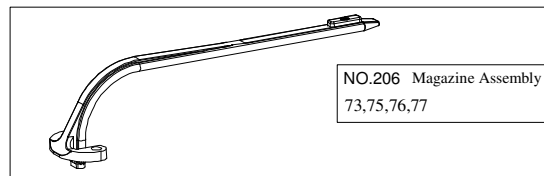
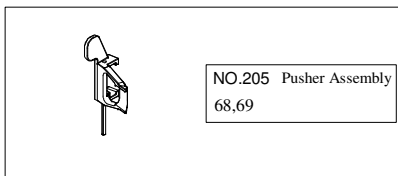
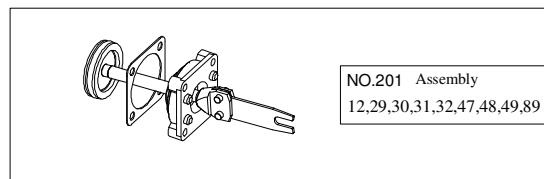
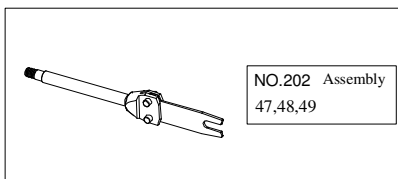
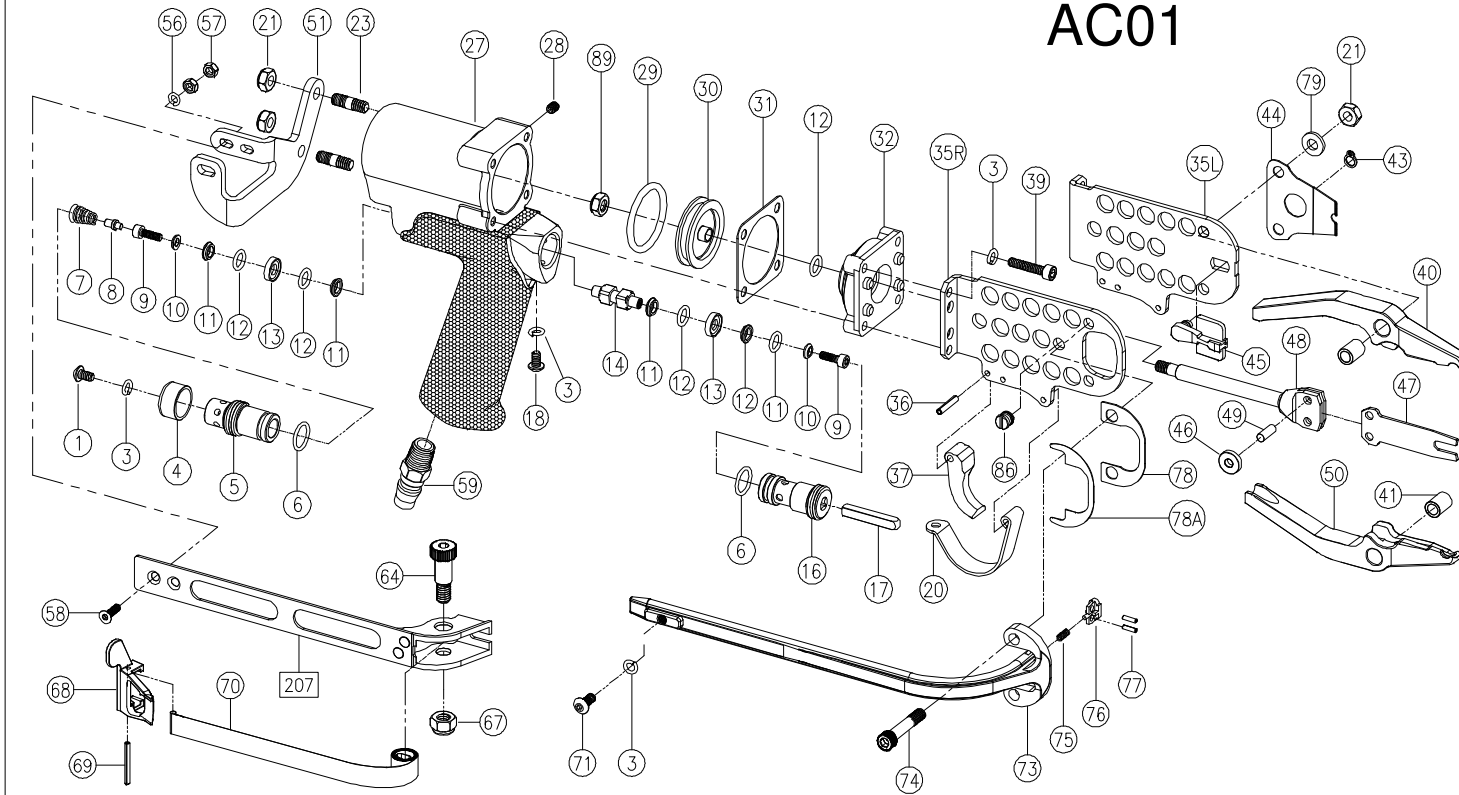
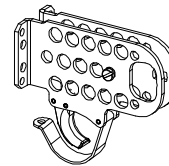


