

Operating Instruction Booklet

Pneumatic Flat-Head Wrench

39-521-19K

391625 A

Dear Customer:

This tool is the result of more than 75 years of experience in the design and manufacturing of pneumatic tools for the industrial market.

We kindly ask that you read these operating instructions carefully so that you will be able to use this tool safely and for many years to come.

If you need additional information, please contact your DEPRAG Representative, one of our international support offices or us direct at DEPRAG. We will be happy to answer any questions. Please visit our web site: www.deprag.com

Content

1	SAFETY TIPS	3
1.1.	General Safety Tips	3
1.2.	General Safety Tips for Pneumatic Screwdriver Spindles.....	4
1.3.	Owner Obligation	5
1.4.	Operator Obligation	5
1.5.	Warranty and Liability	6
1.6.	Symbol Description.....	7
1.7.	Observe Environmental Regulations	9
2	DESIGNATED EQUIPMENT USE	9
3	INSTALLATION.....	10
4	OPERATION	11
5	HANDLING.....	12
6	ASSEMBLY - DISASSEMBLY.....	12
6.1.	Spare Parts Drawing.....	15
6.2.	Dimensional Drawing.....	18
7	MAINTENANCE AND UPKEEP	19
7.1.	Wear Parts.....	19
8	TROUBLE SHOOTING	20
9	DELIVERY CAPACITY.....	20
10	ACCESSORIES - OPTIONAL EQUIPMENT	20
11	STORAGE	21
12	TECHNICAL DATA.....	21
13	DISPOSAL.....	22
14	CONFORMITY DECLARATION	23
15	SERVICE LOCATIONS AND AUTHORIZED PARTNERS.....	24

1 Safety Tips

1.1. General Safety Tips



Before operating tool make sure to carefully read and observe this operating instruction.

Generally, the operator of the equipment and/or machinery is responsible for the equipment's perfect condition and operation, while observing all necessary safety regulations. The equipment and/or machinery has been constructed in accordance with the newest level of technology while recognizing all necessary safety-related requirements. Nevertheless, while operating the equipment and/or machinery there is a risk of bodily harm to the operator as well as damage to equipment and/or machinery and other property.

Operate the equipment and/or machinery only if equipment/machinery

- Is used for the task it was designed for
- is in perfect working condition and safe to use.

It is important to observe the technical data of the equipment, especially in regards to the environmental temperatures. The designated area of use for this equipment is clearly described in chapter *Designated Equipment Use* and those requirements have to be observed as well. Prerequisite for the safe conduct and the uninterrupted operation of the equipment, is the knowledge of the basic safety tips and the safety regulations. Additionally, all current regulations for a safe operational area, for accident-prevention guidelines of electrical and mechanical installations, as well as noise suppression demands must be observed. During any maintenance or repair work, a clean work surface is recommended. Also, it is not recommended to either eat or smoke during repair or maintenance. Arbitrary changes made to the equipment, which alters its designated use, voids the warranty and cancels the manufacturers liability.

- The tool is not insulated to protect against an electrical power surge.
- It is not recommended to use this tool in explosive hazardous environments, unless it was specifically designed for such a use.

The operating instruction booklet, especially the safety symbols and safety tips attached to the equipment or included in the documentation, must be observed at all times by all persons getting into contact with the equipment.

1.2. General Safety Tips for Pneumatic Screwdriver Spindles



- Disconnect the tool from the air supply, when changing bits or when readjusting clutch.
 - Do not wear wide clothing or jewelry, for they can be seized by movable parts. Wear a hairnet if operator has long hair.
 - Keep hands off the installed bit or socket.
 - Injury is possible, if the driver reacts with an unexpected motion or when driver is used with a broken bit.
 - Keep hands away from holding fixture (if used). This applies especially when loosening screws in a tight area. There is a risk of squeezing fingers between holding bracket and tool. Make sure that any bracket used is correctly installed.
 - An unexpected motion of the bit or socket may create a dangerous situation.
 - Especially, when operating an impact wrench, it is possible that an injury occurs, if the bit breaks [flying splinters].
 - When using tool with bit-adapter or bit-extension (i.e. Magnetic Bitholder), make sure, that those items are in good condition and well suited for the application with this tool.
- i**
- When using a screwdriver stand, make sure that the tool is securely mounted. If no stand is used, make sure to have a solid stance to absorb the tools' torque reaction force.
 - If you are not able to absorb the torque reaction force, use a holding fixture or side handle on the screwdriver.
 - After turning-off the tool, the bit will continue to rotate [inertia].
 - Do not exceed the maximum allowable air pressure. A pressure regulator has to be installed, which regulates the air pressure before it reaches the tool.
 - Avoid pressure to fall below the minimum allowable air pressure, because the clutch cannot shut-off safely. This may cause an increased torque reaction force, resulting in risks to operator, tool or product.
 - In case of an interruption of the air supply, make sure to wait until tool has come to a stand still, prior to reactivating tool.

