

Tool &
Product
Update

**SKIDMORE SHIFT SETTING KIT 107569
REVISED**

The **SHIFT SETTING KIT 107569**, employing a Skidmore-Wilhelm tester to set and check the shift valve of the Huck Model 200 Installation Tool, has been revised.

Air Metering Fitting P/N 101303 has been added to the kit to use per revised Instructions 42-348.

Attached is a revised copy of **INSTRUCTIONS AND SPINDLE LOADS FOR USING SHIFT SETTING KIT NO. 107569, 42-348 (Form 68 4/68, Revised 6-1-76)**.

Note: Air Metering Fitting P/N 101303 (same as used in 101300 kit) is available separately.

Continued on Back...

INSTRUCTIONS AND SPINDLE LOADS FOR USING SHIFT SETTING KIT NO. 107569

I. INTRODUCTION

Shift Setting Kit No. 107569 employs a Skidmore-Wilhelm Tension Tester (Model "S") to check the shift valve cartridge setting on the Huck Model 200 Installation Tool. This setting kit checks the spindle load (LBS.) at shift while Shift Setting Kit No. 101300 checks Hydraulic Fluid Pressure (P.S.I.) at Shift.

II. PREPARATION FOR USE

1. The individual responsible for setting the tool should become thoroughly familiar with the operation of the 200 H.I.T. by careful study of the tool and the 200 Instruction Manual (Form 154).
2. Prepare tool for use as outlined in the Manual under Headings: PREPARATION AND USE and FILLING AND BLEEDING TOOL. It is important that all instructions and recommendations be followed. The tool will not function properly unless filtered, lubricated and regulated (90-100 P.S.I.) air pressure is used. The air supply system must be capable of supplying 18 cubic feet per minute.

III. INSTALLING SHIFT SETTING KIT NO. 107569

1. Install the Shift Setting Kit as illustrated on Installation Drawing No. 107568 included with each kit.
2. Assemble Adapter No. 107564 thru the Skidmore-Wilhelm Tester and engage the threads of the tool pull piston. Tighten "Finger Tight."
3. Attach Air Metering Fitting P/N 101303 to Tool and connect air supply.

IV. SETTING THE SHIFT VALVE CARTRIDGE

1. Back out the shift valve adjusting screw flush with the body.
2. From the chart (paragraph V) select the "Spindle Load At Shift" for the Huck Fastener to be installed.
3. Depress the tool trigger (Quickly) and watch the needle on the tester gage. Full spindle load will be shown. There will be no pause indicating shifting of Shift Valve because it is inoperative with adjusting screw backed out.

4. Turn in the adjusting screw until the needle of the gage pauses before reaching full spindle load when the trigger is depressed. This is the "Spindle Load at Shift."
5. Adjust screw to obtain the desired "Spindle Load at Shift" selected from the chart.
6. Remove Air Metering Device and reconnect air supply to tool. Trigger tool ten times to verify setting. (Note: The needle of the gage will bounce when shift occurs. Do not confuse this bounce with the pause indicating "Spindle Load at Shift").
7. Disconnect air supply hose and remove the Setting Kit (Tester and Adapter) from the tool.
8. Attach the proper Nose Assembly to the tool and install a few Fasteners in a test plate to verify that the shift valve cartridge had been set properly and that Nose Assembly is functioning properly:

V. SPINDLE LOAD AT SHIFT CHART

FASTENER		POUNDS	
ASF40911-460 AFS40911-461	CKL-X4	* - 325	
	CKL-X5	475 - 525	
	CKL-X6	700 - 750	
	OCKL-4	* - 450	
	OCKL-5	550 - 600	
	OCKL-6	750 - 800	
NAS1919 & 1921	B04	* - 350	
	B05	475 - 525	
	B06	700 - 750	
	B08	1250 - 1300	
	C04	850 - 900	
	C05	1150 - 1200	
	C06	1850 - 1900	
	M04	750 - 800	
	M05	1100 - 1150	
	M06	1750 - 1800	
	MS21140	B-EU5	1225 - 1300
	MS21141	B-EU6	1780 - 1910
MS90353	B-T5	1400 - 1450	
MS90354	B-T6	2150 - 2250	
—	OB-T5	1400 - 1450	
—	OB-T6	2150 - 2250	

*Set as close as possible to load shown.