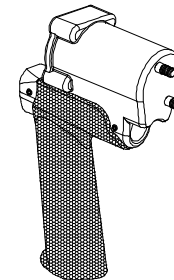
# AC01



NO.203 Frame Assembly  
20,35R,35L,36,37,86



NO.200 Housing Assembly  
23,27,28

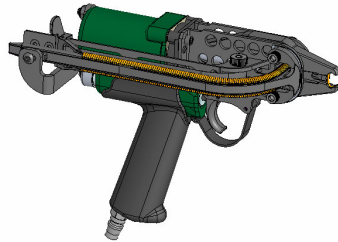


ITEM	DESCRIPTION	PART NUMBER	QTY
1	Set Screw	AC01001	1
3	Shakeproof lock Washer	AC01003	7
4	Air Deflector	AC01004	1
5	Rear Valve Seat	AC01005	1
6	O-Ring	AC01006	2
7	Throttle Spring	AC01007	1
8	Throttle Spring Locator	AC01008	1
9	Throttle Valve Screw	AC01009	2
10	Valve Screw Washer	AC01010	2
11	O-Ring Support	AC01011	4
12	O-Ring	AC01012	5
13	O-Ring Center Support	AC01013	2
14	Throttle Valve Spacer	AC01014	1
16	Front Valve Seat	AC01016	1
17	Throttle Stem	AC01017	1
18	Button Head Cap Screw	AC01018	1
20	Trigger Guard	AC01020	1
21	Flexloc Nut	AC01021	2
23	Stud	AC01023	2
27	Housing	AC01027	1
28	Set Screw	AC01028	2
29	O-Ring	AC01029	1
30	Piston	AC01030	1
31	Cylinder Gasket	AC01031	1
32	Piston Stop Spacer	AC01032	1
35R	Side Plate (Right)	AC0135R	1
35L	Side Plate (Left)	AC0135L	1
36	Roll Pin	AC01036	3
37	Trigger	AC01037	1
39	Socket Head Cap Screw	AC01039	4
40	Upper Jaw	AC01040	1
41	Jaw Bushing	AC01041	2
43	Latch Pin Clip	AC01043	1
44	Latch Spring	AC01044	1
45	Latch	AC01045	1
46	Roller	AC01046	4
47	Feeder Blade	AC01047	1
48	Piston Rod	AC01048	1
49	Roller Pin	AC01049	1
50	Lower Jaw	AC01050	1
51	Feeder Arm	AC01051	1
56	Washer	AC01056	2
57	Nut	AC01057	4
58	Screw	AC01058	2
59	Inlet Bushing	AC01059	1
64	Socket Head Cap Screw	AC01064	1
67	Nut	AC01067	1
68	Pusher	AC01068	1
69	Extruded Rivet	AC01069	1
70	Pusher Spring	AC01070	1
71	Button Head Screw	AC01071	1
73	Magazine Body	AC01073	1
74	Jaw Bolt	AC01074	2
75	Magazine Spring	AC01075	1
76	Magazine Shoe	AC01076	1
77	Roll Pin	AC01077	1
78	Magazine Shim	AC01078	1
78A	Magazine Shim	AC0178A	1
79	Washer	AC01079	2
86	Plate Screw	AC01086	1
89	Flexloc Nut	AC01089	3
207	Feeder Guid Rail	AC01207	1



**ANN-CHAIN ENTERPRISE CO., LTD.**  
**NO.65-5, LANE 540, YOAN-FONG RD.,**  
**CHANG HUA CITY, TAIWAN, R.O.C.**  
**TEL: 886-4-7521297 FAX: 886-4-7521293**

#### **PNEUMATIC CLIP RING TOOL AC01**



#### **OPERATING INSTRUCTIONS & PARTS LIST**

For best operating results and long life, maintain the tool in good working order, do not drop the tool, keep the mechanism free from dirt and other foreign matter and do not operate the tool at air pressures above 100 PSI (7.03 kg/cm<sup>2</sup>). Although your clip ring tool is of high quality and made to exacting standards, failure to follow proper operational precautions may result in damage to your tool and shorten its useful life.

#### **OPERATION**

The air powered clip ring tool should be held firmly in the hand and in most operations the tool is used 90 degrees to the work performed. It should be kept in mind that in using the air powered clip ring tool, this is like any other tool and should be properly maintained. One area of maintenance to be conscious of is when pushing the tool into foam, it should be cleaned occasionally. Also, when "grabbing" a group of wire, the tool is frequently used as a pusher puller and/or a variety of other things. The most important point to remember is to take a long, hard look at your work and choose the best way in which to do it. Obviously, the less the tool is abused, the better. The tool should be handled firmly in your hand and don't stretch too far when you use it in the direction of your application. Please also note that the tool should make a complete closure of the fastener. If for any reason you are not getting complete closure, check to make sure that the application is correct and that the tool is cycling completely. Obviously, moisture, dirt or any other foreign matter that is inside the tool will reduce its Operational efficiency. Please take care in handling, operation and maintenance of your tool for a long and useful work life.