1.3. Owner Obligation

The owner is obliged to only let persons operate the equipment, who

- are familiar with basic work environment safety rules and accident-preventing regulations. Also, those persons must have been instructed in the correct use of the equipment.
- have read and understood all safety and warning notifications in the Operating Instruction Booklet, as well as all other documentation pertaining to this equipment.
- check and confirm at regular intervals, that a safety oriented operation is guaranteed.

Only qualified and authorized personnel is allowed to operate, maintain and repair this equipment. A malfunction, which impairs operator safety, must be immediately removed.

1.4. Operator Obligation

Personnel, who is engaged in the operation of the equipment, must always be committed to

- observe the basic safety and accident preventing regulations,
- read and observe the safety and warning notifications of this operating instruction booklet.

1.5. Warranty and Liability

Unless otherwise specified, our “General Sales and Delivery Conditions” apply. Warranty and liability claims in regards to persons or equipment damages are invalid, if one or several of the following causes apply:

- Use of the equipment in a non-designated application.
- Improper installation, operation, service or maintenance of the machine.
- Operation of the machine with either defective or removed safety and protection devices.
- Non-observance of the requirements stated in the operating instruction booklet, in regards to transportation, storage, mounting, installation, operation, maintenance and service of the equipment.
- Structural change or adjustment on the equipment to a non-designated use.
- Inadequate supervision of wear parts.
- Improper repair, inspection or maintenance.
- Catastrophic cases because of a war, acts of god or other reasons which are beyond our control.

1.6. Symbol Description



Read and observe the Operating Instruction Booklet, prior to and during operation of tool.



DANGER

Reference to an immediate danger to a person. May lead to serious injuries or even death, if unobserved!



Properly recycle environmentally damaging grease, cooling agents or detergents.



RECOMMENDATIONS

Important or additional information on the equipment or in the documentation.



Use eye protection or wear safety goggles.



Wear hearing protection.



Warning against hand-injuries.

Attention: Keep away your hands from areas, which are marked with this symbol!



Hands may be crushed, seized or otherwise injured.



ESD-protected area

Equipment may be damaged or destroyed by an electrostatic discharge.



Maintenance and repair on hydraulic and pneumatic equipment may only be performed by specially trained personnel!
Disconnect equipment from air supply, prior to repair of pneumatic or hydraulic equipment.



Provide regular preventive maintenance on hoses and airlines.
Exchange hose lines, even if there is no visible damage!
(Observe corresponding requirements of the manufacturer!)

After repair and maintenance, check the following items:

- make sure all detached and re-attached connections are solid.
- confirm that removed covers, screens or filters were re-installed
- During disconnecting or reconnecting of an air-operated equipment, injury may occur due to a whipping air-hose

After conclusion of maintenance or repair and prior to start of operation, make sure to

- remove all materials, tools and other supplies needed for the maintenance or repair from work area of the equipment
- remove leaking liquid or oils
- make sure all safety devices on the equipment work perfectly!

1.7. Observe Environmental Regulations



When working on or with the equipment, it is imperative to observe all requirements in regards to waste-disposal and proper recycling.

Especially during installation, repair or maintenance, water damaging agents such as

- lubricating grease and oil
- hydraulic fluid
- cooling agents
- solvent-containing cleaning agents

must not leak into the ground or into the sewage system!

Such materials must be stored, transported, contained and recycled in suitable containers.

2 Designated Equipment Use

This flat-head wrench is designated to be used by respectively skilled staff for manual assembly/disassembly operations under tight space conditions.

3 Installation

- Blow out air line and pressure hose, prior to connection it to the tool.
- Make sure, that all air lines have a sufficient cross-section (see technical data) and hoses must be free of bends and kinks. The hose length should not exceed 2 meters.
- All DEPRAG Screwdrivers, may be operated either with or without lubricated air (see paragraph: Maintenance and Upkeep). Best results are achieved, when machine is lubricated with 1 – 2 drops of oil per 1m³. When operating with oilfree air, a performance reduction of up to 20% occurs and maintenance requirements increases!
- Connect the equipment as follows:
 - a) for standard operation connect equipment to a maintenance unit, consisting of Filter with condensation reservoir, Regulator and Oiler. When choosing a maintenance unit, observe air consumption rate for the tool (see Technical Data).

