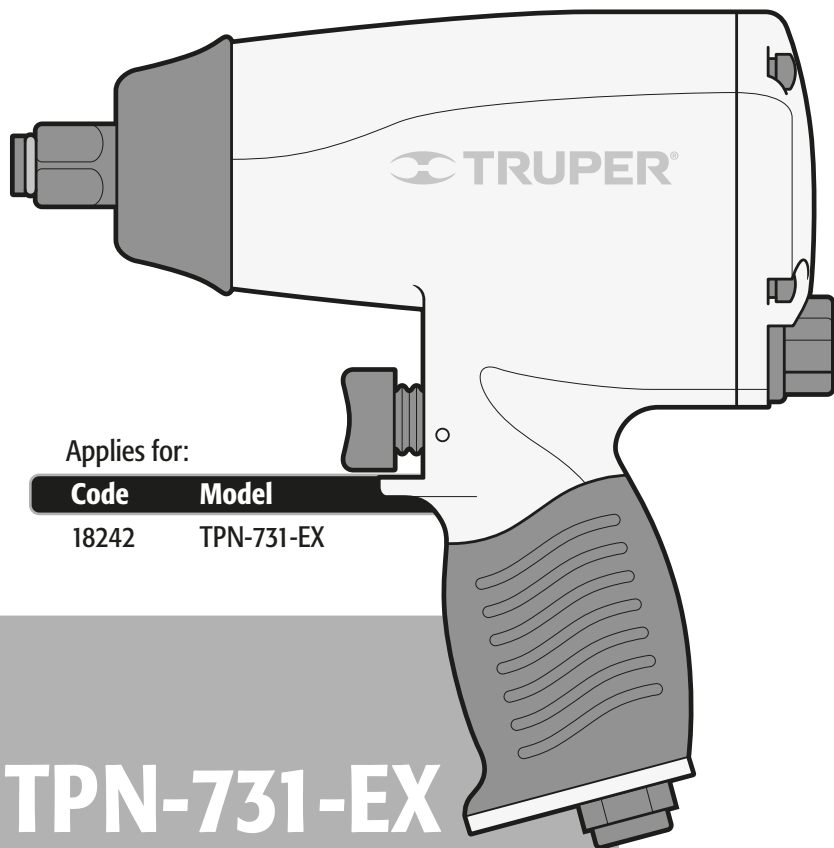


Manual

# Air impact wrench

1/2"



Applies for:

Code	Model
18242	TPN-731-EX

## TPN-731-EX

 **WARNING**



Use oil continuously and dosed to lubricate the tool.

 **CAUTION**



Read this manual thoroughly before using the tool.



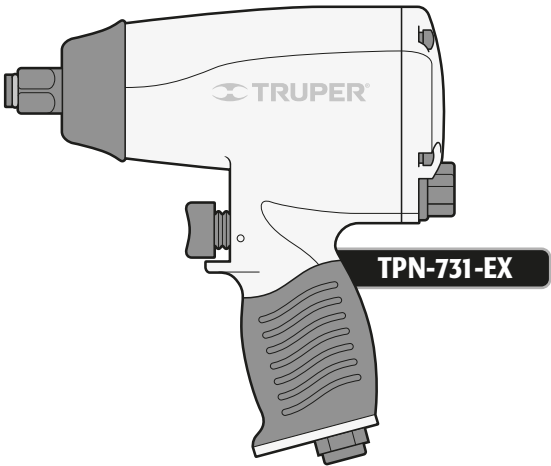
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 **CAUTION**

To gain the best performance of the tool, prolong the duty life, make the Warranty valid if necessary, and to avoid hazards of fatal injuries please read and understand this Manual before using the tool.

Keep this manual for future references.

The illustrations in this manual are for reference only. They might be different from the real tool.



