



NOTE: Parts are no longer available for this tool.

The manual will continue on the next page.



INSTRUCTIONS & PARTS LIST FOR DIE GRINDERS, LAMINATE TRIMMER & ROUTERS 1953HP, 1954HP, 1954HPEXT, 1954HPSC, 1955HP, 1955HPEXT, 1956HP, 1956HPEXT, 1971HP, 1971HPA, 1971HPB, 1971HPC

SAFETY: Before placing the tool in operation, the supervisor and operator are cautioned to study and follow all instructions with special emphasis on safety (refer to "Important Safety Requirements"). The supervisor and safety director must be acquainted with and follow the requirements of the applicable section of the ANSI Safety Code B7.1 latest edition.

AIR SUPPLY: The efficiency and life of this tool depend on the proper supply of clean, dry, lubricated air at a maximum of 90 PSI. The use of an air line filter, pressure regulator, and lubricator is recommended. The air supply hose recommended is 3/8" ID. If an extension hose is necessary, use 1/2" hose with couplings not less than 3/8" I.D.

LUBRICATION: It is very important that the tool receive an adequate supply of oil for proper lubrication of moving parts. An inline oiler is recommended. Adjust to deliver 2-3 drops per minute. If an inline lubricator is not used, about one-half teaspoon of air motor oil should be poured into the air inlet every two to three hours. SIOUX No. 288 Air Motor Oil is recommended.

OPERATION: The tool is equipped with a lock-out type lever in order to prevent accidental startup. Speed of the tool may be adjusted by turning the speed control, which is located under the lever. If holding the tool in a vise or toolpost holder, use moderate pressure.

**SIoux™
TOOLS INC.**

PARTS LIST FOR 1953HP, 1954HP, 1954HPEXT, 1954HPSC, 1955HP, 1955HPEXT, 1956HP, 1956HPEXT, 1971HP, 1971HPA, 1971HPB, 1971HPC POWER UNIT