Air Consumption	Thread Size	Part No.
0,05 - 0,5 m ³ /min	1/4"	820454 A
0,15 – 1,5 m ³ /min	1/2"	820455 A
0,8 – 6,0 m ³ /min	3/4"	821608 A

- b) for the use with minimal lubrication connect to a filter-regulator consisting of Filter with condensation reservoir and pressure regulator

Air Consumption	Thread Size	Part No.
0,05 - 0,5 m ³ /min	1/4"	822408 A
0,15 – 0,9 m ³ /min	3/8"	826981 A
0,5 – 1,5 m ³ /min	1/2"	822409 A
0,8 – 6,0 m ³ /min	3/4"	826982 A

Each in connection with a Point-of-Use Oiler (Part No. 378077 A)

- c) for oilfree operation, connect to Filter/Regulator, consisting of Filter with condensation reservoir and Pressure Regulator.

Air Consumption	Thread Size	Part No.
0,05 - 0,5 m ³ /min	1/4"	822408 A
0,15 – 0,9 m ³ /min	3/8"	826981 A
0,5 – 1,5 m ³ /min	1/2"	822409 A
0,8 – 6,0 m ³ /min	3/4"	826982 A

OUR RECOMMENDATION: The preferred lubricating method for the screwdriver spindles mounted in fixtures, brackets, machines, etc., each in connection with a controller, is method b) with Point-of-Use Oiler.

- Check pressure at directly on the machine. The Regulator needs to be adjusted to an airflow between 5.0 (71 PSI) and 6.3 bar (90 PSI). A higher pressure leads to increased wear and tear. A lower pressure may lead to clutch not being able to correctly shut-off the motor.

In regards to air-quality according to ISO8573-1, we recommend:

	CLASS	RESIDUE OF OIL		RESIDUE OF DUST		RESIDUE OF WATER	
		Content mg/m ³	Particle Size μm	Concentration max. mg/m ³	Dew Point °C	Pressure Concentration max. g/m ³	
Lubricated Air	4	5	15	8	+3	6	
Dry Air	3	1	5	5	-20	0,88	

4 Operation

Reducing the air flow pressure will affect the tools' tightening torque. Please see the following approximate values for pressure/torque ratio:

AIR FLOW PRESSURE (BAR) FOR 39-521-19K	TIGHTENING TORQUE (Nm)
6	appx. 8,5
5	appx. 6,3
4	appx. 5,3
3	appx. 3,9



ATTENTION

If the tool's tightening torque is higher than the screw's maximum tightening torque, the screw may be damaged.

Therefore, please pay specific attention to the fact that the maximum tightening torque of the screw is definitely higher than the one of the flat-head wrench.

5 Handling

Push the tool with the bit onto a screw. If you activate the lever now, the tool will automatically start and tighten the screw. After reaching the pre-set torque value, the automatic clutch will turn the tool off. After releasing the lever now, the tool will automatically be ready for new operation.

6 Assembly - Disassembly

Disassembly: (see Spare Parts Drawing)



Prior to disassembly, disconnect equipment from air supply! Only experienced maintenance personnel may assemble or disassemble this equipment.

After repair or maintenance, verify that equipment runs to specification!

Principally, use only DEPRAG original spare parts. Otherwise, a reduction in equipment power-output and an increased maintenance-requirement occurs. If NON-DEPRAG parts are installed, DEPRAG is justified to void any existing warranty and liability obligations.

For **disassembly** proceed in the sequence described below:

1. Unscrew motor housing 391650 from threaded fitting 391674 (left-hand thread).
2. Remove spindle 391673 and gear parts complete.
3. Unscrew quick release nipple 804273.
4. Remove valve disc 386097 and the pressure spring 802987.
5. Push out tension pin 823154 of the lever and remove lever.
6. Unscrew the valve bushing 389670 together with the bearing needle 802332 and pull-out the valve pin 386093.
7. Remove the lock ring 827407, support washer 801250 and O-ring 827406.
8. Use your hand to push the interior motor housing 386126/1 out of the exterior motor housing 391650 in the direction of the clutch.
9. Remove the four (4) balls 802171.
10. Clamp the interior motor housing 386126/1 into a vice, using protective clamping jaws 460781.
11. Unscrew the valve housing 385700 (right-hand thread).

