

Part #31264

5/16" [8MM] PNEUMATIC SPOTWELD DRILL

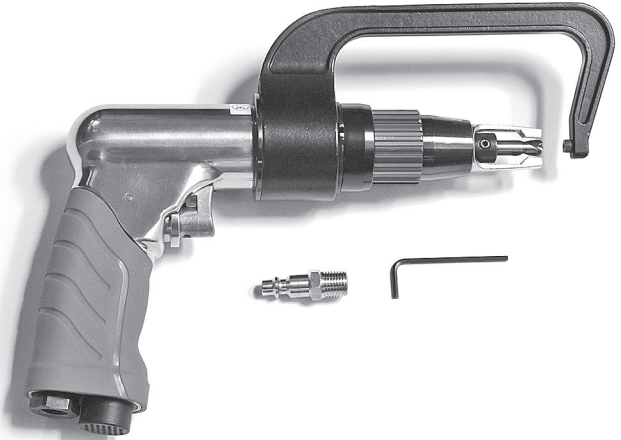
INSTRUCTIONS



The **5/16" [8MM] SPOT WELD DRILL** is a heavy-duty professional auto body tool specifically developed for many years of efficient and reliable use. It features an automatic bit advance feature with positive spot weld cutting depth adjustment. The set-screw bit-retention design provides convenient and secure cutting bit changes. A high-torque, 5 vane, ball bearing air motor with hardened reduction gears provides smooth operation and long life.

CONTENTS

- (1) Pneumatic Spot Weld Drill with Backing Arm and 5/16" [8mm] Cutting Bit installed
- (1) 2.5mm Hex Key
- (1) 1/4" MNPT Quick Disconnect Air Fitting



SPECIFICATIONS

- **Spot Weld Capacity:** 1/4" & 5/16" [6 & 8mm]
- **RPM:** 1,600 free speed
- **Maximum Inlet Air Pressure:** 90 psi [6.3 bar]
- **Air Consumption:** 4 cfm [114 lm]
- **Inlet Thread Size:** 1/4" FNPT
- **Air Motor:** High Torque, 5 vane, ball bearing, with gear reduction

REQUIRED FOR USE

- The inlet air supply must have a moisture separator capable of removing all moisture and impurities from the air supply. Moisture and/or oil in the air supply will cause poor tool performance and damage.
- A suitable regulator must be used to limit incoming air pressure to 90 PSI maximum, 80 PSI is ideal. Excessive air pressure can cause permanent damage to the unit and possible serious personal injury from bursting.
- For best results, a compressor capable of providing a minimum of 4 CFM @ 90 PSI is required. Less available CFM will not provide sufficient force to allow the Spot Weld Drill to adequately function.
- The use of #31266, replacement 5/16" [8mm] Replacement Spot Weld Drill Bits is required for proper operation.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

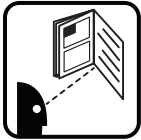
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE is used to address practices not related to personal injury.



READ INSTRUCTIONS

Thoroughly read and understand these product instructions before using the Eastwood Spot Weld Drill.

- Keep these product instructions for future reference.



WARNING HEALTH AND INJURY HAZARDS!

- **Eye Injury Hazard** - This Spot Weld Drill will eject particles and sharp metal fragments at high velocity during operation. Eye protection should be worn at all times when operating this tool. Use ANSI approved safety glasses. Everyday eyeglasses are NOT safety glasses.
- **Injury Hazard** - This Spot Weld Drill can quickly start up when handling while connected to an air supply causing serious personal injury. Always disconnect the Spot Weld Drill from the air supply before making adjustments, replacing cutting bits or other maintenance.
- **Injury Hazard** - Do not force tool or exert side forces on tool while cutting as the Drill body can suddenly kick back or twist causing severe hand or wrist injury. Cutting bits can also break with excessive side force causing them to shatter and eject sharp pieces at high velocity.
- **Injury Hazard** - Keep loose clothing, jewelry and long hair away from rotating components as serious personal injury can occur.
- **Injury Hazard** - Always make sure the workpiece being drilled is securely clamped or anchored to allow two handed operation of the Drill.



