



AcraDyne

5000 Series Pistol Nutrunners

Operations Manual



PO Box 16460, Portland OR 97292-0460 • 800-852-1368 • Fax 800-582-9015

www.aimco-global.com

Introduction

Thank you for purchasing this AcraDyne DC electric assembly tool, one of the lightest and fastest DC electric assembly tools on the market. When used with the AcraDyne iEC tool controller, this tool will provide excellent productivity, ergonomics, reliability and quality on a wide range of industrial assembly applications.

Safety Information

SAVE THESE INSTRUCTIONS

1) WORK AREA

- a) Keep work area clean and well lit. Cluttered and dark areas invite accidents.
- b) Do not operate power tools in explosive atmospheres, such as the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
- c) Keep children and bystanders away while operating a power tool. Distractions can cause you to lose control.

2) ELECTRICAL SAFETY

- a) Power tool plugs must match the outlet. Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- b) Avoid body contact with earthed or grounded surfaces such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
- c) Do not expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
- d) Do not abuse the cord. Never use the cord for carrying, pulling or unplugging the power tool. Keep cord away from heat, oil, sharp edges or moving parts. Damaged or entangled cords increase the risk of electric shock.
- e) This tool is intended for indoor use only.

3) PERSONAL SAFETY

- a) Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
- b) Use safety equipment. Always wear eye protection. Safety equipment such as dust mask, non-skid safety shoes, hard hat, or hearing protection used for appropriate conditions will reduce personal injuries. If the maximum duty cycle of the attached tool is exceeded or the tool temperature exceeds 50° C., then the operator should wear protective hand wear (gloves).
- c) Avoid accidental starting. Ensure the switch is in the off-position before plugging in. Carrying power tools with your finger on the switch or plugging in power tools that have the switch on invites accidents.
- d) Remove any adjusting key or wrench before turning the power tool on. A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- e) Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- f) Dress properly. Do not wear loose clothing or jewelry. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts.
- g) If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used. Use of these devices can reduce dust-related hazards.

4) POWER TOOL USE AND CARE

- a) Do not force the power tool. Use the correct power tool for your application. The correct power tool will do the job better and safer at the rate for which it was designed.
- b) Do not use the power tool if the switch does not turn it on and off. Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- c) This product is designed to be used in combination with the AcraDyne iEC DC tool controller for intermittent hand-held or fixtured assembly processes.

OPERATION



1. Connect tool cable to the iEC controller and the tool:
The tool cable has curved alignment tabs and slots built into the connectors at each end to ensure proper alignment and connection with the tool and controller.

Make sure that power is not turned on at the controller before making any connections. Align the female connector on the cable with the male connector on the tool and insert the cable onto the tool, then slide the connector nut onto the threads on the cable and turn clockwise until hand-tight.

Align the male connector tab on the other end of the tool cable with the female slot on the controller and insert the cable into the connector, then slide the metal outer cover onto the connection threads on the controller and turn clockwise until hand-tight.

2. Multifunction Button Operation:

The tool will flash all LED lights three times when power is first turned on at the controller. After the controller finishes initializing and displays a target torque value, the multifunction button (MFB) is used to toggle the tool from clockwise mode (FWD) to counter-clockwise operation mode (REV). The MFB is the small button opposite the trigger.

The tool will initially start in clockwise mode and will have no LED lights turned on. If the trigger is pressed, the tool will turn on the blue LED meaning the tightening operation is

underway. Pressing the MFB will cause the tool to flash yellow and red LED lights. Pressing the MFB again will switch the tool back FWD mode and will indicate this with no LED lights turned on.

