

2. Apply grease to the end of the Plunger (13 or 37) and insert it with the Plunger Spring (14 or 38) into the Switch Plate.
3. Insert a Switch Adjusting Gauge Rod part no. EL0410B-SG into the Motor Assembly.
4. Place the Gear Case and Motor together by aligning the Motor Assembly Springs with the notches in the Gear Case.
5. Place the Assembly into the Housing by aligning the hole in the Motor with the tab in the Housing.
6. Push the Brake Switch forward until the Switch clicks.
7. Tighten the Switch Plate Screws at this position to 1.6 KG-cm.

8. Remove the Switch Adjusting Gauge Rod. Grease and install the Push Rod (35 or 36) into the Motor Assembly and refit the hole in the Motor to the tab in the Housing.

Assembly of the Housing

1. Install the Housing Bushing (7 or 54) in the groove of the Housing.
2. Install the Trigger (17 or 51) with the Trigger Pin (19 or 53) and Spring (18 or 52) into the Housing.
3. Install the second half of the Housing, while holding the Trigger in place.
4. Tighten the Housing Screws (2 or 45) to 1-1/2 inch pounds.

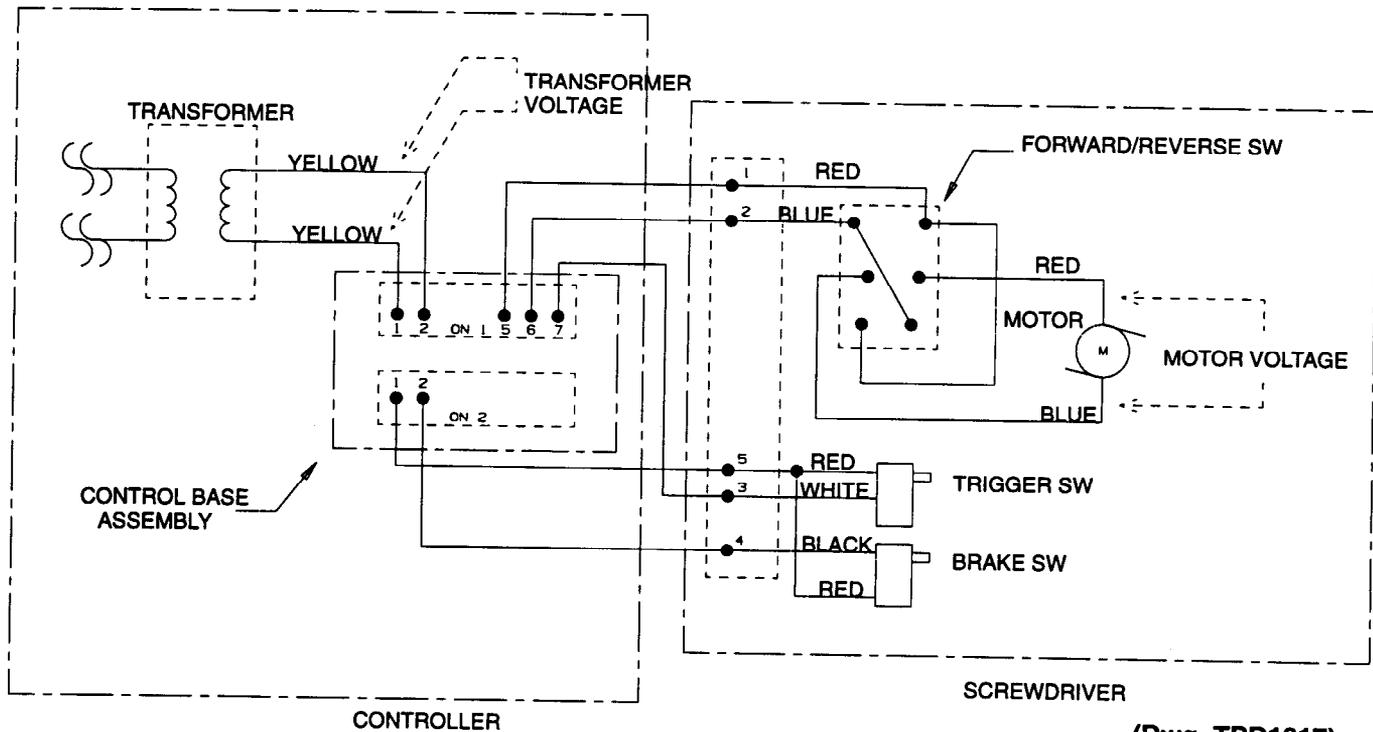
NOTICE

Do not overtighten the Housing Screws.

