

Eastwood®

DO THE JOB RIGHT.®

Item #74163

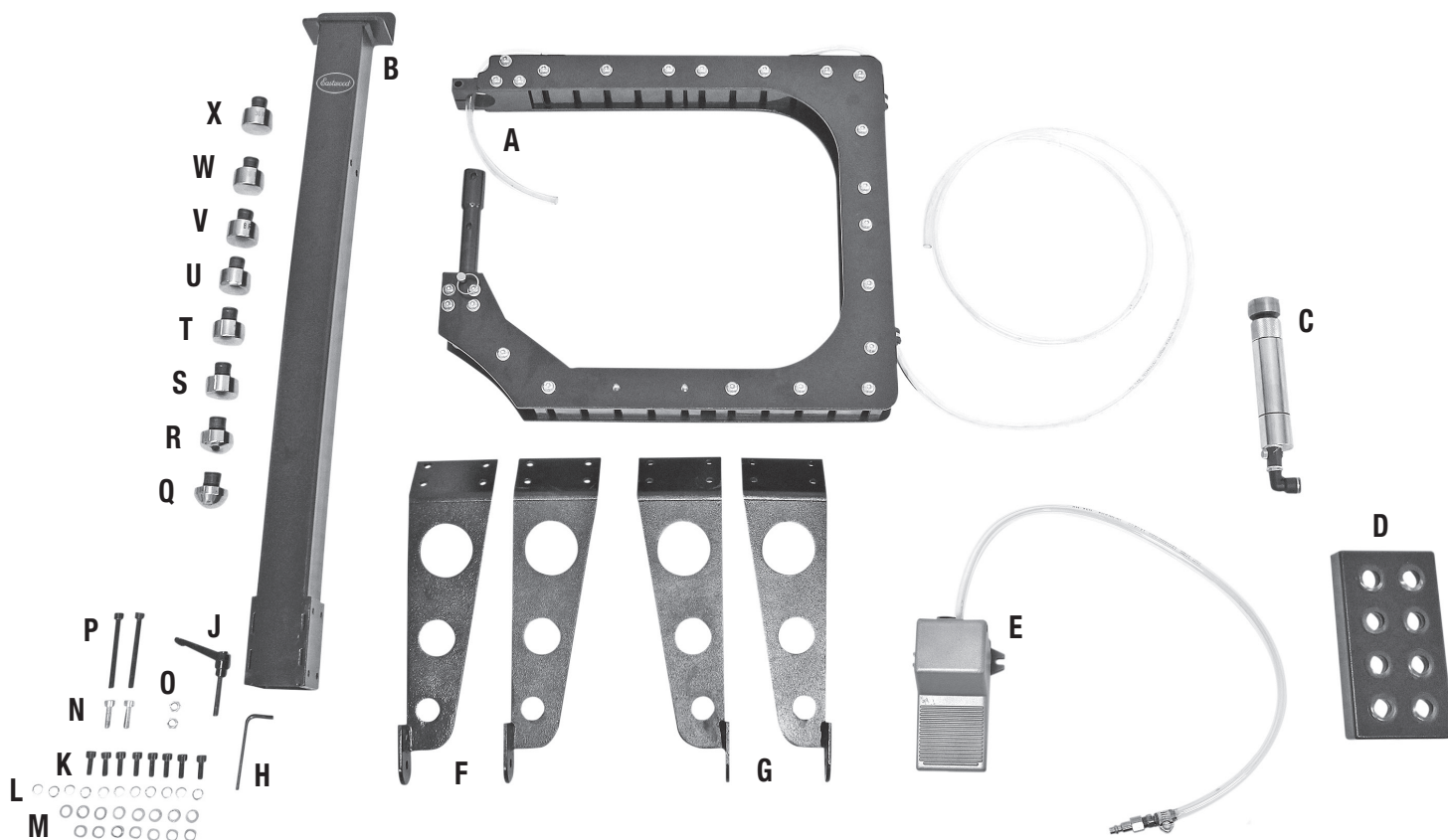
18" PNEUMATIC PLANISHING HAMMER INSTRUCTIONS



The **EASTWOOD 18" PNEUMATIC PLANISHING HAMMER** is a valuable tool in any hobbyist metalworker's arsenal. Planishing hammers are commonly used to smooth large areas of metal, weld beads, and create soft crowns. This pneumatically powered planishing hammer features an 18" throat depth, full assortment of essential anvils, foot pedal operation and an included stand. The quick-release anvil post pin enables fast, toolless anvil changes and clearance for deep-flanged panels. Rigid, steel frame construction allows you to form up to 18 gauge mild steel with ease. Speed up your panel forming workflow with a pneumatic planishing hammer that's sized perfectly for your shop!

