



RELIABLE EQUIPMENT

**CRAFTED WITH PRIDE IN THE U.S.A.
USED WITH CONFIDENCE AROUND THE WORLD**

301 Ivyland Road - Warminster, PA 18974

Phone: 215-357-3500 Toll Free: 800-966-3530

Fax: 215-357-9193

REL-425C

Hydraulic Impact Wrench

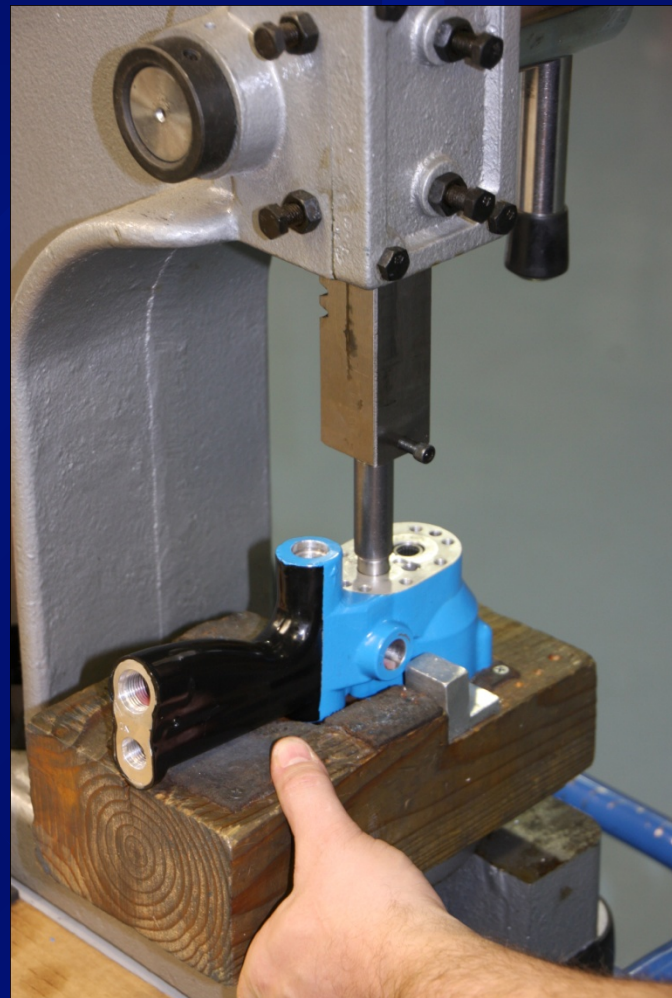


Instructions for Typical Assembly & Repair

Always begin with a clean level working surface. Confirm that all parts are present and in good condition. Any parts that appear worn or damaged should be replaced. Use of a new seal kit is recommended, whenever a complete disassembly and assembly is required.



**Press Upper Bearing
Into Tool Body**



**Press Lower Bearing
Into Tool Body**



**Press Inner Bearing
Into Tool Body**



**Press (2) Bearings
Into Motor Cap**



Insert O-Ring Into Control Spool Port



**Insert Drive Shaft O-ring
Ensure That O-ring Is
Properly Seated**



REL-425C

Pressure Control Spool

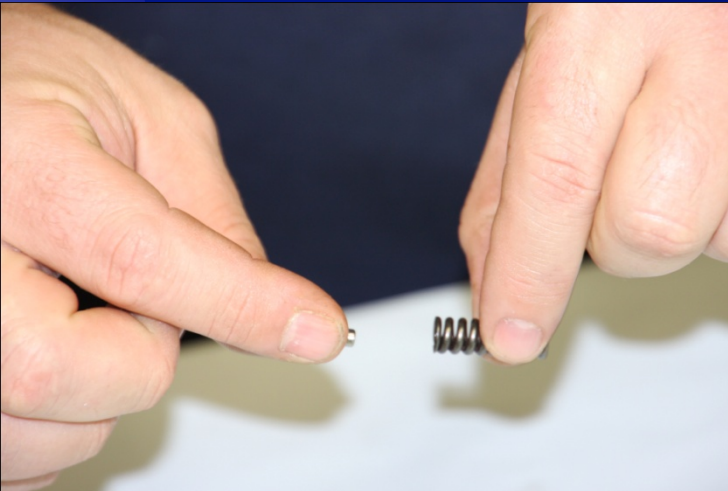


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Install O-Ring Onto Adjusting Plug