5. Install the Coupling (56 or 6) with an open end torque wrench and tighten to 7 Nm torque.
6. Attach the Power Cord (6 or 55).
7. For repair and trouble shooting of the Controller, refer to the Operations and Maintenance Manual for Model SCE24N Screwdriver Controllers, Form No. P7259.

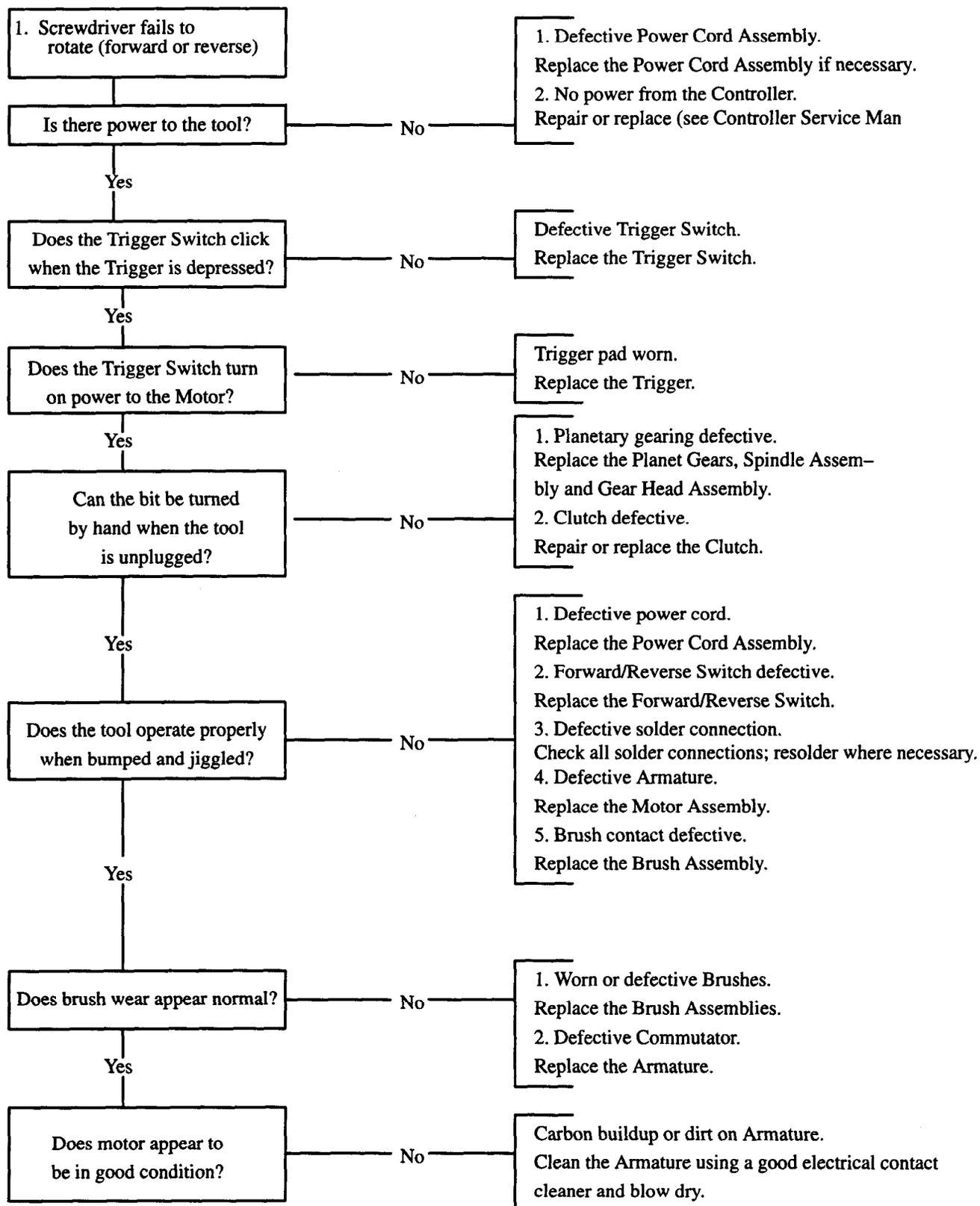
Testing the Tool