12. Clamp the assembly tube 460566 into the vice and use the provided arbor to push the motor- and gearing parts into the assembly tube into the direction of the air-inlet.
 - a. Clamp rotor cylinder into fixing device.
 - b. Pull off shaft-side bearing cover from rotor.
 - c. Remove rotor cylinder.



NOTE

Exchange only complete sets of vanes.

- d. Remove vanes and check them thoroughly. Vanes that are too narrow or damaged have to be replaced **in sets**.
- e. Pull off air connecting-side bearing cover from rotor.
- f. Press the two ball bearings from the bearing covers.

Assembly:



Use the DEPRAG Grease 807293 (100-g tube) to grease the ball bearing, needle bearing and gearing parts prior to reassembly.

- a. Clean rotor.
- b. Press the ball bearings into the two bearing covers.
- c. Press the shaft-side bearing cover with the ball bearing on the rotor.
- d. Insert the new vanes into the rotor.
- e. Put the rotor cylinder over the rotor.



After assembly the bearing covers shouldn't have any axial gap. The rotor must turn freely.

- f. Press air-connecting side bearing cover with the ball bearing on the rotor.
1. Clamp the interior motor housing 386126/1 into the vice, using the protective clamping jaws 460781.
 2. Place the motor- and gearing parts (correctly sequenced) into the assembly tube 460566.
 3. Place the assembly tube adjacent to the interior motor housing 386126/1 and use the provided arbor to push the individual motor- and gearing parts into the interior motor housing.
 4. Assembly the valve housing 385700 (right-hand thread).

5. Apply grease to the valve housing 385700 and press the four (4) balls 802171 into the appropriate recess.
6. Clamp the exterior motor housing 391650 into the vice, using the protective clamping jaws 462049.
7. Push the motor parts into the motor housing 391650 from the clutch side.
8. Slide the two O-rings 828282 and 828424, the support washer 801250 and the lock ring 827407 onto the motor housing 386126/1.
9. Insert the silencers 301295 and 323665 (observe correct sequence!).
10. Push the valve pin 386093 into the motor housing and install the valve bushing 389670 with bearing needle 802332.
11. Reinstall the lever 366465 to the motor housing 391650 using the tension pin 823154.
12. Push the valve disc 386097 and the pressure spring 802987 into the valve housing.
13. Tighten quick release nipple 804273.
14. Insert gear parts and spindle 391623 into motor housing.
15. Tighten motor housing 391650 on threaded fitting 391674 (left-hand thread).
16. For setting the required position of the ratchet head, please counter-screw the screw joint no. 361675 to the motor housing no. 391650.