INCLUDES

- | | | |
|--|----------------------------------|----------------------------|
| (1) Frame Assembly with Air Hose [A] | (1) M8x45 Adjustable Handle [J] | (1) 1" Radius Anvil [R] |
| (1) Post [B] | (8) M8x20 Socket Head Screws [K] | (1) 2" Radius Anvil [S] |
| (1) Air Hammer Assembly [C] | (11) M8 Lock Washers [L] | (1) 3" Radius Anvil [T] |
| (1) Anvil Tray [D] | (15) M8 Washers [M] | (1) 6" Radius Anvil [U] |
| (1) Foot Pedal with Air Hose and Air Fitting [E] | (2) M8x25 Socket Head Screws [N] | (1) 8" Radius Anvil [V] |
| (2) Feet Left [F] | (2) M8 Nylon Locking Nuts [O] | (1) 14.5" Radius Anvil [W] |
| (2) Feet Right [G] | (2) M8x80 Socket Head Screws [P] | (1) 36" Radius Anvil [X] |
| (1) 6mm Hex Key [H] | (1) 3/4" Radius Anvil [Q] | |



SPECIFICATIONS

Throat Depth:	18"	Anvil Retention:	O-ring
Material Thickness Capacity:	18 gauge mild steel 16 gauge aluminum 20 gauge stainless steel	Anvil Size:	Ø40mm
Hammer Speed:	1800 - 4600 BPM	Hammer Size:	Ø40mm
Air Requirement:	80 to 120 psi @ 4 SCFM	Working Height:	47.5"
		Overall Assembled Dimensions (L x W x H):	22" x 22" x 58"
		Overall Assembled Weight:	64.5 lbs.

SAFETY INFORMATION

The following explanations are displayed in this manual, on the labeling, and on all other information provided with this product:

DANGER

DANGER indicates a hazardous situation which, if not avoided, will result in death or serious injury.

WARNING

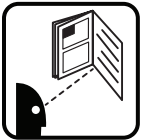
WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.

NOTICE

NOTICE is used to address practices not related to personal injury.



READ INSTRUCTIONS

- Thoroughly read and understand this manual before using.
- Save for future reference.



WARNING BURST HAZARD!

- Excessive air pressure can cause tool to explode, resulting in tool damage and personal injury. Do not exceed 120 psi [8.3 bar] of tool inlet air pressure.



WARNING EYE INJURY HAZARD!

- Metal particles can be ejected from the metal surface when planishing. Sheet metal edges and corners are sharp and can injure eyes. Always wear ANSI approved eye protection when operating this tool.



WARNING INJURY HAZARD!

- Handling sharp metal can cause serious cuts. Wear thick, well-fitting work gloves to prevent cuts from handling sharp metal.
- Using the planishing hammer generates excessive noise. Wear appropriate hearing protection while operating.
- The assembly consists of several large, heavy metal components. The use of safety toe shoes is strongly recommended when assembling.



CAUTION PINCH HAZARD!

- To prevent injury, keep fingers away from the hammer and anvil while operating.
- Avoid pinching hands while handling parts and during assembly. The use of thick, well-fitting work gloves is strongly recommended.