Insert Plug Into Spring

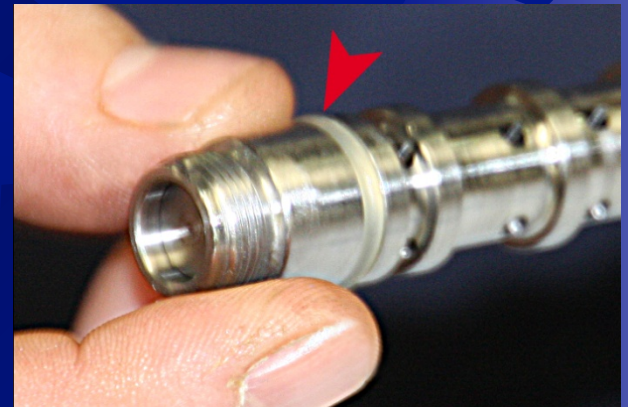


Install Pintle Into Spring





Install Assembly Into Spool



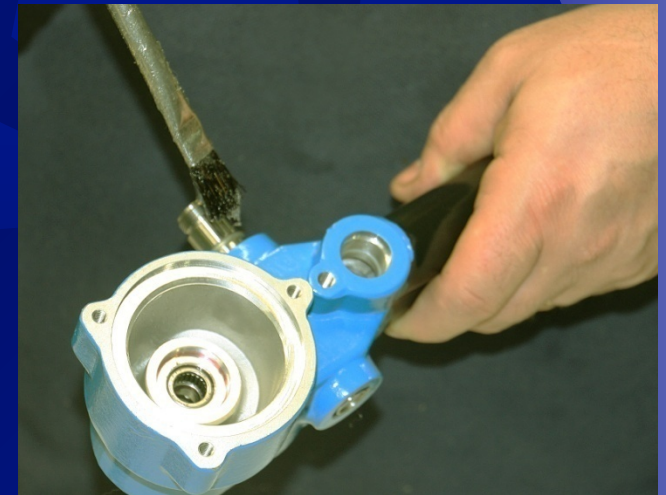
Install O-Ring To First Groove Of Spool



Lubricate Spool & Install Into Impact Body



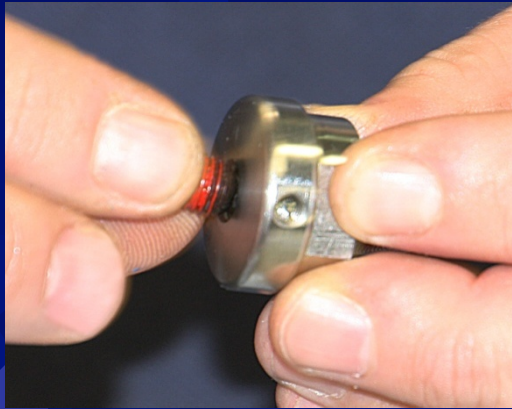
Install O-Ring To First Groove Of Spool



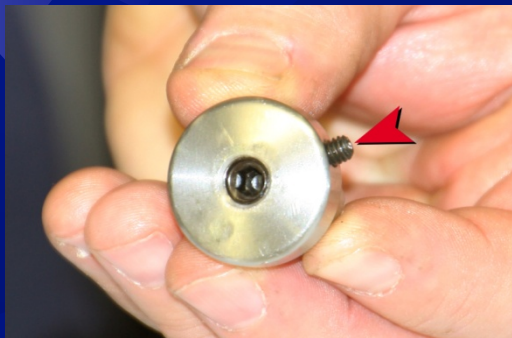
Lubricate O-Ring



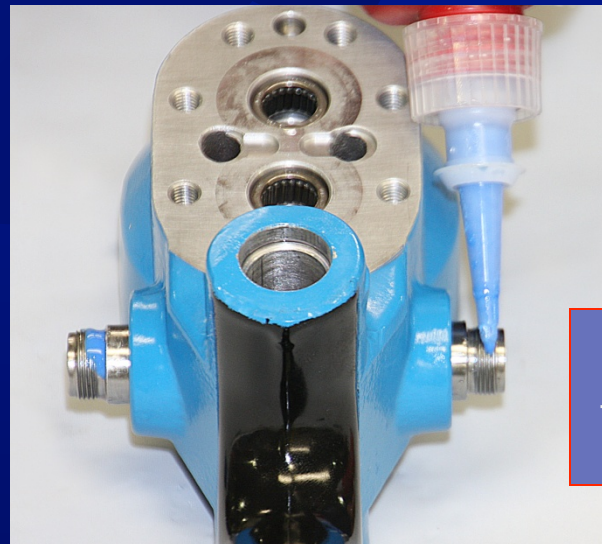
Confirm Spool Operation By Moving From Side To Side



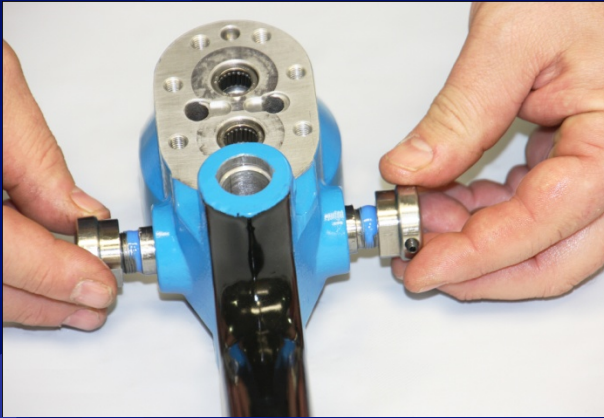
Install Adjusting Screw Into Adjusting Cap



Insert Locking Screw



Apply Locktite
To Spool Threads



Install Adjusting Caps



**Use Two $\frac{3}{4}$ Inch
Open End Wrenches
To Tighten Caps**



**Check Spool
Operation**

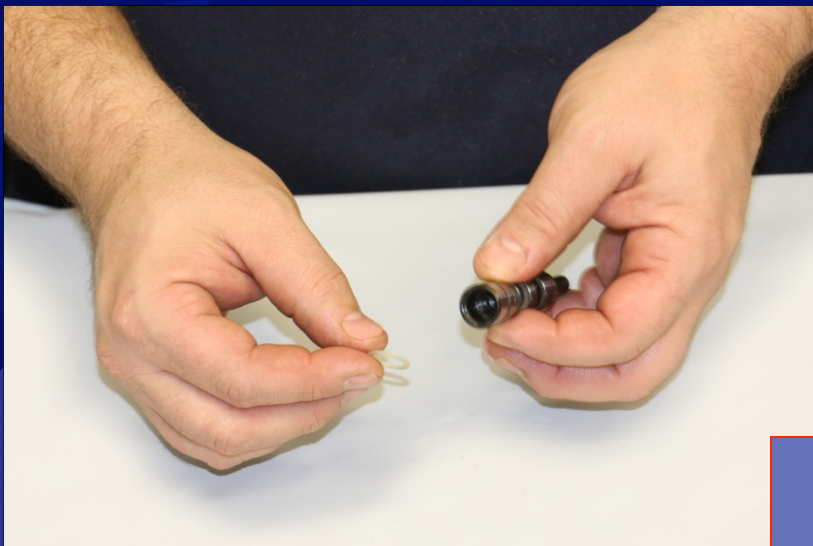
REL-425C

OC / Trigger Control Spool



Instructions for Typical Assembly & Repair

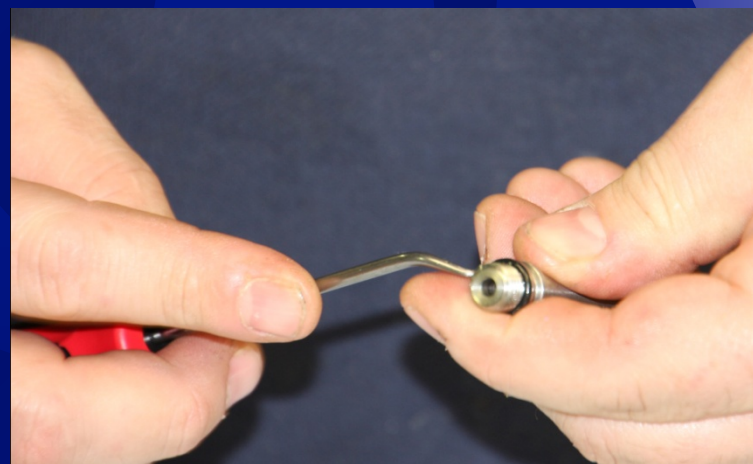
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Install O-Ring Onto Main Spool