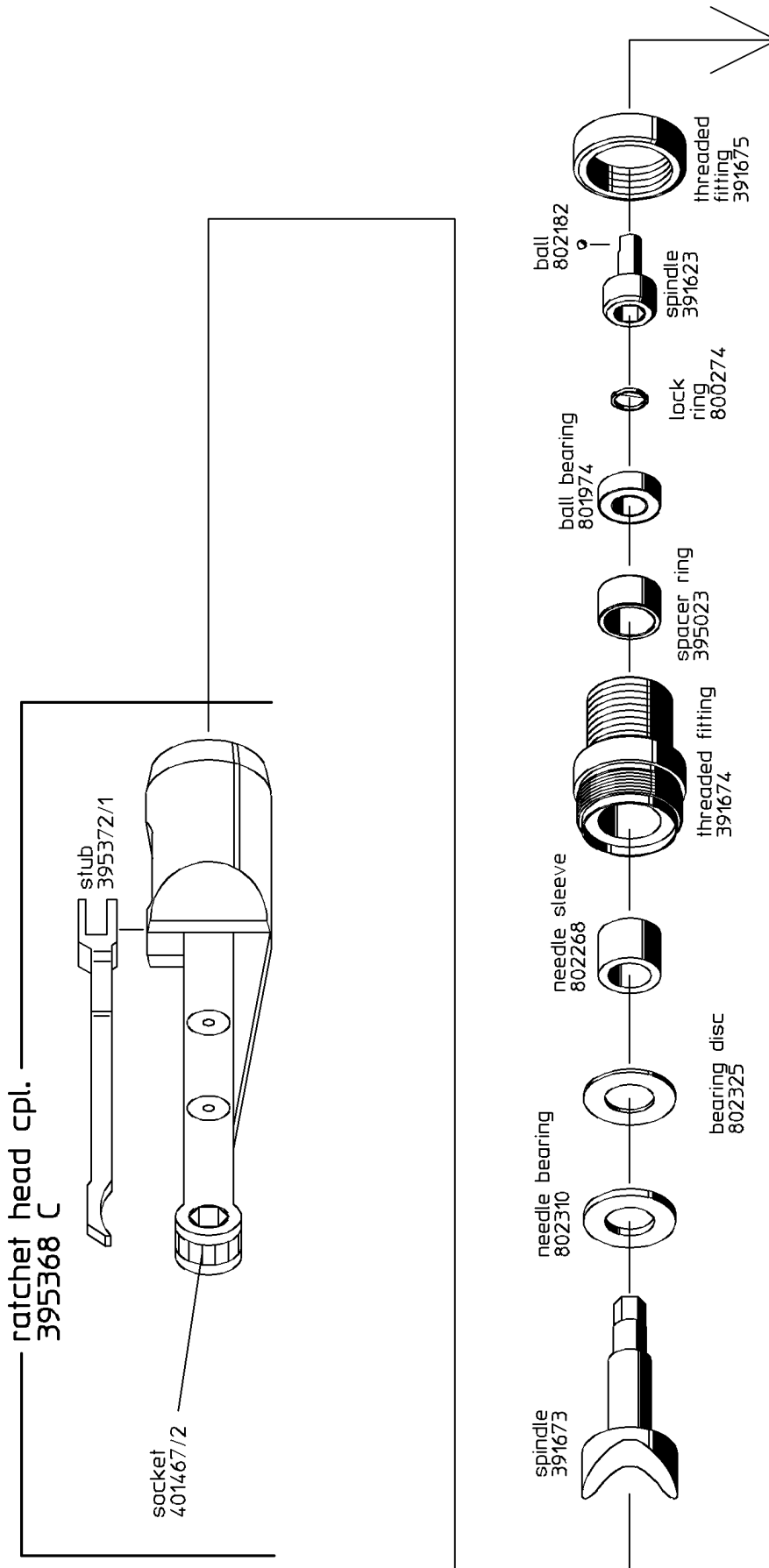
Attention

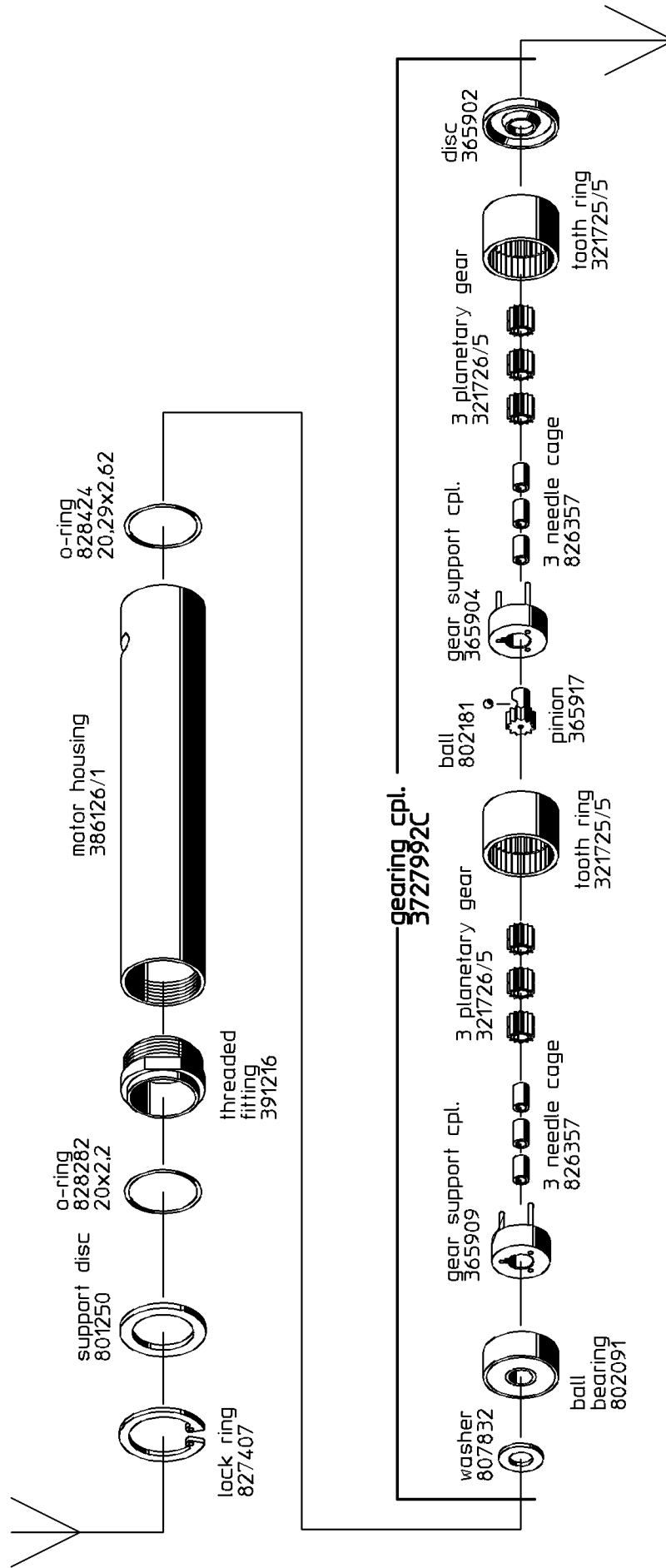
Tighten the double nipple 804273 using a maximum tightening torque of 5 Nm (44 in.lbs.).