3. Start Lever Operation:

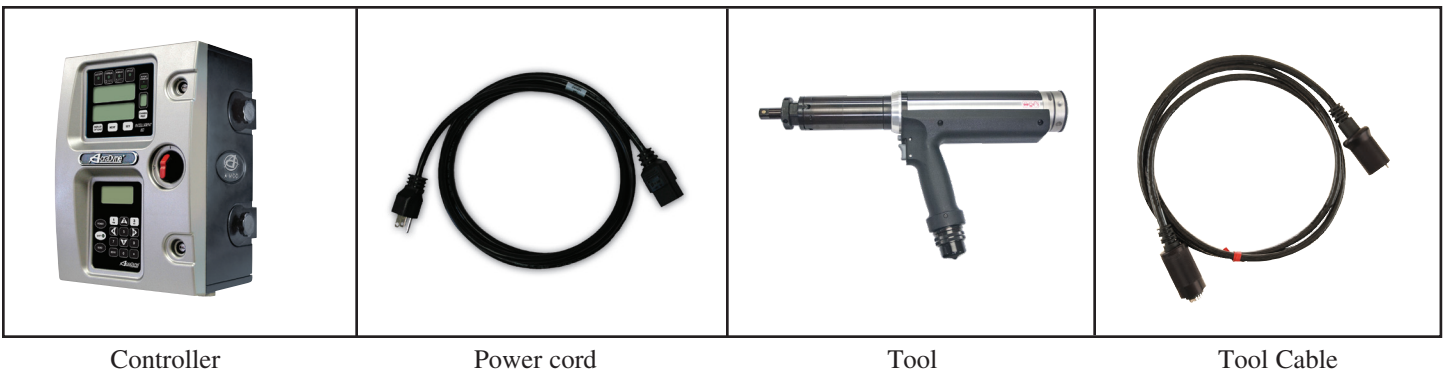
To start the tool, depress the start lever. Blue LED lights will be displayed while tightening a bolt. The tool will stop automatically when it senses its target torque value or if no torque is sensed in a specified time period. After a cycle is complete, the tool will display green LED lights for a success, or red LED lights for failure to reach torque/angle.

Light Ring Light Assignment

The Buzzer and Multi-Function Button are programmable in the DSP Menu of ToolWare.

Light Color	Meaning
Green Solid	OK
Red Flashing	Torque Low
Red Solid	Torque High
Yellow Flashing	Angle Low
Yellow Solid	Angle High
Blue Solid	Tool In-Cycle/Tool Armed
Blue Flashing	P-Set Change thru MFB
All On Flashing	Tool in Disassembly
Buzzer	Bad Assembly/Tool in Disassembly/Power Up

A complete tool system consists of the following items:



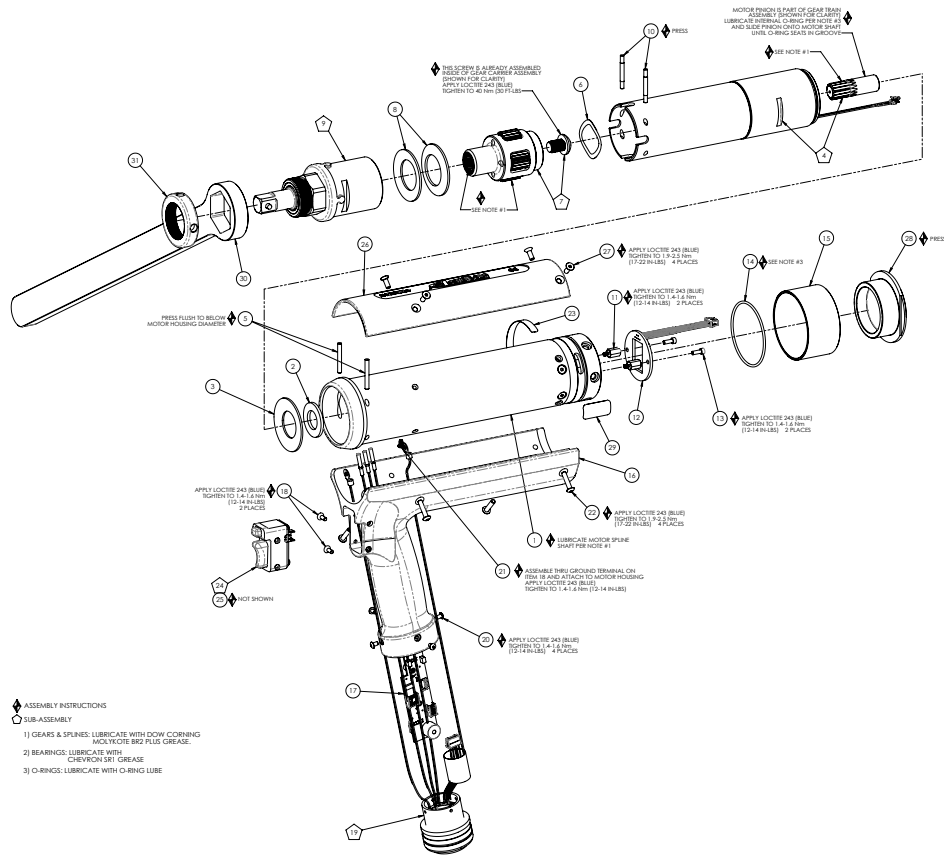
Controller

Power cord

Tool

Tool Cable

5000 SERIES PISTOL NUTRUNNERS

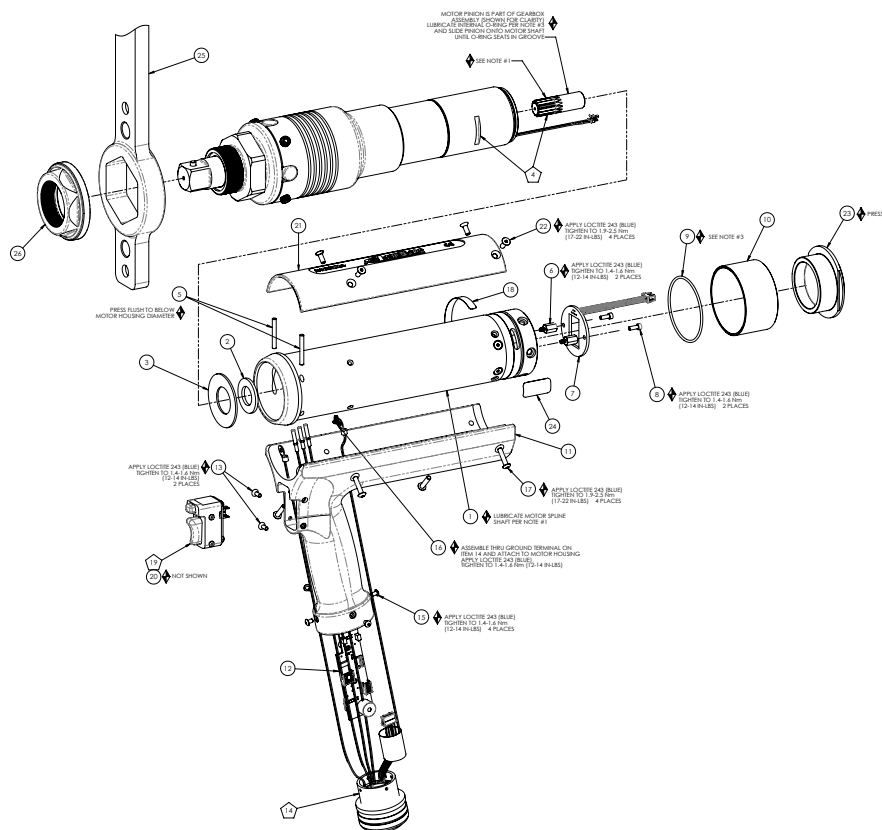


ASSEMBLY INSTRUCTIONS
 SUB-ASSEMBLY
 1) GEARS & SPINDLES: LUBRICATE WITH DOW CORNING MCV NOTE 892 PLUS GREASE.
 2) BEARINGS: LUBRICATE WITH CHEVRON SAE GREASE.
 3) O-RINGS: LUBRICATE WITH O-RING LUBE.

ITEM #	PART NUMBER	QTY.	DESCRIPTION
1	26213	1	PISTOL MOTOR ASSEMBLY
2	26198	1	THRUST WASHER
3	26074	1	BELLEVILLE WASHER
4	SEE CHART	1	GEAR TRAIN ASM.
5	26530	2	DOWEL PIN, 01/8 x 1.00, STEEL
6	20912	1	WAVE SPRING --- 3000 SERIES
7	SEE CHART	1	ASSEMBLY, GEAR CARRIER
8	20911	2	BELLEVILLE WASHER
9	20923	1	INLINE HEAD ASSY - 1/2 IN DRIVE
10	20913	2	PIN, RETAINING
11	26077	2	M-F THREADED HEX STANDOFF
12	26359	1	PISTOL LED BOARD ASM.
13	26078	2	SCREW, SHC 4-40X.312, STEEL, BLACK OXIDE
14	26080	1	O-RING, LED LIGHT RING COVER
15	26079	1	LIGHT RING COVER, LED
16	26085	1	PISTOL HANDLE
17	25847	1	TID BOARD ASM.
18	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
19	26103	1	TOOL CONNECTOR ASM., PISTOL
20	25745	4	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
21	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
22	26089	4	SCREW, BHSC 6-32X.625, STEEL, BLACK OXIDE
23	20534	1	3000 SERIAL/MODEL LABEL
24	25212	1	SWITCH SUB-ASSEMBLY
25	25788	1	CABLE ASM., TRIGGER
26	26081	1	MOTOR HOUSING COVER
27	25385	4	SCREW, FHSC 6-32 X .375, STEEL
28	26087	1	END CAP, PISTOL MOTOR
29	22141	1	SAFETY LABEL
30	20847	1	REACTION BAR
31	20455	1	FIXTURE NUT, INLINE --- 3000 SERIES

