

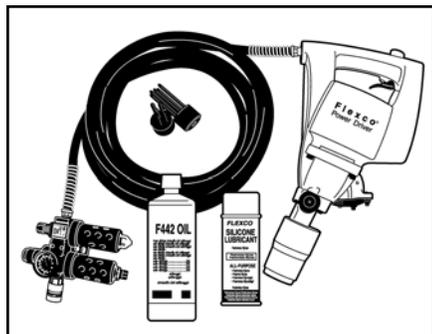
# Flexco® Power Driver

## Air Powered Rivet Fastener Installation Tool

Power Driver Setup • Operating Instructions • Operating Tips for Best Performance • Drive Rod Replacement

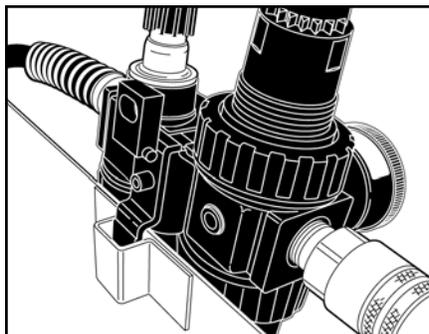
For best results, carefully read the instructions before starting installation.

If you have experience with installing Flexco® SR™ Fasteners, note that in addition to the power driver replacing the hammer as the primary installation tool, other modifications to the installation instructions have been made. Follow your employer's safety procedures and general air safety precautions.

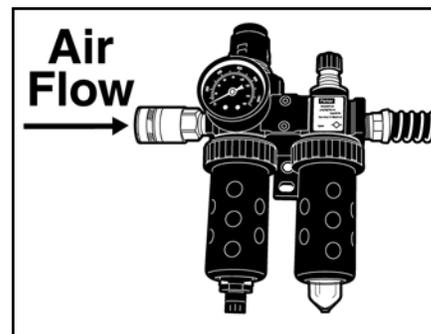


### Power Driver Setup:

1. Remove contents of the power driver tool box. The tool box includes the power driver, two 5-prong drivers, silicone lubricant, SAE #10 non-detergent oil, and regulator kit with hose attached.

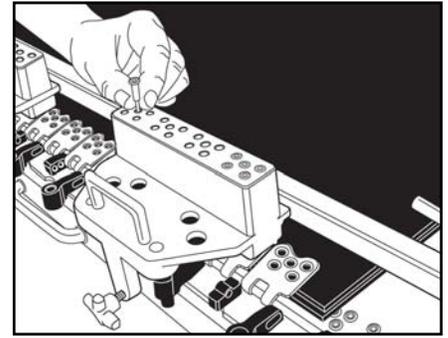
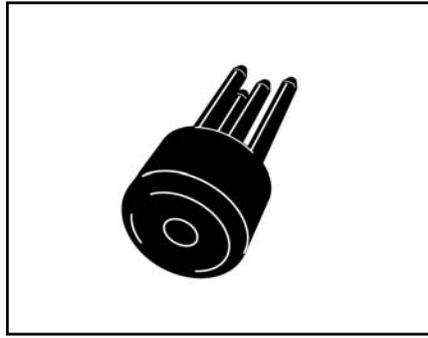
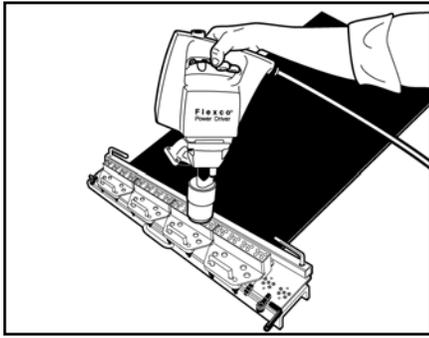


2. Mount regulator kit on the tool box. Insert hook on the back of the regulator kit into the slot on the tool box. The regulator kit must remain level during tool operation. Fill oiler with SAE #10 non-detergent oil. **CAUTION: Do not substitute SAE #10 oil with other types of lubricants, the power driver will not function and will be permanently damaged.**



