

SWE221/221-1/221HD Manual & Pneumatic Torque Multiplier

WARNING

- Sockets must be securely seated on crab nuts before using this tool.
- Inspect sockets (drive and reaction) for cracks and abnormal wear prior to each use.
- Read and understand Operating Instructions for 393 Torque Multiplier and 3900A Pneumatic Power Drive (221-1 Set only), especially noting warnings.
- Keep hands and fingers away from anchor socket and reaction anchor tube interface while applying torque.

1. IMPORTANT INSTRUCTIONS

- 1.1 Read and understand these operating instructions before using this tool.
- 1.2 Make certain that reaction socket and torque multiplier is securely affixed to the reaction anchor tube before using this tool.
- 1.3 Use only Hydratight Sweeney approved replacement parts.

2. DESCRIPTION AND SPECIFICATIONS

- 2.1 Model 221 Manual Torque Multiplier Set and 221-1 Pneumatic Torque Multiplier Set are designed for tightening and loosening of crab nuts on EMD Engine Models 567 and 645.

- 2.2 The 221 Manual Torque Multiplier Set consists of:

- 393-40 Assy., Reaction Anchor
- 393-700 Assy., Square Drive
- 3932 Multiplier, Basic Torque
- 361-61 Socket, 1" sq. F – 2 3/4" Hex F
- 361-40 Assy., Reaction Socket
- 53 Wrench, Torque
- 329A Chest, Complete
- 32919-12 Schematic, Tool Location
- PL-393A-879 List, Parts
- OI-393A Instructions, Operating
- OI-221/221-1 Instructions, Operating
- 921071 Roll Pin
- 942083 O Ring

- The 221-1 Pneumatic Torque Multiplier Set consists of:

- 221 Set (See 2.2 Above)
- 3900A Power Drive, Pneumatic
- 221-88 Kit, Air Control

- The 221HD Pneumatic Torque Multiplier Set consists of:

- 394B Multiplier, Torque 5000 FT-LBS-1 1/2" SQ Output-5% Cert Tag

- A4001E0212AA Impact Skt 1.1/2" Sq Dr 2.3/4"(70mm) AF Std (2)
- SWE53 Wrench, Torque



3. INSTALLATION AND OPERATION

- 3.1 Attach Socket (361-61) to Torque Multiplier output square drive.
- 3.2 Slide Anchor Socket (361-40) over Reaction Anchor (393-40) and attach reaction anchor to Torque Multiplier.
- 3.3 Position the drive socket on the nut to be torqued and the reaction socket over the reaction nut (See Figure 1 below).
- 3.4 Note: The hex insert rotates inside of the reaction socket to allow for socket to crab nut alignment.
- 3.5 The crab nut can now be tightened or loosened, manually or pneumatically (221-1 set only).
- 3.6 The 221 and 221-1 Torque Multiplier Sets can only be used as shown in figure 1 below. Never place torque multiplier across the two closer crab nuts.

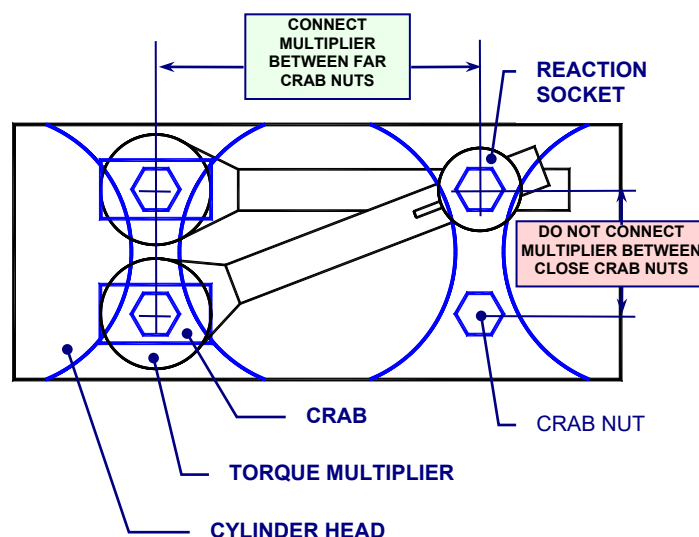


FIGURE 1
ALLOWABLE TORQUE MULTIPLIER
ANCHORING POSITIONS