1. Test forward and reverse operation of the tool by depressing the Trigger with the Reverse Switch (9 or 48) in each position.
2. Tighten the Clutch Adjusting Ring all the way, loosen it one turn and test for proper shut-off and maximum torque using an appropriate tester.
3. Reset the Clutch Adjusting Ring to mid-scale and check for torque repeatability by cycling the tool between 5-10 times.

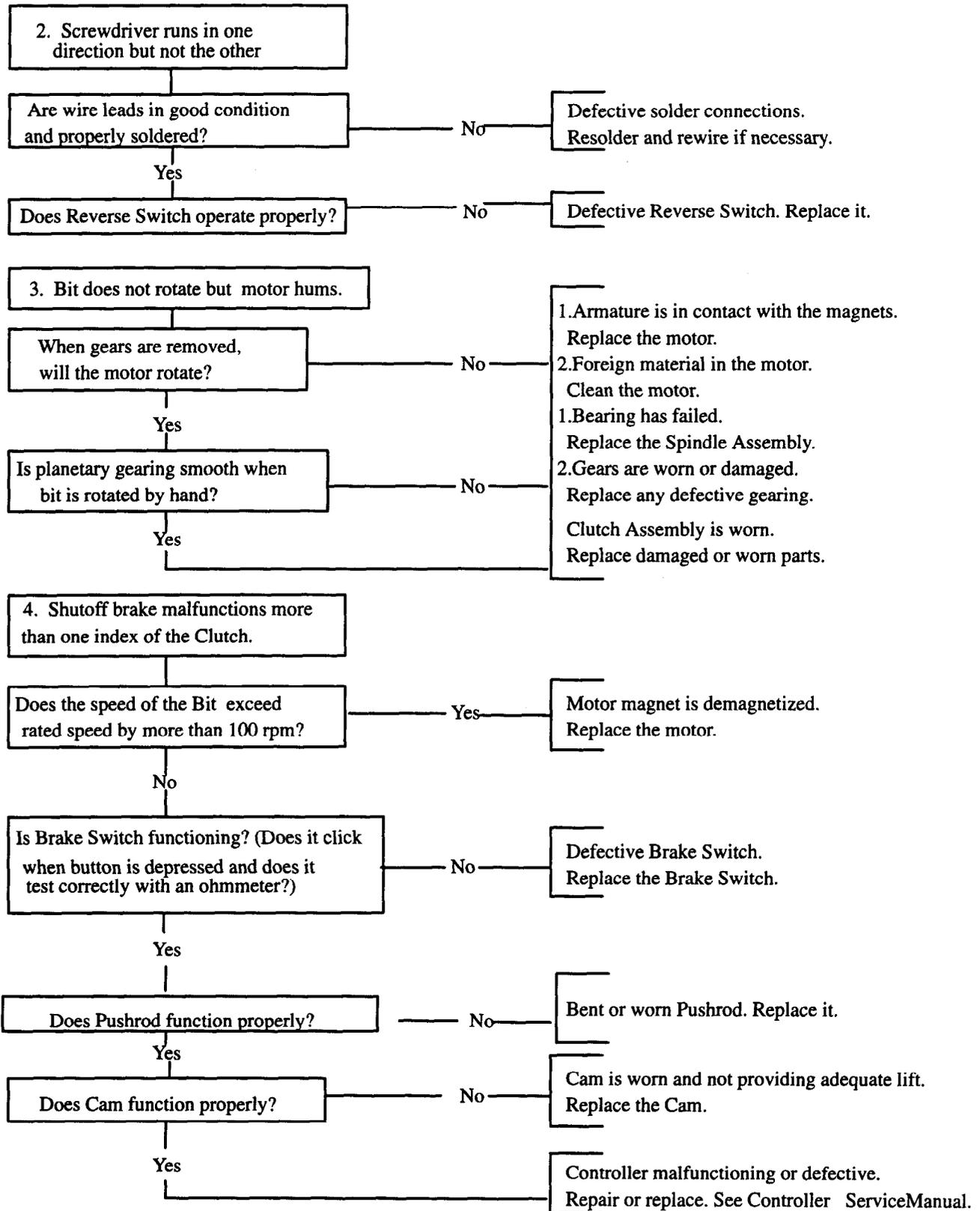


(Dwg. TPD1817)