Install O-Ring Onto Stem



A Pick May Be Used With Care



Install Clip To Secure Stem



**Back Stem Out To Clip
This Is Open Center Setting**



Lubricate Spool Assembly



**Install Spool
Assembly Into
Tool Body**



**A Careful Tap
May Help To Seat
The Spool**



Insert Main Spool Spring



Insert Support Washer



Insert Snap Ring



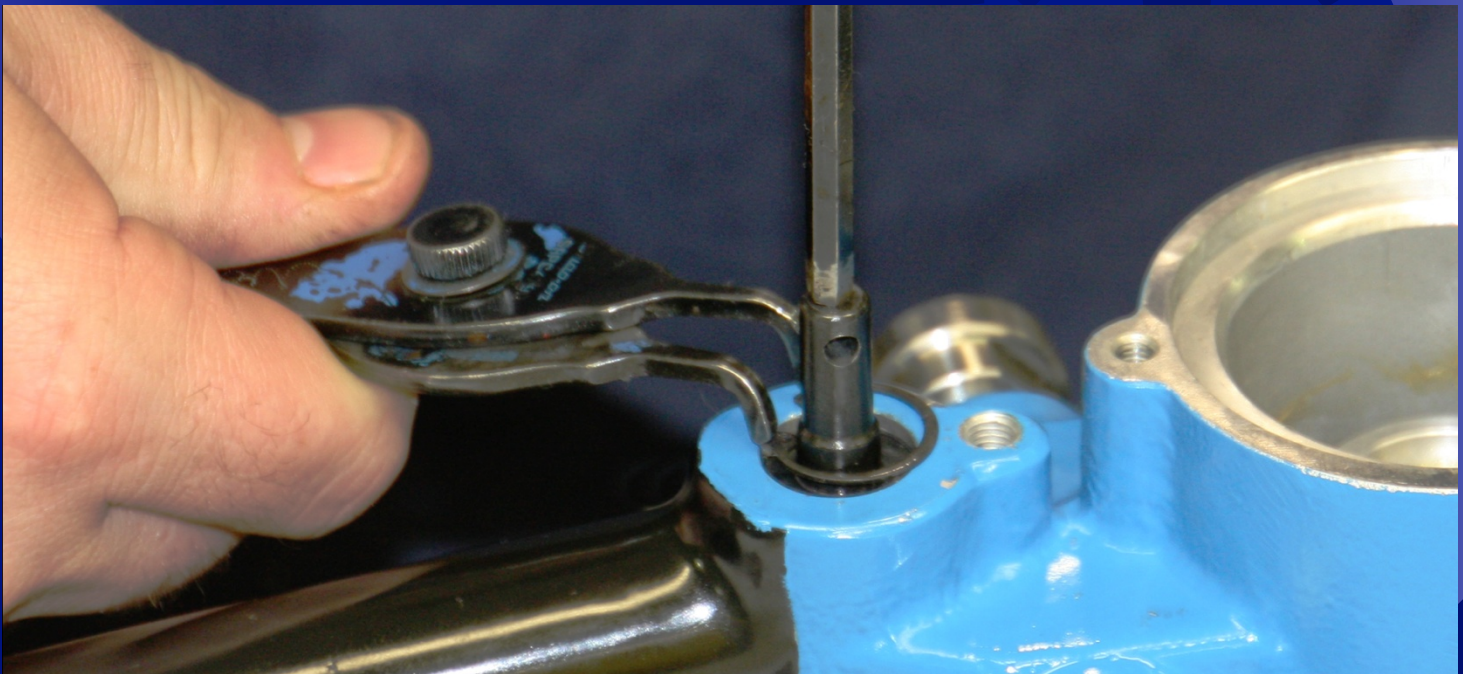
Align Spool For Trigger Installation



Slide Washer Onto Spool



Install Snap Ring To Secure Spool



REL-425C

Motor Side Assembly



Instructions for Typical Assembly & Repair

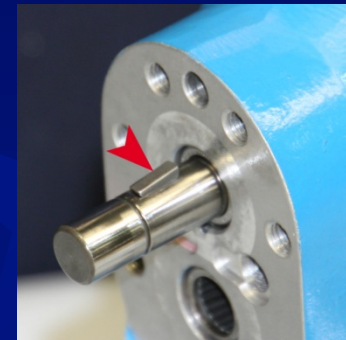
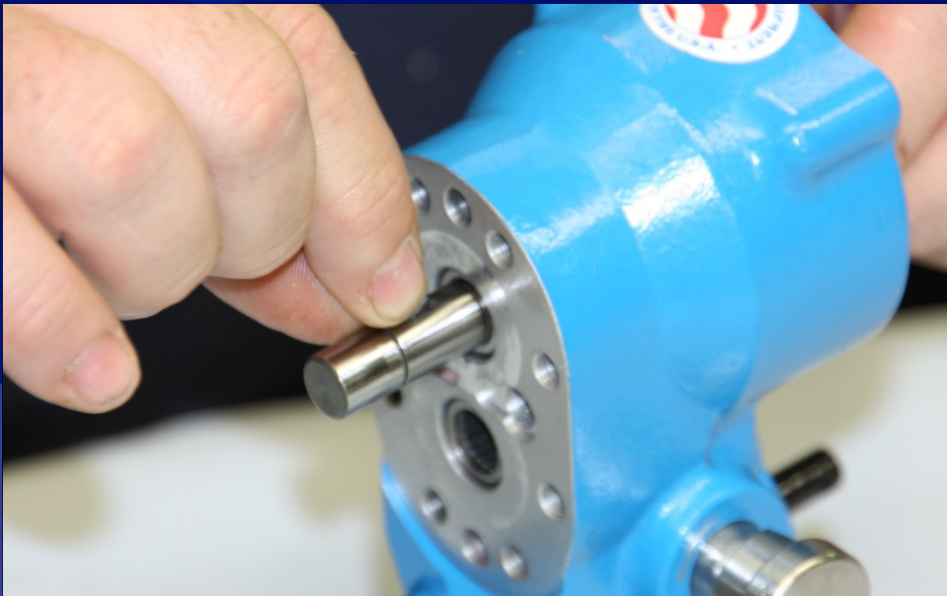
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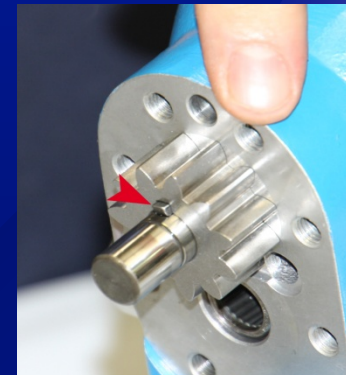
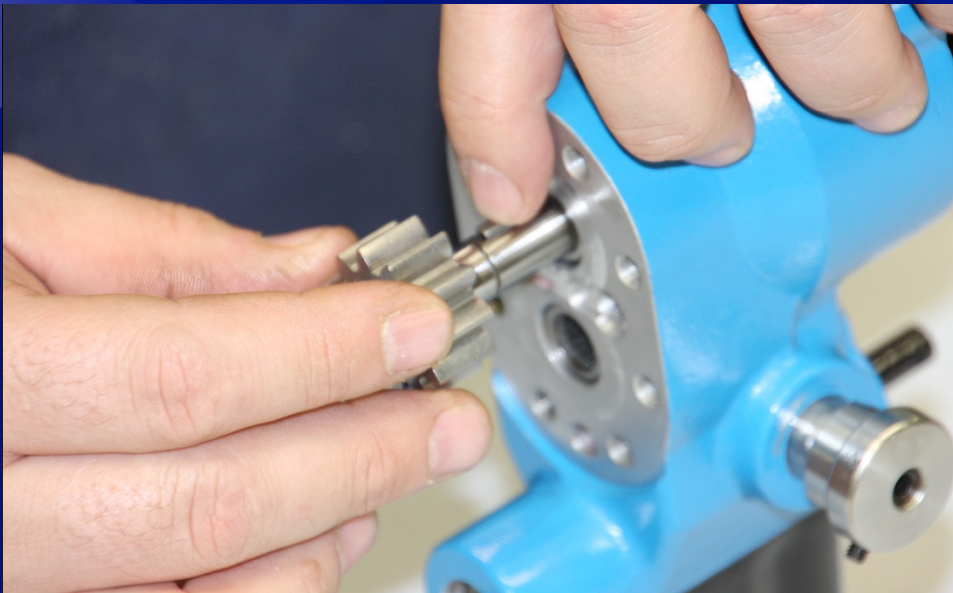
Lubricate The Drive Shaft