#### **AIR PRESSURE**

Air pressure should be maintained at 85-96 PSI (5.98-6.68 kg/cm<sup>2</sup>) using 1/4" (6.35mm) ID air hose. Higher pressures will not increase the operating speed of the tool and may cause damage to it.

#### **AIR FILTER AND REGULATOR**

The air line should have an attached air line filter and regulator sufficient to provide a constant and even flow of clean, dry air. The filter should be installed as close as possible to the tool. Dirt or moisture in the air line will adversely affect the smooth operation of the tool and decrease its serviceable life.

#### **LUBRICATION**

To insure long, trouble-free service, we recommend Air Line Lubricators and Filter Units for proper lubrication and clean, dry air. A good grade of oil that emulsifies in water is recommended for air tools.

#### **MANUAL OILING**

Although the jaws and other moving parts of the tool do need to be oiled, periodic oiling in small amounts may increase the serviceable life of the tool that receives heavy use.

#### **C-RINGS**

These rings are available from ANN-CHAIN and will be shipped promptly from stock. PLEASE SEE C-RING STYLES CHART for further details regarding materials, points and size of C-RING.

#### **REPAIR AND SERVICE PARTS**

If any tool is not operating properly, remove it from service at once and have it checked for proper operation. ANN-CHAIN will ship replacement parts for repairs. Parts price lists are available upon request. Use only parts that are specifically fabricated for the AC model tool which you own.

#### **TO DISASSEMBLE**

##### **Jaws, Magazine, Feeder Guide Rail**

Remove Flexlock Nuts(21) and Jaw Bolts (#74). Take out Jaws(#40 and #50). Remove Magazine Assembly(#73) and Feeder Guide Rail (#207).

##### **Feeder Blade, Rollers and Piston Rod**

Remove Cap Screws (#18 & #39 x 4 pcs) and Frame Assy. (203) from Cylinder Housing. After taking off Piston(#30) and Piston Stop Spacer (#32). Piston Rod Assembly with Feeder Blade (#47) and Rollers (#46 x 4 pcs) can be taken out the front end of the Frame.

#### **THROTTLE**

Loosen Set Screws (#28) and remove Adjustable Valve Seats (#5 & #16). Using two Allen wrenches, unscrew Throttle Valve Screw (#9) to remove Valve units. One Valve will stay on Spacer (#14) and can be disassembled after removal from Housing.

#### **TO ASSEMBLE**

Assemble one Valve on Spacer (#14). Holding Allen wrench, bring second Valve mounted on Screw (#9) in from other side and complete Valve Assembly (should then have free motion of about 1/16").

#### **THROTTLE VALVE ADJUSTMENT**

With Throttle Spring Locator (#7 & #8) in place, partially screw in Adjustable Valve Seat (#5). With air partly turned on and holding front Valve closed with a 3/8" dia. turn Valve Seat in until air stops leaking through Valve. Using Throttle Stem (#17) to turn, install Front Valve Seat (#16), turning until air stops exhausting through Handle. After finer adjustment, lock Valve Seats in place with Set Screws (#28) in Housing casing.

#### **TO LOCATE AND CORRECT AIR LEAKS**

If an Adjustable Valve Seat is turned too far, the opposite Valve will be raised from its Bushing Seat, causing air leakage. To correct back off Adjustable Valve Seat until leak stops. If leaks do not stop, check Piston (#30) and Piston O-Ring (#29).

#### **FEEDER BLADE, ROLLERS, PISTON ROD**

Onto Piston Rod (#48) mount Feeder blade (#47), Roller Pins(#49 x 2pcs) and Rollers (#46 x 4 pcs). Put in Frame. Mount Piston Stop Spacer (#32), Piston (#30) and Flexloc Stop Nut (#21). Insert Throttle Stem (#17) and then assemble Frame to Housing.

#### **FEEDER GUIDE RAIL**

With Feeder Arm (#51) in place, assemble Feeder Guide Rail(#207). Pusher spring (#70), slide into Bracket and insert lower Cap Screw (#64) tight. Continue turning to desired Pusher Spring tension and lock with Nut (#67).

#### **MAGAZINE**

Assembly Latch(#45) and Latch Pin Clip (#43). Insert Jaw Bushings (#41 x 2 pcs) into Jaws (#40 & #50), side jaws into place and complete assembly.

#### **ADJUSTMENT OF MAGAZINE**

Before tightening Cap Screws (#74), insert enough Shims (#78) between Magazine (#73) and Side Plate (#35R) to produce a clearance between Magazine Shoe (#76) and Feeder Blade (47). Magazine must be held tight against Side Plate while checking this clearance; then, after tightening the Cap Screws (#74 x 2 pcs), clearance should be rechecked.

**DO NOT POINT THE TOOL AT ANY PERSON.  
KEEP HANDS AND CLOTHING AWAY FROM  
THE FRONT OF JAWS OF THE TOOL AND  
AWAY FROM ALL MOVING PARTS. INJURY  
MAY RESULT. FAILURE TO FOLLOW THESE  
PRECAUTIONS MAY RESULT IN SERIOUS  
INJURY.**