SAFETY INFORMATION



⚠ WARNING HEALTH AND INJURY HAZARDS!

- **Injury Hazard** – Handling sharp metal can cause cuts. Always wear heavy work gloves to protect hands.
- **Explosion Hazard** - Excessive air pressure can cause tool to explode resulting in tool damage and personal injury. Do not exceed 90 psi [6.3 bar] of tool inlet air pressure.



⚠ CAUTION HEARING HAZARD!

- This Spot Weld Drill can generate excessive noise. Wear appropriate hearing protection while using.



CONNECTION

1. Be sure that the air supply to the Spot Weld Drill is clean and dry. Moisture in the supply line will quickly damage the motor and valves.
2. A minimum 3/8" I.D. air line should be used for optimal performance.

SET-UP, ADJUSTMENT AND OPERATION

The Pneumatic Spot Weld Cutting Drill features Adjustable Cut Depth Limiting and Automatic Cutting Bit Advance.

Adjusting Cut Depth – Depth of cut is adjustable to allow the cutting bit to cut through only the upper steel panel of the spot weld while underlying panels remain untouched. To do so:

1. Pull back the Prongs against spring pressure and observe the relationship between the end of the Cutting Bit and the end of the Prongs. That is the depth of cut.
2. To lessen the depth of cut, rotate the Serrated Red Sleeve Clockwise (when viewed from the cutting end of the tool) (**FIG 1**).
3. To increase the depth of cut, rotate the Serrated Red Sleeve Counter-Clockwise (when viewed from the cutting end of the tool) (**FIG 2**).
4. Recheck the cutting depth dimension and readjust if necessary.



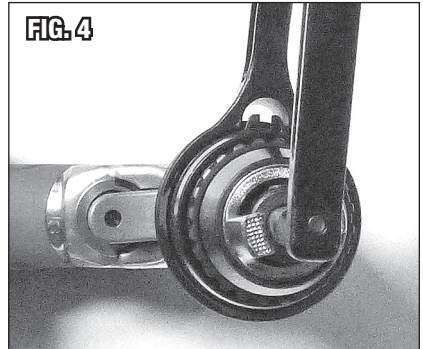
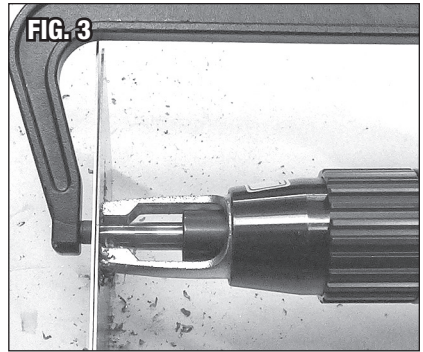
Automatic Cutting Bit Advance – The cutting bit automatically advances toward the spot weld as the trigger is depressed.

With the Backing Arm in place when the back of the spot weld is accessible:

1. Place the Prongs squarely against the uppermost panel of the spot welded part and the end of the Backing Arm in place behind the spot welded panel then depress the Trigger only partially. This will move the Cutting Bit outward against the spot welded panel (**FIG 3**).
2. Depressing the Trigger fully will allow the Cutting Bit to rotate and cut through the outer panel of the spot weld.

With the Backing Arm removed when the back of a spot weld is not accessible:

1. View the Pneumatic Spot Weld Drill from the cutting end and observe the position of the large Backing Arm Snap Ring tabs.
2. Rotate the Backing Arm about the tool body so that the cutout in line with the arm is over the snap ring tabs. Then pull the Backing Arm outward and off the body of the Spot Weld Drill (**FIGS 4, 5**).
3. Place the Prongs squarely against the uppermost panel of the spot welded part and depress the Trigger only partially. This will move the Cutting Bit outward against the spot welded panel. At this point, it is important to grasp the body of the Spot Weld Drill firmly and continue to hold the prongs squarely against the spot welded panel.
4. Depressing the Trigger fully will allow the Cutting Bit to rotate and cut through the outer panel of the spot weld. Continue to grasp the body of the Spot Weld Drill firmly and hold the prongs squarely against the spot welded panel until through the outer panel, leaving the underlying panel intact.