# Technical Data



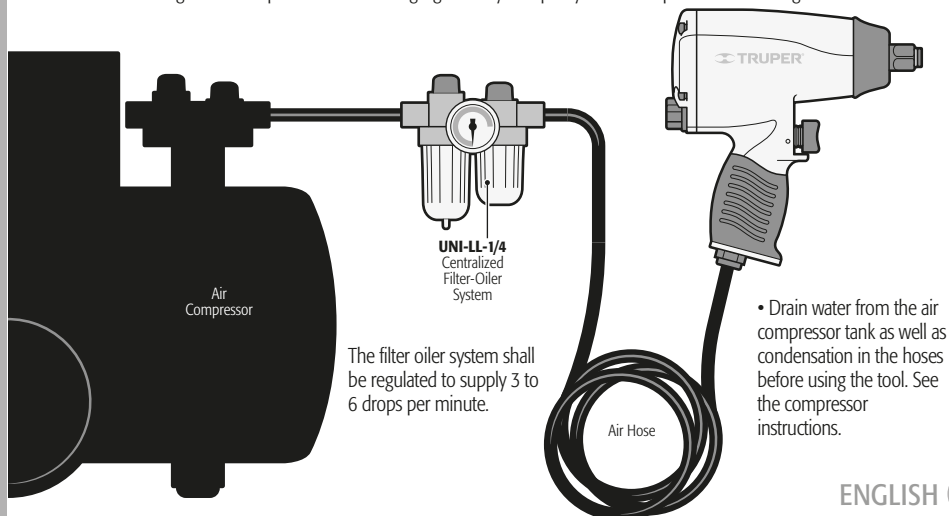
## TPN-731-EX

Code	18242
Description	Air impact wrench
Impact Mechanism	Rocking Dog
Box Impeller	1/2"
Screws Capacity	5/8"
Maximum Torque	250 lb-ft
Air Ejection	Below
Noise Level	85 dB
Vibration	> 2.5 m/s <sup>2</sup>
Free speed	6 500 RPM
Blows per minute	1 100 bpm
Weight	4.6 lb
Total Length	7-3/8"
Air Pressure	90 PSI
Air Consumption	4 CFM
Air Inlet Connection	1/4 NPT
Hose Inside Diameter	3/8"

**CAUTION** Please consider the increase in pressure in the line or the hose inside diameter to compensate the use of too long hoses (more than 26.2 ft). The hose minimum inside diameter shall be 3/8" and the connectors shall be 1/4" NPT. Use the right size and good quality couplers and accessories.

## Filtering and Lubrication Requirements

**CAUTION** Dust, water and lack of oil specific for pneumatic tools are the main cause of potential malfunction of the tool. Setting up a **TRUPER** Brand **UNI-LL-1/4** centralized filter-oiler system is recommended. This system ensures lubrication reducing oil consumption 80% increasing significantly the quality of air the operator is breathing.



**Keep your work area clean, tidy and well lit.**

**CAUTION** Cluttered and dark areas may cause accidents.



**Never use the tool in explosive areas or in the presence of flammable liquids or with no ventilation.**

**DANGER** Sparks the tool generates could trigger an explosion or start a fire.



**Keep children and passersby at a safe distance while operating the tool.**

**WARNING** Distractions can cause losing control and cause accidents.



**Avoid making contact with power lines and circuits.**

**DANGER** Find and avoid power lines and circuits, especially hidden wiring as well as any grounded object.



**Stay alert, use care and common sense.**

**CAUTION** Familiarity with the tool operation could lead to distractions while using it. It could cause accidents.



**Refrain from using the tool if tired or under the influence of drugs, alcohol or medication.**

**DANGER** Being momentarily distracted while using the tool could cause severe personal injury.



**Operate the tool with guards and protection devices in place and in good working condition.**

**WARNING** Failure to comply with this warning is a hazard of severe personal injury.



**Securely fasten and support the work piece.**

**CAUTION** Use brackets and a stable work surface.

**Never force the tool.**

**CAUTION** Working within the tool's working design assures a better and safer job.



**Keep the tool in a safe place and out of the reach of children.**

**WARNING** Power tools are dangerous to inexperienced people.



**Wear proper clothes.**

**WARNING** Loose clothes, jewelry or long hair could get caught in the mobile parts.



**Keep hands away from rotating and/or mobile parts.**

**WARNING** Failure to comply with this warning is a hazard of severe personal injuries or crushing.



**Wear adequate protective safety accessories.**

**CAUTION** Wear eye protection, dust mask, non-skid safety shoes, helmet and ear plugs. In normal conditions, the risk of injury is reduced.