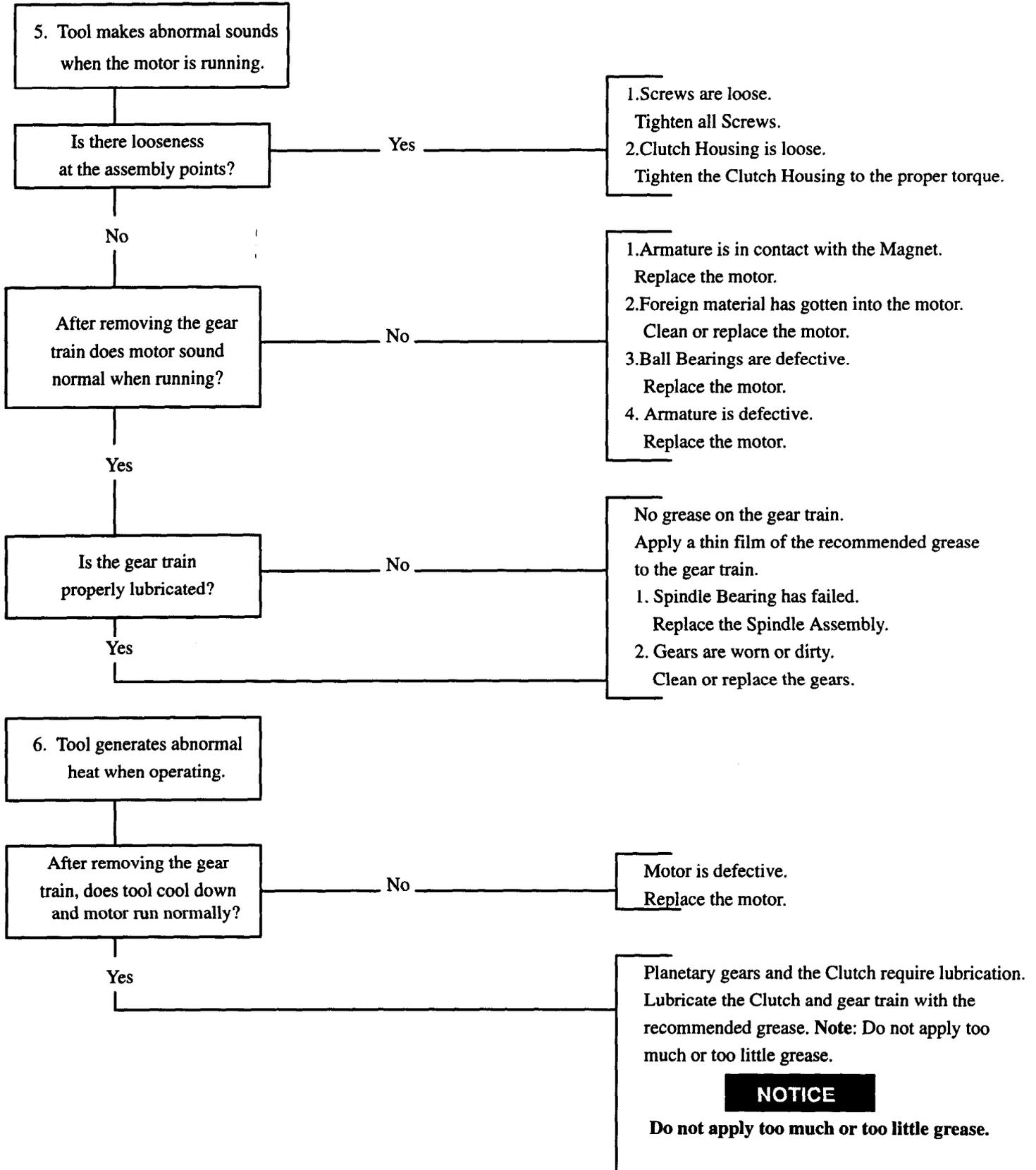
TROUBLESHOOTING GUIDE