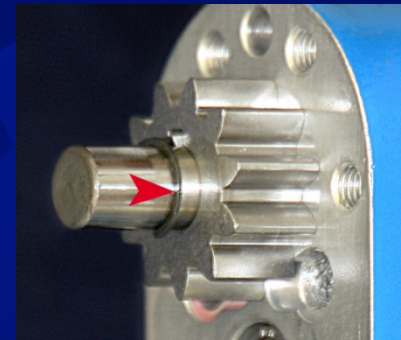
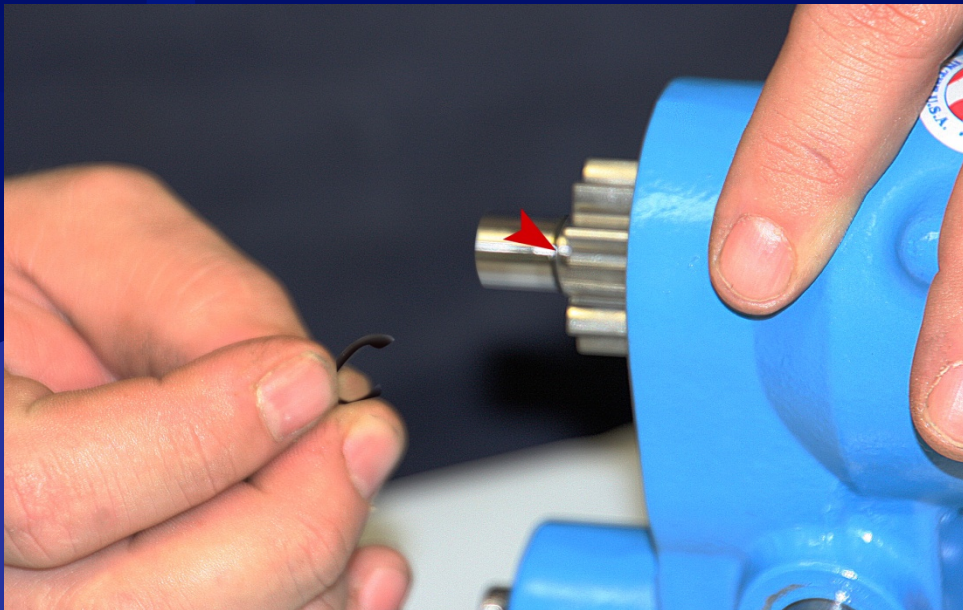
**Insert Drive Shaft
Through Tool Body**



**Install Drive Key
Into Drive Shaft**



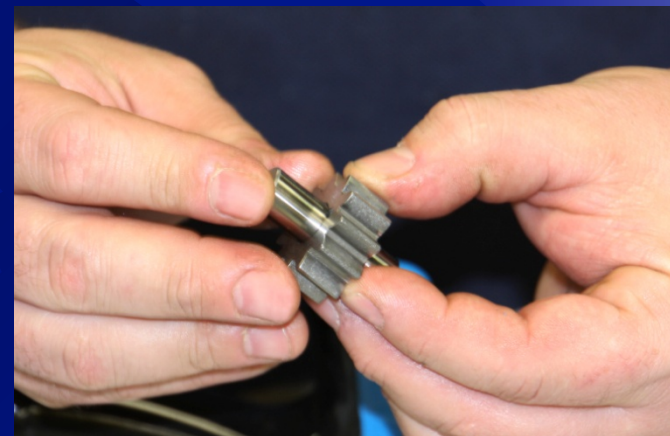
**Install Gear Onto
Drive Shaft & Over Key**



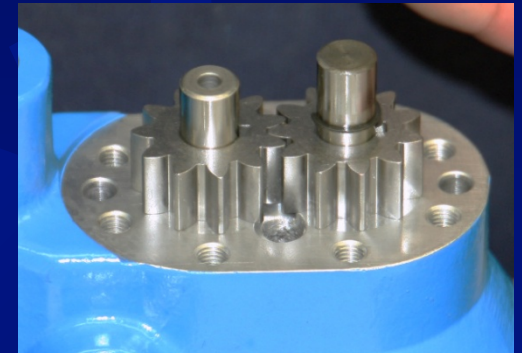
**Secure With
Circle Clip**



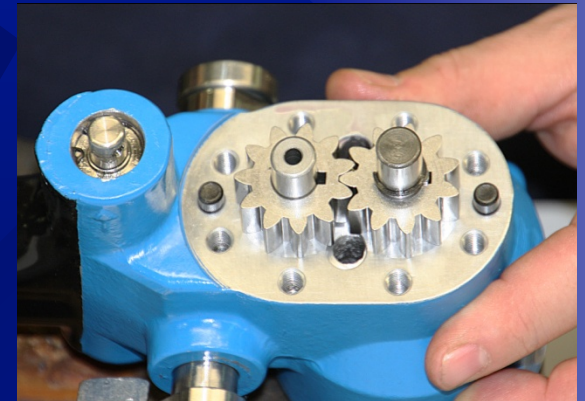
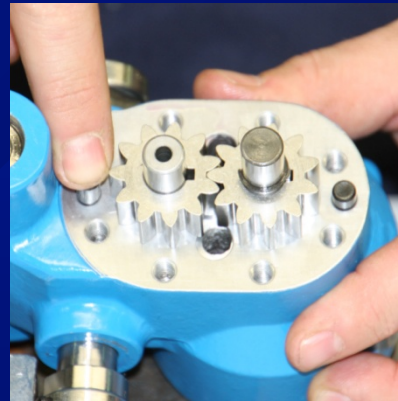
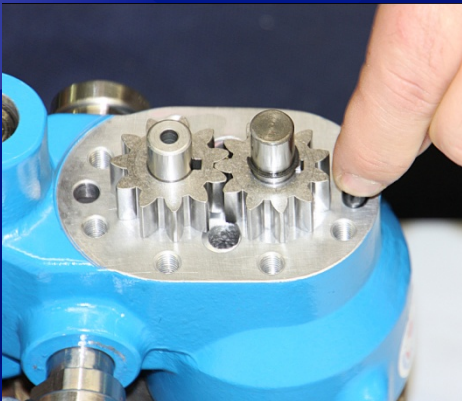
Install drive Pin Into Idler Shaft



