



# Air Tool Instructions

Amtak Model #221



## Safety Information

- To ensure safe and trouble-free operation of your Air Tool, read all instructions before assembly. Also, follow instructions in the order they appear in this instruction sheet.
- WARNING: OPERATORS MUST WEAR SAFETY GLASSES OR GOGGLES AND HEARING PROTECTION WHEN OPERATING THIS TOOL. NOISE DURING INSTALLATION OF THE METAL TACK MAY EXCEED 100dB.**
- Operating pressure must not exceed 100 PSI (7 kg/sq cm).
- Always disconnect the air supply before servicing, when removing the Driver or when the tool is not in use.
- Check regularly to be certain the Driver moves freely and does not stick or bind in the extended or cocked position during operation (See "Maintenance").
- Do not connect a female quick coupler to the tool; attach a male free flow nipple to the tool and a female quick coupler to the supply hose. An improper connection will cause the tool to remain charged after it is disconnected, allowing it to be fired if the trigger is activated.
- Do not, under any circumstances, fire the tool with the Driver in the cocked position without driving a fastener.
- Keep hands and face away from the area being fastened.
- Do not use oxygen or combustible gas as a power source for this tool.
- FAILURE TO OBSERVE ANY OF THESE WARNINGS MAY RESULT IN INJURY.**

## Here's what you need

1.



221 Air Tool



# 20380 Regulator



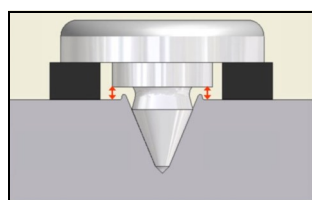
A Driver  
See Selection Guide



Metal-Tacks or Punch-Pins  
See Selection Guide

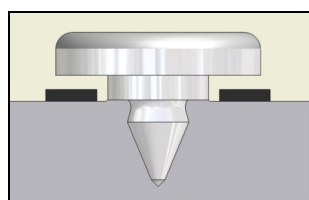
## Make sure you have the correct Metal-Tack or Punch-Pin

2.



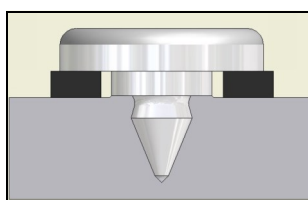
Grip length too short

The locking groove will not fill with base material.



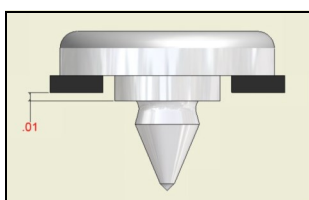
Grip length too long

The attachment will not be secured to the base material.



Just Right

The attachment is secure and the locking groove is filled.



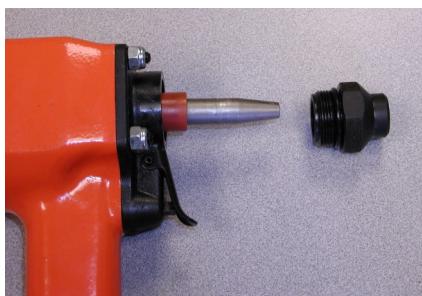
Quick Check

Position a fastener through the hole in the attachment. You may see up to .010 Inches of the shank beyond the attachment surface.

■ = Attachment  
■ = Base Metal

## Prepare the tool

3.



Unscrew the nose piece and slide the blunt end of the driver into the tool. Re-assemble and tighten the nose piece.



Start with 50 PSI for fastening to aluminum, 60 PSI for fastening to steel and 70 PSI for cast iron.



Place the fastener on end of magnetic driver.

## Apply the fasteners

4.



Carefully position tool perpendicular to the work surface and guide the Metal-Tack into the center of the hole. Use a magnet or tape to temporarily hold the nameplate during fastening.



Depress the driver into the tool, then activate the trigger. Always use both hands to hold the tool firmly in place.



Do not lean on the tool with one hand because this will cause the tool to skip forward.

## Fine tune the air pressure

5.

**If the attachment is loose** - make certain that you have the right fastener (see step 2.) and then increase the air pressure in increments of 5 PSI until the attachment is tight.

**If the Metal-Tacks smash the attachment** - decrease the air pressure in increments of 5 PSI until the attachment is secured but not damaged.

**If the Metal-Tacks don't hold**- make certain that you have the right fastener (see step 2.) and then contact Amtak customer service 800-346-5039

6.

## Maintenance & Troubleshooting

**Lubricate** - A filter-regulator-lubricator unit should be installed within 20 feet of the tool. Use S.A.E # 10 non detergent oil.

### Driver Magnetism

If the driver no longer holds the fastener, check for driver wear. The tip of the magnetic driver will eventually become worn and will need to be replaced.



**Air Tool "Jumps"** If the fastener misses the target, try holding the tool more firmly. Also make certain that the base material is solidly supported. This is particularly important when fastening to a curved surface.