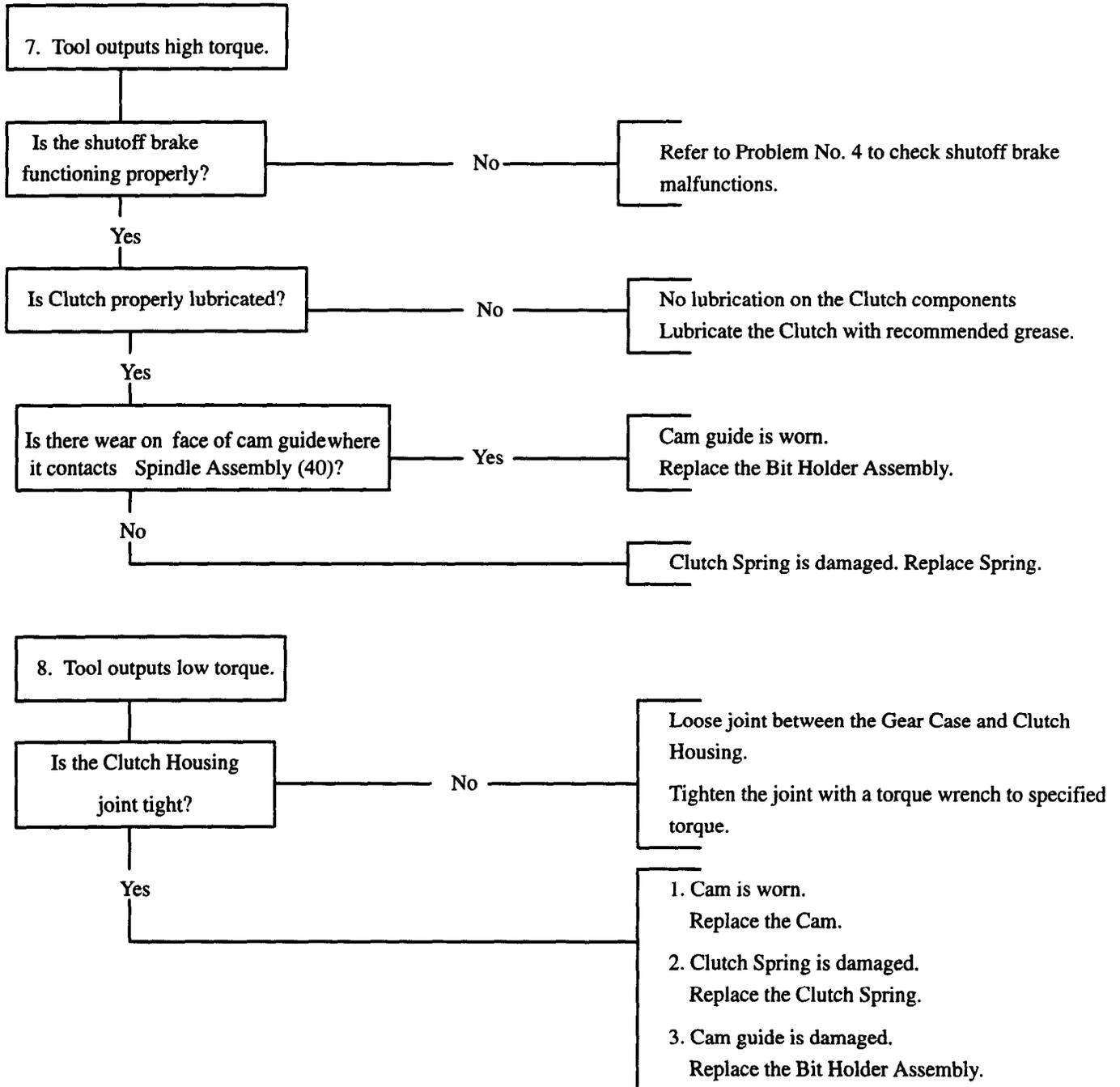
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