FSI FASTENING SYSTEMS INTERNATIONAL, INC.
www.fsirivet.com

1444HPL

OPERATING INSTRUCTIONS

AIR SUPPLY

The efficiency and life of this tool depends on the proper supply of clean, dry, lubricated air at about 90 lbs. P.S.I., although higher or lower pressures may be used. The use of an airline filter, pressure regulator and lubricator is recommended.

Before connecting the tool, blow the airline to remove water and dirt, which may have accumulated. This is especially important for a new line or when the line has not been used for some time.

HOSE AND HOSE CONNECTION

The air supply hose is 3/8" I.D. If extension hose is necessary, use 1/2" hose, with couplings not less than 3/8" I.D.

LUBRICATION

An oil supply to the air motor is important. SIOUX airline lubricators are recommended. Adjust to deliver 2 drops of SIOUX Air Motor Oil No. 288 per minute. When airline lubricator is not used squirt several drops of oil into the air inlet before using. Gear case must be lubricated after every 40 hours of operation, with SIOUX Grease No. 289.

SAFETY

1. Keep work area clean.
2. Do not force tool.
3. Secure work where possible - use clamps or vise.
4. Keep tools sharp and in good shape.
5. Disconnect tools when not in use.
6. The use of accessories not provided or specified may be hazardous.
7. Use goggles or safety glasses.

NIBBLER HEAD INSTRUCTIONS

OPERATION

The Nibbler Head is recommended for CR sheet steel up to 18 gauge. Secure work piece. To start cut, place die opening of nibbler slightly onto the edge of the work piece to steady the tool and ready it for the cut. Depress the trigger switch on the drive motor and guide the nibbler into the work. Don't force it. Avoid double thickness of material, which exceed the 18 gauge recommended capacity. For cutting within perimeter of work piece, drill a 1/2" diameter-starting hole and follow instructions above. If resistance to tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication; chip clogging; thickness of material, sharpness of punch and die.

ADJUSTMENTS

The die rotates a full 360 degrees. To change position, loosen clamp nut and set die in desired position, tighten clamp nut. When cutting corrugated metal, set die at 90 degrees to the motor unit. This will allow the motor and head to roll with the corrugations.

TO CHANGE PUNCH AND/OR DIE

1. Disconnect motor unit from power source.
2. Remove clamp nut 64089 and the die 64091 will slide off.
3. Remove retainer nut 64092 and the punch 64090 will slide out of the head.
4. Insert new punch into head and secure with retainer nut.
5. Insert new die and secure with clamp nut.