Special Repair Tools (Optional Equipment)

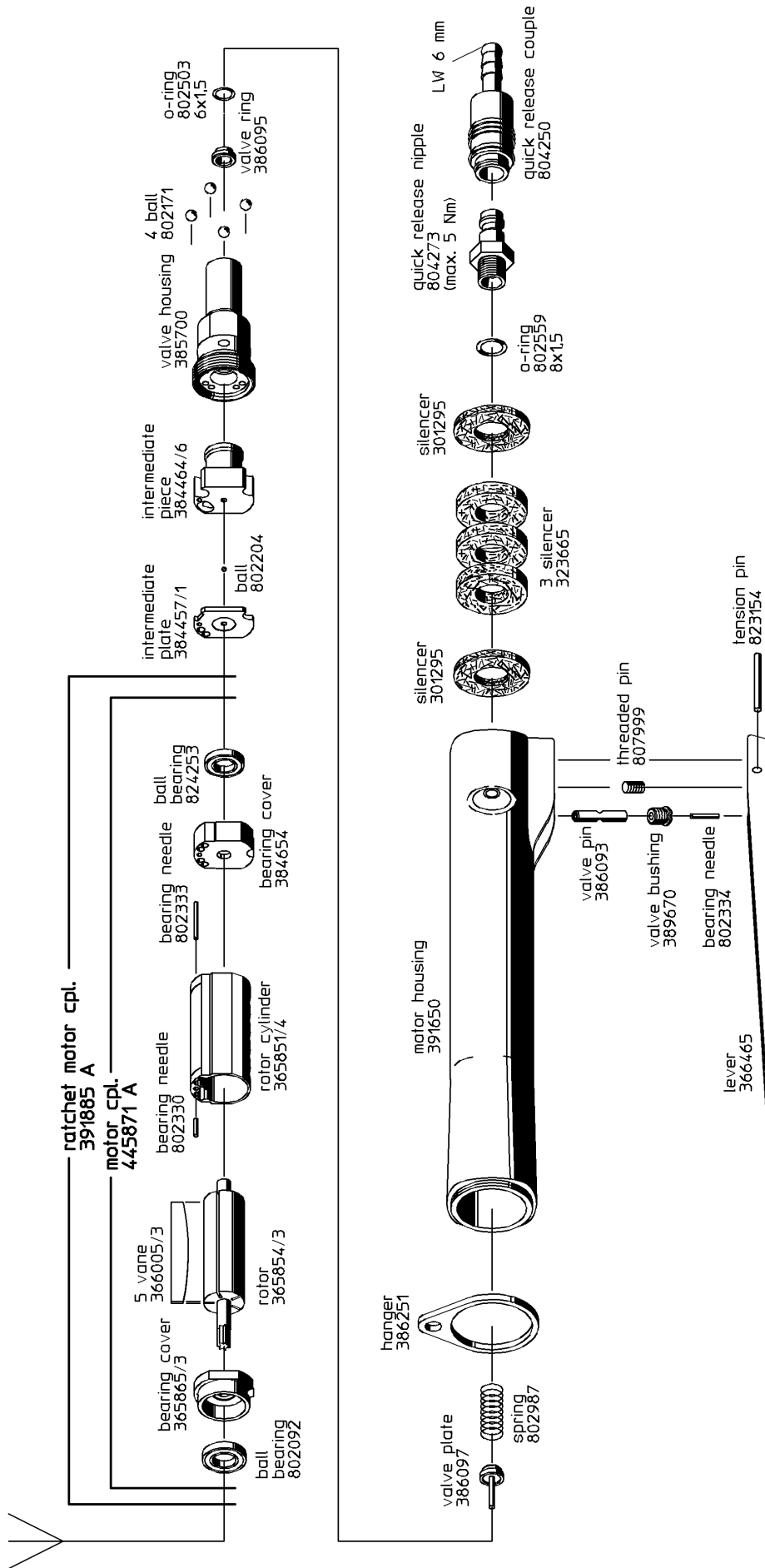
NAME	PART No.
Fixing device (for rotor cylinder)	460474
Fixture (for threaded fitting 391216)	462189
Chucking jaws (for motor housing 391650)	462049
Chucking jaws (for motor housing 386126/1)	460781
Assembly help (for valve disc 386097)	462123
Assembly tube	460566