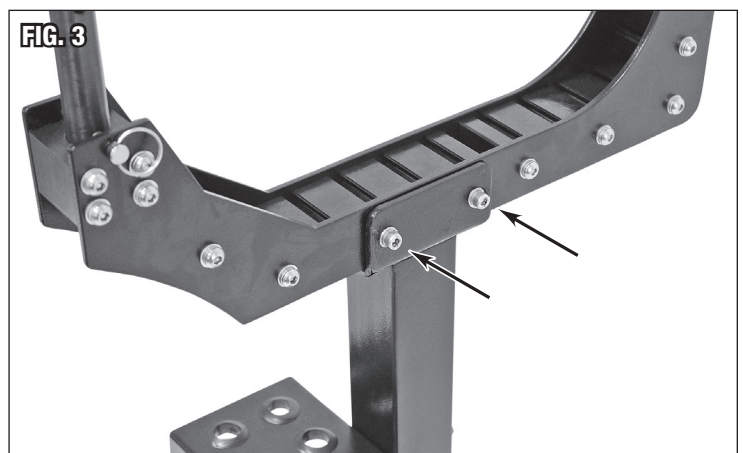
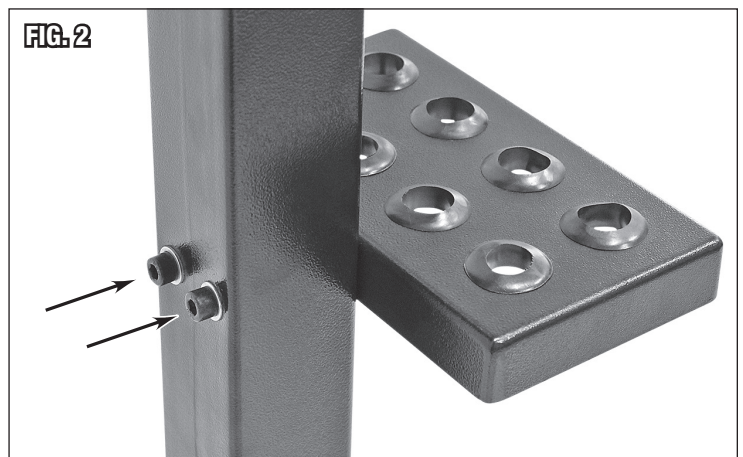
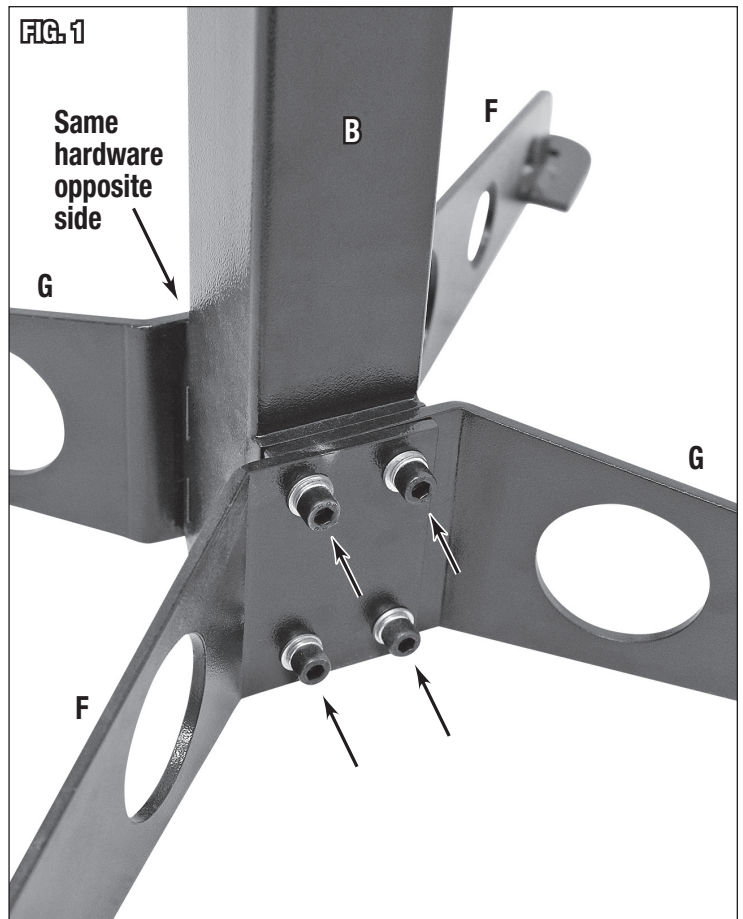
CAUTION INJURY HAZARD!