**Unplug the air hose from the tool before carrying out maintenance or replacing accessories.**

**WARNING** Prevent accidental startups that cause accidents.



**Refrain from operating the tool if the switch is not working or is not properly assembled.**

**WARNING** Failure to comply with this warning is a hazard of personal injury. Immediately send it to a TRUPER® Authorized Service Center.



**Do not overreach.**

**CAUTION** Good balance and support lead to better controlling the tool in unexpected situations.



**Never pull the air hose.**

**WARNING** Do not use it to carry or unplug the tool from the air outlet. Damaged or tangled hoses may burst and project residues towards the operator.



**Prevent unintentionally starting the tool.**

**WARNING** Double-check the motor is OFF before lubricating, setting up accessories or carry out maintenance.



**Remove brackets before turning on the tool.**

**DANGER** Additional tools or vices installed in a rotating part could cause severe personal injury.



**Double-check maintenance and good working conditions before using the tool.**

**CAUTION** Carefully check mobile parts, alignment and assembly. Do it periodically. Look for any damaged element or parts not working properly. Repair immediately in a TRUPER® Authorized Service Center.



**Accessories.**

**CAUTION** Use only accessories or spare parts indicated in this Manual or certified by TRUPER.



**Never leave a running tool unattended.**

**CAUTION** Turn off and disconnect tool after using. Set it in a safe position to avoid severe injury.

# Risk Control When Using Pneumatic Tools



## Risk of injury in head and eyes



**⚠ WARNING** • Compressed air out of pneumatic equipment may be dangerous. Objects like brackets, burrs, splinters, dust and other residues may be impelled towards head and eyes due to high speed of the air flow. The air flow itself can only injure soft tissue such as eyes, ears, etc.

**⚠ CAUTION** • The tool attachments may get lose or break and project particles towards the operator or other operators in the work area.

## To prevent head and eyes injuries

- Always, when operating pneumatic equipment wear protection glasses in compliance with the ANSI Z87.1 Standard. As additional protection, wear a mask.
- Never aim the air flow towards people or animals.
- Disconnect the air hose from the tool when not in use.
- Never set a tool unattended when connected to the air outlet.
- Before using the tool verify all the parts and accessories are perfectly secured.



## Risk of explosion



**⚠ WARNING** • Incorrect handling of pressure in pneumatic equipment may cause an explosion causing severe injuries.

## To prevent explosions

- Before using the tool double check the compressed air source is regulated to the tool specified pressure and must not exceed 200 PSI.

## Risk of hearing loss



**⚠ WARNING** • Being exposed long periods of time to noise pneumatic tools produce may damage hearing permanently causing hearing loss.

## To prevent hearing loss

- Always, when operating pneumatic equipment wear hearing protection in compliance with the ANSI S3.19 Standard



## Risk of inhaling particles



**⚠ WARNING** • Abrasive tools like grinders, sanders and cutting tools generate dust and particles that damage the lungs and respiratory system.

- Some materials like resin or adhesive are made with chemicals and the vapors emitted may cause serious damage if the operator is exposed for long periods of time.

## To prevent inhaling particles

- Always wear a face mask or breathing device when operating these types of tools.
- Always work in a clean, well ventilated area.



## Risk of electric shock



**⚠ WARNING** • Pneumatic tools do not have electric insulation. If during the operation, the tool makes contact with a source of electricity, the energy will be conducted to the operator causing a fatal electrocution.

## To prevent electric shock

- Never use pneumatic tools to work energized electric wiring.
- Before operating the tool find the possible hidden wiring in the work zone to prevent making contact.
- Avoid contact with grounded surfaces like pipes, radiators or refrigerators. The risk of electrocution increases if the operator's body gets grounded.

## Risk of damaging the tool



**⚠ WARNING** • Pneumatic tools forced beyond the capacity and lacking of adequate lubrication or used to loosen rusted nuts (with impact guns) will get damaged and make the Warranty void.

## To prevent damaging the tool

- Keep the tool duly lubricated.
- Do not force the tool.
- Apply "loose it all" liquid to rusted nuts or lugs before trying to loosen with the tool (impact gun).

## Risk of injuries



**⚠ WARNING** • Damaged hoses may burst and cause serious injuries or deafness.

• Pneumatic tools connected to the compressed air source, if operated by untrained staff or underage people, will cause severe injuries.