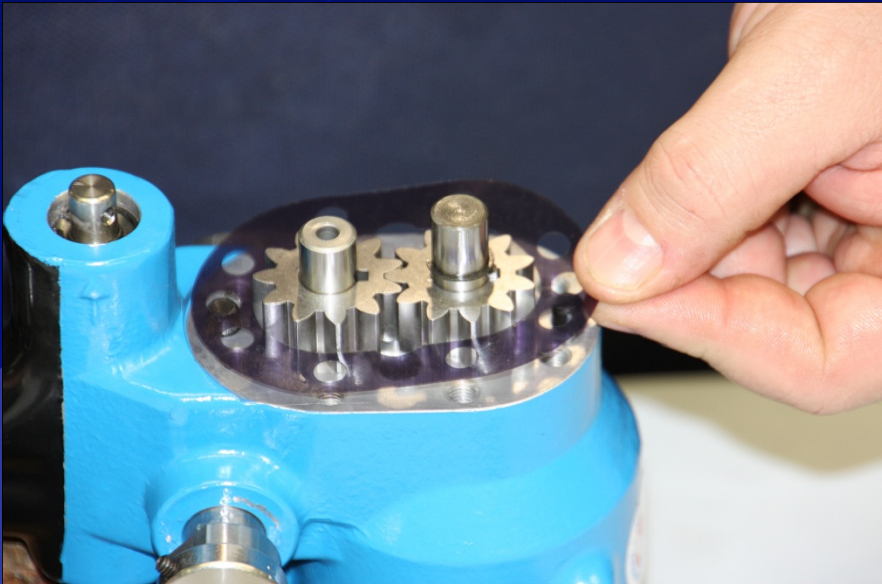
Install Gear Onto Idler Shaft



**Fit Idler Assembly
Into Drive Gear**



Insert Two Dowel Pins Into Tool Body



Install Motor Cap Gasket



**Install Motor Cap Using
Dowel Pins As Guides**



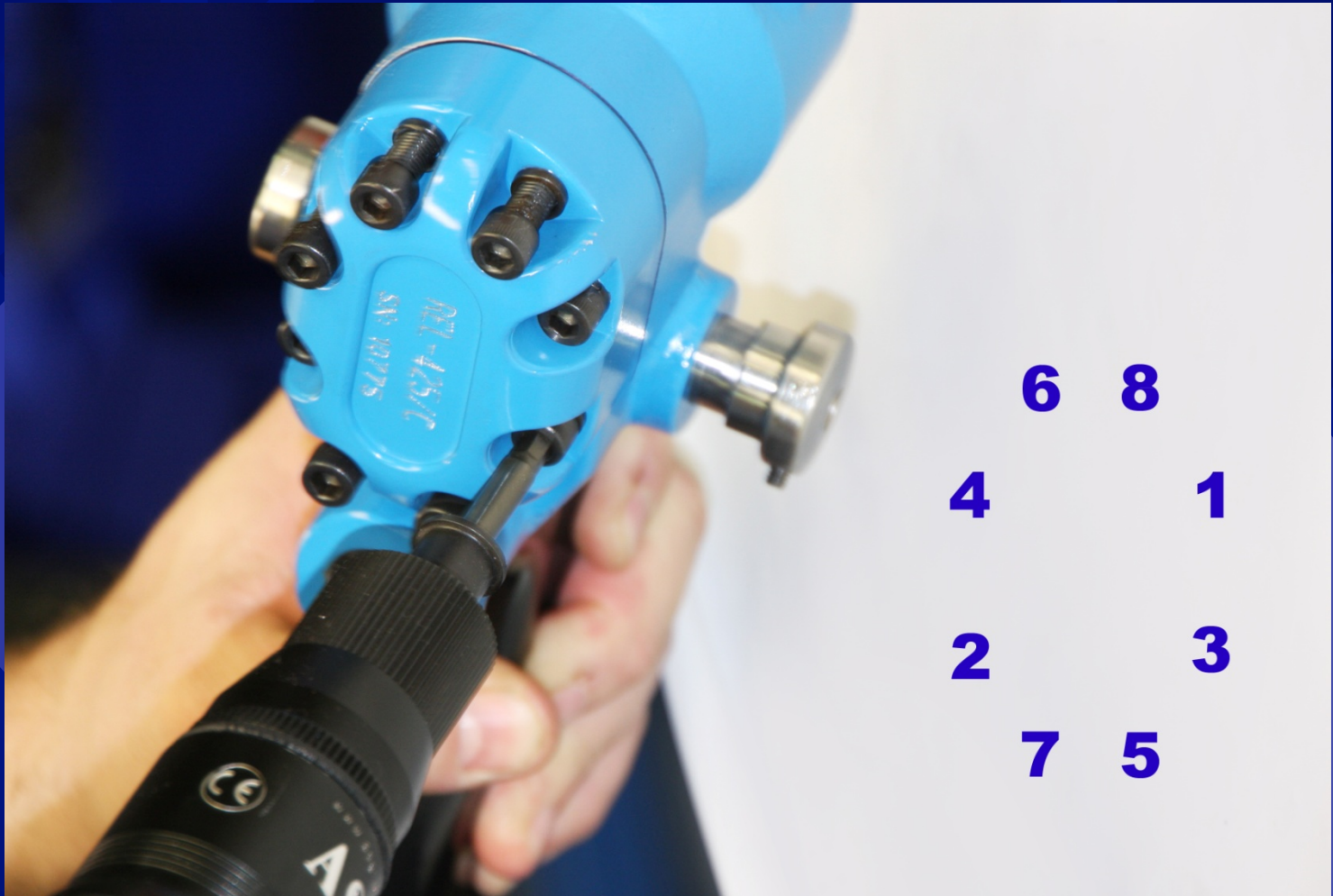
**Install Eight Sets
Socket Head Screws
& Lock Washers**

DO NOT TIGHTEN

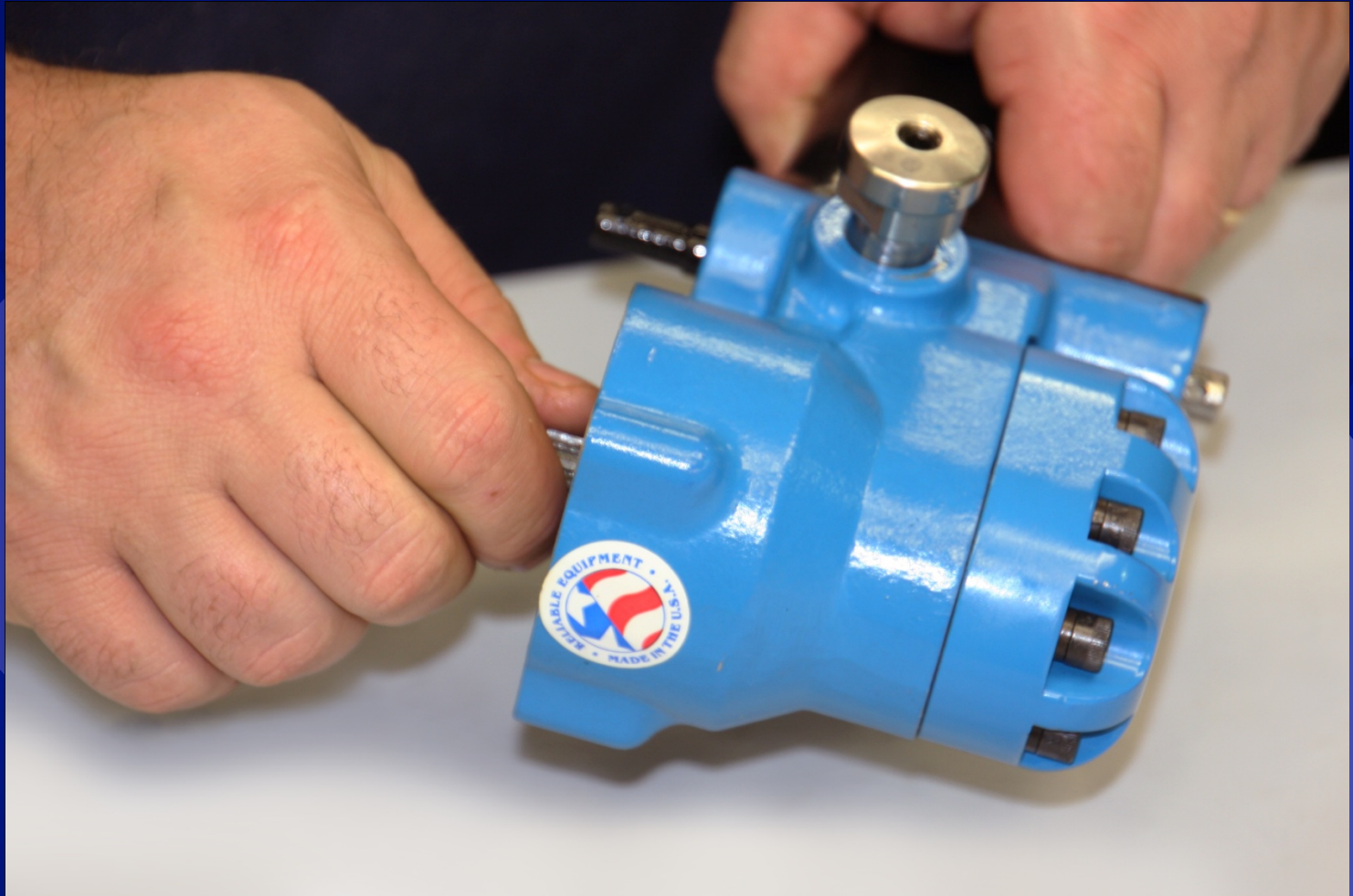
**A Torque Wrench
Is Required For
Proper Installation**

