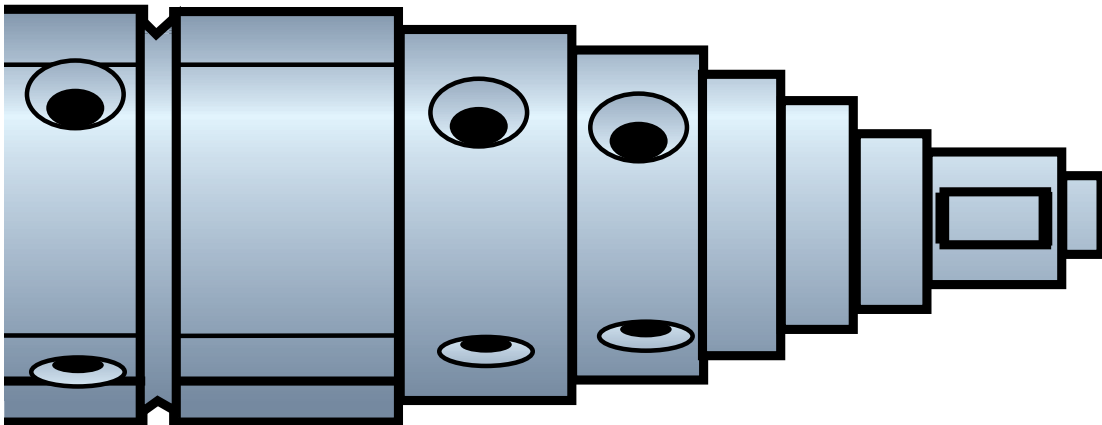


ENGLISH

Preventative Maintenance Quick Reference Grundomat Piercing Tool

Reduce Premature Wear and
Avoid Warranty Issues



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Proper Tool Lubrication

Make sure the oiler is full and operating properly before every bore. Prior to connecting the boring tool to the black air hose do the following:

1. Pour 1-2 oz ($\frac{1}{4}$ cup) of Grundo-oil directly into the whip hose of the Grundomat.
2. Connect the black hose to the oiler. Hold the end of the black hose, then open the ball valve at the oiler for approximately 30 seconds until you can verify lubricant is flowing through the hose.

Maximum Operating PSI

The Grundomat tool is designed to run properly at 95 psi. Never operate beyond 95 psi (at the tool itself). Check compressor while the tool or tools are running to ensure that it does not exceed 105 psi.

There is approximately 10 psi of pressure loss while air is traveling from the compressor to the Grundomat. While higher psi can make the tool run faster, it also overworks the tool and will eventually cause damage. Any Grundomat piercing tool usage over 95 psi will void warranty.

Operating Multiple Tools Off of a Single Air Compressor

Operating multiple tools off a single air compressor will require more air volume (cfm) not air pressure (psi). Make sure your air compressor has enough air volume (cfm) to run both tools. Increasing the air pressure beyond 95 psi to run multiple tools could damage tools and will not increase production. As the seals wear in the Grundomat, more volume can be required to run the tool properly – allow approximately 20% beyond published factory standards.

Proper Power Setting for Reverse Operations

When reversing the Grundomat tool, the tool power (controlled by volume of air) should be reduced by half or more by adjusting the ball valve on the oiler/lubricator. For example, if the tool was being operated at 100% with the ball valve wide-open, then it should be reduced to 50% or 25% to avoid creating a loose stroke and damaging the tool casing. Use reverse only when necessary, for occasions where a problem has been encountered, not for every bore.

Proper Cleaning

Important, flush the Grundomat piercing tool at the end of every day. Pour a $\frac{1}{4}$ cup of oil directly into the whip hose, then attach the whip hose directly to the oiler or black hose. Run tool in forward and reverse for 10 to 15 seconds each way. This will clean out any dirt and lubricate the tool so that it is ready for the next use.

Tool Tightening

If the tool body becomes loose during operation, disassemble the tool and clean the threads. Use Loctite on the threads and reassemble the tool using the proper wrenches and torque. Never hand tighten and continue to use the tool. A hand-tightened tool will vibrate loose and damage the threads. The tool head and rear components should be checked at the end of each bore, to make sure all parts are tight into the casing threads.

Grundomat Operations Manual

This document focuses on preventative maintenance and is not intended to serve as an operations manual. The comprehensive Grundomat Operations Manual is available from TT Technologies and can be accessed from the TT Technologies website.

Call: 630-851-8200

Web: www.tttechnologies.com

Scan QR Code for
Complete Manual