• The compressed air used in pneumatic equipment may be dangerous. Objects like vices, burrs, splinters, dust and other residues may be impelled by the high-speed air flow towards the operator or other people in the work area.


• Using inflation nozzles to clean or torch blowing may cause severe injuries.

• Tools and accessories not suitable, damaged or low quality like grinding discs, chisels, contacts, drills, brad nailer, staplers, etc., may shoot out during the operation and project particles causing severe injuries.

• Brackets may get lose and be projected causing severe injuries or damage to property.

• Tools that accidentally start may cause severe injuries.

• Tools and accessories with no maintenance may cause severe injuries.

• Tools using accessories without  **TRUPER®** certification may cause severe injuries.

• Damaged or banded tools may cause severe injuries.

## To prevent injuries

- Do not abuse the hose or the connectors.
- Keep the hose away from sharp or abrasive edges.
- Unplug the hose when setting up accessories like grinding discs or bits.
- Never use the hose to carry the tool.
- Never pull the hose to unplug it.
- Do not expose the hose to heat, oil or solvents.
- Before operating the tool, verify the hoses are not damaged.

• Unplug the air hose when the tool is not in use. Store the tool in a safe place away from children or untrained people. Keep children and untrained people away from the work area.

• Keep the work area clean, tidy and with good lighting.

• Remove any wrench or plier from the tool before operating.

• Do not use inflation nozzles to clean or to torch blowing.


• Use only parts, vices and accessories recommended by  **TRUPER®**.

• Double check all connections are correctly installed.

- Never carry the tool by the trigger.
- Disconnect the air hose out from the tool when not in use.
- Never leave the tool unattended when connected to the air outlet.

• Keep the tool handle clean and dry, free of oil or grease.

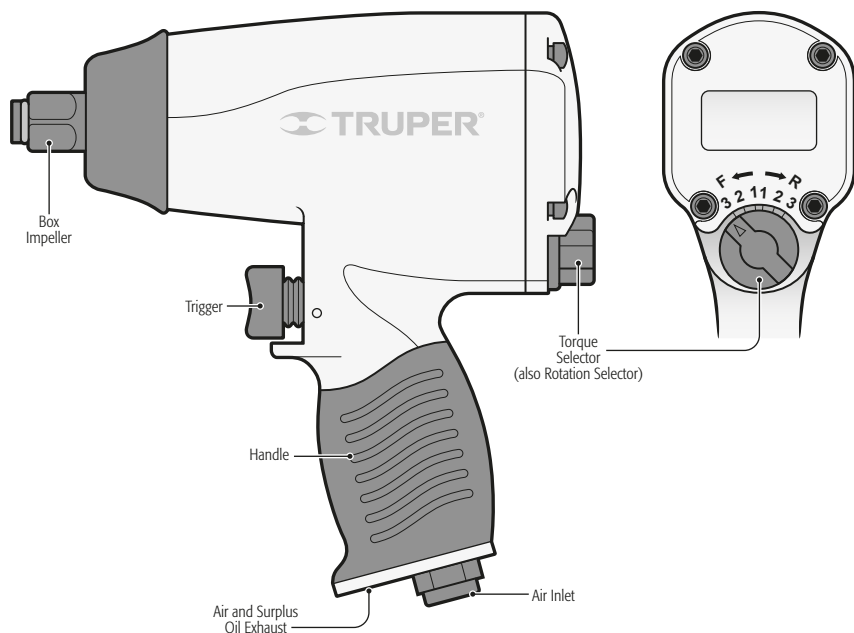
• Keep tools clean. A meticulously cleaned and oiled tool delivers a more effective performance and is easier to control.

• Any type of repair can only be carried out in a  **TRUPER®** Authorized Service Center.

• Use always accessories matching the tool speed.

• Use only  **TRUPER®** certified accessories.


• Do not use damaged or banded tools.