Proceed When Ready





Torque Screws To 120 in-lb - Follow The Sequence Shown



Inspect to Ensure Proper Movement of the Drive Shaft

REL-425C

OC / Trigger Control Spool

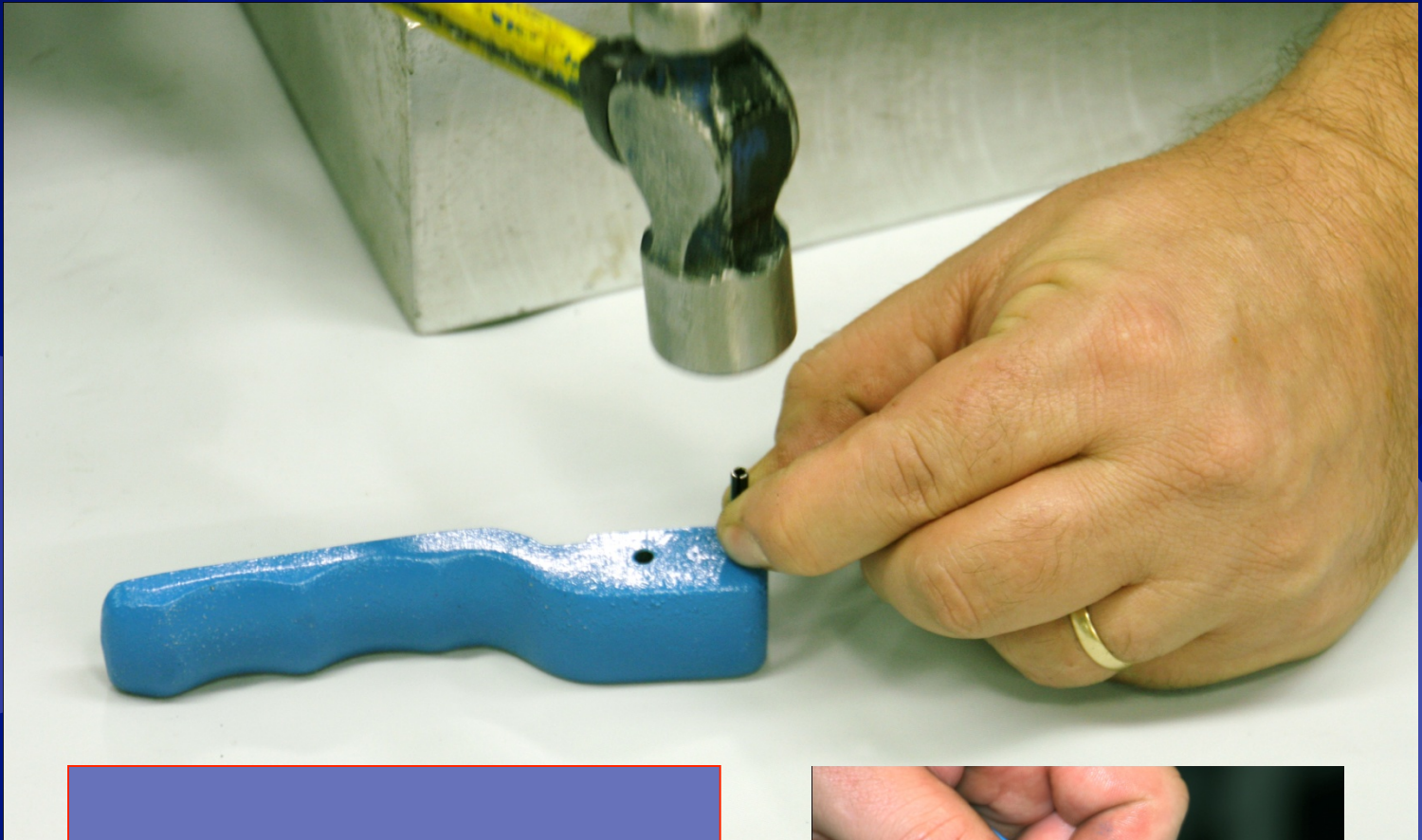


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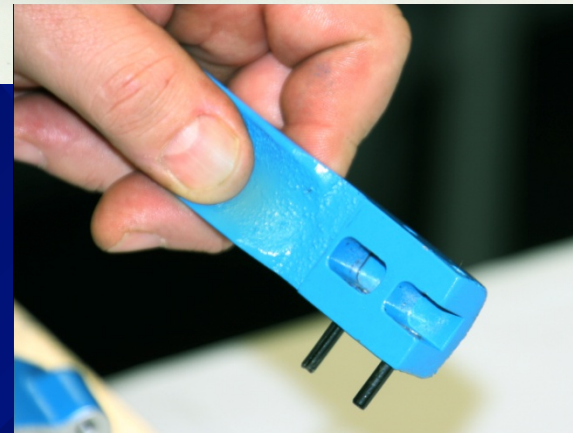


Screw Trigger Nut Into Tool Body



Pre-Install
Coiled Spring Pins
Into Trigger

**DO NOT BLOCK SEATS
FOR TRIGGER NUT & SPOOL**





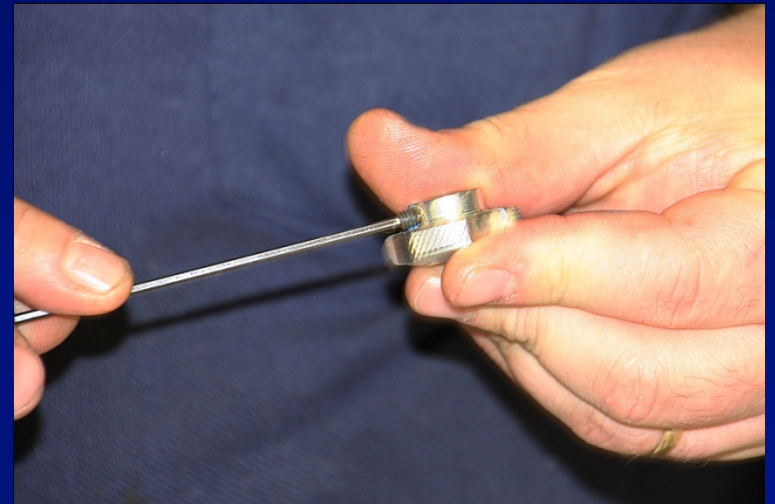
**Insert Trigger Over
Trigger Nut & Spool**