MODEL NO.	GEAR TRAIN ASM.	GEAR CARRIER ASM.
AEP35075AV	26116	20924
AEP35090AV	26115	26117
AEP35110AV	26114	20924
AEP35135AV	26113	26117
AEP35170AV	26111	26117

5000 SERIES PISTOL NUTRUNNERS

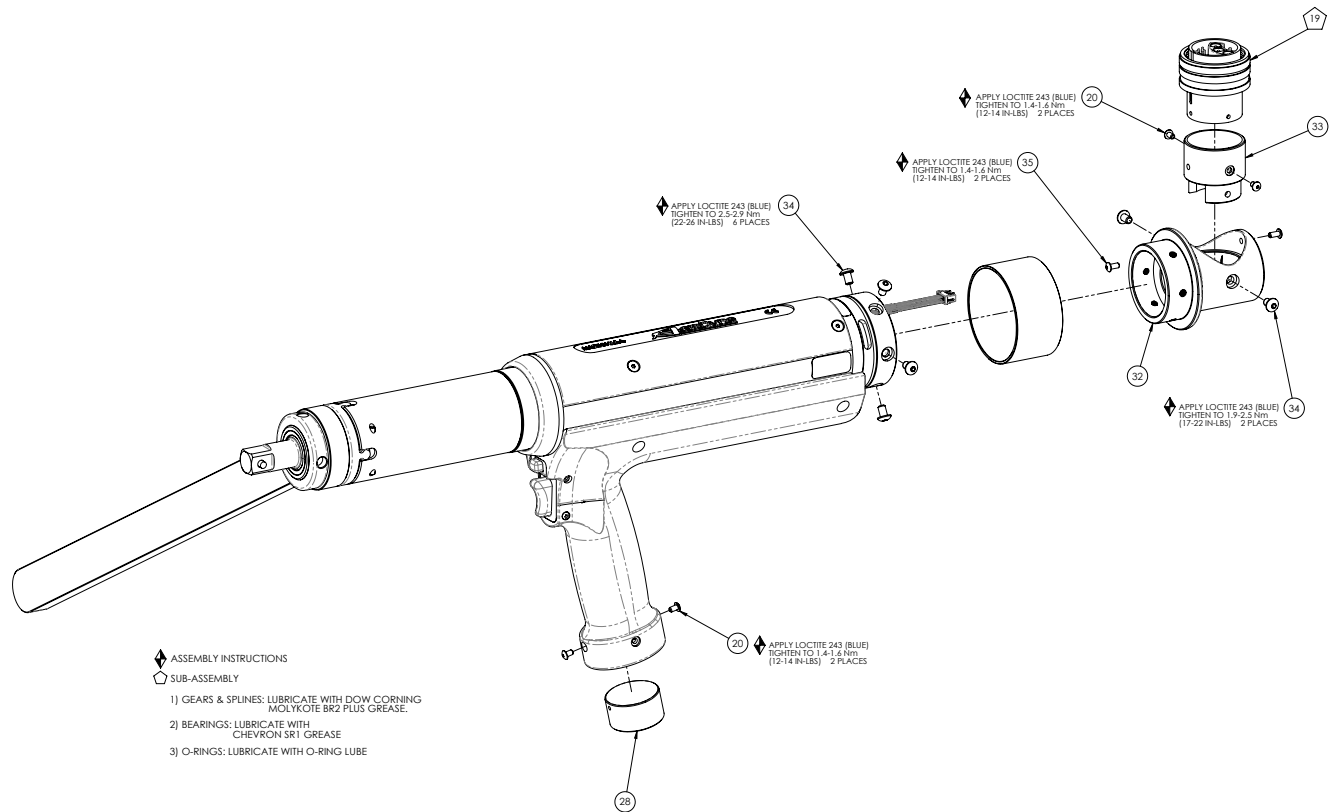


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2	26198	1	THRUST WASHER
3	26074	1	BELLEVILLE WASHER
4	SEE CHART	1	GEARBOX ASM. - TRIPLE STEP
5	26530	2	DOWEL PIN, 01/8 x 1.00, STEEL
6	26077	2	M-F THREADED HEX STANDOFF
7	26359	1	PISTOL LED BOARD ASM.
8	26078	2	SCREW, SHC 4-40X.312, STEEL, BLACK OXIDE
9	26080	1	O-RING, LED LIGHT RING COVER
10	26079	1	LIGHT RING COVER, LED
11	26085	1	PISTOL HANDLE
12	25847	1	TID BOARD ASM.
13	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
14	26103	1	TOOL CONNECTOR ASM., PISTOL
15	25745	4	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
16	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
17	26089	4	SCREW, BHSC 6-32X.625, STEEL, BLACK OXIDE
18	20534	1	3000 SERIAL/MODEL LABEL
19	25212	1	SWITCH SUB-ASSEMBLY
20	25788	1	CABLE ASM., TRIGGER
21	26081	1	MOTOR HOUSING COVER
22	25385	4	SCREW, FHSC 6-32 X .375, STEEL
23	26087	1	END CAP, PISTOL MOTOR
24	22141	1	SAFETY LABEL