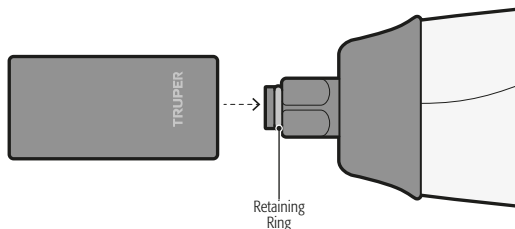
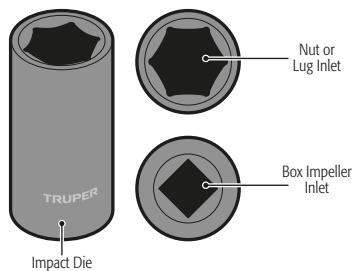
## Assembly

### Die Set Up

- Disconnect the tool from the air outlet before replacing the die.
- Select the die you need and set it in the box impeller.

- Always use impact dies with this tool. Do not use dies for hand tools. Consult the  **TRUPER** catalogue to learn about our accessories variety.
- Use 1/2" dies for box impellers.
- Using adaptors for other sizes are not recommended. Use only if strictly necessary.
- If the die has orifices always use rubber rings and steel tips when setting it into de box impeller.
- When the box impeller is made with a retaining ring, verify it is in good repair. If damaged, replace immediately.

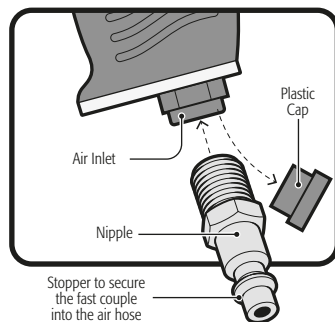
**⚠ WARNING** • When a die has not been secured and adjusted as indicated, it can shoot out and injure the operator.



## Air Outlet Connection

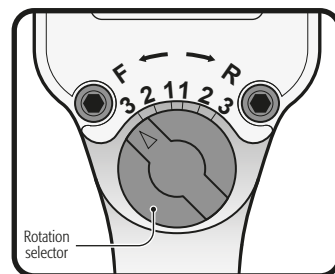
**⚠ CAUTION** • We recommend using fast couple hoses to easily get them connected to the included nipple. This way it can be connected and disconnected tools fast and interchange easily.

- Remove the plastic cap covering the air inlet in the handle base.
- Screw the included nipple to the air inlet
- Connect the air hose via the quick-connect nipple.



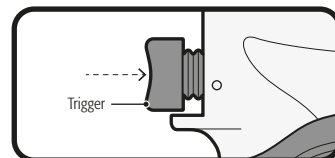
## Rotation Direction and Torque Selection

- The direction of rotation is adjusted with the torque selector.
- To tighten a nut or lug, push the rotation selector and turn clockwise (**F**). To loosen, push the rotation selector and turn counter-clockwise (**R**).
- To select the torque and avoid overtightening a nut or stud, turn the knob to the left (**F**) or right (**R**) to the desired torque level.
- It is recommended to use the maximum torque, in case of not having a torque wrench to verify the proper torque.
- The torque value may vary depending on the size of the air compressor and the amount of cubic feet (CFM) of air delivered.



## Turning ON



- Turn the air compressor ON and allow it to get filled.
- Regulate the air compressor outlet pressure to 90 PSI to 110 PSI.
- **⚠ WARNING** • The tool operates with this pressure range. If operating in a higher pressure range the tool useful life will be shorter.
- Let run some air through the hose and coupling to verify both are clean before connecting into the tool.
- Select the adequate rotation direction and torque.
- Press the trigger so that the die can rotate.
- Release the trigger to stop the die.




## Operation


- Set the die in the nut or lug you want to loosen or tighten.
- Do not try to make contact with the nut or lug with the die moving. Do not press the trigger unless the nut or lug is set correctly inside the die.
- Apply firm and constant pressure without forcing the tool. Otherwise it can be damaged.

## Service

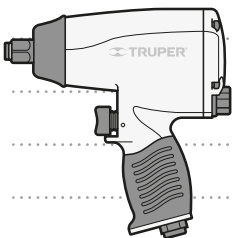
- Servicing the tool shall be carried out every 3 months only in a  **TRUPER**® Authorized Service Center. Service and maintenance carried out by not certified people may be dangerous and can cause severe personal injuries as well as making the product Warranty void.
- Malfunction in the tool caused by not using the recommended dose of lubrication, or not complying with this Instructions, or repairs carried out by people not certified by  **TRUPER**® will not be covered with the Warranty. We reserve the right to carry out technical improvements without notice.

