

Item Part No.	Description
1 SA76.01	Motor housing
2 SA76.02	Pin
3 SA76.03	Air inlet bush
4 SA76.04	Thrigger
5 SA76.05	Valve Stem
6 SA76.06	Valve bush
7 SA76.07	O-Ring
8 SA76.08	Spring
9 SA76.09	O-Ring
10 SA76.10	Muffer diffuser
11 SA76.11	Bearing cap
13 SA76.13	Ball bearing
14 SA76.14	Rear Plate
15 SA76.15	Rotor
16 SA76.16	Rotor Blade
17 SA76.17	Pin
18 SA76.18	Cylinder
19 SA76.19	Front End Plate
20 SA76.20	Ball bearing
21 SA76.21	Ball bearing
22 SA76.22	Set screw
23 SA76.23	O-Ring
24 SA76.24	Air regulator

Item Part No.	Description
25 SA76.25	Planet pin
26 SA76.26	Planet cage
27 SA76.27	Planet gears
28 SA76.28	Needle bearing
29 SA76.29	Spacer
30 SA76.30	Ball bearing
31 SA76.31	Internal gear
32 SA76.32	Gear housing
33 SA76.33	Bit Holder
34 SA76.34	Set Screw
35 SA76.35	Support
36 SA76.36-6.5	Drill bit, 6.5mm
SA76.36-8	Drill bit, 8mm
37 SA76.37	Adjusting nut
38 SA76.38	Spring
39 SA76.39	Ball
40 SA76.40	Retaining ring
41 SA76.41	Wave washer
42 SA76.42	Adjustment attachment
43 SA76.43	Retainer
44 SA76.44	Spring
45 SA76.45	Hex, key wrench
46 SA76.46	Hex, screw

**NOTE:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice. **IMPORTANT:** No liability is accepted for incorrect use of this equipment. **WARRANTY:** Guarantee is 12 months from purchase date, proof of which will be required for any claim. **INFORMATION:** For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.


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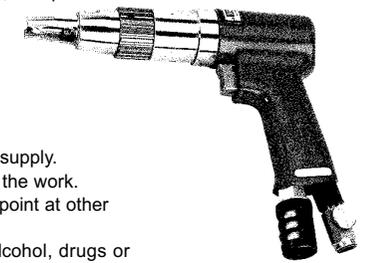
INSTRUCTIONS FOR:  
**AIR OPERATED SPOT WELD DRILL**  
 Model: **SA76**

Thank you for purchasing a Sealey Product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

**IMPORTANT:** PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THIS PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.

## 1. SAFETY INSTRUCTIONS

- WARNING!** Ensure Health & Safety, local authority, and general workshop practice regulations are adhered to when using this equipment.
- WARNING!** Disconnect from air supply before changing drill bits, servicing ,or performing any maintenance.
- ✓ Maintain the drill in good condition (use an authorised service agent).
- ✓ Replace or repair damaged parts. Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- ✓ Use in a suitable work area. Keep area free from unrelated materials and ensure that there is adequate lighting.
- ✓ Before each use check condition of drill bit. Sharpen if necessary. If worn or damaged replace immediately.
- ✓ Ensure the speed rating (rpm) of the drill bit is the same as, or greater than, the speed rating of the drill.
- ✓ Ensure there are no flammable or combustible materials near the work area.
- WARNING!** Always wear approved eye (or face) and hand protection when operating the drill.
- ✓ Use face, dust, or respiratory protection in accordance with COSHH regulations.
- ✓ Depending on the task, the drilling noise level may exceed 84dB in which case wear safety ear defenders.
- ✓ Remove ill fitting clothing. Remove ties, watches, rings, other loose jewellery and contain and/or tie back long hair.
- ✓ Wear appropriate protective clothing and keep hands and body clear of working parts.
- ✓ Maintain correct balance and footing. Do not over reach, ensure the floor is not slippery, wear non-slip shoes.
- ✓ Keep children and unauthorised persons away from the working area.
- ✓ Check moving parts alignment on a regular basis.
- ✓ Ensure workpiece is secure before operating the drill. Never hold a workpiece by hand.
- ✓ Check the workpiece to ensure there are no protruding screws, bolts, nuts etc.
- ✓ Avoid unintentional starting.
- ✓ Remove hexagonal key wrench before starting the drill.
- WARNING!** Ensure correct air pressure is maintained and not exceeded. Recommended pressure 70-90psi
- ✓ Keep air hose away from heat, oil and sharp edges. Check air hose for wear before each use and ensure that all connections are secure.
- ✓ Prolonged exposure to vibration from this drill poses a health risk. It is the owner's responsibility to correctly assess the potential hazard and issue guidelines for safe periods of use and offer suitable protective equipment.
- ✓ When not in use disconnect from air supply and store in a safe, dry, childproof location.
- x **DO NOT** use the drill for a task it is not designed to perform.
- x **DO NOT** operate drill if any parts are damaged or missing as this may cause failure and/or personal injury.
- WARNING!** **DO NOT** drill any materials containing asbestos.
- x **DO NOT** carry the drill with your finger on the trigger.
- x **DO NOT** direct air from the air line at yourself or others.
- x **DO NOT** carry the drill by the hose, or yank the hose from the air supply.
- x **DO NOT** force, or apply heavy pressure to the drill; let the tool do the work.
- x **DO NOT** place air line attachments close to your face and do not point at other people or animals.
- x **DO NOT** operate drill when you are tired, under the influence of alcohol, drugs or intoxicating medication.
- x **DO NOT** use drill where there are flammable liquids, solids or gases such as paint solvents and including waste wiping or cleaning rags etc.