Drive Coiled Spring Pins Into Trigger Until Flush Or Recessed



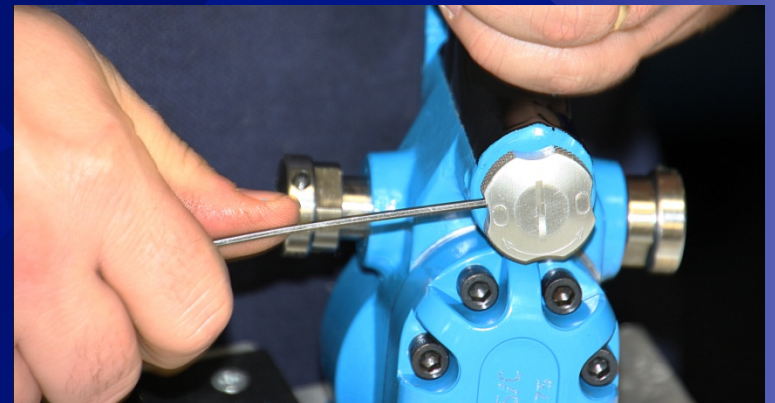
Align Spool As Needed



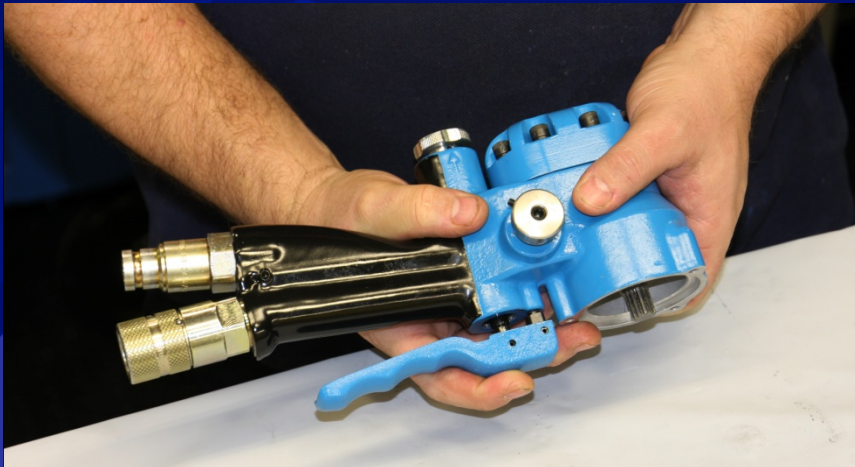
Locktite & Pre-Install Set Screws



Install OC Knob Onto Spool



Tighten Set Screws



Install LP Coupler Set For Testing



Connect To Hydraulic Test Source



Turn ON Test Source



Test & Check For Leaking



Reverse Spool & Test Again



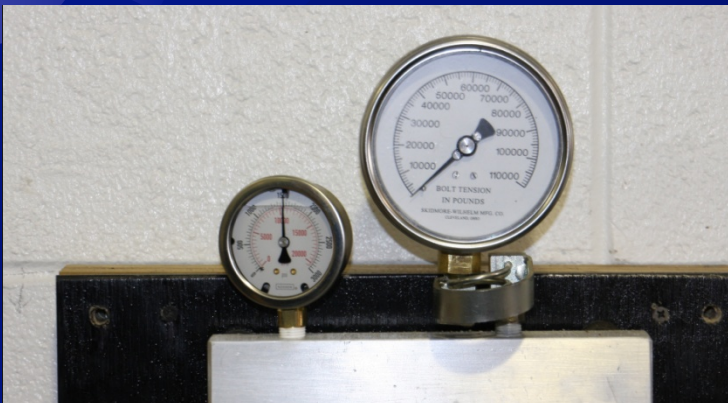
Observe Tool Operation



Mount Into REL-425TS Test Stand



Test Operation Under Load



Observe Flow / Pressure



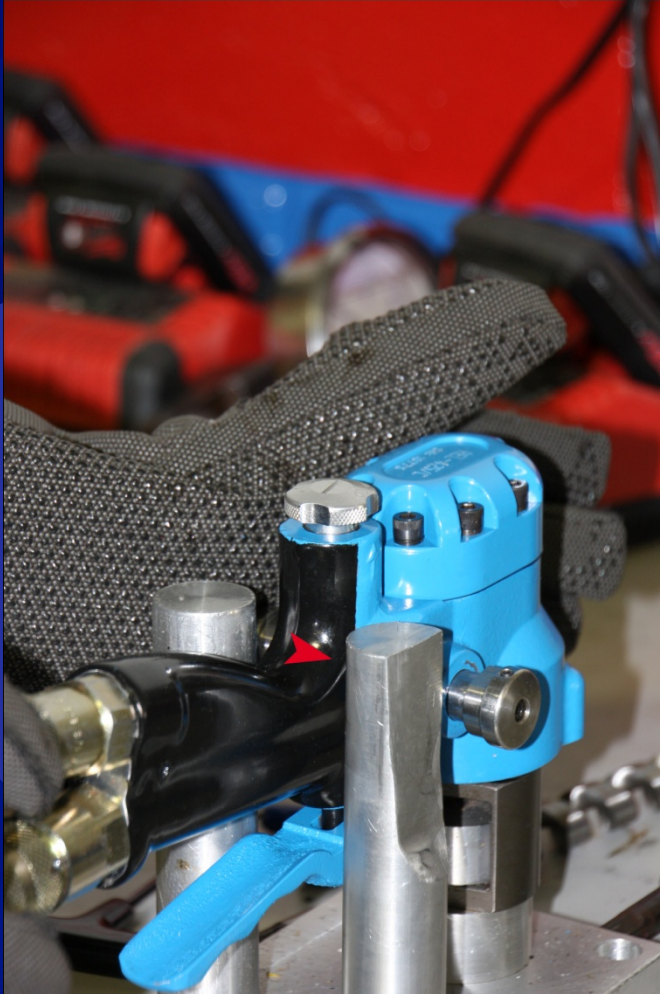
Re-Test To Confirm Results



**Adjust Flow / Torque
To Required Setting**



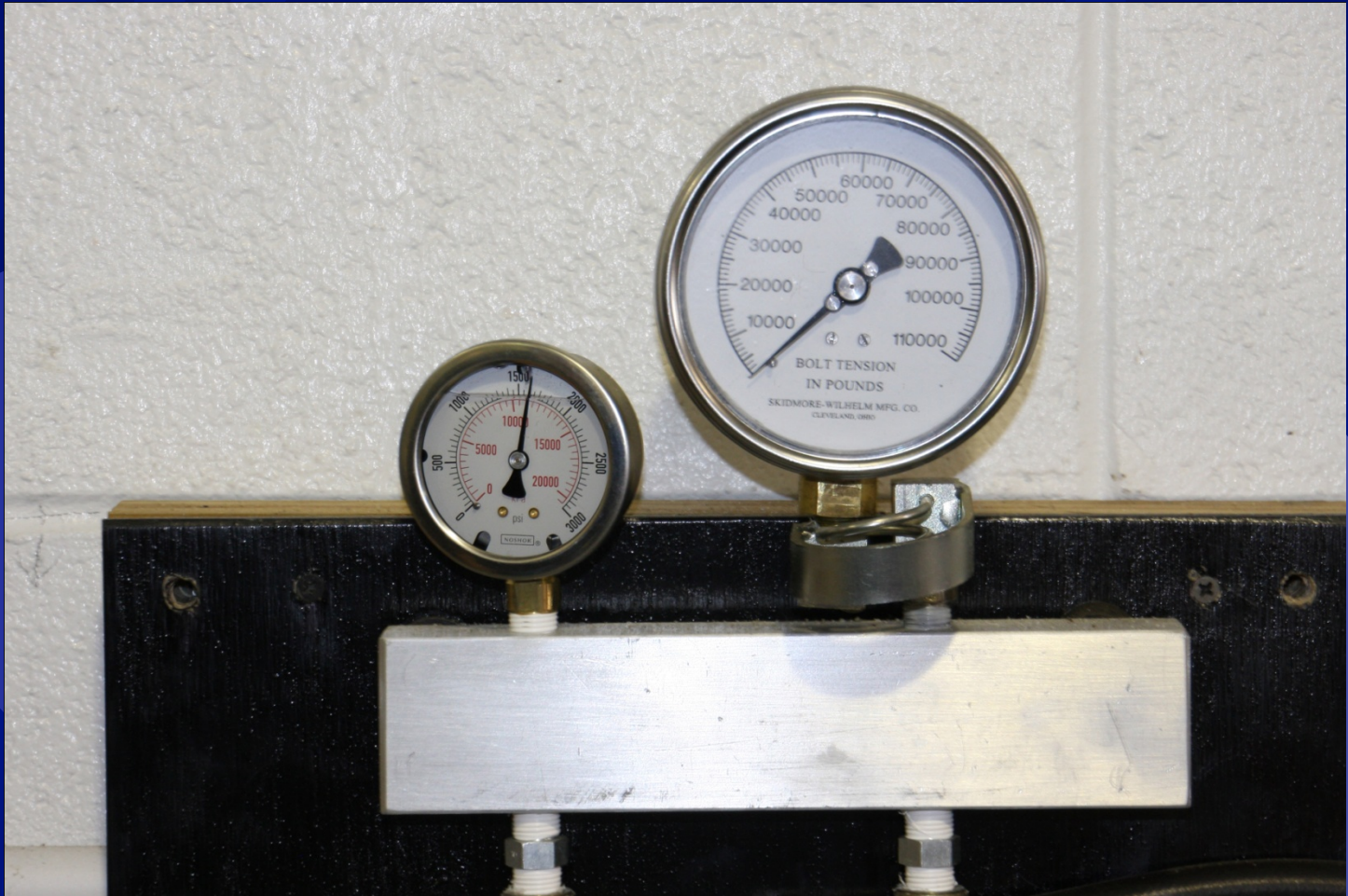
Tighten Set Screws



Operate Spool And Test



Operate Spool & Test



Observe Pressure & Repeat Previous Test Procedures As Needed



Turn OFF Test Source



Disconnect From Test Source

REL-425C

Impact Mechanism



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**Apply Grease
To Drive Shaft**



Install Washer & Apply Grease



Install Thrust Bearing & Grease



Install Washer & Apply Grease



Install Spacer & Apply Grease



Install Pin Washer



Apply A Coating Of Grease