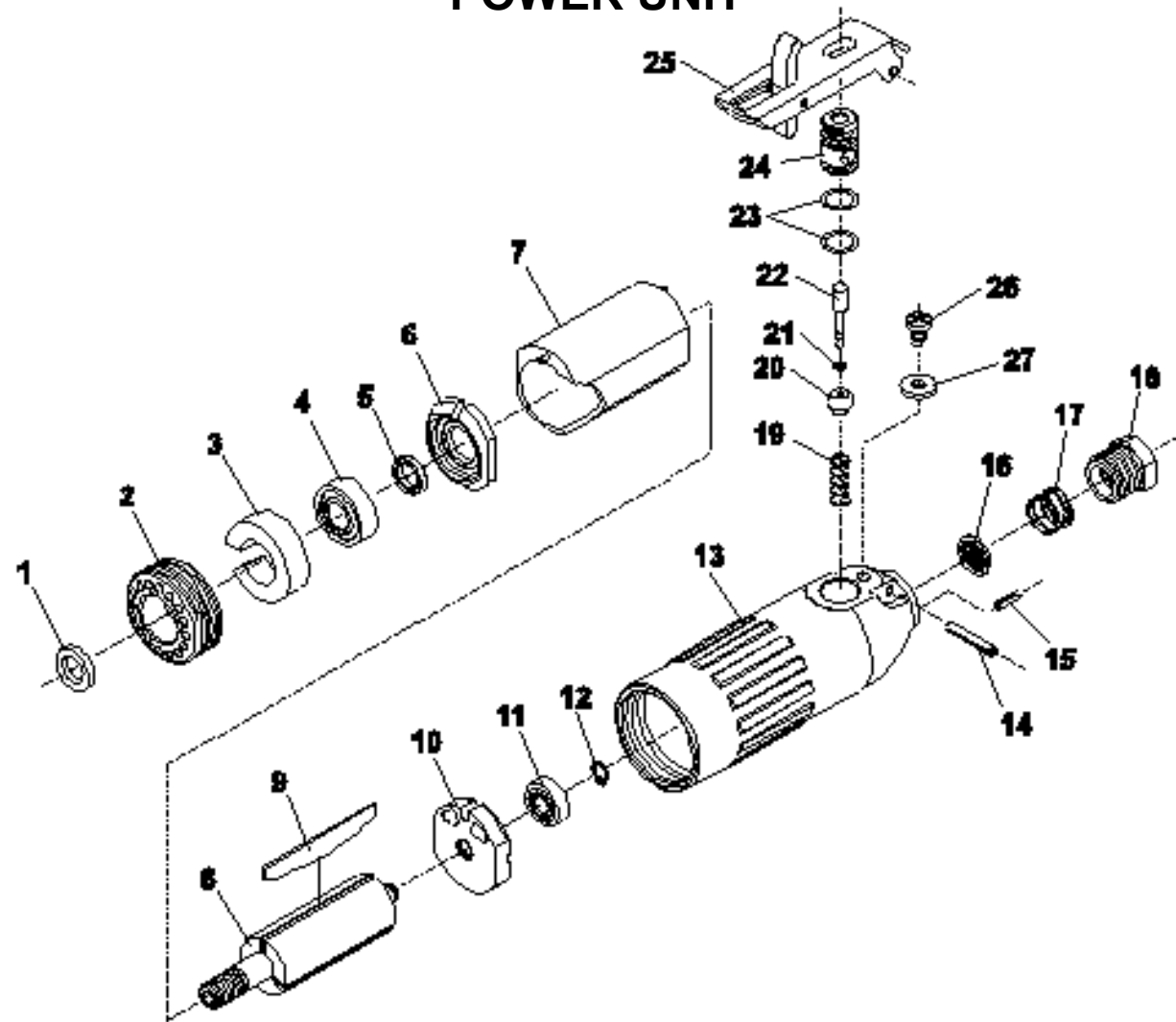


Fig. No.	Part No.	Description
1.	25680	Washer (1953HP, 1954HP)
	44122	Washer (1955HP)
2.	64065	Retainer
	64191	Retainer (1954HPEXT, 1955HPEXT, 1956HPEXT)
3.	04046	Pad—Silencer (Not used on 1954HPEXT, 1955HPEXT, 1956HPEXT)
4.	10257	Bearing—Ball
5.	44488	Spacer—Rotor
6.	64059	End Plate—Front
7.	64057	Cylinder
	64108A	Cylinder (1956HP, 1956HPEXT)
	65916	Cylinder (1954HPSC)
8.	64058	Rotor—3 Slot
	64185	Rotor—5 Slot (1956HP, 1956HPEXT, 1954HPSC)
9.	63527	Vane—Rotor (Set of 3)
	63192	Vane—Rotor (Set of 5)(1956HP, 1956HPEXT)

Fig. No.	Part No.	Description
10.	10552	End Plate—Rear
11.	10253	Bearing—Ball
12.	21491	Ring—Retaining
13.	12774	Housing (Includes Fig. 15)
14.	30362	Pin—Roll (1/8" x 3/16")
15.	30235	Pin—Roll (3/32" x 3/8")
16.	30462	Screen
17.	21417	Spring
18.	44100	Bushing—Reducing
19.	21372	Spring
20.	04205	Valve
21.	25957	Washer
22.	34900	Valve—Plunger
23.	14290	Ring—"O" (2)*
24.	64064	Body—Valve
25.	63514	Ass'y—Lever Lock
26.	06650	Screw—Phil. Pan Hd. #8 x 5/16"
27.	25196	Washer