## 2. INTRODUCTION & SPECIFICATION

The SA76 provides quick and simple removal of all types of spot weld. Simply insert a 6.5mm or 8mm spot drill and set the depth on the nose of the tool. This drill can even take a out a spot-weld, a panel at a time, without damaging the panels below. Supplied with 6mm drill bit

Free Speed .....2000rpm  
 Operating Pressure .....90psi  
 Air Consumption .....4cfm  
 Air Inlet .....1/4"BSP

Sound Pressure .....74.5dB(A)  
 Vibration .....>2.5m/s<sup>2</sup>  
 Weight .....1.4kg  
 Chuck Size .....3/8"

## 3. PREPARING DRILL FOR USE

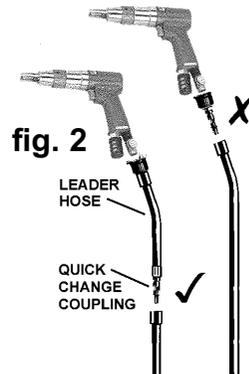
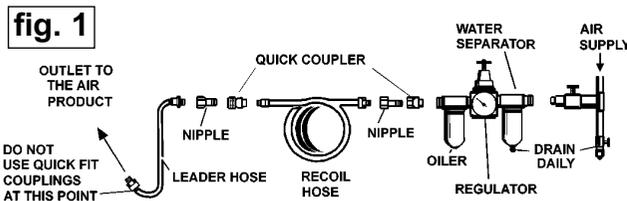
### 3.1. Air Supply

**WARNING!** Ensure the air supply is clean and does not exceed 90 psi while operating the drill. Too high an air pressure and unclean air will cause excessive wear, and may be dangerous, causing damage and/or personal injury.

- 3.1.1. Ensure the drill air valve (or trigger) is not depressed before connecting to the air supply.
- 3.1.2. You will require an air pressure between 70-90psi, and an air flow according to the specification above.
- 3.1.3. Drain the air tank daily. Water in the air line will damage the drill and invalidate your warranty.
- 3.1.4. Clean air inlet filter weekly. Recommended hook-up procedure is shown in fig 1.
- 3.1.5. Line pressure should be increased to compensate for unusually long air hoses (over 8 metres). The minimum hose diameter should be 1/4" I.D. and fittings must have the same inside dimensions.
- 3.1.6. Keep hose away from heat, oil and sharp edges. Check hoses for wear, and make certain that all connections are secure.

### 3.2. Couplings

Vibration may cause failure if a quick change coupling is connected directly to the air drill. To overcome this, connect a leader hose - Sealey model number AH2R or AH2R/38 - to the drill. A quick change coupling may then be used to connect the leader hose to the air line recoil hose. See figs. 1 & 2.



## 4. OPERATING INSTRUCTIONS

**WARNING!** Ensure you read, understand and apply safety instructions before use.  
**WARNING!** Unplug from the air supply before inserting the hexagonal key wrench.