**Low Air Tool Impact** If the air tool impact decreases, first check the air pressure, then look for the following worn or broken parts.

**Check for driver binding** - Make certain that the driver slides freely in the nose piece. If the driver is not lubricated or binds it will decrease the tool's impact.



**Check for a cracked Driver Retainer.** This part will fail if the tool is repeatedly "dry" fired without installing a fastener.

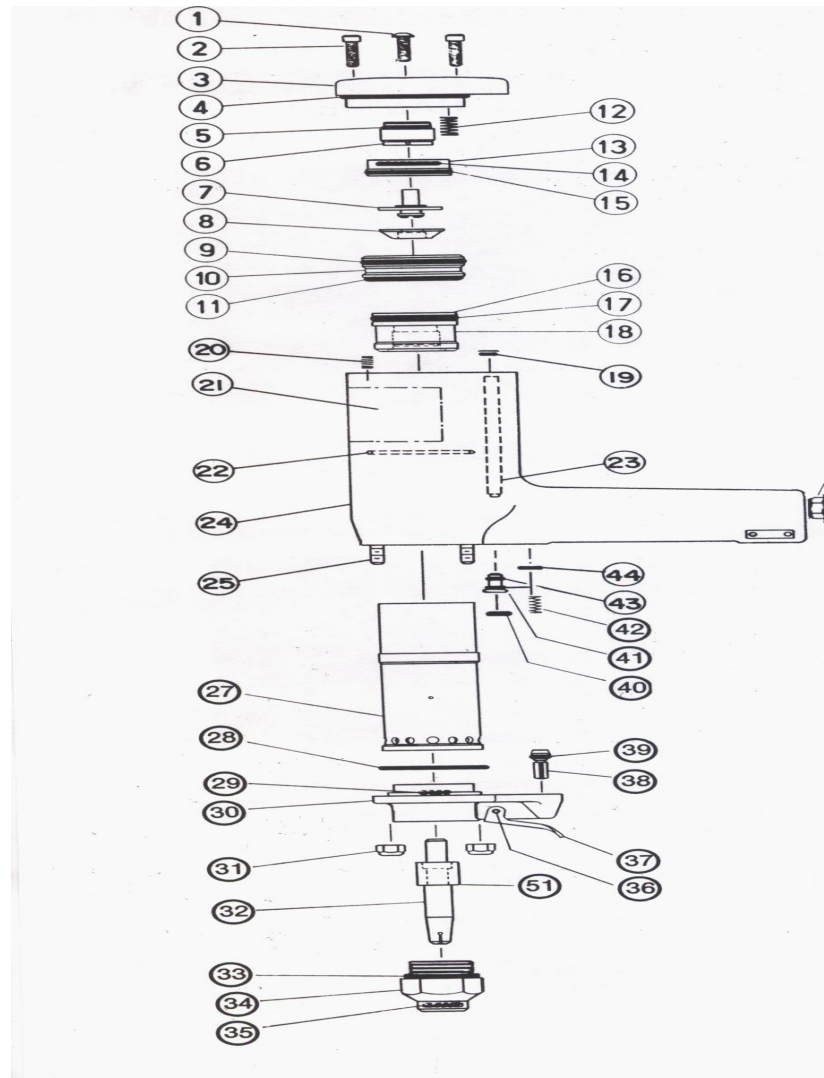


**Check for cracked Piston Bumper** Remove tool nose and look inside. Replace piston bumper if cracked.



7.

## Replacement Parts List



| No.                                   | Description                  | Part# |
|---------------------------------------|------------------------------|-------|
| 1                                     | #10-32X3/4 button head screw | 60304 |
| 2                                     | #10-32X3/4 socket cap screw  | 60128 |
| 7                                     | valve retainer               | 30321 |
| 8                                     | exhaust seal                 | 30322 |
| 10                                    | valve body                   | 30324 |
| 12                                    | compression spring           | 64408 |
| 13                                    | valve insert                 | 30325 |
| 16                                    | piston                       | 30327 |
| 18                                    | bumper piston                | 30314 |
| 25                                    | stud                         | 30330 |
| 30                                    | nose                         | 30326 |
| 31                                    | 1/4"-28 elastic stop nut     | 62005 |
| 37                                    | trigger                      | 30319 |
| 38                                    | pilot valve stem             | 30318 |
| 41                                    | shuttle valve                | 30320 |
| 42                                    | compression spring           | 64407 |
| 49                                    | regulator                    | 44116 |
| 50                                    | gauge                        | 44117 |
| 51                                    | driver retainer              | 30331 |
| Not Shown                             | O-ring kit                   | 20248 |
| Consult Factory for parts not on list |                              |       |

Call us with questions 800-346-5039 or visit [www.amtakfasteners.com](http://www.amtakfasteners.com)

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