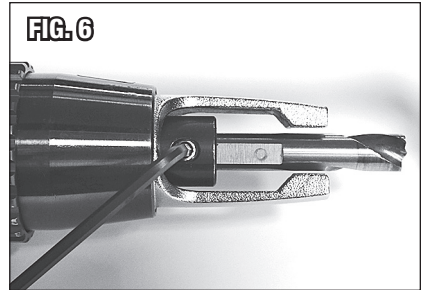
CHANGING CUTTING BIT

⚠ WARNING INJURY HAZARD!

This Spot Weld Drill can quickly start up when handling while connected to an air supply causing serious personal injury. Always disconnect the Spot Weld Drill from the air supply before making adjustments, replacing cutting bits or other maintenance.

View the Pneumatic Spot Weld Drill from the cutting end and observe the position of the large Backing Arm Snap Ring tabs.

1. Rotate the Backing Arm so that the cutout in line with the arm is over the snap ring tabs. Then pull the Backing Arm outward to provide clearance for Cutting Bit removal (FIG 4).
2. The Cutting Bit is held in place with a Set Screw. Grasp and rotate the Prongs to expose the Set Screw (FIG 6).
3. Using the included 2.5mm Hex Key, loosen the Set Screw and withdraw the Cutting Bit from the Arbor (FIG 6).
4. Replace the Cutting Bit making sure the flat is aligned under the set screw (FIG 6).



⚠ CAUTION INJURY HAZARD!

The set screw flat on the shank of the Cutting Bit must be aligned under the Set Screw for proper engagement and the Cutting Bit must be fully seated in the Arbor or Personal Injury and or tool damage can occur.

5. Tighten the Set Screw securely.
6. Return the Backing Arm to the proper position on the Spot Weld Drill body.

MAINTENANCE

- Add several drops of air tool oil before each use directly into the air inlet.
- If tool is to be unused for an extended period, add 10 drops of air tool oil directly to the air inlet then store the tool handle up.
- Check to see that the Cutting Bit retaining Set Screw is tight before each use.

PROBLEM	CAUSE	CORRECTION
Spot Weld Cutter Doesn't Respond to Trigger Depression	Air Supply Pressure Too High	Reduce air supply PSI to tool. Must be 90 PSI or less. Higher pressure will cause Automatic Cutting Bit Advance to stop Cutting Bit rotation.
	Insufficient Air Supply	Verify air supply to Drill. Should be 4 CFM or more.
	Moisture in Valves and Air Motor	Check for moisture in air line and air inlet.
Spot Weld Cutter Performance is Slow or Sluggish	Insufficient Air Supply	Verify air supply to Drill. Should be 4 CFM or more.
	Moisture in Valves and Air Motor	Check for moisture in air line and air inlet.
Spot Weld Cutter Vibrates Excessively During Use	Chipped or Broken Cutting Bit	STOP USE IMMEDIATELY and replace Cutting Bit.
	Loose Cutting Bit Set Screw	Tighten Cutting Bit Set Screw.
Spot Weld Cutter Emits Excessive Noise During Use	Tool Lacks Lubrication	STOP USE IMMEDIATELY and add air tool oil directly to air inlet.

ADDITIONAL ITEMS

#31266 5/16" [8mm] Replacement Spotweld Drill Bits

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techelp@eastwood.com

PDF version of this manual is available online >> eastwood.com/31264manual

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA

US and Canada: 800.345.1178 Outside US: 610.718.8335

Fax: 610.323.6268 eastwood.com