3. Hookup your air compressor to the "in" side of the regulator kit with a 3/8" fitting. Use compressed air directly from an air compressor. **WARNING: Do not use any bottled gases, including oxygen, to operate this tool. Explosion will occur.** Air pressure should maintain 8 SCFM at 75 PSI through the 3/8" fitting. The regulator is factory preset at 75 PSI and is not adjustable. **CAUTION: Increasing PSI beyond 75 PSI will damage the tool.**



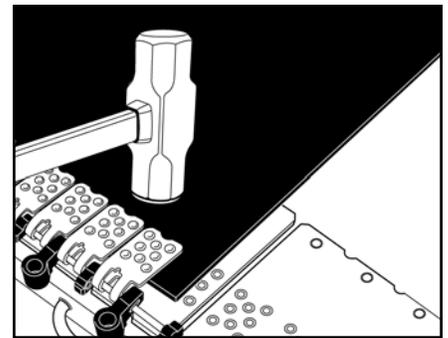
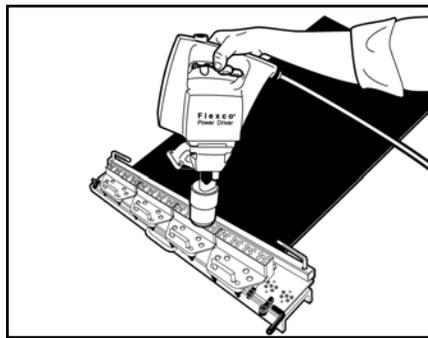
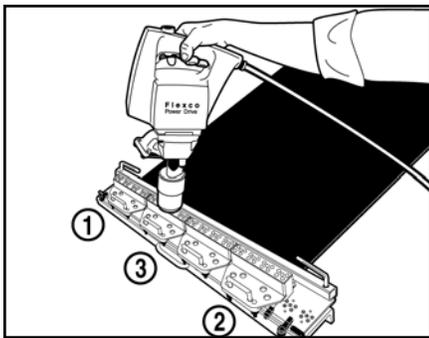


### Operating Instructions:

1. Follow these steps to install Flexco® SR™ fasteners using the power driver. Push the power driver over the 5-prong driver until the driver's metal collar is completely inside of the power driver. This allows for the air to pass into the chamber and power the drive rod.

2. Note: The 5-prong driver used with the hammer drive system cannot be used with the power driver. Do not use the driver with the yellow tape. A special 5-prong driver (order number: FPD-PD) was developed for exclusive use with the power driver. While these drivers look similar, they are not interchangeable.

3. For faster installation, insert multiple guide blocks across the entire width of the splice. Spray guide blocks with silicone lubricant, and load rivets.



4. Starting with the end plate (position 1), insert the 5-prong driver into the guide block and drive rivets with one hit from the Flexco Power Driver. To perform one hit, push down and pull the trigger. Repeat this step on the other end of the splice (position 2) and in the center of the splice (position 3). Next, from left to right, drive rivets one time to complete the initial setting of the fasteners. For best results, the power driver should be operated below the operator's waist. **IMPORTANT: Pause between hits to allow the tool to reset.**

5. Working left to right, drive rivets with approximately seven hits from the power driver. Final set rivets and fastener plates with a 4 lb. hammer. The fastener plates should be tight against the belt so that your fingernail will not slide between the fasteners and the belt.

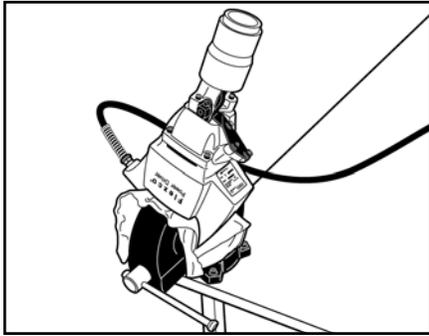
6. If installing Flexco® SR™ RAR8 fasteners, remove guide blocks and drive remaining rivets using a 4-lb hammer.