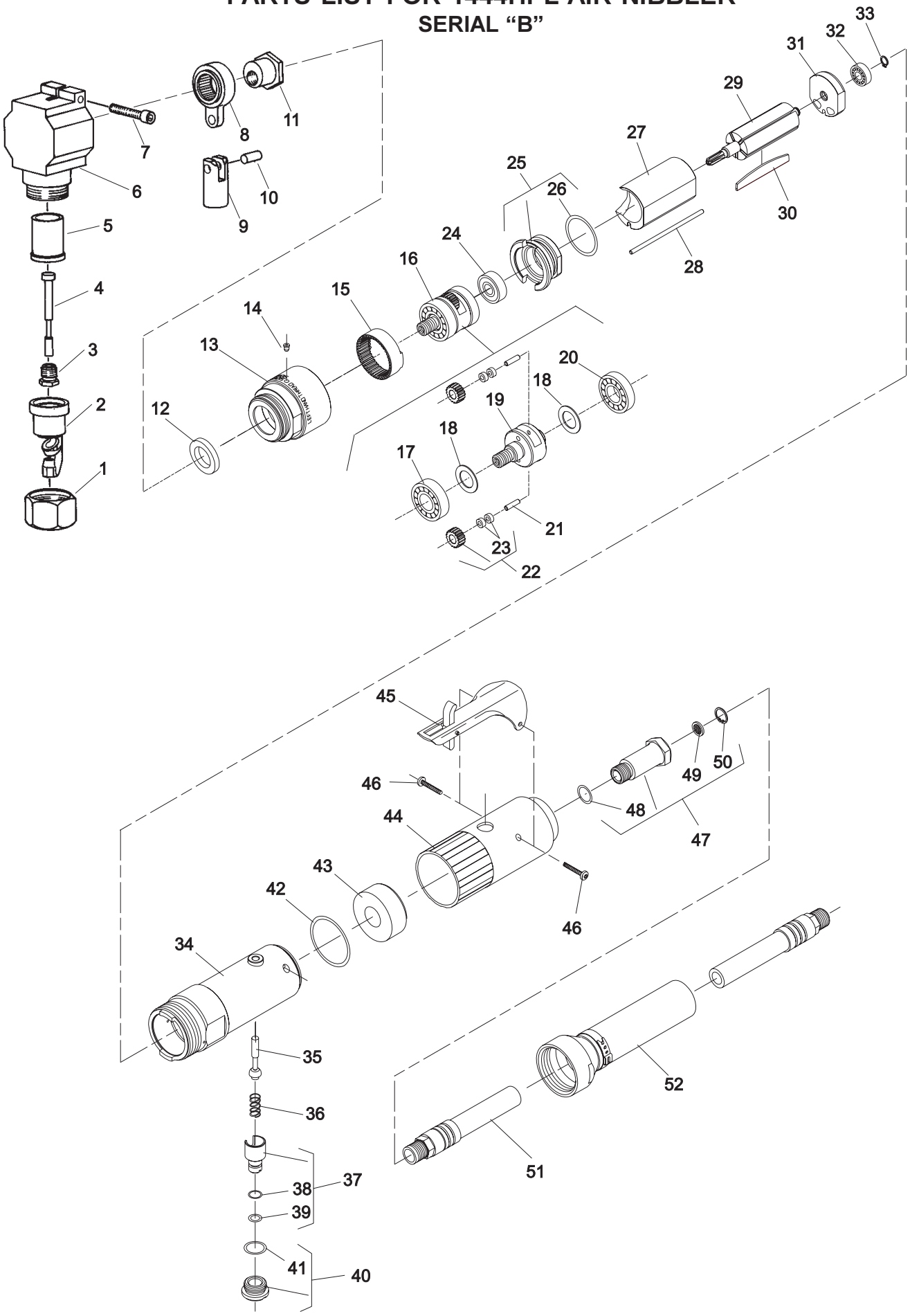
MAINTENANCE

Once every three months, depending upon usage, remove the nibbler head from the power unit by loosening clamping screw and pull the head with a twisting action. Lubricate bearing surface of the eccentric nut with a good grade of bearing grease. Place nibbler head back onto motor unit. Eccentric nut must engage with the link assembly as head is placed onto motor. Tighten clamping screw snugly to lock head assembly in place.

SIOUX TOOLS INC.
250 SNAP-ON DRIVE ■ PO BOX 1596 ■ MURPHY, NC 28906 ■ USA ■ Printed In U.S.A.

PARTS LIST FOR 1444HPL AIR NIBBLER

SERIAL "B"



PARTS LIST FOR 1444HPL AIR NIBBLER
SERIAL "B"

Fig. No.	Part No.	Description
1.	64089	Nut—Clamp
2.	64091	Die
3.	64092	Nut—Retainer
4.	64090	Punch
5.	64088	Sleeve—Brass
6.	64086	Housing—Nibbler
7.	57002	Screw—Soc. Hd. Cap (M5 x .8 x 30 MM)
8.	63523	Ass'y—Link
9.	64093	Plunger
10.	64094	Pin
11.	64087	Nut—Eccentric
12.	44122	Spacer—Chuck
13.	67928	Case—Gear
14.	30375	Fitting—Grease
15.	67858	Gear—Ring
16.	67893	Ass'y—Planetary Reduction (Includes Fig. 17-23)
17.	10228	Bearing—Ball
18.	25439	Washer—Thrust (2)*
19.	67869	Spindle—Chuck
20.	10203	Bearing—Ball
21.	67857	Roller—Torrington (2)*
22.	67944	Ass'y—Gear & Bushing (2)*
23.	10080	Bearing—Needle (4)*
24.	10220	Bearing—Ball
25.	13550	End Plate—Front
26.	14342	Ring—"O"
27.	64057	Cylinder
28.	68403	Pin
29.	67855	Rotor
30.	63192	Vane—Rotor (Set of 5)
31.	10552	End Plate—Rear
32.	10230	Bearing—Ball
33.	21491	Ring—Retaining

Fig. No.	Part No.	Description
34.	64036	Housing—Lever (Non-Reversing)
35.	63241	Ass'y—Valve
36.	21427	Spring
37.	54843	Control—Speed
38.	14290	Ring—"O"
39.	14291	Ring—"O"
40.	54844	Retainer—Speed Control
41.	14309	Ring—"O"
42.	14333	Ring—"O"
43.	40116	Silencing Material
44.	04042	Housing—Cover (Non-Reversing)
45.	63258	Ass'y—Lever
46.	65499	Screw—Pan HD. (Self-Tap)(#6-32 x 3/4)(2)*
47.	54837	Adapter—Inlet
48.	14312	Ring—"O"
49.	30463	Screen
50.	21541	Retainer
51.	1317	Hose—Leader — Remote Exhaust
52.	63355	Ass'y—Hose Exhaust — Remote Exhaust

Complete Assemblies:

63522	Ass'y—Nibbler Head (Includes Figs 1-11)
75202	Ass'y—Motor (Includes Figs 24-33)

30096	Wrench—Allen (5/32" Hex)(Not Shown)
64071	Shear Adaptor (Not Shown)

*Order Quantity As Required

FURNISH CATALOG, SERIAL, AND MODEL NUMBER WHEN ORDERING PARTS

GENERAL SAFETY INSTRUCTIONS FOR AIR TOOLS

1. **KEEP WORK AREA CLEAN:** Cluttered areas and benches invite accidents.
2. **AVOID DANGEROUS ENVIRONMENT:** Keep work-area well lit,
3. **KEEP CHILDREN AWAY:** All visitors should be kept safe distance from work area.
4. **STORE IDLE TOOLS:** When not in use, tools should be stored in dry, high or locked-up place-out of reach of children.
5. **DON'T FORCE TOOL**: It will work best and safest at the designed rate.
6. **RIGHT TOOL USE:** Don't force small tool to do the job of a heavy-duty tool.
7. **WEAR PROPER APPAREL:** No loose clothing or jewelry to get caught in moving parts.
8. **USE SAFETY GLASSES:** Use safety glasses with most tools. Also face or dust mask if it is a cutting operation.
9. **SECURE WORK:** Use clamps or vise to hold work. It's safer than using your hand and it allows freedom of both hands to hold tool.
10. **DON'T OVERREACH:** Keep proper footing and balance at all times.
11. **MAINTAIN TOOLS WITH CARE:** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
12. **DISCONNECT TOOLS:** When not in use: before servicing; when changing accessories such as blades, bits, cutter, etc.
13. **REMOVE ADJUSTING KEYS AND WRENCHES:** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
14. **CAUTION:** The use of an accessory with this tool not provided or specified by SIOUX TOOLS may be hazardous.

⚠ WARNING
Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm.

⚠ ADVERTENCIA
El polvo generado al lijar, aserrar, afilar, taladrar y realizar otras tareas de construcción contiene sustancias químicas que podrían causar cáncer, malformaciones congénitas y otras alteraciones del aparato reproductor.

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