*Order Quantity As Needed

PARTS LIST FOR DIE GRINDERS

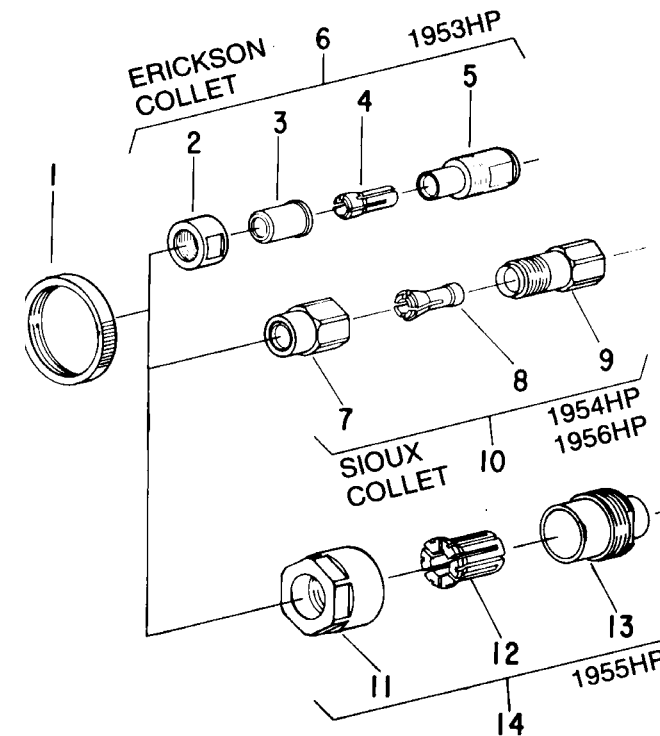


Fig. No.	Part No.	Description
1.	44537	Ring—Thread Cover
2.	21104	Nut—Collet
3.	21105	Piece—Nose
4.	21100	Collet—1/4"
	21101	Collet—3/16"
	21102	Collet—1/8"
5.	21103	Body—Collet
6.	43348	Chuck—1/4" Complete Collet
	43346	Chuck—1/8" Complete Collet
	43347	Chuck—3/16" Complete Collet
7.	21097	Nut—Collet
	44440	Collet—1/4"
	44522	Collet—1/8"
	44523	Collet—3/16"
9.	21096	Body—Collet
10.	43340	Chuck—1/4" Complete Collet
	43342	Chuck—1/8" Complete Collet
	43341	Chuck—3/16" Complete Collet
11.	21138	Nut—Collet
12.	21125	Collet—3/8"
13.	21140	Body—Collet
14.	63577	Chuck—3/8" Complete Collet

WRENCHES

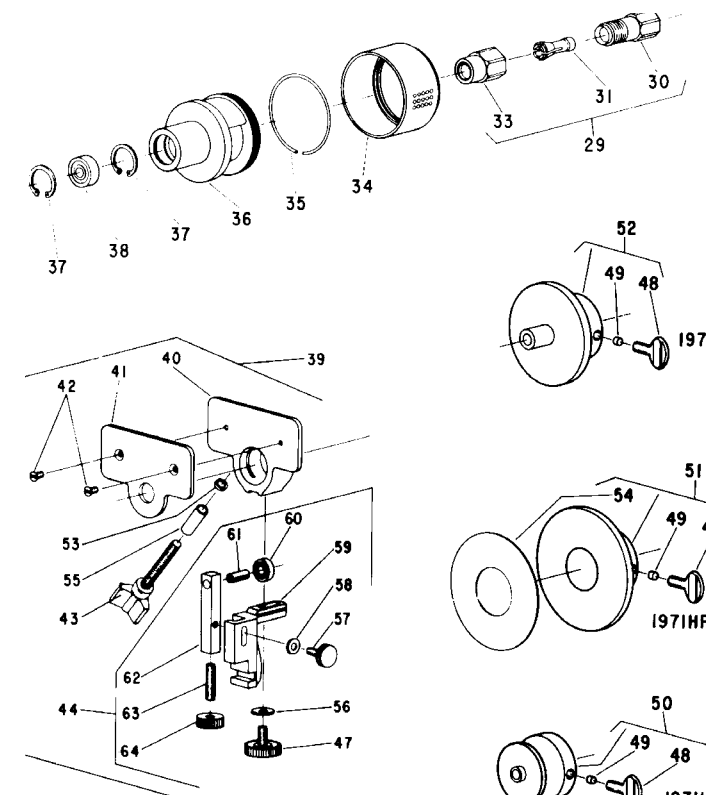
30465	Wrench 9/16" (1953HP, 1954HP, & 1956HP)
30466	Wrench 9/16" (1953HP, 1954HP, & 1956HP)
25480	Wrench 7/8" (1955HP)
40149	Wrench 1 1/16" (1955HP)

Fig. Part

No.	No.	Description
29.	43340	Chuck—1/4" Collet Complete
30.	21096	Body—Collet
31.	44440	Collet—1/4"
33.	21097	Nut—Collet
34.	54184	Cover
35.	21770	Retainer
36.	12366	Adapter—Laminate Trimmer
37.	21540	Ring—Retaining (2)*
38.	10270	Bearing—Ball
39.	1991	Ass'y—Laminate Trimmer Base Complete
40.	11414	Base—Laminate Trimmer
41.	14102	Pad
42.	06181	Screw—Flat Hd. (2)*
43.	65648	Knob—Clamping (Includes Fig. 55)
44.	63562	Ass'y—Support & Adjusting Guide
47.	04054	Knob—Locking (Includes Fig. 56)
48.	08236	Screw—Thumb
49.	14103	Plug—Locking
50.	1994	Ass'y—Template Guide-2" Complete
51.	1992	Ass'y—Router Base Complete
52.	1993	Ass'y—Template Guide-3" Complete
53.	09748	Washer—Lock 1/4"
54.	14108	Cover—Protector
55.	64135	Spacer
56.	35118	Washer
57.	04053	Knob—Aligner
58.	35234	Washer
59.	11601	Support—Guide
60.	10927	Bearing—Ball
61.	30179	Pin—Roll
62.	64119	Guide—Adjusting (Includes Figs. 60, 61, & 63)
63.	08006	Screw—Soc. Hd. Cup Pt. Set
64.	64120	Knob—Adjusting