**Grease Entire Cage
Work Into All Areas**



Apply A Coating Of Grease To Both Hammer Pieces



Assemble Hammers Into Cage



Align & Insert Hammer Pin



Install Second Hammer Pin



Re-Apply Grease To Assembly



Install Adapter Flange



Install O-Ring Over Flange



**Apply A Coating Of
Grease To The Inside
Of Nose Assembly**



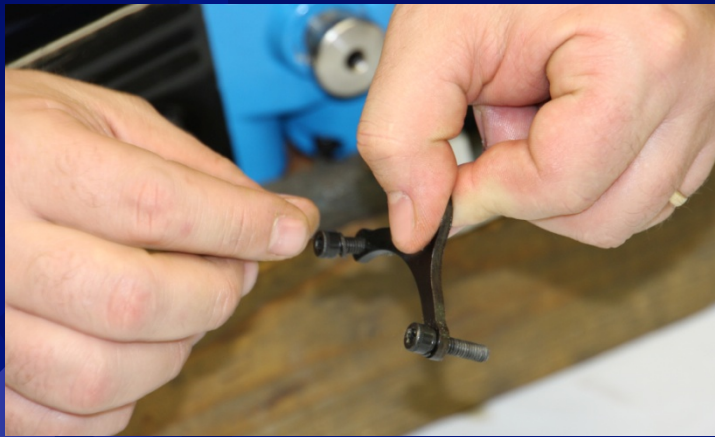
Place Cage Assembly Onto Tool



Cage Must Mesh With Drive Shaft



Install & Align Nose Assembly



Insert Screws & Lock Washers



Install Nose & Hanger Assembly



Tighten (3) Front End Screws



Wipe Impact Wrench To Remove Any Residual Grease



Apply Lubricant To Skidmore Test Machine



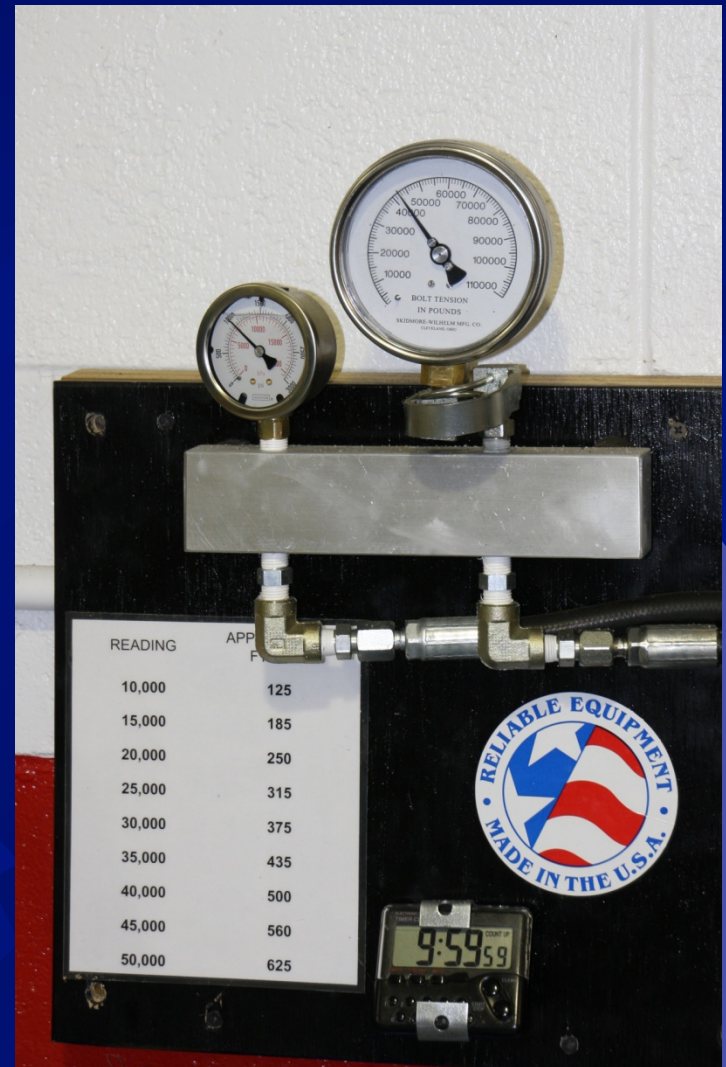
Wear Safety Apparel & Connect To Hydraulic Test Source



Turn On Hydraulic Test Source



Test Torque On Skidmore Unit



Observe Pressure & Torque



Install Test Bit



Test Tool Operation



Turn OFF Unit



Disconnect From Test Source

The Information Provided In This Document Is Intended As A Guide For Trained Professionals Only.

Shop MUST Be Equipped with Appropriate Power Supply, Test and Safety Equipment.

Contact Reliable Equipment With Any Questions BEFORE You Start.



Remove Test Bit



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