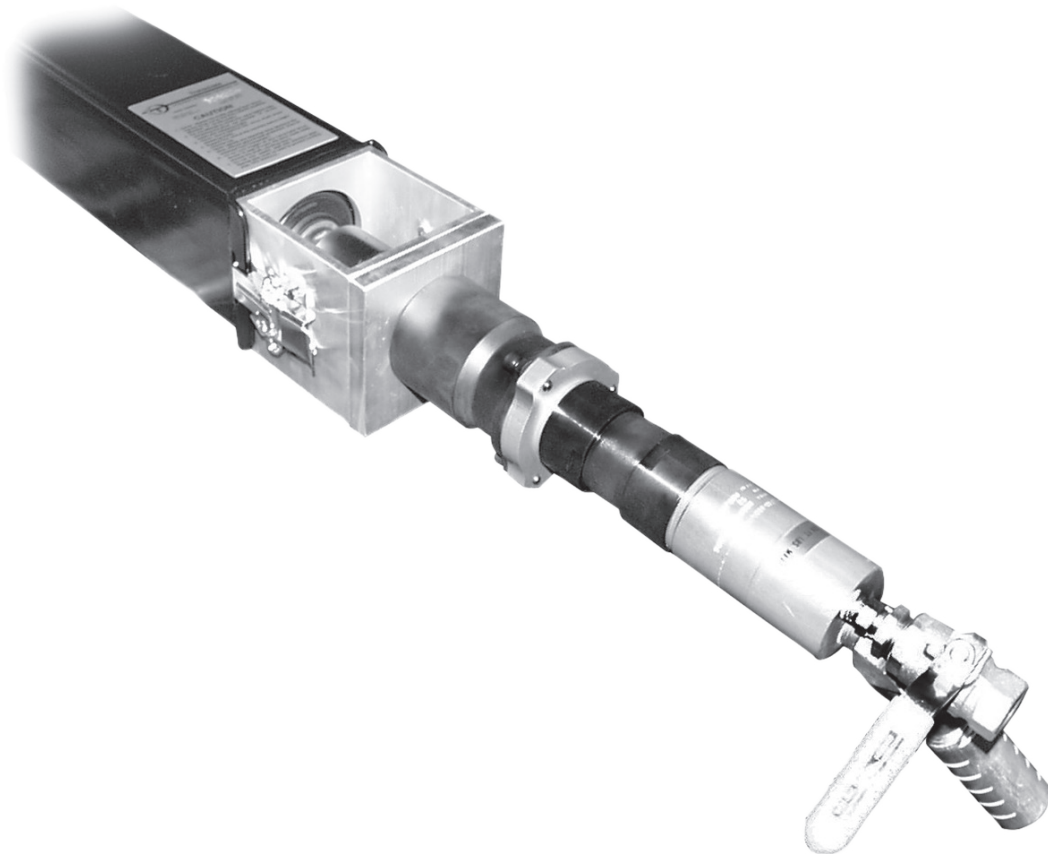




## OPERATING MANUAL

# AIR DRIVE

371-00



**Thank you for your purchase of the Transmate Air Power Drive.**

This drive will give you years of service if the instructions below are followed. Please read the accompanying Ingersoll Rand Air Motor instructions for care and maintenance of the air motor. Clean air and proper motor lubrication are essential for longevity of the air motor. If you have any questions, please call us at 1-800-426-9341



**WARNING**



If the following key points are NOT followed this air motor will be damaged.  
Please read the cover sheet and IR motor manual before using this drive.

- Use only clean, dry, lubricated air to drive the motor. The use of an FRL or equivalent air quality system is essential to ensure continued performance and avoid costly maintenance.
- Air tool oil in the air supply is essential. Make sure air oil lubricator is filled with air tool oil.
- Locate the air oil lubricator as close to the drive as possible.
- Clean air is essential. Make sure your filters are clean.
- Sand or dirt entering the air motor will destroy it. Make sure no sand or dirt enters this motor.
- If the motor seizes up, do not attempt to disassemble or repair the Air Drive Motor yourself. Call Romac for assistance.

Please follow this warning and read the manual.

**THE TRANSMATE AIR POWER DRIVE (371-00)**

for use with the

**TapMate Drilling Machine (350-00)**

06/25/20 Revision 4.0

The Air Drive is driven by an external compressor with the following minimum requirements:

- Air Output: 36 CFM (cubic feet per minute) minimum
- Pressure Output: 90 psi. (pounds per square inch) Max at Air Drive inlet

**\* Please note that pressure less than 90 psi will severely effect the power of the air motor and its ability to complete the cut. The use of an FRL or equivalent Air Quality System is critical to maintaining proper pressure.**

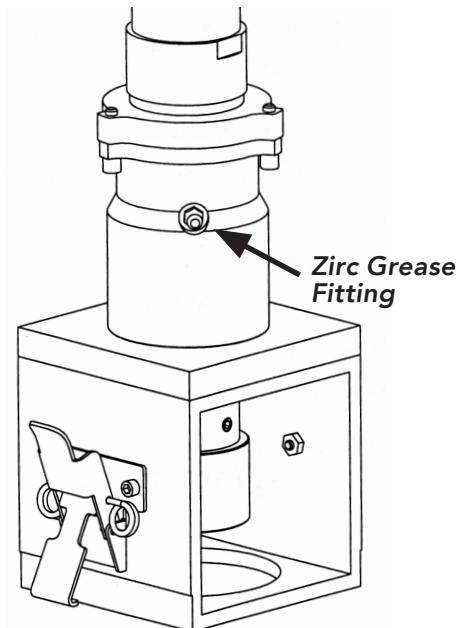
**The Air Drive Specifications (Model M007RHR374BR):**

- Horsepower: 0.76 hp
- Weight: 11 lbs (approx)

**LUBRICATING THE AIR DRIVE MOTOR**

After each (40) hours of operation inject 1.5 cc of Ingersoll Rand No. 28 grease at the Zirc fitting as shown. Do not grease excessively.

After each (8) hours of continuous operation add ten drops of Ingersoll Rand No. 10 oil to the grease fitting location (this keeps the grease from drying out).



**AIR QUALITY**

Use Ingersoll-Rand No. 10 Air Tool Oil or equivalent Air Tool Oil for air lubrication. Lubrication is necessary to prevent rust on all moving parts. Excessive moisture in the air line may cause rust or ice to form in the Muffler when air expands as it passes through the Air Drive Motor. The use of an FRL (Filter- Regulator-Lubricator) or equivalent Air Quality System is critical to prevent damage to the Motor from environmental debris and moisture which requires costly repair.

**SHUTDOWN AND STORAGE PROCEDURE**

1. Shut off the Air Drive Valve and remove the Air Drive from the Drilling Machine.
2. Safely disconnect the air source from the Air Drive Valve.
3. Remove the Muffler from the 45-Degree Street Elbow.
4. Using clean, dry air at low pressure, use an air blow gun to "flush out" condensates, such as water by inserting the nozzle of the Blow Gun into the Air Drive intake thru the Air Drive Valve.

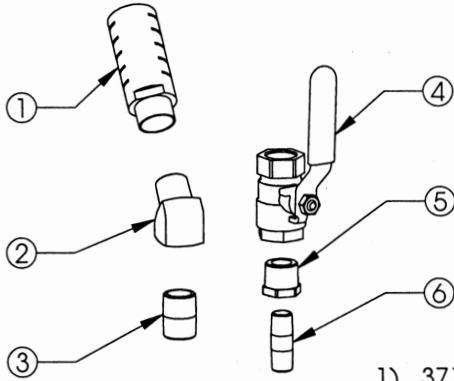
**WARNING: Solid or liquid material exiting the unit can cause eye or skin damage. Keep away from the air stream.**

5. Re-lubricate the air motor with a squirt of Ingersoll-Rand No. 10 Air Tool Oil in the air intake port. Rotate the shaft by hand several times.
6. Replace the Muffler and cap or plug the intake port. The unit is now ready for storage.

**IN THE EVENT THE AIR DRIVE IS SUBMERGED UNDERWATER:**

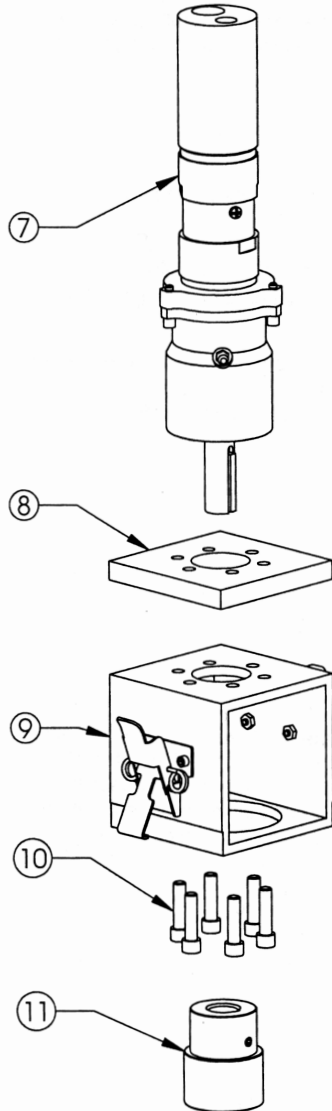
If the Air Drive should be submerged under water continue to run the Air Drive until the unit is lifted out of the water. Do not interrupt or shut off the Air Supply at any point until it is clear of the water as this will help to keep the water from getting into the Air Motor. Once the Air Drive is out of the water, disconnect the hose and pour Ingersoll-Rand No. 10 Air Tool Oil into the air motor then it run for ten minutes. This will help clean the water out of the Air Drive and lubricate all internal parts.

If the Air Drive is left underwater not running or with an interrupted or shut off Air Supply for any length of time call Romac for assistance.

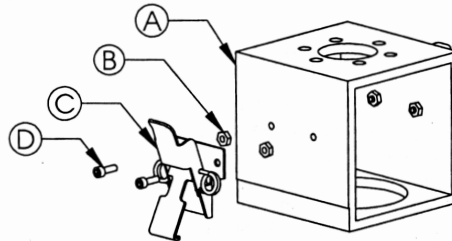


### 371-00 AIR DRIVE

- 1) 371-08 AD SUPER QUIET FLOW METAL PNEUMATIC SILENCER # ASQF-4F
- 2) 371-12 AD BRASS 45 DEG. STREET ELBOW
- 3) 371-09 AD BRASS CLOSE PIPE NIPPLE
- 4) 371-02 AD AIR DRIVE VALVE 1/2 IN. BALL VALVE
- 5) 371-10 AD BRASS PIPE BUSHING
- 6) 371-11 AD BRASS LONG PIPE NIPPLE
- 7) 371-07 AD AIR DRIVE MOTOR  
INGERSOL-RAND M007RHR374BR6
- 8) 371-06 AD AIR DRIVE ADAPTER PLATE
- 9) 371-04 AD AIR DRIVE ADAPTER
- 10) 371-03 AD AIR DRIVE BOLTS,  
5/16 IN.-18 X 1-1/4 IN. SHCS, ALLOY
- 11) 371-05 AD AIR DRIVE COUPLING

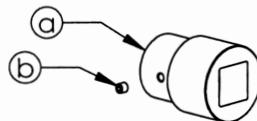


### 371-04 AD AIR DRIVE ADAPTER



- A) 371-04 AIR DRIVE ADAPTER (tube only)
- B) 372-09-02 HD HYDRAULIC ADAPTER LATCH NUT
- C) 372-06-01 HD HYDRAULIC ADAPTER LATCH
- D) 372-09-01 HD HYDRAULIC ADAPTER LATCH BOLT

### 371-05 AD AIR DRIVE COUPLING



- a) 371-05 AD AIR DRIVE COUPLING (only)
- b) 351-51-2 TT,ARBORS & HANDLE SET SCREW