6.1. Spare Parts Drawing

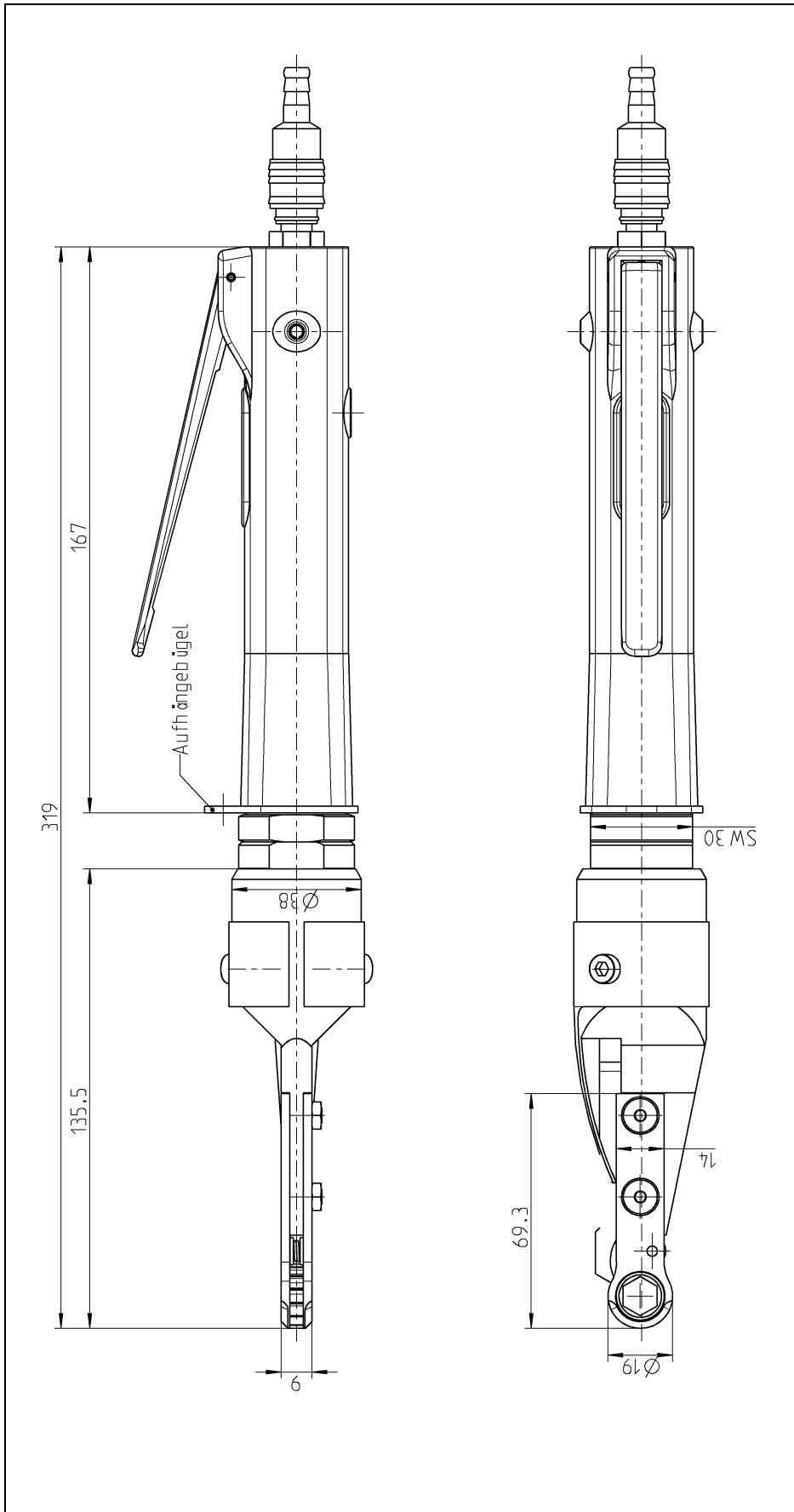




For example: spare parts order 5 off vane 366005/3



6.2. Dimensional Drawing



7 Maintenance and Upkeep

Testing and maintenance can be provided by Operator, disassembly and re-assembly of the DEPRAG Screwdriver Spindle should be done by experienced maintenance personnel. Incorrect assembly or disassembly can lead to injury of an operator and damage of the tool.

