STATEMENT OF USE
This tool is designed for only right hand rotation tapping of holes in metal and plastics.
Tap removal is by pulling the tool away from the workplace, so engaging reverse at twice forward speed.

GENERAL

Recommended inlet hose

3m

20mm

Lubrication
Correct lubrication is vital for the maximum performance of the tool and an airline lubricator should be fitted in the system down line of the filter. Use ISO VG 15 in lubricator set to provide 50 drops per minute.
158733 = Molykote PG75
273283 = BP FQ00EP
208893 = Rocal M204G
27662 = ISO VG 15
273273 = BP Q5618

DATA
Maximum air pressure Pmax = 6.3 bar
Minimum air pressure Pmin = 2.0 bar
Sound Pressure Level (dB(A)) = 79 ± 2 dbA. CAGL-PNEUROP
Test code
Vibration Range (m/sec²) = < 2.5 ma ISO 8662

Weight
D16S/L - 1000 RPM = 1.3 kg
D16S/L - 500 RPM = 1.4 kg

Accessories
A wide range of accessories are available and a suitable item should be selected from the relevant Desoutter Catalogue.

OPERATING
1. Slide handles are recommended (No.70442; 293093) especially above 4.5N.m - the tool may be mounted on a toolstand.
2. The tools are fitted with a progressive throttle motion. This allows for a low speed with a small throttle opening, ideal when commencing an operation.
3. To reverse rotation quickly whilst the motor is running, pull the tool away from the workplace briskly. It is unnecessary to cut the power to the motor before reversing. Trials are recommended before commencing work.
4. Take precautions to avoid stalling the tool in tapered holes or swarf jamming in blind holes.
5. Use a depth gauge or indicator.
6. Use the correct pilot hole size.
7. Always use a sharp cutting tool at the correct speed.
8. Do not reduce air supply pressure.

MAINTENANCE INSTRUCTIONS
1. Service should be carried out at intervals of 1000 hours use.
2. All torque figures ±10%.
3. Replace as necessary all 'O' rings, bearings and rotor blades.
4. When disposing of components, lubricants, etc... ensure that the relevant safety procedures are carried out.
5. Indicates direction of dismantling.
6. Torque values stated are for assembly.

CYLINDER ORIENTATION
The cylinder must be correctly orientated so that all cut-outs in the cylinder and the bearing plates coincide.

WARNING
BEFORE OPERATING THIS TOOL, READ AND UNDERSTAND PNEUMATIC DRILL & TAPPER SAFETY INSTRUCTIONS PART NO. 354349

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