New Filling & Bleeding

New Filling and Bleeding Procedure for 2012, 2015, 202, 210, and 212

Equipment Required:

- Shop airline with 90 - 100 psi max.
- Air regulator
- Fill bottle, 120337, (supplied with tool).
- Large flat blade screwdriver
- Nose assembly or optional stall nut
- Fasteners (optional)
- Optional stall nuts (and *stop):
  124090 for 2012, 202, 210, and 212.
  125340 and *stop, 125341 for 2015.

Stall nut is used to load tool during bleeding and for measuring stroke.
NOTE: 210 bleed port is on top of head - - do not bend bottle.

Preparation:

1. Install air regulator in airline and set pressure to 20 - 40 psi.

2. Fill bleed bottle almost full of DEXRON II - - ATF (automatic transmission fluid) - - see *FIGURE 1.*

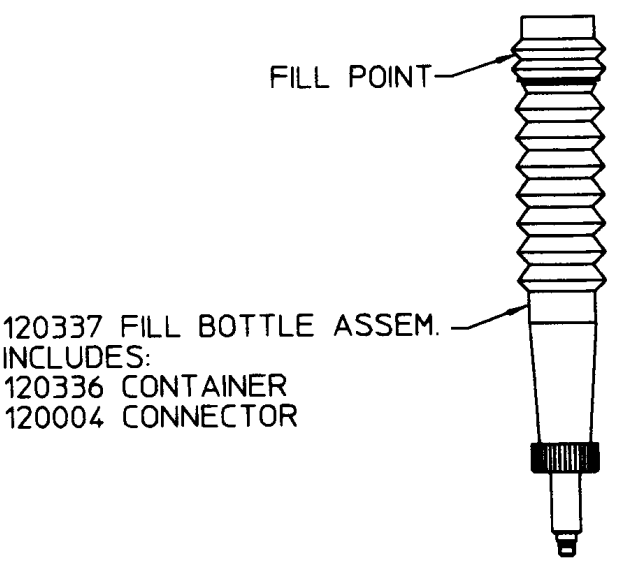


Figure 1

ALCOA
Huck Fasteners
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Procedure to Fill Empty Tool (new or rebuilt) - - as Applicable:

1. Attach tool to air supply to seat the air piston at bottom of the air cylinder - - disconnect tool. With fillport facing up, lay tool on it's side.

2. With a screwdriver, remove bleed plug from fillport.

WARNING
Never cycle tool trigger without bleed plug installed and tightened, the fill bottle installed and tightened in the tool head, or the fillport held over a suitable container (see *FIGURE 2* below). *If fluid is present, it will spray out of tool. Severe eye injury may result.* Air pressure *MUST* be set to 20 - 40 psi.

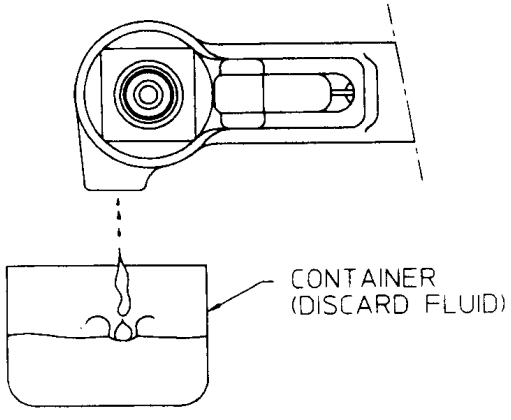


Figure 2

3. Screw fill bottle into fillport in the head.

4. Set airline pressure to 20 - 40 psi and connect airline to tool.

5. Stand tool upright on bench. While actuating the trigger slowly (20 - 30 cycles), bend fill bottle at right angles to tool - - see *FIGURE 3.* Observe that air bubbles emerge from tool. When bubbles are no longer observed, cycling may be discontinued.

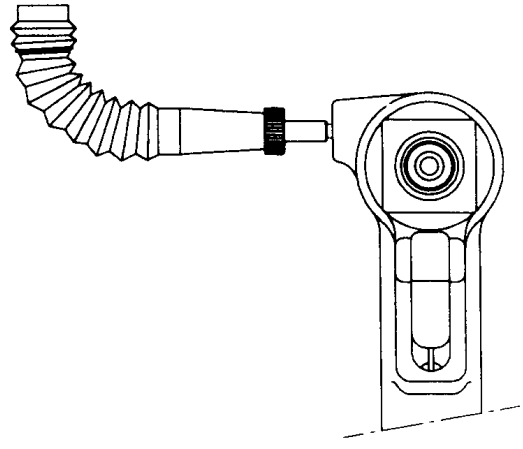


Figure 3

6. When trigger is released, pull piston returns to idle position (full forward). Disconnect tool from airline with piston full forward.

7. Lay tool on it's side. Remove fill bottle. Top off fluid in fillport. Install bleed plug and tighten with screwdriver.

8. Connect airline to tool. Cycle tool and measure stroke, i.e. piston travel - - see applicable figure for stroke dimension and procedure. If stroke is less than specified, remove bleed plug and top off fluid. Reinstall bleed plug.

9. Increase air pressure to specification. Install two fasteners to check function and installation in a single stroke, or cycle tool with stall nut fully threaded onto piston. Measure stroke again. Remove plug and top off fluid. Reinstall plug and cycle again - - measure again. Continue this process until stroke meets minimum requirements.

Bleed Procedure for Partially Filled Tool in Field Use - - as Applicable:

1. Disconnect tool from airline. With fillport facing up, lay tool on it's side.

2. Remove bleed plug from bleed port with a screwdriver.

3. Hold tool over suitable container with fillport facing into container.

WARNING

Never cycle tool trigger without bleed plug installed and tightened, the fill bottle installed and tightened in the tool head, or the fillport held over a suitable container (see *FIGURE 4* below). *If fluid is present, it will spray out of tool. Severe eye injury may result.* Air pressure *MUST* be set to 20 - 40 psi.

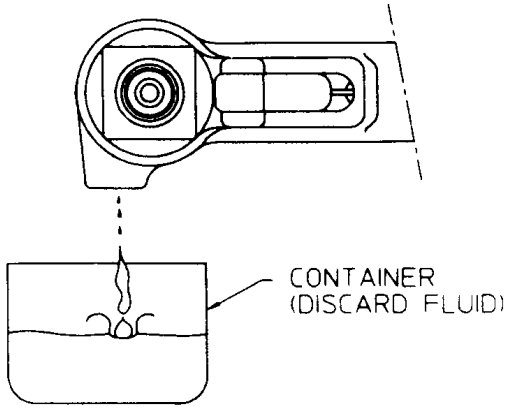


Figure 4

4. Connect tool to airline. Cycle tool several times to drain the old fluid, air and foam.

5. Screw fill bottle into fillport in the head.

6. Set airline pressure to 20 - 40 psi and connect airline to tool.

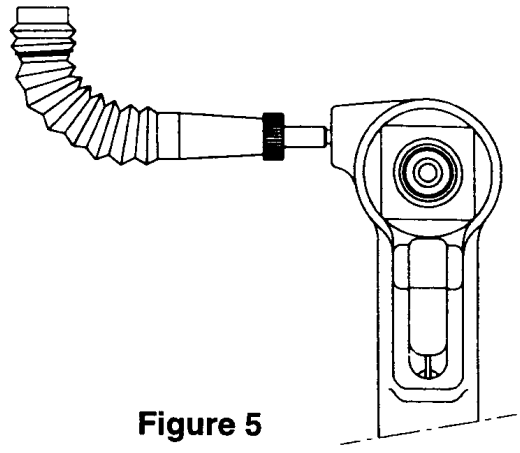


Figure 5

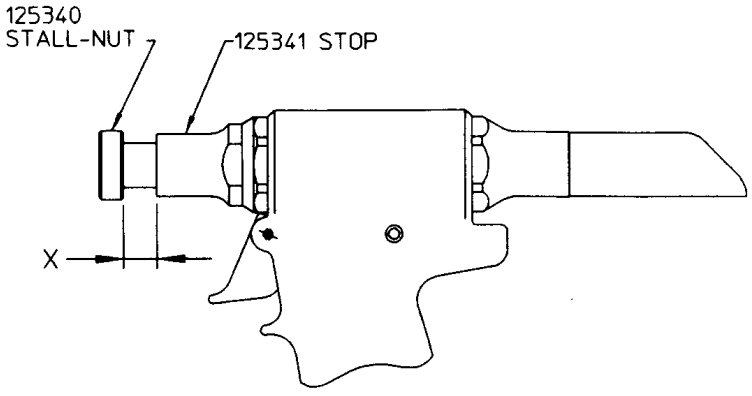
7. Stand tool upright on bench. While actuating the trigger slowly (20 - 30 cycles), bend fill bottle at right angles to tool - - see *Figure 5*. Observe that air bubbles emerge from tool. When bubbles are no longer observed, cycling may be discontinued.

8. When trigger is released, pull piston returns to idle position (full forward). Disconnect tool from airline with piston full forward.

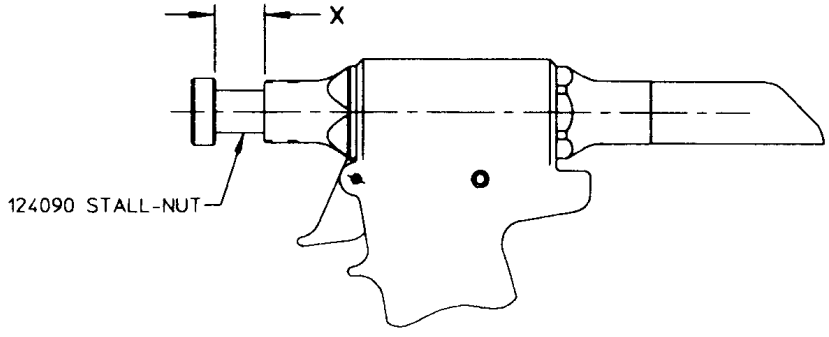
9. Lay tool on it's side. Remove fill bottle. Top off fluid in fillport. Install bleed plug and tighten with screwdriver.

10. Connect airline to tool. Cycle tool and measure stroke, i.e. piston travel - - see applicable figure for stroke dimension and procedure. If stroke is less than specified, remove bleed plug and top off fluid. Reinstall bleed plug.

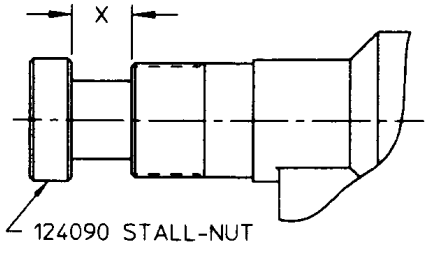
11. Increase air pressure to specification. Install two fasteners to check function and installation in a single stroke, or cycle tool with stall nut fully threaded onto piston. Measure stroke again. Remove plug and top off fluid. Reinstall plug and cycle again - - measure again. Continue this process until stroke meets minimum requirements.



2015



2012
202



210
212

Minumum Stroke

2012 - - - .650
2015 - - - .650
202 - - - - .743
210 - - - - .937
212 - - - - .812

To measure stroke of the tool with stall-nut threaded onto piston:

NOTE: Stop, 125341, must be tightly threaded into 2015 tool's adapter.

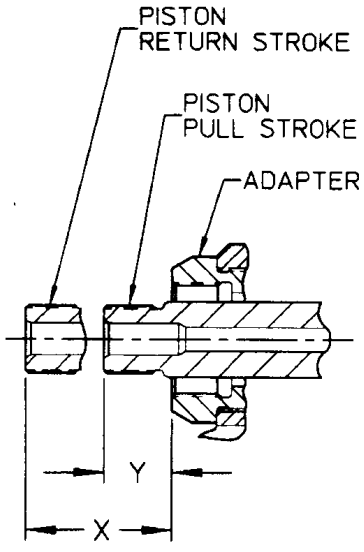
1. With piston fully forward (end of RETURN stroke), bottom the stall-nut on piston. Back stall-nut off five (5) turns.

2. Cycle tool and hold trigger depressed - - this keeps piston fully to the rear and at end of PULL stroke.

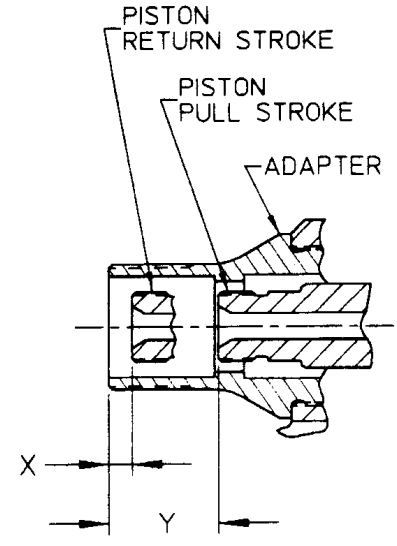
3. Thread stall-nut back onto piston until it contacts adapter (stop on 2015).

4. Release trigger. Stall-nut will move forward with piston. See appropriate illustration and measure "X" dimension. This is the tool's stroke.

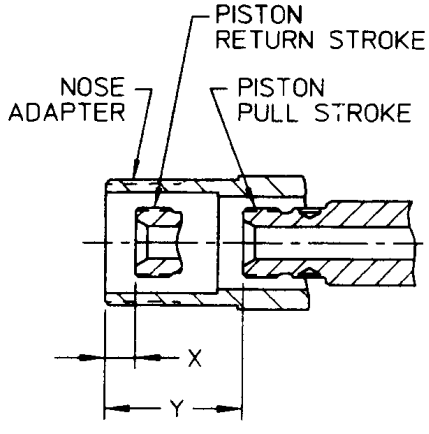
5. If stroke is less than the minumum listed in the *MINIMUM STROKE* chart , refer to appropriate previous section. Follow filling and topping off instructions



2015



2012
202



210
212

Minumum Stroke

2012 - - - .650
2015 - - - .650
202 - - - - .743
210 - - - - .937
212 - - - - .812

To measure stroke of tool without stall-nut:

1. With piston fully forward (end of RETURN stroke), measure and record "X" dimension. See appropriate illustration.

2. Hold trigger depressed. Piston is now fully to the rear and at end of PULL stroke. Measure and record "Y" dimension.

3. Subtract the smaller dimension from the larger. For the minumum stroke allowable, see *MINIMUM STROKE* chart.

4. If stroke is less than that listed for tool, refer to appropriate previous section. Follow filling and topping off instructions