

Production Installation Tooling

Power Tools

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 stabilized 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 three 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

Pneumatic Power Tool



Front End Assembly



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
- Easy Adjust Depth Control Collar
- Suitable for use with torque control
- Hardened Steel Hex Drive Mandrel screwdrivers

Electric Power Tool with Mandrel



Compressed Air Supply for Pneumatic Installation Tools chart

		PRESSURE RECOMMENDATIONS FOR INSERT SIZES									
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.

Strip-Feed Inserts

To complete the Recoil power installation tools, Recoil has inserts available on strip (M2.5-M12, #2-5/16) to optimize production with increased installation cycles and reduced operator fatigue. Recoil strip feed inserts provide many advantages such as minimized handling costs, faster, more economical assembly and positive inventory control. When used in combination with Recoil pneumatic installation tooling, each insert is retained in plastic strip which is passed through a slot in the front end assembly nozzle, indexing the insert to the installation mandrel. Recoil Strip-Feed inserts are available in most common thread diameters and lengths in addition to the various surface finishes which are available on standard Recoil bulk inserts. The table shows some commonly supplied Recoil Strip-Feed inserts and defines the typical quantity of inserts supplied per reel for each given thread size. Additional insert diameters and lengths may be available to special order.