- This tool vibrates excessively during use. Prolonged, repeated exposure to vibration may cause physical injury.
- If accidentally triggered while connected to an air supply, this tool can quickly start up and cause personal injury. Always disconnect the tool from the air supply before changing anvils or performing maintenance.



ASSEMBLY

- Install the Feet Left and Right **[F, G]** to both sides of the Post **[B]** as shown in **(FIG 1)**. Fasten securely with the M8x20 Screws, Lock Washers, and Washers **[K, L, M]**.
- Install the Anvil Tray **[D]** to the Post with the M8x80 Screws, Washers, and Nylon Locking Nuts **[P, M, O]**. The anvils can be stowed in the tray **(FIG 2)**.
- With a suitable lifting device or assistance of a capable helper, hoist the Frame Assembly with Air Hose **[A]** to the Post mount and fasten securely with the M8x25 Screws, Lock Washers, and Washers **[N, L, M]** **(FIG 3)**.



- Remove the collar and hammer (**FIG 4**) from the Air Hammer Assembly [**C**] then slip it into the pinch collar at the top of the frame. Reinstall the hammer and collar, hand tighten snug (**FIG 5**).
- Install an anvil in the holder and adjust the height of the hammer such that the hammer is lowered minimum 1/16" into it's travel range. Reducing the travel range will reduce the force of the blows but increase the rate of blows (**FIG 5**). Then tighten pinch collar with the M8x45 Adjustable Handle, Lock Washer, and Washer [**F, L, M**].
IMPORTANT NOTE: Hammer must rest against anvil or internal snap ring and hammer shaft will be damaged.
- Drip a few drops of air tool lubricant into the hammer air inlet (**FIG 6**). You will need to repeat this periodically with use to keep the hammer lubricated.
- Insert the air line at the top of the frame into the push-to-lock fitting on the Air Hammer (**FIG 6**). Insert the opposite end into the push-to-lock fitting on the Foot Pedal with Air Hose and Air Fitting [**E**] (**FIG 7**).
- The planishing hammer will vibrate and "walk" around your shop floor during use. Anchoring it to the floor or laying sandbags over the feet to stabilize it is highly recommended.

