

Pneumatic Rolling Right Angled Drive PT72-RT-90/PT72-RT-190

Operating and Maintenance Manual



Pneumatic Rolling Right Angled Drive Operation & Service Manual



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1. Technical Specifications for both Models.

Models	SPEED AND TORQUE 90PSIG PRESSURE					
	FREE SPEED	MAXIMUM TORQUE	MINIMUM TORQUE	TUBE CAPACITY	SQUARE DRIVE	WEIGHT
	RPM	Nm	Nm	Inch	Inch	Kg
P72-RT-190	190	190	95	2.5	5/8	5.8
P72-RT-90	90	410	200	4.0	3/4	6.7

2. Safety Precautions.

1. Read this manual and understand the safety precautions and operating instructions before use. Make sure all operators are fully trained in the operation of this pneumatic tool.
2. Always wear impact eye protection and hearing protection at all time as well for other personnel in the immediate vicinity.
3. This tool is designed to operate at a maximum of 7 BAR. With a consumption of 1.6m³/Min (57CFM). Excessive pressure increases the loads and stresses on the integral parts of this unit, sockets and fasteners and could result in breakage.
4. Always use a filter – regulator – lubricator incorporated in the air supply line.
5. Discharge the supply line before disconnecting the tool from the air line. All tool and socket changes should be done with air supply disconnected.
6. For safe operation the operator must use good balance, sure footing and proper posture in anticipation of a torque reaction.
7. Make sure the operators hand will not be wedged or pinched between the work piece and the tool when operating.

CAUTION:

When using the right angled rolling motor ensure the throttle is positioned relative to the right angled head so that the throttle will not become wedged against an adjacent object in the ON position due to torque reaction.

Tools with clutches may stall rather than shut off if adjusted over maximum power output of the tool or if there is a drop in air pressure. The operator must resist stall torque until the throttle is released. Higher torque right angled tools can be equipped with splined torque reaction mounting plates which accept torque reaction bars. These bars can be braced against any suitable part to absorb and relieve the operator of the torque reaction transmitted by the tool.

Supervisors and operators are to be fully aware of the effects this tool can produce. Avoid continuous exposure to vibration and operators to brace themselves accordingly when using this tool.

3. OPERATING INSTRUCTIONS

The P72-RT Series Machines are designed to operate on 7 bar air pressure using a 1/2" hose, maximum length 16 ft.

Machine Set Up

1. The reaction bar clamp and reaction bar bracket are installed on the Gear Case next to the bearing retainer.
2. Use sockets approved for power master tool service only before operation pour 20-30ml of light oil into the inlet bushing and start the tool at free rotation at 1 to 2 minutes.
3. The K Series machines are designed to operate on 90 PSIG air Pressure, but does not depend on controlled air pressure to maintain accurate torque.
4. Accurate torque is achieved by setting the clutch to the desired torque on the application.
5. The tool will automatically shut off at the torque set on the tool.
6. Releasing the throttle will reset the tool for the next cycle.
7. **Clutch adjustment: Rotate the adjustment cover until the adjustment slot is uncovered.**
8. **Use the clutch adjustment pin to rotate the adjustment nut counterclockwise ("H") to increase the torque setting and clockwise ("L") to decrease the setting. After adjustment, rotate the cover over the slot to lock the nut in place.**

Caution! If the clutch is adjusted over the maximum power output of the tool, the clutch will not function and the tool will not operate like a stall type tool. Also, if the tool is being operated at its upper torque limits, a drop in air pressure could cause the clutch not to function due to loss of motor power and the tool will function like a stall-type tool. Grip tool securely and be prepared to counteract stall torque in case when clutch is adjusted improperly. **Always use the reaction bar provided.**

Air Supply

An automatic in line filter lubricator is strongly recommended to supply the tool with clean, lubricated air, keep it in sustained operation and increase tool life. For maximum performance use a minimum 1/2" ID air hose no longer than 16ft in length. If additional length is required then 3/4" ID hose or larger should be connected to the 1/2" hose. All hoses should be checked of debris and moisture before being used and a generous amount of air tool oil (10W) should be poured into the machine before connecting all hoses.

Lubrication

Application of the tool should govern how often it is greased. The right angle gears should receive a generous amount of grease, such as Retinax EPX2 through the grease plug after every 100 hours of operation.