

OPERATING INSTRUCTIONS AND SAFETY MANUAL



MODELS

RR-500, RR-625, RR-875, RR-1000, RR-1250

CAREFULLY READ THIS MANUAL BEFORE OPERATING TOOL

MODEL NUMBER	FREIGHT AXLE	CAP SCREW SIZE	PASSENGER AXLE CLASS	LOCOMOTIVE AXLE CLASS	LENGTH	WEIGHT
RR-500		1/2"			9.5"	3.2 lbs.
RR-625		5/8" & 3/4"			9.5"	3.2 lbs.
RR-875	Class D—50 Tons	7/8"	E, F/EE, G	GG	9.5"	3.2 lbs.
RR-1000	Class E,F—70-100 Tons	1" & 1 1/8"		G	9.5"	3.2 lbs.
RR-1250	Class G—125 Tons	1 1/4"			9.5"	3.2 lbs.



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These pneumatic tools are designed to bend tabs on railroad wheels. They are well balanced and ergonomic. Specifically designed for bending tabs on railroad wheel nuts. Any other application please consult the factory.

SAFETY INSTRUCTIONS

1. Read this manual and understand all safety instructions before operation of the tool. If you have questions please contact our authorized distributors or the factory.
2. Only those tabs and nuts listed in the operating instructions are to be bent with the tool specific to the size. Any other use may damage tool or cause harm to operator.
3. Only the main energy (air supply) and lubricants listed in the instructions may be used.
4. For maintenance of the tab bender only spare parts and jaws specified by the manufacturer shall be used.
5. Repairs to be carried out by authorized agents or the factory only.
6. Tab bending tools operated by compressed air shall only be connected to compressed air lines where the maximum allowable pressure CANNOT be exceeded by a factor of more than 10%. This can be achieved by a pressure reduction valve which includes a downstream safety valve.
7. When using the tab bender operated by compressed air, particular attention must be paid to avoid exceeding the maximum allowable pressure.
8. Tab bender should be operated at the lower possible air pressure to perform the task at hand. This will help avoid unnecessary noise levels, increased wear and resulting failures.
9. There is possibility of fire and explosion when using oxygen or combustible gases for operating compressed air driving tab bender.
10. Carry tab bender using only the handgrip and never by trigger or with trigger actuated. Never carry the tool by the hose or pull hose to move the tool.
11. Disconnect the tool from air supply before cleaning, servicing, adjusting and during non-operation.
12. Wear eye protection. 
14. Do not use a check valve or any other fitting which allows air to remain in tool.
15. Do not place hand or any part of your body in the jaw area of the tool when connecting or disconnecting air supply. 
16. Never point tool at yourself or at any other person.

AIR SUPPLY AND CONNECTION

1. Many air tool users find it convenient to use oiler to help provide oil circulation through tool and increase the efficiency and useful life of the tool. Check oil level in the oiler daily.
2. Many air tool users find it convenient to use a filter to remove liquid and impurities which can rust or wear internal parts of the tool. A filter also increases the efficiency and life of the tool. The filter must be checked on a daily basis and drained if necessary.
3. For better performance, install a 3/8" quick connector (1/4" NPT threads) with inside diameter of 0.315" on your tool and 3/8" quick coupler on the air hose.

LUBRICATION AND MAINTENANCE

1. Disconnect the air supply from the tool before lubricating.
2. Your tool requires lubrication before you use it the first time.
3. Wipe off excessive oil at the exhaust. Excessive oil will damage O'rings of tool. If in-line oiler is used, manual lubrication through air inlet is not required on a daily basis.
4. Turn the tool so the inlet is facing up and put one drop of high speed spindle oil or sewing machine oil into air inlet. NEVER use detergent oil or additives. Operate the tool briefly after adding oil.

OPERATING THE TOOL



1. Protect your eyes and ears. Wear z87.1 safety glasses with side shields. Wear hearing protection. Employers and users are responsible for ensuring the user or anyone near the tool wear proper safety protection.
2. Check and replace any worn components on the tool.
3. Add a few drops of lubricating oil into the air inlet.
4. Attach a high flow quick connect fitting to the tool.
5. Connect the tool to an air compressor using a 3/8" I.D. hose. Make sure the hose has a rated working pressure exceeding 200 PSI (13.8 bar) and a female quick coupler.
6. Regulate the air pressure to obtain 70 PSI (4.8 bar) at the tool.
7. Test for proper bending of the tab. Adjust the air pressure to achieve proper bend. Do not exceed 110 PSI (7.6 bar) at the tool.

CLEANING THE TOOL

1. Never use gasoline or other flammable liquids to clean the tool. Vapors in the tool will ignite by a spark and cause the tool to explode and result in death or serious personal injury.
2. Disconnect the air supply from tool when repairing or cleaning.
3. Jaws should be kept clean. ALWAYS clean or service with air supply disconnected from tool.