FIG. 4



FIG. 5

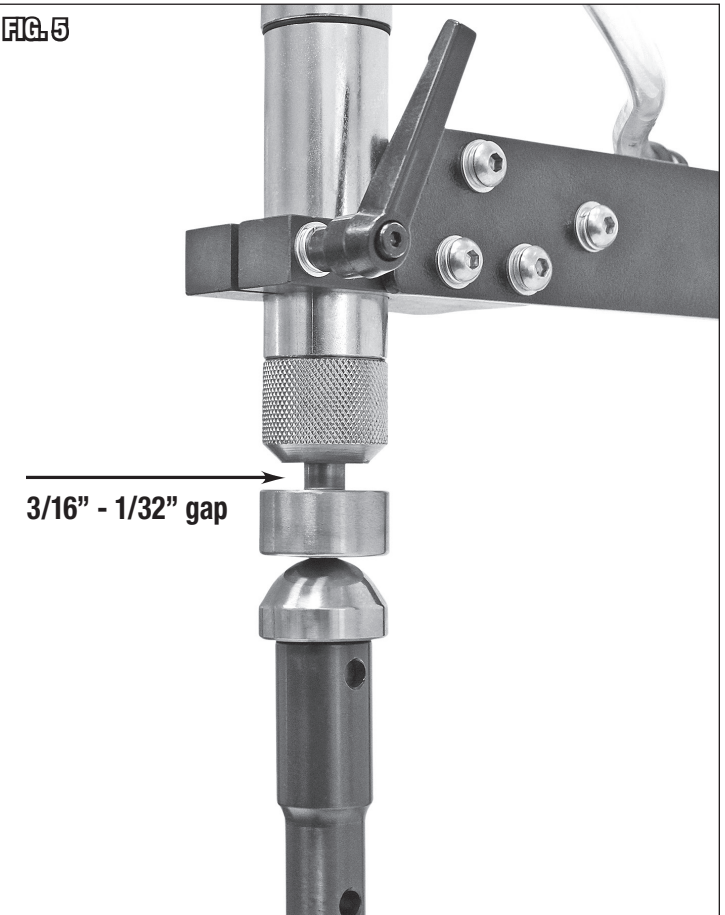


FIG. 6

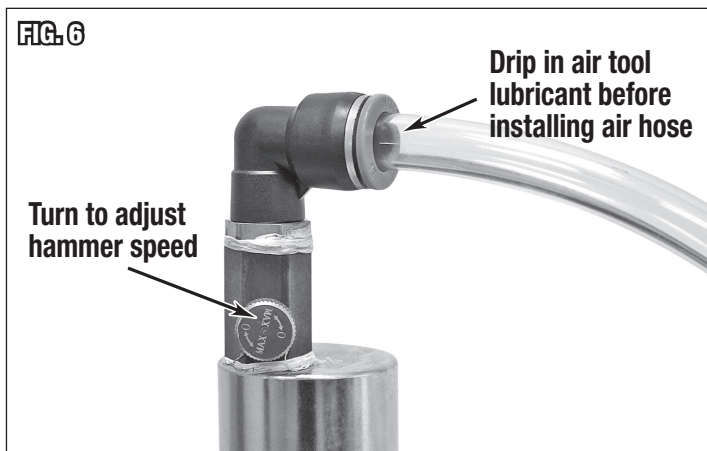
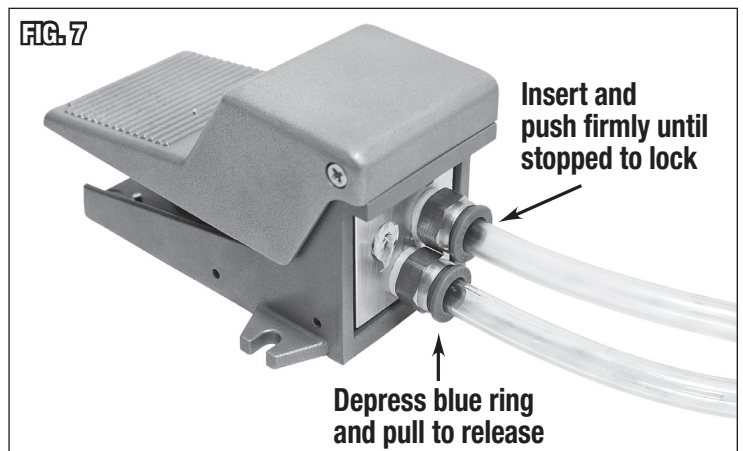


FIG. 7



SET-UP

AIR SUPPLY REQUIREMENTS

- The inlet air supply must have a moisture separator capable of removing all moisture and impurities from the air supply. Moisture and/or oil in the air supply will cause corrosion and failure of the Air Hammer.
- A suitable regulator must be used to limit incoming air pressure to 80-120 PSI. Excessive air pressure can cause permanent damage to the unit and possible serious personal injury from bursting.
- For best results, a compressor capable of providing a minimum of 4 CFM @ 90 PSI is required. Less flow will drastically reduce performance. Utilize a minimum of a 3/8" air line to connect to the planishing hammer.

ANVIL SELECTION

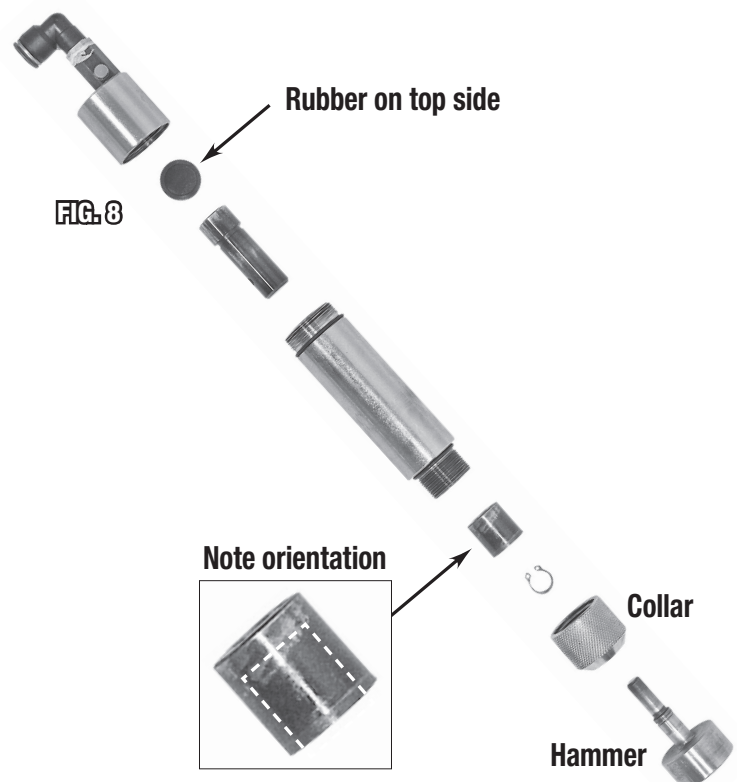
- Choose an anvil based on which profile best suits your desired curvature. Utilizing a radius profile gauge to check is highly recommended.
NOTE: The workpiece's final radius will always be greater than the anvil's and the amount of time working the metal will dramatically affect the finished radius as well.
- Install the anvil by pulling the anvil holder pin, lowering the anvil holder, and slipping the anvil into the holder. Raise the holder again and reinsert the pin for operation.