## Operating Tips for Best Performance:

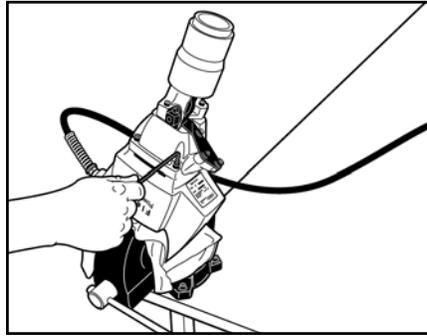
- Keep the power driver perpendicular (90°) to the fasteners. Excessive leaning will cause glancing blows and will break the drive rod.
- Do not use your body weight to push power driver, this will over-stress and break the drive rod. Instead, let the weight of the tool do all the work and bounce naturally between blows. The bouncing allows the safety valve to reset.
- Too much oil in the tool will cause “seal swell”; when this occurs the tool will not fire all the time. Follow the oiler’s instructions, refer to enclosed manufacturer’s instructions. If smoke comes out of the exhaust while firing the tool, you have a “seal swell” problem.
- Only use the number of hits required to set the fasteners. The drive rod force is absorbed by curling the rivet. If the rivet is curled and you fire the tool for “extra set” the drive rod will break. Every situation is different, experiment to determine the correct number of hits for full curl.
- Do not dry fire the tool for the same reason as above. Dry fire is when you place the tool on something other than a rivet, press down the safety, and pull the trigger. The drive rod needs to hit the rivets. Dry firing will break the drive rod.
- Do not attach a hose longer than 25 ft. from the air compressor to the regulator, the tool will not get the required volume of air and can misfire or not fire at all. The minimum requirement is 8 SCFM with a 25 foot maximum hose with 3/8” fittings throughout the pneumatic system including the air compressor.
- Only use hoses in good condition. Old hoses delaminate internally and begin to expand, you will not be able to see this. When this happens you will not get the required volume of air to the tool and the tool will not fire.
- Use compressed air only from an air compressor. Do not use any bottled gases, including oxygen, to operate this tool. Explosion will occur.
- The drive cap on the 5-prong driver has an indentation designed to match the tip of the drive rod. Examine the indentation regularly for wear and deformation, replace as needed. Using 5-prong drivers that are in good condition will prolong the life of the drive rod.
- Allow the power driver to complete its pneumatic cycle before disconnecting the air. The safety cup (inner sleeve) should not be resting against anything to retract it into the outer sleeve when the air is disconnected. If the air is disconnected before the cycle is complete the drive rod in the tool could stop in a position out of pneumatic sequence, and the next time the air is connected the tool will not fire. The drive rod will have to be physically pushed back against its stop to reset the tool.
- **WARNING:** Only reset the drive rod with the air line disconnected.
- If you would like a copy of the Operating and Maintenance Video, please contact Flexco’s customer service department at 630-971-0150.

## Drive Rod Replacement Instructions:

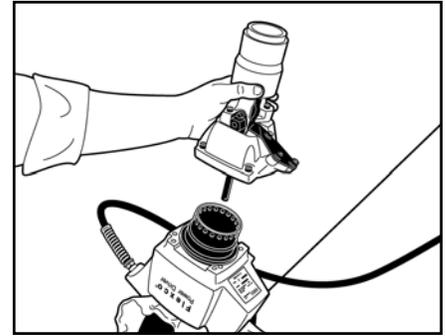
When the drive rod breaks, the power driver will not operate. (A sound of escaping air can be heard when the trigger is pulled.) For best results, Flexco recommends replacing the drive rod in a maintenance area with proper lighting and clean work conditions.