*Order Quantity As Needed

PARTS LIST FOR 1971HP, 1971HPA, 1971HPB, 1971HPC LAMINATE TRIMMER



30465	Wrench—9/16"
30466	Wrench—11/16"

PARTS LIST FOR 1954HPEXT, 1955HPEXT, 1956HPEXT DIE GRINDER EXTENSION

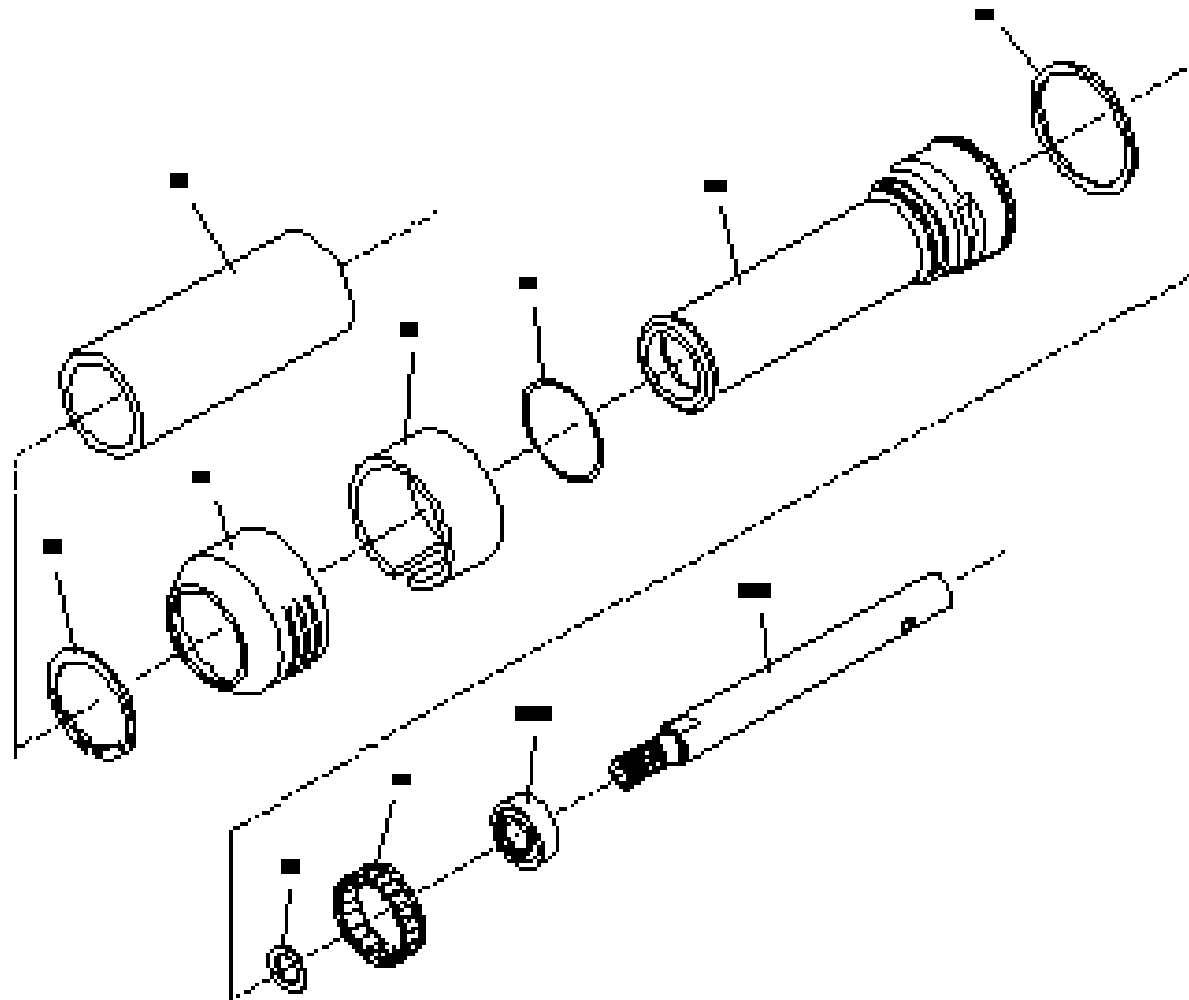


Fig. No.	Part No.	Description
1.	04335	Sleeve
2.	21830	Ring—Retaining
3.	64190	Deflector
4.	64195	Pad—Silencer
5.	04336	Ring—"O"
6.	64192	Housing (Front)(Includes Fig. 9)
7.	64189	Washer
8.	25680	Washer
*9.	65514	Ring—Tolerance (New Style)
10.	10257	Bearing—Ball
11.	64193	Extension—Spindle

*To service early tools with 21543 retaining ring and 64194 tolerance ring, order 64192 housing which includes new tolerance ring 65514.

SERVICE INSTRUCTIONS FOR 1954HPEXT, 1955HPEXT, 1956HPEXT

Disassembly of Extension

1. Remove rubber cover (04335).
2. Remove outer snap ring (21097), deflector (64190), and silencer pad (64195).
3. Remove collet nut (21097) and collet (44440).
4. Unscrew the collet body (21096) and washer (25680) by placing a pin thru the air exhaust slots on the housing extension (64192) and the hole in the spindle extension (64193).
5. Unscrew housing (64192).
6. Remove the spindle (64193) and washer (25680) by using the 7/16" flats on the shaft and a 7/32" hex wrench at least 6 1/2" long, inserted into the shaft and engaging the rotor (64058).
7. Press the bearing (10257) off of the spindle (64193). Support the bearing by the inner race only, while pressing to prevent brinelling the bearing.

Assembly of Extension

1. Install the spindle (64193) and washer (25680).
2. Install housing (64192), washer (64189), and tolerance ring (65514).
3. Press the bearing (10257) onto the spindle and into the housing by pushing only on the inner race until it bottoms onto the spindle.
4. Replace the collet body (21096) and washer (25680). Use a pin to lock the spindle while tightening the collet body.
5. Check for free rotation of the spindle. If it does not turn freely, tap the nose of rear of the tool with a soft mallet to free up the spindle.
6. Replace the remaining parts in the reverse order that they were remove.



Instructions Laminate Trimmer Model 1971HP