25	23793	1	REACTION BAR
26	23792	1	RETAINING NUT, HEX

MODEL NO. GEARBOX ASM.

AEP35280AV	26202
AEP35350AV	26203
AEP35420AV	26201
AEP35515AV	26200
AEP35635AV	26129

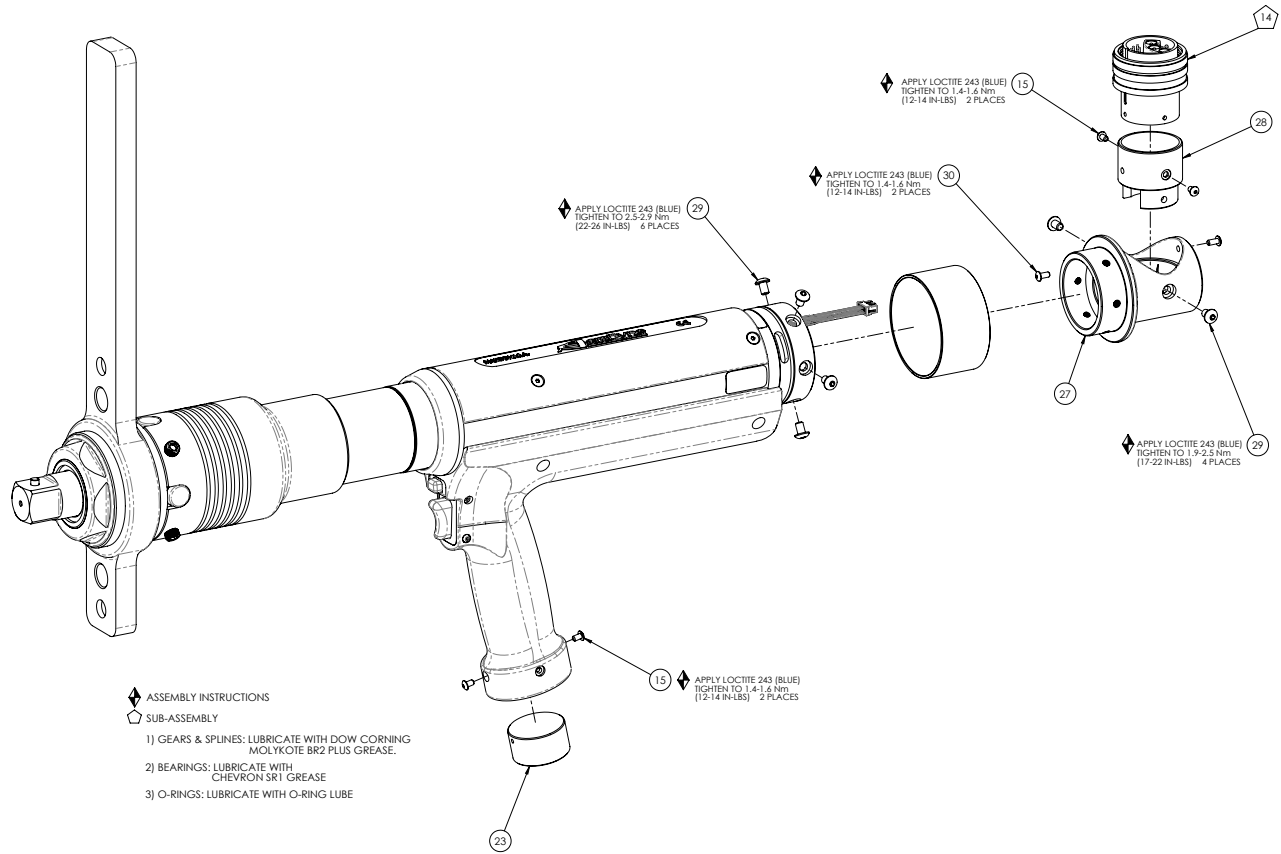
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13	26078	2	SCREW, SHC 4-40X.312, STEEL, BLACK OXIDE
14	26080	1	O-RING, LED LIGHT RING COVER
15	26079	1	LIGHT RING COVER, LED
16	26085	1	PISTOL HANDLE
17	25847	1	TID BOARD ASM.
18	24934	2	SCREW, FHC 4-40 X .312, STEEL, BLACK OXIDE
19	26407	1	TOOL CONNECTOR ASM., FIXTURED
20	25745	4	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
21	25102	1	SCREW, BHC 4-40X.188, STEEL, BLACK OXIDE
22	26089	4	SCREW, BHSC 6-32X.625, STEEL, BLACK OXIDE
23	20534	1	3000 SERIAL/MODEL LABEL
24	25212	1	SWITCH SUB-ASSEMBLY
25	25788	1	CABLE ASM., TRIGGER
26	26081	1	MOTOR HOUSING COVER
27	25385	4	SCREW, FHSC 6-32 X .375, STEEL
28	26239	1	"J" HANDLE PLUG
29	22141	1	SAFETY LABEL
30	20847	1	REACTION BAR
31	20455	1	FIXTURE NUT, INLINE --- 3000 SERIES
32	26399	1	RIGHT ANGLE ADAPTER
33	26400	1	SHELL ADAPTER, TOOL CONNECTOR
34	26088	8	SCREW, BHCS 8-32X.25, STEEL, BLACK OXIDE
35	26404	2	SCREW, BHSC,4-40 X 1/4, STEEL

MODEL NO.	GEAR TRAIN ASM.	GEAR CARRIER ASM.
AEP35075AVT	26116	20924
AEP35090AVT	26115	26117
AEP35110AVT	26114	20924
AEP35135AVT	26113	26117
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AEP35515AVT	26200
AEP35635AVT	26129

Specifications

Environmental

- Operating Temperature: 0°C to 32°C
- Storage Temperature: 0°C to 65°C
- Humidity:
 - 5% to 90% RH, Non-Condensing, for temperatures 0°C to 40°C
 - 5% to 60% RH, Non-Condensing, for temperatures 0°C to 65°C
- Maximum Altitude of Operation: 3000m
- Maximum decibel level: 77 dB(A)

Electrical

- Motor Type: BLDC
 - Motor Phase Voltage: 160 Volts Pulse DC @ Controller Supply Voltage of 120 RMS, or 320 Volts Pulse DC @ Controller Supply Voltage of 230 RMS
- Duty Cycle: The Nutrunner tools are intended for intermittent operation with recommended maximum duty cycles not to exceed 25%. Note: actual maximum duty cycles are dependant upon several factors including: Ambient Temperature, Tool selection, Joint conditions, Fastening-parameter programming, and different applications and strategies. For optimum duty cycle determination, please contact your AcraDyne sales representative.

Physical

- 6.9 lbs/3.1 kg - 16.1 lbs/7.3 kg

Performance (Series)

- Torque Range: 19 - 635 NM
- Speed Range: 14 - 468.6 RPM

*Notes: Full speed 50% of rated for 5000 series tools @ 120VAC.
5000 series tools must be connected to iEC controllers equipped
with 40A servo drive.*



AIMCO CORPORATE HEADQUARTERS
10000 SE PINE STREET
PORTLAND, OREGON 97216
PHONE: (503) 254-6600
TOLL FREE: 1-800-852-1368

AIMCO CORPORATION DE MEXICO SA DE CV
AVE. CRISTOBAL COLON 14529
CHIHUAHUA, CHIHUAHUA. 31125
MEXICO
PHONE: (01-614) 380-1010
FAX: (01-614) 380-1019

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