The tool requires little maintenance. If the following service rules are observed, the tool will have a long life expectancy and will remain in a safe condition.

- Check tool on a regular basis for external damage.
- Check your maintenance unit on a regular basis, make sure that sufficient oil is in the lubricator (if lubrication is used) and that the adjustment is correct. We recommend for your lubricator DEPRAGOL, part 790081 E.
- After cleaning, the gearing parts have to be greased prior to re-assembly, preferably with Grease, part 807293.
- After assembly fill 2 – 3 drops of DEPRAGOL into the air inlet nipple.
- If tool are being used with lubrication, we recommend to have tools tested and cleaned every 12 months (single shift).
- If tools are being used without lubrication, we recommend to have tools tested and cleaned every 6 months (single shift).
- Exchange broken or worn plug in tools immediately, for they can cause injury to the Operator.
- If tool malfunctions, we recommend to send the machine to DEPRAG.

7.1. Wear Parts

QUANTITY	NAME	PART No.
5	Vanes	366005/3

8 Trouble Shooting

In the case of a malfunction, check and observe all instructions contained in this technical documentation. If necessary, adjust equipment as needed.

Possible faults and their causes are shown below:

ERROR	REASON	SOLUTION
Screwdriver does not start	No air, Shut-Off valve is closed	Open Shut-Off valve
Insufficient Power	Air pressure too low	Minimum air pressure should be 90 PSI for maximum performance
	Restriction in air hose	Remove bends or other restrictions
	Hose I.D. is too small	Use required hose I.D.
	Vanes are worn	Exchange vanes
	Screen Support or silencer clogged	Clean screen support/silencer or exchange with new one
Driver does not shut-off or ratchets	Air pressure is too low for required torque value	Maintain air pressure of 90 PSI

If necessary, please send tool to DEPRAG for service.

9 Delivery Capacity

Please check the delivery capacity in regards to its completeness.

QUANTITY	NAME	PART No.
1	Operating Instruction Booklet	012456EN
1	Screwdriver	391625 A

10 Accessories - Optional equipment

ACROSS FLATS	NAME	PART No.
AF 10	Socket	401467/2
AF 9	Socket	401467/3
AF 8	Socket	401467/4
AF 7	Socket	401467/5
AF 6	Socket	401467/6
AF 5,5	Socket	401467/7
AF 5	Socket	401467/8

11 Storage

Unused machines should be stored in a dry, locked area.

12 Technical Data

Manufacturer DEPRAG SCHULZ GMBH u. CO.
Address Kurfürstenring 12 - 18 Postfach 1352
D-92224 Amberg D-92203 Amberg
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Technical Data:

TYPE	39-521-19K
PART No.	391625 A
SHAPE OF HEAD	CLOSED
Screws	M3 – M6
Across Flats/Hexagon (mm)	AF5 – AF10
Speed, unloaded (rpm)	90
Air consumption (m³/min / cfm)	0,36
Head height (mm)	9
Head diameter (mm)	19
Head length (mm)	69
Total length (mm)	319
Noise level (dB(A))	80
Weight (kg/lbs)	1,16
Required Hose I.D. (mm)	6
Connecting thread	G 1/8 a
Air pressure (bar/PSI)	6,3 / 90
Direction	right

13 Disposal

Unused machines should be stored in a dry, locked area. Disassemble the machine for the required disposal complete. Observe local and environmental regulations for the separation and recycling of materials.



Recycle waste oil to avoid environmental contamination!

14 Conformity Declaration

EC-Conformity Declaration according to the EC-Machine-Guidelines 98/37/EC, Amendment IIA

We,

DEPRAG SCHULZ GMBH & CO.
PO Box 1352
D-92203 Amberg

hereby confirm, that the design of the
flat-head screwdriver

39-521-19K


conforms to the following, relevant regulation:

- EC-Machine-Guidelines, Version 98/37/EC, Amendment No. 1 and No. 2.2.

Applicable Standard:

- EN ISO 12100-1 und 12100-2

Amberg, 14.12. 2006


Dipl. Ing. (FH) A. Lanig
Mr. Design Dept.

15 Service Locations and Authorized Partners

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