



The Recoil range of power tooling ensures consistent high volume thread insert installation for a variety of applications.

Recoil powered installation tools may be supplied for use with either a compressed air supply or via a stabilised low voltage power supply to suit your particular requirements. Both equipment types offer significant productivity gains for high volume insert use.

### Pneumatic Power Tooling

- Wide thread size range #2-56 through 3/4", or M2.5 through M16, coarse and fine.
- Rugged and versatile air motor.
- May be used with captive strip feed or bulk insert insertion.
- Standard speed 1500 rpm.
- Auto reverse on release of trigger.

The complete pneumatic insert installation tool comprises of 3 components:-

- Air motor with single lever control to install and retract.
- Adaptor - connect the motor to the insert drive nozzle - small and large types.
- Front end assembly nozzle to suit the particular insert thread size.

### Electric Power Tooling

- Size range #2-56 through 1/4", M2.5 through M8
- Auto reverse on installation
- Clean, lightweight, quiet
- Suitable for bulk insert only

Recoil offer two different types of air motors, the 56010 series and the NR-HL series. For further details please contact your Recoil distributor.

## Compressed Air Supply for Pneumatic Installation Tools

### PRESSURE RECOMMENDATIONS

FOR INSERT SIZE										
Inch	#2	#4	#5	#6	#8 #10	1/4"	5/16"	3/8"	7/16"	1/2"
Metric	M2 - 2.5	M2.5	M3	M3.5	M4, M5	M6, M7	M8	M10	-	M12
RECOMMENDED PRESSURE										
psi	25	20-30	25-30	40	45	50-60	60	70	70-80	90
bar	1.70	1.3-2.0	1.7-2.0	2.72	3.06	3.4-4.0	4.0	4.76	4.7-5.4	6.0
MPa	0.172	0.138-0.206	0.172-0.206	0.275	0.310	.344-0.413	0.413	0.482	0.482-0.551	0.620

If difficulty is encountered within the above settings, reduce the pressure until the optimum setting is found.

It is imperative that a regulated moisture - free and filtered air supply is used with all Recoil pneumatic tooling. Reliability will be affected if an adequate and regulated air supply is not used with these tools.

Guidelines for typical Recoil insert tool pressure requirements are shown above.

## Recoil Inserts-Pneumatic Installation Tooling

The following table denotes the part numbers of all pneumatic installation tooling for the most popular thread size ranges.

THREAD SIZE	FRONT-END ASSEMBLY	ADAPTOR	AIR MOTOR	AIR MOTOR & ADAPTOR	AIR MOTOR & ADAPTOR
	PART No.	PART No.	PART No.	PART No.	PART No.
<b>UNC</b>					
2-56	53520	56030	56010	56010-3	NR-HL 1409
4-40	53540	56030	56010	56010-3	NR-HL 1409
5-40	53550	56030	56010	56010-3	NR-HL 1409
6-32	53560	56030	56010	56010-3	NR-HL 1409
8-32	53580	56030	56010	56010-3	NR-HL 1409
10-24	53600	56030	56010	56010-3	NR-HL 1409
1/4-20	53040	56030	56010	56010-3	NR-HL 1409
5/16-18	53050	56040	56010	56010-4	
3/8-16	53060	56040	56010	56010-4	
7/16-14	53070	56040	56010	56010-4	
1/2 13	53080	56040	56010	56010-4	
5/8-11	53100	56040	56011	56010-4	
3/4-10	53120	56040	56011	56010-4	
<b>UNF</b>					
6-40	54560	56030	56010	56010-3	NR-HL 1409
10-32	54600	56030	56010	56010-3	NR-HL 1409
1/4-28	54040	56030	56010	56010-3	NR-HL 1409
5/16-24	54050	56040	56010	56010-4	
3/8-24	54060	56040	56010	56010-4	
7/16-20	54070	56040	56010	56010-4	
1/2-20	54080	56040	56010	56010-4	
5/8-18	54100	56040	56011	56010-4	
3/4-16	54120	56040	56011	56010-4	
<b>METRIC COARSE</b>					
2.2 x .45	55010	56030	56010	56010-3	NR-HL 1409
2.5 x .45	55250	56030	56010	56010-3	NR-HL 1409
3 x .5	55030	56030	56010	56010-3	NR-HL 1409
3.5 x .6	55350	56030	56010	56010-3	NR-HL 1409
4 x .7	55040	56030	56010	56010-3	NR-HL 1409
5 x .8	55050	56030	56010	56010-3	NR-HL 1409
6 x 1	55060	56030	56010	56010-3	NR-HL 1409
7 x 1	55070	56030	56010	56010-3	
8 x 1.25	55080	56040	56010	56010-4	
10 x 1.5	55100	56040	56010	56010-4	
12 x 1.75	55120	56040	56010	56010-4	
16 x 2	55160	56040	56011	56010-4	
<b>METRIC FINE</b>					
8 x 1	57080	56040	56010	56010-4	
10 x 1	58100	56040	56010	56010-4	
10 x 1.25	57100	56040	56010	56010-4	
12 x 1.25	58120	56040	56010	56010-4	
12 x 1.5	57120	56040	56010	56010-4	
14 x 1.5	57140	56040	56010	56010-4	