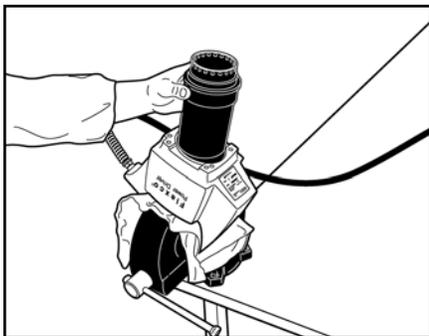
1. Invert the power driver and lock it in a tool vise. Keep the power driver in the vise during entire maintenance.



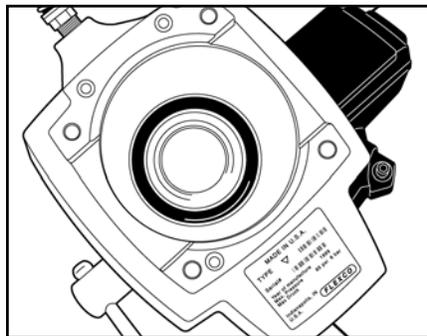
2. Using a 1/4" hex wrench, loosen the four screws that hold the nose support unit onto the handle portion of the tool.



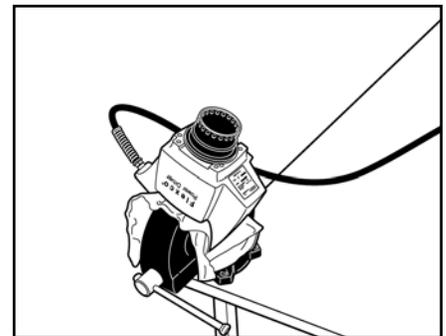
3. Leaving the screws in place, gently lift the nose support unit off the tool. This will expose the broken drive rod. The rod portion will probably still be held in the nose support unit.



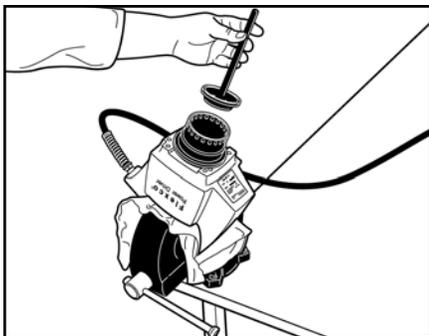
4. Remove the cylinder by lifting it straight up. Remove broken drive rod parts.



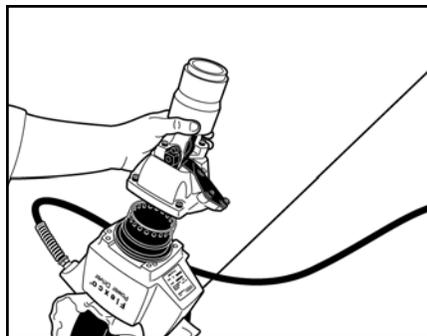
5. Check the now empty housing to make sure the seal is in place and properly seated.



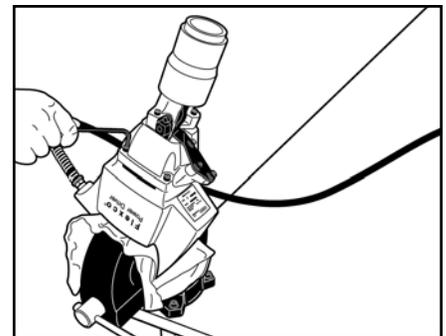
6. Carefully replace the cylinder, press down until you feel the cylinder snap into the seal and all parts are locked.



7. Lubricate the new drive rod's o-ring with SAE #10 oil. Insert the new drive rod, sliding it completely down the cylinder until it rests on the bottom.



8. Replace the nose support unit, match the irregularities of the upper and lower castings to restore the seal and assure the operation of the safety probe.



9. Tighten the four screws using a torque wrench set to 18 ft. lbs. and the opposing corners method. Drive rod replacement is complete. **WARNING: Do not dry fire to test the tool.**

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