The SIOUX Air Laminate Trimmer is a very versatile, small, powerful routing tool which will add the professional touch to your laminate trimming and provide a very effective router for close in work areas where a bulky sized router would be impractical.

Excellent tool adjustments are available to aid you in doing precision work. It does require accurate set up and some practice to turn out quality products for which this tool was designed.

For best results, the direction of the tool travel is generally from left to right. It is recommended that movement be counterclockwise on outside curves and clockwise on inside curves. The tool spindle rotates clockwise.

Laminated Plastics, Phenolics and similar bonded laminates are much too hard to be effectively shaped by ordinary tools. This trimmer with appropriate carbide tipped bits will enable you to professionally trim almost any shape of material with a hard surface top and edge laminate of your choice.

CHANGING CUTTING BITS

1. Disconnect tool from air line.
2. Remove air deflector by twisting and pushing deflector towards on-off valve. This allows wrench access to collet.
3. Hold collet stationary with a 9/16 wrench. Loosen collet retaining nut with 11/16 wrench.
4. Insert bit thru support bearing into collet to desired depth. Tighten collet securely. Replace exhaust deflector.

ADJUSTMENTS

1. Base plate may be adjusted to expose desired length of cutter edge by loosening large knob.
2. Distance from guide tip to base plate may be changed by adjusting guide tip supporting bracket.
3. Cutting depth is set by loosening thumb screw and adjusting guide tip in or out with respect to cutter.

SAFE OPERATIONS MAKES GOOD SENSE

1. Disconnect tool from air line when changing cutting bits.
2. Keep your fingers and hands away from the revolving cutter.
3. Use sharp cutting bits and do not subject carbide bits to shock loading.
4. Tighten securely and check frequently all adjustable features to prevent accidents or work spoilage.

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This pdf incorporates the following model numbers:

1953HP, 1954HP, 1954HPEXT, 1954HPSC, 1955HP, 1955HPEXT, 1956HP, 1956HPEXT,
1971HP, 1971HPA, 1971HPB, 1971HPC