OPERATION

- Connect the planishing hammer to an air supply.
- Place the workpiece between the hammer and anvil and adjust the height as needed.
- The speed of the hammer may be adjusted by rotating the throttle valve knob. Adjusting by turning "MAX" to align with the body of the valve increases speed while turning "0" to align will decrease speed (**FIG 6**). Increased speed will deliver blows harder and more rapidly.
- Grip panel firmly and step on the foot pedal to run the planishing hammer. Release pedal to stop operation.
- Move the workpiece panel around evenly as necessary to form a crown or smooth out previously hammered, pleated, shrunken or stretched panel.
- A helpful tip is to create a gauge out of firm cardboard or wood before forming a crowned panel so that you may check your progress against it as you go.
- When finished with the planishing hammer, disconnect from the air supply.

MAINTENANCE

- Add several (3-5) drops of air tool lubricant to air inlet before each use.
- If tool is to be unused for an extended period, add 10 drops of air tool oil to the inlet before storing.
- Keep hammer and anvil surfaces clean of grit, metal chips, excess oil and debris.
- See air hammer exploded diagram (**FIG 8**). After heavy use, disassembly and cleaning is recommended. Sliding surfaces can be polished if desired.



TROUBLESHOOTING

PROBLEM	CAUSE	CORRECTION
Poor Hammer Performance	Throttle valve not sufficiently open	Adjust throttle valve position to more opened.
	Compressor inadequate, insufficient CFM	For best results, a compressor capable of sustaining at least 4 CFM @ 90 PSI is recommended. Lesser output will result in diminished performance.
	Pinched, kinked or damaged air supply hose	Straighten or replace air supply if required. Note: The shorter the air supply hose is, the better the performance.
	Air hammer requires maintenance	Disconnect air supply to foot pedal. Remove air supply hose and throttle valve at inlet of air hammer and add 10 drops of a good quality air tool oil.
	Moisture in air line	Eliminate source of moisture/water in air supply.
Excessive or Unusual Noise and Vibration	Loose fasteners	Check and tighten all stand, frame and hammer mounting hardware.

ADDITIONAL ITEMS

R&D MUST-HAVE ACCESSORIES



#28045
Eastwood Panelbeater Sandbag
and Teardrop Mallet



#73304
Eastwood English Wheel
with Floor Stand



#21489-21491
Eastwood Elite Deep Jaw Metal
Shrinker Stretcher and Stand

REPLACEMENT ITEMS

- #74171** 18" Eastwood Air Hammer Assembly (74163)
- #74172** 28" Eastwood HD Air Hammer Assembly (74164)

OPTIONAL ITEMS

- #74173** Eastwood Linear Stretching Anvil for 18" and 28" Planishing Hammers

Visit eastwood.com for complete info and pricing.

If you have any questions about the use of this product, please contact

The Eastwood Technical Assistance Service Department: 800.343.9353 >> email: tech@eastwood.com

PDF version of this manual is available at eastwood.com

The Eastwood Company 263 Shoemaker Road, Pottstown, PA 19464, USA 800.343.9353 eastwood.com

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