## Lubrication

- Pneumatic tools need constant lubrication along their useful life and during the operation. The compressed air needed in the tool to run carry humidity which could oxidize the motor and bearing in the tool. To prevent this possibility, it is necessary to constantly deliver lubricating oil through a  **TRUPER**® Brand **UNI-IL-1/4** centralized filter-oiler system installed between the air compressor and the tool.

 **WARNING** • Any excess of oil in the motor is immediately expelled through the exceeding oil escape. Keep the escape free of obstructions and never point it towards people or objects.

- If not using the tool for long periods of time, it shall need to be lubricated with care.
- After 60 hours' operation, the tool mechanism need a little greasing. Excessive grease may diminish power.



In the event of any problem contacting a  **TRUPER** Authorized Service Center, please see our webpage [www.truper.com](http://www.truper.com) to get an updated list, or call our toll-free numbers **800 690-6990** or **800 018-7873** to get information about the nearest Service Center.

**AGUASCALIENTES** **DE TODO PARA LA CONSTRUCCIÓN**  
GRAL. BARRAGÁN #1201, COL. GREMIAL, C.P. 20030,  
AGUASCALIENTES, AGS. TEL.: 449 994 0537

**BAJA CALIFORNIA** **SUCURSAL TIJUANA**  
AV. LA ENCANTADA, LOTE #5, PARQUE INDUSTRIAL EL  
FLORIDO II, C.P. 22244, TIJUANA, B.C.  
TEL.: 664 969 5100

**BAJA CALIFORNIA SUR** **FIX FERRETERÍAS**  
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**CAMPECHE** **TORNILLERÍA Y FERRETERÍA AAA**  
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C.P. 24080 CAMPECHE, CAMP. TEL.: 981 815 2808

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JILOTEPEC, JILOTEPEC, EDO. DE MÉX. C.P. 54257  
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CHILPANCIÑO, GRO. TEL.: 747 478 5793

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LIBERTAD ORIENTE #304 LOCAL 50, INTERIOR DE PASAJE  
ROBLEDO, COL. CENTRO, C.P. 43600, TULANCINGO,  
HGO. TEL.: 775 753 6615 / 775 753 6616

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VALLE, C.P.: 45655, TLAJOMULCO DE ZUÑIGA, JAL.  
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CENTRO, C.P. 62740, CUAUTLA, MOR.  
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**NAYARIT** **HERRAMIENTAS DE TEPIC**  
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**NUEVO LEÓN** **SUCURSAL MONTERREY**  
CARRETERA LAREDO #300, 1B MONTERREY PARKS,  
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NUEVO LEÓN, TEL.: 81 8352 8791 / 81 8352 8790

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TUXTEPEC, OAX. TEL.: 287 106 5092

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MORA, C.P. 80143, CULIACÁN, SIN.  
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2A ETAPA, C.P. 86010, VILLAHERMOSA, TAB.  
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RODRÍGUEZ, FRACC. REYNOSA, C.P. 88780, REYNOSA,  
TAMS. TEL.: 899 926 7552

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CALLE 33 #600 Y 602, LOCALIDAD ITZINCAB Y MULSA,  
MPIO. UMAN, C.P. 97390, MÉRIDA, YUC.  
TEL.: 999 912 2451

**Code**

19372

**Model**

TPN-731EK

**Brand** **TRUPER®**

**Warranty.** Duration: 2 years. Coverage: parts, components and workmanship against manufacturing or operating defects, except if used under conditions other than normal; when it was not operated in accordance with the instructive; was altered or repaired by personnel not authorized by **Truper®**. To make the warranty valid, present the product, stamped policy or invoice or receipt or voucher, in the establishment where you bought it or in Corregidora 35, Centro, Cuauhtémoc, CDMX, 06060, where you can also purchase parts, components, consumables and accessories. It includes the costs of transportation of the product that derive from its fulfillment of its service network. . Phone number **800-018-7873**. Made in China. Imported by **Truper, S.A. de C.V.** Parque Industrial 1, Parque Industrial Jilotepec, Jilotepec, Edo. de Méx. C.P. 54257, Phone number 761 782 9100.

**2  
YEARS**

Stamp of the business. Delivery date: