

# ASSEMBLY



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# ASSEMBLY

Combining Efficiency, Reliability and Value...

## Putting it all together

To keep up with the rapidly growing demands of modern assembly applications, Sioux Tools remains on the cutting edge of engineering design. We continue to be innovative in creating new tools to provide faster rundown speeds with exceptional accuracy and consistent torque delivery, combined with ergonomic design for operator comfort and safety.

We build every tool to help assembly operators become more productive. We believe they deserve tools that will help improve their quality of performance and maximize the skills they bring to the job.

## Exclusive Designs

Sioux Tools is the exclusive manufacturer of the Z-handle. This unique feature allows access to tight, hard to reach angles.

## Impact Wrenches

Suitable for general assembly, repair jobs etc. When you require a powerful, lightweight tool, with little reaction force and moderate accuracy. This is the best choice for loosening joints.

## Screwdrivers

Sioux Tools offers a wide range of screwdrivers designed to meet today's fast paced, high output assembly and manufacturing applications.

## Nutrunners

Sioux offers nutrunners that are designed for high volume industrial production. You can choose from free speeds of up to 2200 rpm, and a torque range of up to 600 in lb (68 Nm). These are outstanding tools for fast accurate assembly.

## Assembly Safety

**Broken sockets, bits and adapters can cause injury.**

Proper eye protection must be worn at all times by tool user and bystanders. Use only sockets, bits and adapters made for power tools and that are in good condition. Use only bits and adapters that are in good condition. Keep hands away from sockets, bits and adapters.

**Sudden and unexpected tool movement can cause injury.**

Be sure your body position allows you to have control of the tool at all times. Make sure your footing is secure. Consult manufacturer for proper reaction bar if movement is excessive.

**Tools starting unexpectedly can cause injury.**

Always remove the tool from air supply and activate trigger to bleed air line before making any adjustments, changing accessories, or doing any maintenance or service on the tool.

**Falling tools can cause injury.**

If the tool is used with a balancer or other suspension device, be sure the tool is firmly attached to the device.

## Assembly Principles of Operation

An air motor and planetary reduction gearing are used to drive a clutch spindle, producing torque in a fastener.

The action of the torque creates clamp-load in the assembly.

Motor size (horsepower), gear ratio, and type of clutch determine performance, and are key factors in selecting the appropriate tool for a given application.

Generally equipped with a 1/4" female hexagon spindle that allows inserting a screwdriver bit.

## An Easy Drive Home



Sioux Tools offers a wide range of screwdrivers and nutrunners designed to meet today's fast paced, high output assembly and manufacturing applications. Sioux Tools is able to provide a perfect match for any job requirement. As industries strive to reduce fastener requirements, we work to meet the demand for greater accuracy and precision in fastening performance. The productivity demands for quality and speed, as well as user comfort, convenience and safety make Sioux Tools your number one choice.

## Configurations

Sioux screwdrivers are available in pistol grip, inline, right angle and our exclusive Z-handle configurations. Most screwdriver models offer your choice of Quick Change or Locking Internal Hex spindles. The spring-loaded chuck on the Quick Change

allows for fast, easy bit changes without the need for additional tools or hardware. The slimmer design of the Locking Internal Hex ensures that the bit stays firmly in place until you choose to remove it with the aid of a vise or pliers.

## Reducing Physical Load

We design all our screwdrivers with ergonomics in mind. We help you get the job done with a minimum amount of effort and wear and tear on the operator. By reducing the physical load on the operator, which includes noise and oil mist, productivity will be improved. Sioux Tools offers many benefits including high torque accuracy, low sound levels and ergonomic grips. Fast clutch shutoff reduces reaction force, while the shape reduces the amount of gripping and trigger force required.

## Clutch Selection

**Positive Clutch** – Spindle will not turn with motor until operator exerts forward pressure on spindle engaging the clutch. The clutch ratchets when torque resistance from the fastener overcomes the forward pressure and the jaws begin to cam apart. Torque output of the tool is determined by forward pressure from operator and by the cam angle of the clutch jaws. For wood, sheet metal, and machine screws and lag bolts.

Sioux Tools is the exclusive manufacturer of three different positive clutches; Low, Mid and High torque output. Your choice of clutch allows you to more precisely control the amount of torque exerted on the fastener.

**Stall Drive** – Spindle is coupled directly with the output of the motor. Final torque is reached when resistance of the fastener overcomes the torque output of the motor. Final torque can be influenced by air pressure and/or operator twisting the tool.



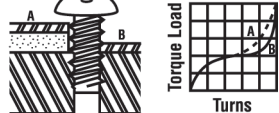



For prevailing torque or soft pull applications involving machine, wood, or self-tapping screws.

**Adjustable Clutch** – Spindle will not turn with motor until operator exerts forward pressure on spindle engaging the clutch. When fastener is tight, clutch will ratchet. Adjusting spring pressure will effect final output torque. Offers consistent torque control with little operator reaction.

**Torque Control** – Motor shuts off automatically when fastener is tight. Adjusting spring pressure changes final output torque for critical torque requirements. Perfect for applications with little or no prevailing torque where final torque is substantially higher than rundown torque.

**Direct Clutch** – Spindle will not turn with motor until operator exerts forward pressure on spindle engaging the clutch. Final torque is reached when resistance of the fastener overcomes the torque output of the motor. Excellent stall type tool when tightening group of fasteners without turning off motor.

### Clutch Selection Guide

Type of Job	Clutch Performance			
	Torque Control	Adjustable	Direct/Stall Drive	Positive Clutch
<p><b>1. Free-Running – Sudden Stop</b></p>  <p>Turns easily until screw head or nut seats against a solid stop. Resistance then builds up suddenly.</p>	Excellent for all size screws.	Good for all size screws. Close torque control is not required.	Good for large or medium nuts or cap screws only.	Fair for all size screws where close torque accuracy is not required.
<p><b>2. Soft Pull-Up</b></p>  <p>Turns easily until screw head or nut seats, then resistance builds up gradually through one or more turns as resilient material compressed.</p>	Excellent for all size screws.	Good for most screws. Close torque control is not required. Slow on large screws with long pull-up.	Good for large and medium size screws. Must be adjusted to run rather slowly for small screws.	Good for small to medium size screws. Requires considerable operator pressure on large screws.
<p><b>3. Self-Tapping in Thick Material</b></p>  <p>Increasing heavy resistance through entire travel until screw head seats. Then either (A) gradual, or (B) sudden final build-up resistance.</p>	Excellent for all size screws. Not suitable if tapping torque exceeds stripping torque.	Good for most screws. With proper operator technique, can be used where tapping torque exceeds stripping torque. Slow on large screws.	Not recommended unless stripping torque is considerably higher than tapping torque.	Good for most size screws where stripping torque is considerably higher than tapping torque. Excellent in non-uniform or misaligned material.
<p><b>4. Sheet Metal Screws</b></p>  <p>Resistance increases rapidly at first, then eases slightly. At the end, it usually builds up suddenly when screw head seats.</p>	Good for all size screws. Not suitable if tapping torque exceeds stripping torque.	Good for most screws. With proper operator technique, can be used where tapping torque exceeds stripping torque.	Not recommended unless stripping torque is considerably higher than tapping torque.	Good for all size screws where stripping torque is considerably higher than tapping torque. Excellent when sheets are frequently misaligned.
<p><b>5. Lock Nuts</b></p>  <p>Starts with heavy resistance that last through entire travel until screw or nut seats. Then either (A) gradual, or (B) sudden further build-up resistance.</p>	Excellent for all size screws.	Good for most screws. Close torque control is not required.	Good for large and medium screws. Must be adjusted to run rather slowly for small screws.	Fair for all size screws.
<p><b>6. Wood Screws</b></p>  <p>Starts with small resistance that steadily increases through entire travel with additional resistance as screw head seats.</p>	Fair for all size screws.	Good for all size screws.	Excellent for large and medium screws. Must be adjusted to run rather slowly for small screws.	Excellent for all size screws.

# Tool Selection Guide

## Considerations for Selecting Screwdrivers

This should be done in a systematic way to ensure no details are overlooked that could have an adverse affect on job function or results. The following are variables that must be considered to ensure proper tool selection.

- What is being assembled?
- What material is involved?
- What type of screw or nut is being driven? What head type?
- What screw size (standard or metric)?
- What U.S. grade or metric class?
- What torque (inch pounds or Newton meters)?
- What torque tolerance (accuracy)?
- What is the run-down torque vs. seating torque?
- What type of joint pull-up (hard, medium, soft)?
- What pull-up conditions (free run-down, sheet metal, wood, or plastic)?
- What is the production rate?
- Are there clearance problems?
- What handle style is required (straight or pistol)?
- Is the tool to be hand held or fixtured?
- What type of clutch?
- Speed required?
- Is there a need for a reversible tool?
- What type of drive (square, 1/4" hex, quick change)?
- How is the application being done now?
- Special consideration?

## What is the size and type of screw or fastener on which the tool will be used?

- No 1 Series Tools** – 2 to 50 in lb of torque. (Fasteners up to 1/4")
- .6 & 1 HP Signature Series Tools** – 5 to 400 in lbs of torque. (Fasteners up to 3/8")
- No 3 Series Tools** – 5 to 50 ft lbs of torque. (Fasteners up to 1/2")

## What kind of application and material will the fastener be used on?

The type of material helps to determine which type of clutch is needed.

### Application & Material Guide

Screw Size				
	Clutch	Free Run Down	Soft Pull-Up	Prevailing Torque
<b>No 8 and Smaller</b>	Adjustable	Excellent	Excellent	Excellent
	Stall	Excellent	Good	Excellent
	Direct	Good	Good	Good
	Positive	Fair	Fair	Good
<b>No 10 and Larger</b>	Adjustable	Good	Fair	Fair
	Stall	Good	Excellent	Excellent
	Direct	Good	Excellent	Excellent
	Positive "P"	Good	Excellent	Excellent
	Positive "PS"	Good	Excellent	Excellent

## What are the torque requirements?

Most air tools share the quality: as the speed increases, the torque decreases. This applies to tools within the same horsepower rating.

- A.** Stall or direct clutch gives the most torque.
- B.** Positive clutch tools are operator influenced.
- C.** Adjustable torque clutches are available on most Sioux fastening tools.
- D.** Torque control is available on No 1

## At what angle or position will the tool be used?

This will determine the style of tool best suited from an ergonomics point of view.

- A.** If the fastener is in a vertical position, a straight or lever style tool will be best.
- B.** If the fastener is in a horizontal position a pistol style tool will be best.
- C.** If the fastener is in a tight or constricted area the "2S" series works well in this application.

## Is reversing necessary?

Most fastening applications are going to require a reversible tool. Keep in mind that in most cases a non-reversing tool will have more torque than a reversible tool.

## Is the application operator influenced or restricted?

- A.** Is the operator male or female? This can be a factor in determining the size of the power tool (weight for example).
- B.** Does the application lend itself to an auto start tool, as in the No 1 series?

## An example of applying these questions to an application would be:

Driving a 2" long wood screw into hardwood with a pilot hole. The fastener is in a horizontal position during assembly. A test with a hand torque wrench indicates a prevailing torque of 80 in lbs, and a failing torque of 120 in lbs.

- 1. 2" long wood screw
- 2. Hard Wood use positive clutch
- 3. SSD10P20PS – 100 in lbs
- 4. Pistol will work best
- 5. Need reversing
- 6. Mostly male workers

# Screwdriver Maintenance



- 1 Tipper valve and valve seat is easily accessible for service
- 2 Slip fit of front end plate bearing allows easy service of the air motor without disturbing the rotor spacing
- 3 Rotor pinion is case hardened to resist wear
- 4 Grease zerk makes it easy to grease the gears without disassembly
- 5 Ring gear is machined into the motor retainer for ease of assembly and disassembly
- 6 Planet gear pins are slip fit for ease of assembly and disassembly
- 7 Interchangeable rotor, cylinder, bearings and end plates. This reduces the number of spare parts tool cribs need to stock

## Guide to Fasteners

### Guide To Fasteners

Screw Type	Standard Nosepieces Available For All Fasteners Shown Below
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#### Wood Screws



#### Machine Screws

\* Standard or Special, depending on the washer diameter.

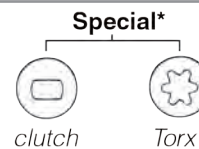
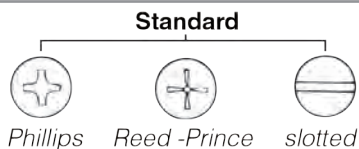


#### Tapping or Sheet Metal Screws



#### Drive Systems

\* Special bits required for Clutch and Torx internal and external. Call factory.



POSITIVE CLUTCH PISTOL GRIP & T-HANDLE SCREWDRIVERS



**Performance:**

Torque: 20 in lb (2.3 Nm) – 216 in lb (24.4 Nm)  
 Speed: 500 rpm – 2,500 rpm

**Features:**

Reversible and Non-reversible  
 Trigger or Shuttle Reverse  
 Comfort Grip

Positive Clutch Pistol Grip & T-Handle Screwdrivers



Model Number	Max Torque <sup>1</sup> (Soft Joint)		Free Speed rpm	Weight		Length		Side To Center		Air Consumption	
	in lb	Nm		lb	kg	in	mm	in	mm	cfm	l/s
<b>0.4 hp (0.3 kW) Trigger Start - Shuttle Reverse</b>											
SSD4P5P	95	10.7	500	1.8	0.8	7.0	178	0.7	17	20	10
SSD4P7P	65	7.3	700	1.8	0.8	7.0	178	0.7	17	20	10
SSD4P11P	45	5.1	1100	1.8	0.8	7.0	178	0.7	17	20	10
SSD4P14P	35	3.9	1400	1.6	0.7	6.5	165	0.7	17	20	10
SSD4P18P	26	2.9	1800	1.6	0.7	6.5	165	0.7	17	20	10
SSD4P26P	20	2.3	2600	1.6	0.7	6.5	165	0.7	17	20	10
<b>0.6 hp (0.45 kW) Medium Clutch Screwdrivers – 1/4" Quick Change</b>											
SSD6P12P	100	11.3	1200	2.6	1.18	8.6	218	0.8	20	25	12
SSD6P20P	55	6.2	2000	2.2	0.98	6.8	171	0.8	20	25	12
SSD6P20PSRR	55	6.2	2000	2.2	0.98	6.8	171	0.8	20	25	12
SSD6P25P	40	4.5	2500	2.2	0.98	6.8	171	0.8	20	25	12
SSD6P25PSRR	40	4.5	2500	2.2	0.98	6.8	171	0.8	20	25	12
<b>1 hp (0.75 kW) Medium Torque Clutch Screwdrivers – 1/4" Quick Change</b>											
SSD10P12P	135	15.3	1200	2.8	1.30	9.1	231	0.8	20	30	14
SSD10P20P	70	7.9	2000	2.4	1.07	7.3	185	0.8	20	30	14
SSD10P25P	50	5.7	2500	2.4	1.07	7.3	185	0.8	20	30	14
<b>1 hp (0.75 kW) High Torque Clutch Screwdrivers – 1/4" Quick Change</b>											
SSD10P12PS	145	16.4	1200	2.8	1.30	9.1	231	0.8	20	30	14
SSD10P20PS	80	9.0	2000	2.4	1.07	7.3	185	0.8	20	30	14
SSD10P25PS	58	6.5	2500	2.4	1.07	7.3	185	0.8	20	30	14
<b>1 hp (0.75 kW) – Medium Torque Positive Clutch Rapid Reverse Screwdriver</b>											
SSD10P20PRR	70	7.9	2000	2.4	1.07	7.3	185	0.8	20	30	14
SSD10P25PRR	50	5.7	2500	2.4	1.07	7.3	185	0.8	20	30	14
<b>3 Series T-Handle – 7/16" Quick Change</b>											
3T2303 <sup>1</sup>	216	24.4	850	6.7	3.0	33	840	1	25	33	16

<sup>1</sup> Torque output varies with force exerted by operator

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual

**Accessories:**

Screwdriver Accessories, Screwdriver Bits and Finders see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

POSITIVE CLUTCH INLINE SCREWDRIVER

**Performance:**

Torque: 55 in lb (6.2 Nm)  
Speed: 800 rpm

**Features:**

Reversible  
Lever Start  
Rear Exhaust



Positive Clutch Inline Screwdrivers

Model Number	Max Torque <sup>1</sup> (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption	
	in lb	Nm		lb	kg	in	mm	in	mm	cfm	l/s
1SM2103	55	6.2	800	1.4	0.6	9.1	231	0.6	15	8	4

<sup>1</sup> Torque output varies with force exerted by operator

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1SM series) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Comfort Grip (1SM series)

**Accessories:**

Screwdriver Accessories, Screwdriver Bits and Finders see page 36

STALL PISTOL GRIP SCREWDRIVERS

**Performance:**

Torque: 20 in lb (2.3 Nm) –  
400 in lb (45.2 Nm)  
Speed: 300 rpm – 2,600 rpm

**Features:**

Reversible  
Rapid or Shuttle Reverse  
Comfort Grip  
1/4" Quick Change



Stall Pistol Grip Screwdrivers

Model Number	Max Torque (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption	
	in lb	Nm		lb	kg	in	mm	in	mm	cfm	l/s
<b>0.4 hp (0.3 kW) Trigger Start - Shuttle Reverse</b>											
SSD4P5S	95	10.7	500	1.5	0.7	5.5	140	0.7	17	20	10
SSD4P7S	65	7.3	700	1.5	0.7	5.5	140	0.7	17	20	10
SSD4P11S	45	5.1	1100	1.5	0.7	5.5	140	0.7	17	20	10
SSD4P14S	35	3.9	1400	1.3	0.6	5.0	127	0.7	17	20	10
SSD4P18S	26	2.9	1800	1.3	0.6	5.0	127	0.7	17	20	10
SSD4P26S	20	2.3	2600	1.3	0.6	5.0	127	0.7	17	20	10
<b>0.6 hp (0.45 kW) Trigger Start – Shuttle Reverse</b>											
SSD6P7S	155	17.8	700	2.4	1.10	6.8	171	0.8	20	25	12
SSD6P12S	100	11.3	1200	2.4	1.10	6.8	171	0.8	20	25	12
SSD6P20S	55	6.2	2000	2.0	0.90	5.8	146	0.8	20	25	12
SSD6P25S	40	4.5	2500	2.0	0.90	5.8	146	0.8	20	25	12
<b>0.6 hp (0.45 kW) Trigger Start – Rapid Reverse</b>											
SSD6P20SRR	55	6.2	2000	2.0	0.90	5.8	146	0.8	20	25	12
<b>1 hp (0.75 kW) Trigger Start – Shuttle Reverse</b>											
SSD10P3S	400	45.2	300	2.6	1.17	7.5	191	0.8	20	30	14
SSD10P5S	325	36.7	500	2.6	1.17	7.5	191	0.8	20	30	14
SSD10P7S	220	24.9	700	2.6	1.17	7.5	191	0.8	20	30	14
SSD10P12S	145	16.4	1200	2.6	1.17	7.5	191	0.8	20	30	14
SSD10P20S	80	9.0	2000	2.2	0.98	6.5	165	0.8	20	30	14
SSD10P25S	58	6.6	2500	2.2	0.98	6.5	165	0.8	20	30	14
<b>1 hp (0.75 kW) – Stall Rapid Reverse</b>											
SSD10P20SRR	80	9.0	2000	2.2	0.98	6.5	165	0.8	20	30	14

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1OM series); 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Comfort Grip

**Accessories:**

Screwdriver Accessories, Screwdriver Bits and Finders see pages 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

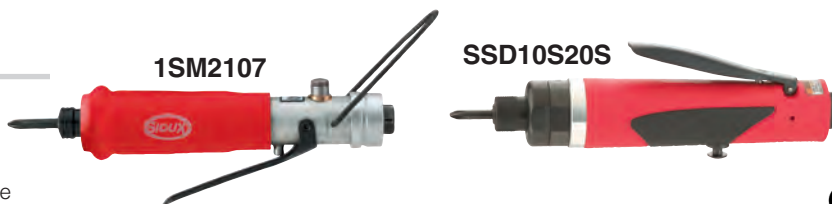
STALL INLINE SCREWDRIVERS

**Performance:**

Torque: 24 in lb (2.7 Nm) – 400 in lb (45.2 Nm)  
Speed: 300 rpm – 2,500 rpm

**Features:**

Reversible  
Lever Start  
Rear Exhaust  
Suspension Bail  
1/4" Quick Change



**Stall Inline Screwdrivers**

Model Number	Max Torque (Soft Joint)		Free Speed rpm	Weight		Length		Side To Center		Air Consumption	
	in lb	Nm		lb	kg	in	mm	in	mm	cfm	l/s
<b>Inline – Reversible – 1/4" Quick Change Drive</b>											
1SM2107	55	6.2	800	1.4	0.60	9.1	231	0.6	15	8	4
1SM2407	24	2.7	2200	1.3	0.60	8.1	206	0.6	15	8	4
<b>Inline – Stall Clutch</b>											
SSD10S3S	400	45.2	300	2.2	1.00	9.5	240	0.8	20	30	14
SSD10S5S	325	36.7	500	2.2	1.00	9.5	240	0.8	20	30	14
SSD10S7S	220	24.9	700	2.2	1.00	9.5	240	0.8	20	30	14
SSD10S12S	145	16.4	1200	2.2	1.00	9.5	240	0.8	20	30	14
SSD10S20S	80	9.0	2000	1.9	0.85	8.4	215	0.8	20	30	14
SSD10S25S	58	6.6	2500	1.9	0.85	8.4	215	0.8	20	30	14

**General:** Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1SM series); 3/8" (10 mm) (SSD series) • Performance rated @ 90 psig (6.2 bar) air pressure  
**Standard Equipment:** Parts List • Safety and Instruction Manual • Comfort Grip (1SM series) • Suspension Bail  
**Accessories:** Screwdriver Accessories, Screwdriver Bits and Finders see page 36

ADJUSTABLE CLUTCH PISTOL GRIP SCREWDRIVERS

**Performance:**

Torque: 23 in lb (2.6 Nm) – 140 in lb (15.8 Nm)  
Speed: 300 rpm – 2,600 rpm

**Features:**

Reversible  
Rapid or Shuttle Reverse  
Comfort Grip



**Adjustable Clutch Pistol Grip Screwdrivers**

Model Number	Max Torque (Soft Joint)		Free Speed rpm	Weight		Length		Side To Center		Air Consumption	
	in lb	Nm		lb	kg	in	mm	in	mm	cfm	l/s
<b>0.4 hp (0.3 kw) Trigger Start - Shuttle Reverse</b>											
SSD4P5AC	70	7.9	500	2.1	1.0	8.5	216	0.7	17	20	10
SSD4P7AC	60	6.8	700	2.1	1.0	8.5	216	0.7	17	20	10
SSD4P11AC	40	4.5	1100	2.1	1.0	8.5	216	0.7	17	20	10
SSD4P14AC	30	3.4	1400	1.9	0.9	8.0	203	0.7	17	20	10
SSD4P18AC	23	2.6	1800	1.9	0.9	8.0	203	0.7	17	20	10
SSD4P26AC	17	1.9	2600	1.9	0.9	8.0	203	0.7	17	20	10
<b>0.6 hp (0.45 kw) Trigger Start – Shuttle Reverse</b>											
SSD6P7AC	140	15.8	700	3.0	1.36	10.3	262	0.8	20	25	12
SSD6P12AC	100	11.3	1200	3.0	1.36	10.3	262	0.8	20	25	12
SSD6P20AC	55	6.2	2000	2.6	1.16	8.5	216	0.8	20	25	12
SSD6P25AC	40	4.5	2500	2.6	1.16	8.5	216	0.8	20	25	12
<b>1 hp (0.75 kw) Trigger Start – Shuttle Reverse</b>											
SSD10P3AC	140	15.8	300	3.2	1.45	10.2	259	0.8	20	30	14
SSD10P5AC	140	15.8	500	3.2	1.45	10.2	259	0.8	20	30	14
SSD10P7AC	140	15.8	700	3.2	1.45	10.2	259	0.8	20	30	14
SSD10P12AC	120	13.5	1200	3.2	1.45	10.2	259	0.8	20	30	14
SSD10P20AC	80	9.0	2000	2.8	1.25	8.4	213	0.8	20	30	14
SSD10P25AC	60	6.8	2500	2.8	1.25	8.4	213	0.8	20	30	14

**General:** Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1OM series); 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure  
**Standard Equipment:** Parts List • Safety and Instruction Manual • Comfort Grip • Clutch Adjustment Wrench • All Applicable Clutch Springs  
**Accessories:** Screwdriver Accessories, Screwdriver Bits and Finders see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1



## ADJUSTABLE CLUTCH INLINE SCREWDRIVERS

**Performance:**

Torque: 20 in lb (2.3 Nm) – 140 in lb (15.8 Nm)  
Speed: 300 rpm – 2,500 rpm

**Features:**

Reversible  
Rear Exhaust  
External Clutch Adjustment



**Adjustable Clutch Inline Screwdrivers**



Model Number		Max Torque (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption	
1/4" Quick Change	1/4" Internal Hex	in lb	Nm	rpm	lb	kg	in	mm	in	mm	cfm	l/s
<b>Inline – Lever Start</b>												
1SM2105Q		50	5.7	800	1.6	0.70	10.3	262	0.6	15	8	4
1SM2205Q		35	4.0	1100	1.6	0.70	10.3	262	0.6	15	8	4
1SM2305Q		25	2.8	1500	1.6	0.70	10.3	262	0.6	15	8	4
1SM2405Q	1SM2405	20	2.3	2200	1.4	0.60	9.3	236	0.6	15	8	4
<b>Inline – Lever Start</b>												
SSD10S3AC		140	15.8	300	2.8	1.25	12.3	315	0.8	20	30	14
SSD10S5AC		140	15.8	500	2.8	1.25	12.3	315	0.8	20	30	14
SSD10S7AC		140	15.8	700	2.8	1.25	12.3	315	0.8	20	30	14
SSD10S12AC		120	13.5	1200	2.8	1.25	12.3	315	0.8	20	30	14
SSD10S20AC		80	9.0	2000	2.5	1.15	11.2	285	0.8	20	30	14
SSD10S25AC		60	6.8	2500	2.5	1.15	11.2	285	0.8	20	30	14

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1SM series); 3/8" (10 mm) (SSD series) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Comfort Grip (1SM series) • Suspension Bail • Clutch Adjustment Wrench • All Applicable Clutch Springs

**Accessories:**

Screwdriver Accessories, Screwdriver Bits and Finders see page 36

## TORQUE CONTROL SCREWDRIVERS

**Performance:**

Torque: 5 in lb (0.6 Nm) – 50 in lb (5.5 Nm)  
Speed: 725 rpm – 2,800 rpm

**Features:**

Push-to-Start  
Reversible  
Locking Button Reverse  
External Clutch Adjustment



**Torque Control Screwdrivers**



Model Number		Max Torque (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption	
1/4" Quick Change		in lb	Nm	rpm	lb	kg	in	mm	in	mm	cfm	l/s
<b>Inline – Push To Start</b>												
1ST2108Q		5-50	0.6-5.5	800	1.6	0.7	9.3	236	0.6	15	8	4
1ST2208Q		5-35	0.6-4	1100	1.6	0.7	9.3	236	0.6	15	8	4
1ST2308Q		5-25	0.6-3	1500	1.6	0.7	9.3	236	0.6	15	8	4
1ST2508Q		5-14	0.6-1.5	2800	1.4	0.6	8.3	211	0.6	15	8	4
<b>Pistol Grip – Push To Start</b>												
1OT2108Q		5-50	0.6-5.5	725	2.1	1.0	8.8	225	0.7	17	10	5
1OT2208Q		5-35	0.6-4	1000	2.1	1.0	8.8	225	0.7	17	10	5
1OT2308Q		5-25	0.6-3	1400	2.1	1.0	8.8	225	0.7	17	10	5
1OT2508Q		5-14	0.6-1.5	2600	1.9	0.9	7.8	200	0.7	17	10	5

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1OT, 1ST series) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Comfort Grip • Suspension Bail (Inline models) • All Applicable Clutch Springs

**Accessories:**

Screwdriver Accessories, Screwdriver Bits and Finders see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

Z-HANDLE SCREWDRIVERS



**Performance:**

Torque: 30 in lb (3.4 Nm) – 70 in lb (7.9 Nm)  
Speed: 1,000 rpm – 2,200 rpm

**Features:**

Lever Start  
Rear Exhaust

**Z-Handle Screwdrivers**

Model Number	Max Torque <sup>1</sup> (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption		
	1/4" Quick Change	in lb		Nm	rpm	lb	kg	in	mm	in	mm	cfm
<b>Z-Handle – Stall</b>												
2S2107		70	7.9	1000	2.3	1.0	2.9	74	0.9	23	16	8
2S2207		50	5.7	1600	2.3	1.0	2.9	74	0.9	23	16	8
2S2307		36	4.1	2200	2.3	1.0	2.9	74	0.9	23	16	8
<b>Z-Handle – Low Torque Clutch<sup>1</sup></b>												
2S2103Q		60	6.8	1000	2.6	1.2	4.3	109	0.9	23	16	8
<b>Z-Handle – Mid-Torque Clutch<sup>1</sup></b>												
2S2103AQ		60	6.8	1000	2.6	1.2	4.3	109	0.9	23	16	8
2S2203AQ		46	5.2	1600	2.6	1.2	4.3	109	0.9	23	16	8
2S2303AQ		30	3.4	2200	2.6	1.2	4.3	109	0.9	23	16	8
<b>Z-Handle – Lever Start – Adjustable Clutch</b>												
2S2105Q		60	6.8	1000	2.9	1.3	5.8	147	0.9	23	16	8
2S2305Q		30	3.4	2200	2.9	1.3	5.8	147	0.9	23	16	8

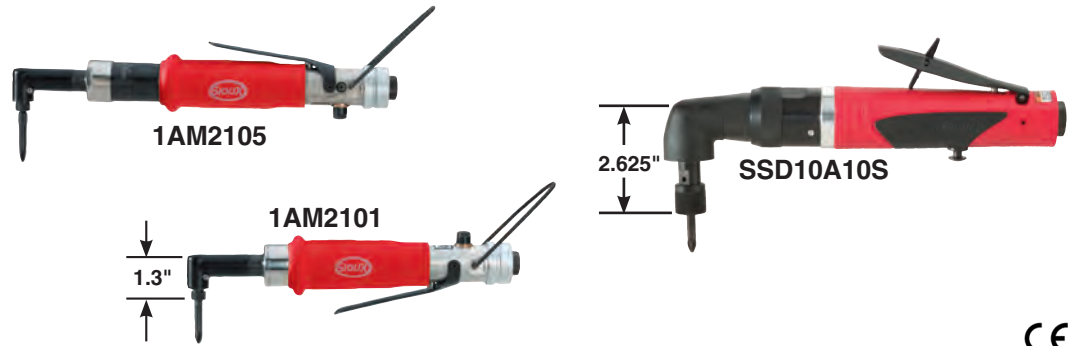
<sup>1</sup> Torque output varies with force exerted by operator

**General:** Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:** Parts List • Safety and Instruction Manual • Suspension Bail

**Accessories:** Screwdriver Accessories, Screwdriver Bits and Finders see page 36

RIGHT ANGLE SCREWDRIVERS



**Performance:**

Torque: 35 in lb (4 Nm) – 400 in lb (45.2 Nm)  
Speed: 300 rpm – 2,000 rpm

**Features:**

Stall Drive & Adjustable Clutch  
Button Reverse  
Lever Start  
Rear Exhaust

**Right Angle Screwdrivers**

Model Number	Max Torque (Soft Joint)		Free Speed	Weight		Length		Side To Center		Air Consumption			
	1/4" Quick Change	1/4" Internal Hex		in lb	Nm	rpm	lb	kg	in	mm	in	mm	cfm
<b>Stall Drive</b>													
	1AM2101		50	5.7	800	1.5	0.70	10.0	254	0.3	8	8	4
	1AM2201		35	4.0	1100	1.5	0.70	10.0	254	0.3	8	8	4
<b>Stall Drive</b>													
	SSD10A3S		400	45.2	300	3.4	1.50	12.0	305	0.8	20	30	14
	SSD10A5S		325	36.7	500	3.4	1.50	12.0	305	0.8	20	30	14
	SSD10A6S		220	24.9	600	3.4	1.50	12.0	305	0.8	20	30	14
	SSD10A10S		145	16.4	1000	3.4	1.50	12.0	305	0.8	20	30	14
	SSD10A16S		80	9.0	1600	3.0	1.35	11.0	280	0.8	20	30	14
	SSD10A20S		58	6.6	2000	3.0	1.35	11.0	280	0.8	20	30	14
<b>Adjustable Clutch</b>													
	1AM2105		50	5.7	800	1.9	0.90	11.8	300	0.3	8	8	4
	1AM2205		35	4.0	1100	1.9	0.90	11.8	300	0.3	8	8	4

**General:** Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1AM series); 3/8" (10 mm) (SSD series) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:** Comfort Grip (1AM series)

**Accessories:** Screwdriver Accessories, Screwdriver Bits and Finders see page 36

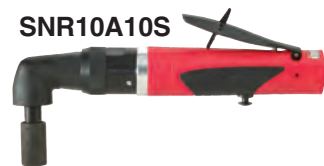


**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

RIGHT ANGLE NUTRUNNERS



3A2104



SNR10A10S



1AM2106

**Performance:**

Torque: 50 in lb (5.7 Nm) – 600 in lb (68 Nm)  
Speed: 300 rpm – 2,000 rpm

**Features:**

Reversible  
Lever Start  
Rear and Side Exhaust

Right Angle Nutrunners



Model Number	Bolt Capacity <sup>2</sup>		Max Torque (Soft Joint)		Free Speed rpm	Weight		Length		Side To Center		Drive Size	
	in	mm	in lb	Nm		lb	kg	in	mm	in	mm	in	mm
<b>Torque Control Clutch</b>													
3A2108 <sup>1</sup>	3/8	M10	360	41	300	7.4	3.40	18.3	465	0.8	20	1/2	13
3A2208 <sup>1</sup>	3/8	M10	294	33	480	7.4	3.40	18.3	465	0.8	20	1/2	13
<b>Adjustable Clutch</b>													
1AM2106	#10	M4.5	50	5.7	800	1.9	0.90	11.6	295	0.3	8	1/4	6
<b>Stall Drive</b>													
1AM2102	#10	M4.5	50	5.7	800	1.5	0.70	11.5	292	0.3	8	1/4	6
<b>Stall Drive</b>													
3A2102 <sup>1</sup>	7/16	M11	600	68	300	6.2	2.81	17.8	452	0.8	20	1/2	13
3A2104 <sup>1</sup>	7/16	M11	600	68	300	5.5	2.50	15.5	394	0.8	20	1/2	13
<b>Stall Drive</b>													
SNR10A3S	3/8	M10	400	45.2	300	2.9	1.30	12.0	305	0.8	20	3/8	10
SNR10A5S	3/8	M10	325	36.7	500	2.9	1.30	12.0	305	0.8	20	3/8	10
SNR10A6S	3/8	M10	220	24.9	600	2.9	1.30	12.0	305	0.8	20	3/8	10
SNR10A10S	5/16	M8	145	16.4	1000	2.9	1.30	12.0	305	0.8	20	3/8	10
SNR10A16S	1/4	M6	80	9.0	1600	2.6	1.15	11.0	280	0.8	20	3/8	10
SNR10A20S	#10	M4.5	58	6.6	2000	2.6	1.15	11.0	280	0.8	20	1/4	6

<sup>1</sup> Not CE Certified

<sup>2</sup> Bolt capacities are based on suggested assembly torques applied to SAE Grade 5 and metric Class 9.8 fasteners under slightly lubricated conditions.

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 1/4" (6 mm) (1AM series); 3/8" (10 mm) (SNR, 3A series) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Comfort Grip (1AM series) • Clutch Adjustment Wrench

**Accessories:**

Nutrunner Accessories, see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

RATCHET WRENCHES

**Performance:**

Power: 0.3 hp (0.25 kW)  
Torque: 35 ft lb (47 Nm)

**Features:**

Lever Start  
Teasing Throttle  
Comfort Grip



SRW03S-25

**Ratchet Wrenches**

Model Number	Drive Size		Torque		Free Speed	Weight		Length		Side to Center		Air Consumption		Exhaust
	in	mm	ft lb	Nm	rpm	lb	kg	in	mm	in	mm	cfm	l/s	
<b>0.3 hp (0.25 kW)</b>														
SRW03S-25	1/4"	6	35	47	235	1.4	0.6	7.7	197	1.1	28	1.4	0.66	Rear
SRW03S-38	3/8"	10	35	47	235	1.4	0.6	7.7	197	1.1	28	1.4	0.66	Rear
SRW03S-38Q	3/8"	10	35	47	235	1.4	0.6	7.7	197	1.1	28	1.4	0.66	Rear

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Boot for Head

**Accessories:**

Ratchet Accessories, see page 36



SRW07-38

**Performance:**

Power: 0.7 hp (0.52 kW)  
Torque: 65 ft lb (88 Nm)

**Ratchet Wrenches**

Model Number	Drive Size		Torque		Free Speed	Weight		Length		Side to Center		Air Consumption		Exhaust
	in	mm	ft lb	Nm	rpm	lb	kg	in	mm	in	mm	cfm	l/s	
<b>0.7 hp (0.52 kW)</b>														
SRW07-38	3/8"	10	65	88	260	3.0	1.3	11.8	300	1.0	25	2.7	1.27	Front
SRW07-50	1/2"	13	65	88	260	3.0	1.3	11.8	300	1.0	25	2.7	1.27	Front

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Boot for Head

**Accessories:**

Ratchet Accessories, see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

# ASSEMBLY

## We're Making A Big Impact

Impact wrenches are the true workhorses of industrial power tools. These incredibly powerful tools make easy work of any job in a variety of applications. Before the creation of impact tools, workers had to manually strike a hammer against a hand wrench in order to loosen or tighten nuts or bolts. They could only manage a few blows per minute. But today's impact wrenches can exert more powerful blows, and some can produce over 2000 blows per minute. This is accomplished by using the energy of compressed air and converting the motor's torque into a rapid series of powerful rotary impacts.

### Choice of Configuration

Sioux Tools offers Industrial and Force Impact Wrenches and Impact Drivers in a wide variety of configurations to meet your specific applications. In order to select the correct impact tool for your job requirements, you must take into account several factors including fastener size and grade, required torque output, and accessibility. Choosing the right mix of features such as handle configuration, type of retainer, torque output, anvil length, and drive size will make operators more productive, with less risk of discomfort and/or injury.

### Industrial Impact Tools

Built to a higher level of quality, Sioux Industrial Impact Wrenches and Impact Drivers are built a step above the standard. Manufactured from the highest quality materials, and utilizing the most advanced motor and clutch designs, these tools are constructed to hold up under continuous use in the toughest working environments.

Our extensive lineup of impact tools includes a wide selection of important features including:

- Ball & Cam or Twin Hammer impact mechanisms
- Inline, pistol grip, or D-handle configurations
- Pin, friction ring, quick change, or thru hole socket retainers
- Standard or extended anvils

In addition, Sioux offers a wide range of performance levels and characteristics to ensure a perfect match to your application. With drive sizes ranging from 1/4" (6 mm) to 1-1/2" (38 mm), and torque outputs up to 2500 ft lb (3390 Nm), finding the tool to meet your performance requirements will be simple.

### Impact Wrench Principles of Operation

An impact wrench delivers a series of rotary blows to a fastener, producing torque.

The action of the torque creates clamp force in an assembly.

Interaction of the motor, clutch and drive-end determine the type of application an impact wrench can handle.

The advantages of impact wrenches are a high power-to-weight ratio, fast rundown, and no torque reaction to operator.

### Class of Service

High production – automobile assembly plants, farm and construction equipment, etc.

Low production – large machinery assembly

Maintenance or repair work

### Job Conditions

Hard pull-up – rigid joint

Soft pull-up – spring joint

Run-down – free running, or prevailing torque (lock nut, self threading screw)

### Material

Metal-to-metal

Metal/gasket

Rubber or plastic

### Assembly Method

General tightening – operator judgement

Turn-of-the-nut – permanent assemblies (steel erection and construction equipment)

**Note:** If it takes five seconds or longer to reach final tightness, a larger wrench should be used.

IMPACT DRIVERS



IW38TBP-2Q



IW38TBP-3P

**Performance:**

Torque: 10 ft lb (13 Nm) – 70 ft lb (270 Nm)  
 Drive Size: 1/4" (6 mm) & 3/8" (10 mm)  
 Working Torque up to 70 ft-lb

**Features:**

Pistol Grip  
 Belt Clip

1/4" (6 mm) & 3/8" (10 mm) Impact Drivers



Model Number	Drive Size		Working Torque Range <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed	Weight		Length		Side To Center		Avg Air Consumption		Socket Retainer Style
	in	mm	ft lb	Nm	ft lb	Nm			rpm	lb	kg	in	mm	in	mm	cfm	
IW38TBP-2Q	1/4	6	10-70	13-95	70	95	2000	8000	2.1	1.0	6.3	160	0.9	22	2	1	QC
IW38TBP-3P	3/8	10	10-70	13-95	70	95	2000	8000	2.1	1.0	6.3	160	0.9	22	2	1	Pin

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Suspension Bail

**Accessories:**

Impact Wrench Accessories, see page 36



ID375AP-2Q



ID375AP-2QRR



IW375AP-3P

3/8" Pinned Anvil

3/8" Friction Ring Anvil



1/4" Quick Change



**Key Features:**

High power to weight ratio  
 High impact rate of 5,000 blows per minute  
 Working torque range up to 95 ft-lb  
 Smooth Impacting that creates minimal torque reaction  
 Includes rubber boot for hammer case

**Applications:**

Wood Screws  
 Self-tapping screws  
 Lag bolts  
 High prevailing torque applications

1/4" (6 mm) & 3/8" (10 mm) Impact Drivers

Model Number	Drive Size		Working Torque Range <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed	Weight		Length		Side To Center		Socket Retainer Style
	in	mm	ft lb	Nm	ft lb	Nm			rpm	lb	kg	in	mm	in	
ID375AP-2Q	1/4	6	10-55	13-75	60	80	5000	4000	2.5	1.1	8.5	216	0.85	21	Quick Change
ID375AP-2QRR	1/4	6	10-55	13-75	60	80	5000	4000	2.5	1.1	8.5	216	0.85	21	Quick Change
IW375AP-3P	3/8	10	10-95	13-130	100	135	5000	4000	2.5	1.1	8.5	216	0.85	21	Pin
IW375AP-3F	3/8	10	10-95	13-130	100	135	5000	4000	2.5	1.1	8.5	216	0.85	21	Ring

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual

**Accessories:**

Impact Wrench Accessories, see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

## 1/2" IMPACT WRENCHES

**Performance:**

Working Torque: 100 ft lb (135 Nm) – 625 ft lb (1058 Nm)  
 Drive Size: 7/16" (11 mm) – 1/2" (13 mm)  
 Bolt Capacity: 9/16" (14 mm) – 5/8" (10 mm)

**Features:**

High power to weight ratio  
 Forged Aluminum Anvil Housing  
 One Hand Forward/Reverse Operation



### 1/2" (13mm) Impact Wrenches

Model Number	Drive Size		Bolt Cap Grade 5		Working Torque Range <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed rpm	Weight		Length		Side To Center		Avg Air Consumption		Socket Retainer Style
	in	mm	in	mm	ft lb	Nm	ft lb	Nm			lb	kg	in	mm	in	mm	cfm	l/s	
IW500MP-4R	1/2	13	5/8	16	100-625	135-845	780	1058	1200	9400	4.2	1.9	7.0	178	1.5	38	4	2	Ring
IW500MP-4R3	1/2	13	5/8	16	100-625	135-845	780	1058	1200	9400	4.4	2.0	10.0	254	1.5	38	4	2	Ring
IW500MP-4P	1/2	13	5/8	16	100-625	135-845	780	1058	1200	9400	4.2	1.9	7.0	178	1.5	38	4	2	Pin
IW500MP-4P3	1/2	13	5/8	16	100-625	135-845	780	1058	1200	9400	4.4	2.0	10.0	254	1.5	38	4	2	Pin
IW500MP-7Q	7/16	11	9/16	14	80-500	110-675	600	810	1200	9400	4.3	2.0	7.4	188	1.5	38	4	2	QC

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:**

Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual

**Accessories:**

Impact Wrench Accessories, see page 36

## 3/4" & 1" IMPACT WRENCHES

**Performance:**

Maximum Torque: 1,000 ft lb (1356 Nm) – 1,100 ft lb (1492 Nm)  
 Drive Size: 3/4" (19 mm) – 1" (25 mm)

**Features:**

Aluminum nose  
 Long-life Impact mechanism  
 Grease Clutch  
 Reverse biased  
 One hand Forward / Reverse operation



### Heavy Duty Impact Wrenches

Model Number	Drive Size		Bolt Cap Grade 5		Maximum Working Torque <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed rpm	Weight		Length		Side To Center		Avg Air Consumption		Socket Retainer Style
	in	mm	in	mm	ft lb	Nm	ft lb	Nm			lb	kg	in	mm	in	mm	cfm	l/s	
IW750MP-6P	3/4	19	3/4	19	800	1085	1050	1423	1050	6700	7.5	3.44	8.5	215	N/A	N/A	5.6	2.6	Pin
IW750MP-6H	3/4	19	3/4	19	800	1085	1050	1423	1050	6700	7.5	3.44	8.5	215	N/A	N/A	5.6	2.6	Hole
IW750MP-6R	3/4	19	3/4	19	800	1085	1050	1423	1050	6700	7.5	3.44	8.5	215	N/A	N/A	5.6	2.6	Friction Ring
IW75BP-6H	3/4	19	3/4	19	800	1085	1000	1356	1000	5700	11.6	5.3	7.6	193	1.75	45	15.0	7.0	Hole
IW75BP-8H	1	25	3/4	19	825	1119	1100	1492	1000	5700	11.7	5.3	7.6	193	1.75	45	15.0	7.0	Hole

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:**

Air Inlet Size: 3/8" NPT • Recommended Hose Size: 1/2" (30 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:**

Parts List • Safety and Instruction Manual • Suspension Bail (IW75BP)

**Accessories:**

Impact Wrench Accessories, see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1

TETHERED IMPACT WRENCHES

**Performance:**

Working Torque: 100 ft lb (135 Nm) – 800 ft lb (1085 Nm)  
 Drive Size: 1/2" (13 mm) – 3/4" (19 mm)  
 Bolt Capacity: 5/8" (10 mm) – 3/4" (19 mm)

**Features:**

High power to weight ratio  
 Forged Aluminum Anvil Housing  
 One Hand Forward/Reverse Operation



1/2" (13mm) Impact Wrenches

Model Number	Drive Size		Bolt Cap Grade 5		Working Torque Range <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed rpm	Weight		Length		Side To Center		Avg Air Consumption		Socket Retainer Style
	in	mm	in	mm	ft lb	Nm	ft lb	Nm			lb	kg	in	mm	in	mm	cfm	l/s	
IW500MP-4PT	1/2	13	5/8	16	100-625	135-845	780	1058	1200	9400	4.2	1.9	7.0	178	1.5	38	4	2	Pin
IW750MP-6PT	3/4	19	3/4	19	800	1085	1050	1423	1050	6700	7.5	3.44	8.5	215	N/A	N/A	5.6	2.6	Pin

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:** Air Inlet Size: 1/4" NPT • Recommended Hose Size: 3/8" (10 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:** Parts List • Safety and Instruction Manual

**Accessories:** Impact Wrench Accessories, see page 36



IW1000MP-8H

**Performance:**

Working Torque: 1,200 ft lb (1630 Nm) – 2,500 ft lb (3390 Nm)  
 Drive Size: 1" (25 mm) – 1-1/2" (38 mm)  
 Bolt Capacity: 1-1/4" (32 mm) – 2" (50 mm)

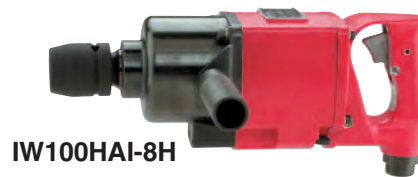
**Features:**

D-Handle  
 Inside and Outside Trigger  
 Steel Anvil Housing

1" (25 mm), 1-1/2" (38 mm) Impact Wrenches



IW1000MP-8H5



IW100HAI-8H

Model Number	Drive Size		Bolt Cap Grade 5		Maximum Working Torque <sup>1</sup>		Maximum Torque		Blows Per Minute	Free Speed rpm	Weight		Length		Side To Center		Avg Air Consumption		Socket Retainer Style
	in	mm	in	mm	ft lb	Nm	ft lb	Nm			lb	kg	in	mm	in	mm	cfm	l/s	
<b>D-Handle – Inside Trigger</b>																			
IW1000MP-8H	1	25	1-1/4	32	1200	1630	1700	2300	825	6500	18.2	8.3	14.8	376	1.85	47	34	16	Hole/Ring
IW1000MP-8H5	1	25	1-1/4	32	1200	1630	1700	2300	825	6500	19.7	8.9	19.3	490	1.85	47	34	16	Hole/Ring
IW1000MP-8H8	1	25	1-1/4	32	1200	1630	1700	2300	825	6500	20.7	9.4	22.3	556	1.85	47	34	16	Hole/Ring
IW100HAI-8H	1	25	1-3/8	35	1600	2170	2000	2710	850	5000	22.0	10.0	12.4	315	2.0	51	38	18	Hole
IW100HAI-8H6	1	25	1-3/8	35	1600	2170	2000	2710	850	5000	26.2	11.8	18.4	467	2.0	51	38	18	Hole
IW100HAI-5S	#5 Spline		1-3/8	35	1600	2170	2000	2710	850	5000	22.0	10.0	12.4	315	2.0	51	38	18	Hole
IW100HAI-5S6	#5 Spline		1-3/8	35	1600	2170	2000	2710	850	5000	26.2	11.8	18.4	467	2.0	51	38	18	Hole
IW150HAI-5S	#5 Spline		2	50	2500	3390	3000	4070	650	3750	33.0	15.0	14.5	368	2.5	65	60	28	Hole
IW150HAI-12H	1-1/2	38	2	50	2500	3390	3000	4070	650	3750	33.1	15.0	14.5	368	2.5	65	60	28	Hole
<b>D-Handle – Outside Trigger</b>																			
IW100HAO-8H	1	25	1-3/8	35	1600	2170	2000	2710	850	5000	22.0	10.0	12.4	315	2.0	51	38	18	Hole
IW100HAO-8H6	1	25	1-3/8	35	1600	2170	2000	2710	850	5000	26.2	11.8	18.4	467	2.0	51	38	18	Hole
IW100HAO-5S	#5 Spline		1-3/8	35	1600	2170	2000	2710	850	5000	22.0	10.0	12.4	315	2.0	51	38	18	Hole
IW100HAO-5S6	#5 Spline		1-3/8	35	1600	2170	2000	2710	850	5000	26.2	11.8	18.4	467	2.0	51	38	18	Hole
IW150HAO-5S	#5 Spline		2	50	2500	3390	3000	4070	650	3750	33.0	15.0	14.5	368	2.5	65	60	28	Hole
IW150HAO-12H	1-1/2	38	2	50	2500	3390	3000	4070	650	3750	33.0	15.0	14.5	368	2.5	65	60	28	Hole

<sup>1</sup> Maximum working torque determined by 5 second rundown on appropriate Skidmore-Wilhelm Torque-Tension Tester.

**General:** Air Inlet Size: 1/2" NPT • Recommended Hose Size: 1/2" (30 mm) • Performance rated @ 90 psig (6.2 bar) air pressure

**Standard Equipment:** Parts List • Safety and Instruction Manual • Support handle (D-Handle models)

**Accessories:** Impact Wrench Accessories, see page 36



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1



**Clutch Springs**



41284  
(Green)



41249B



66048  
(Silver)



66049  
(Blue)



66050  
(Green)

Part Number	Color	Torque Range	
		in lb	Nm
<b>SSD6P, SSD10P, 2S Adjustable Clutch</b>			
41284	Green	<25	<2.8
41249B	Plain	>25	>2.8
<b>1 Series Adjustable Clutch &amp; Torque Control</b>			
66048	Silver	30-50	3.4-5.7
66049	Blue	15-35	1.7-4
66050	Green	2-20	0.22-2.3

**Tether Plate Kits for Impact Wrenches\***



IW500-3



74994A

Part Number	For Use On
IW500-3	IW500MP
74994A	IW750MP

\*See Page 35 for Impacts with Pre-Installed Tether

**Comfort Grips**



66124



68340



66193

Part Number	For Use On (Drills)	For Use On (Screwdrivers)
66124	800 rpm	1 Series inline (800, 1100 & 1500 rpm)
66193	All (except 800 rpm)	1 Series inline (2200 & 2800 rpm)
68340	N/A	SSD4P Series pistol grip

**Boots**

For use on Signature series



SDR6PNBOOT / SDR10PNBOOT

For use on IW500MP models



IW500MP-BOOT

**Support Handles**



77067A

Sioux Part Number	Description
77117A	For use on 4P series screwdrivers
77067A	6P, 10P series screwdrivers



**SAFETY PRECAUTION:** Read and follow all safety and operating instructions.  
**WARNING:** Face & eye protection must be worn while operating power tools, per ANSI B186.1