Note: Numbers in brackets refer to Item Numbers in the parts list.

### 4.1. DRILL BIT CHANGING. Regularly check the drill bit and always change if worn, cracked or otherwise damaged.

- 4.1.1. Rotate the adjustment attachment (42), in the direction of the arrow shown in fig. 3, sufficiently to gain access to the hexagonal screw (46) in the bit holder (33).
- 4.1.2. Using the hexagonal key wrench (45), loosen the hexagonal screw to allow removal of the drill bit (36).
- 4.1.3. Insert a new drill (36), tighten the hexagonal screw and remove the hexagonal key wrench.



**WARNING!** Ensure you remove the hexagonal key wrench before starting the drill.

- 4.2. Connect air supply to drill. Squeeze the trigger to check that the drill is working correctly before starting work.
- 4.2.1 **DO NOT** allow drill to run freely for an extended period of time as this will shorten the life of its bearings.

### 4.3. DRILLING INSTRUCTIONS.

**WARNING!** Ensure you wear approved safety goggles and any other safety item required for the job. Remove the hexagonal key wrench before using the drill. Also ensure that all other safety requirements are followed.

✓ Ensure the workpiece is secured and that neither plate is free to move as the drill bit rotates.

Note: Numbers in brackets refer to Item Numbers in the parts list.

- 4.3.1. Set the required cutting depth by rotating the adjustment attachment (42). The cutting depth is INCREASED by rotating the adjustment attachment in the direction of the arrow shown in fig.3.
- 4.3.1. Connect drill to air supply.
- 4.3.2. Hold tool firmly and place the support over the weld to be drilled.
- 4.3.3. Depress the trigger to start drill. Apply pressure to the tool to move the drill bit into the weld applying only enough pressure to keep the bit cutting.
- 4.3.4. When drilling metals, use a light oil on the drill bit to keep it from overheating. Oil will prolong life of bit and improve the drilling action.
- 4.3.5. For hard smooth surfaces use a centre punch to mark desired hole location. This will prevent bit from slipping as you start to drill.
- 4.3.6. Adjust the cutting depth as necessary for the first weld. Once set the drill can take out a spot-weld, a panel at a time without damaging the panels below.

**WARNING!** Be prepared for drill binding. When this situation occurs the drill has a tendency to grab and kick in the opposite direction which could cause loss of control. If you are not prepared, this loss of control can result in damage and/or personal injury.

- 4.3.7. If the bit jams in the work piece or if the drill stalls, release the trigger switch immediately. Remove the bit from the work piece and determine the reason for jamming.

## 5. MAINTENANCE

**WARNING!** Disconnect drill from air supply before changing drill bit, servicing or performing maintenance.

- 5.1. Replace or repair damaged parts. Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.
- 5.1. Lubricate the drill daily with a few drops of good grade air tool oil, such as Sealey ATO/500 or ATO/1000, dripped into the air inlet before use or dispensed automatically through an air system oiler, such as Sealey model SA100L or SA1/L.
- 5.2. Clean the drill after use and change the bit when worn or damaged.
- 5.3. Loss of power or erratic action may be due to the following:
  - a) Excessive drain on the air supply. Moisture or restriction in the air line. Incorrect size or type of hose connectors. To remedy check the air supply and follow instructions in Section 3.
  - b) Grit or gum deposits in the drill may also reduce performance. Flush the drill with gum solvent oil or an equal mixture of SAE No 10 oil and kerosene. Allow to dry before use. If you continue to experience problems, contact your local Sealey service agent.
- 5.4. For a full service contact your local Sealey service agent.
- 5.5. When not in use, disconnect from air supply, clean drill and store in a safe, dry, childproof location.

## Declaration of Conformity



We, the sole importer into the UK, declare that the product listed here is in conformity with the following standards and directives. The construction file for this product is held by the Manufacturer and may be inspected, by a national authority, upon request to Jack Sealey Ltd.

**AIR OPERATED  
 SPOT WELD DRILL  
 Model: SA76**

98/37/EC Machinery Directive  
 93/68/EEC Marking Directive

Signed by Mark Sweetman

25th July 2002

For Jack Sealey Ltd. Sole importer into the UK of Sealey Power Tools.