TOOL SPECIFICATIONS

TOOL LENGTH—7.36" (187 mm)

TOOL HEIGHT—14.72" (374 mm)

TOOL WIDTH—3.42" (87 mm)

WEIGHT—3.2 lbs. (1.45 kg)

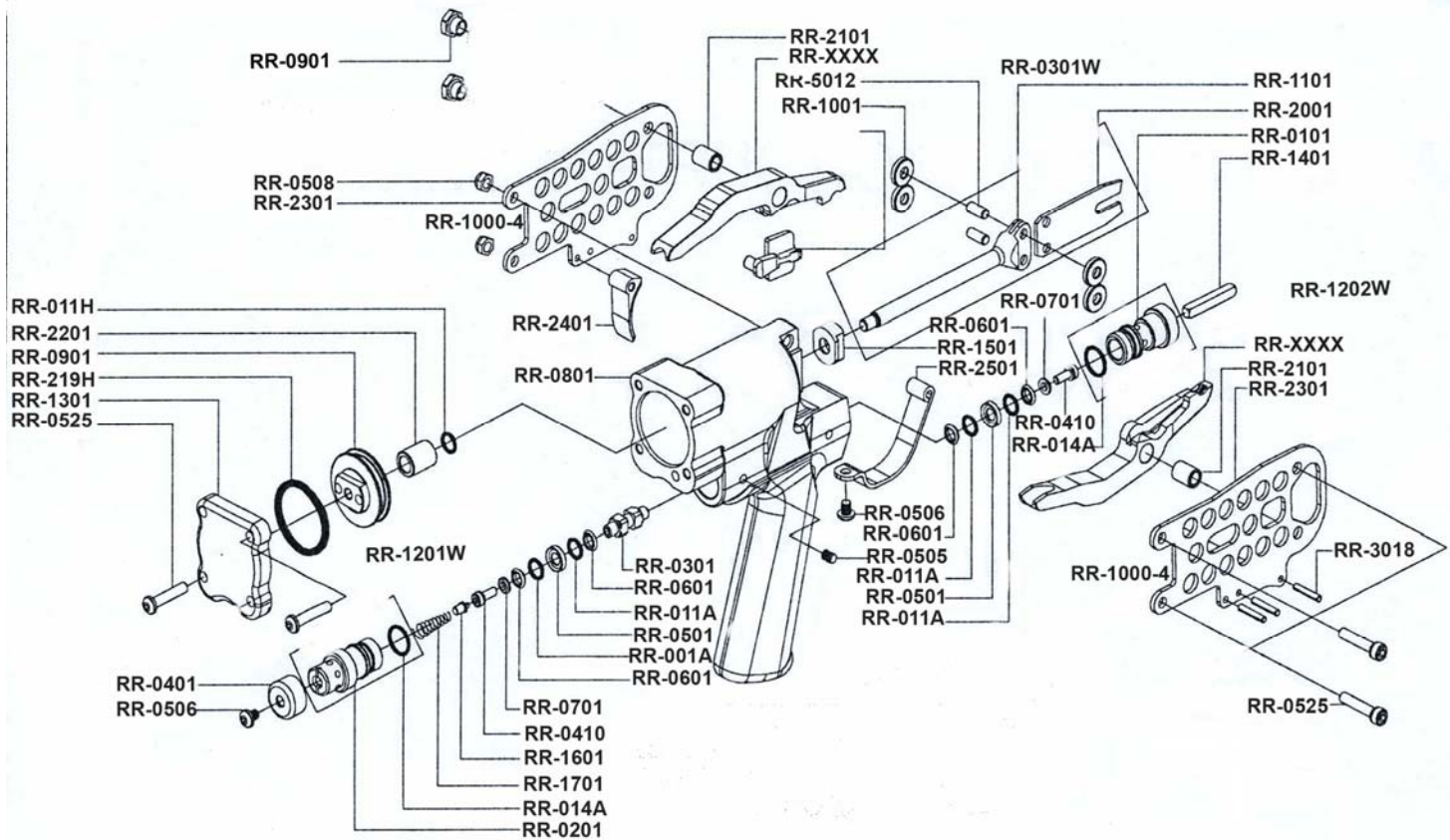
AIR INLET—1/4" NPT

COMPRESSED AIR:

Max. Permissible Operating Pressure—110 PSIG (7.5 bar)

Recommended Operating Pressure—95-110 PSI (6.5—7.5 bar)

Air Consumption—0.052 scfm @ 90 psi (6.2 bar)



DRWG NO.	DESCRIPTION	QTY.	DRWG NO.	DESCRIPTION	QTY.
RR-0901	Nut	2	RR-0801	Body	1
RR-1000-6	Hex Set Screw	2	RR-0901	Main Piston	1
RR-0410	Hex Set Screw	2	RR-1001	Roller	4
RR-0525	Hex Set Screw	2	RR-1101	Rod Piston	1
RR-5102	Parallel Pin	2	RR-1201W	Trigger Valve Guide Assy.	1
RR-0506	Button Hd. Bolt	2	RR-1301	Cylinder Cap	1
RR-3018	Spring Pin	3	RR-1401	Trigger Valve Stem	1
RR-001A	O'Ring	4	RR-1501	Bumper	1
RR-011H	O'Ring	1	RR-1601	Spring Seat	1
RR-014A	O'Ring	2	RR-1701	Compression Spring	1
RR-219H	O'Ring	1	RR-1802	Jaw Lower***	1
RR-0101	Trigger Valve Guide	1	RR-1902	Jaw Upper***	1
RR-0201	Trigger Valve Guide	1	RR-2001	Driver	1
RR-0301	Trigger Valve Seat	1	RR-2101	Cap	2
RR-0301W	Driver Assy.	1	RR-2201	Cap	1
RR-0401	Exhaust Cap	1	RR-3201	Side Plate	2
RR-0501	O'Ring	2	RR-2401	Trigger	1
RR-0601	O'Ring Cap	4	RR-2501	Guard Trigger	1
RR-0701	Spacer	2	RR-2601	Latch	1

*** - Consult Factory on Proper Jaw for Tool. Must have Tool Number

Tool Number	Jaw Part Number
RR-500	RR-500-1
RR-625	RR-625-1
RR-875	RR-875-1
RR-1000	RR-1000-1
RR-1250	RR-1250-1