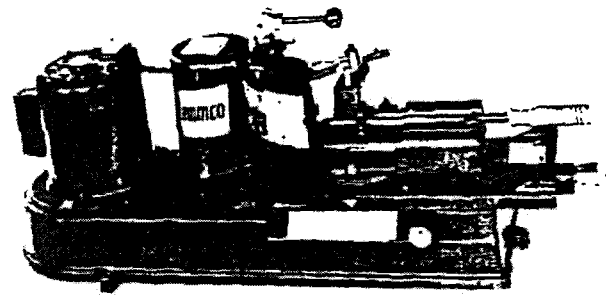


**COATS
BADA**

AMMCO

8000

AMMCO Brake Shoe Grinder



Installation and Operating Instructions *with Parts Identification*

8818 5/96

HENNESSY INDUSTRIES, INC.

P.O. Box 3002, 1601 J. P. Hennessy Drive, La Vergne, TN 37086-1982 615/641-7533 800/688-6359

HENNESSY INDUSTRIES INC Manufacturer of AMMCO®, COATS® and BADA® Automotive Service Equipment and Tools.

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IMPORTANT SAFETY INSTRUCTIONS

For All Tools As Applicable

1. Keep guards in place and in working order.
2. Remove adjusting keys and wrenches. Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
3. Keep work area clean. Cluttered areas and benches invite accidents.
4. Avoid dangerous environments. Don't use power tools in damp or wet locations. Do not expose them to rain. Keep work area well lighted.
5. Keep children away. All visitors should be kept a safe distance away from the work area.
6. Make the workshop kid-proof. Use padlocks and master switches. Remove starter keys.
7. Don't force a tool. It will do the job better and safer at the rate for which it was designed.
8. Use the right tool. Don't force a tool or an attachment to do a job for which it was not designed.
9. Wear proper apparel. No loose clothing, gloves, neckties, or jewelry to get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
10. Use safety glasses. Also use a face or dust mask if the cutting operation is dusty.
11. Secure the work. Use clamps or a vise to hold the work when practical. It's safer than using your hands and it frees both hands to operate the tool.
12. Don't overreach. Keep proper footing and balance at all times.
13. Maintain tools with care. Keep tool sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
14. Disconnect tools before servicing and when changing accessories such as blades, bits, cutters, etc.
15. Avoid unintentional starting. Make sure the switch is in the OFF position before plugging the tool in.
16. Use recommended accessories. Consult the manufacturer's catalogs for recommended accessories. The use of improper accessories may cause risk of injuries to operator and bystanders.
17. Never stand on a tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
18. Check damaged parts. Before the further use of a tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
19. Direction of feed. Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
20. Never leave tools running unattended. Turn the power off. Don't leave the tool until it comes to a complete stop.
21. Be sure equipment for asbestos dust control is in good working order. Breathing asbestos dust may cause serious bodily harm.

Basic Operations & Principal Operating Parts

Brake shoe grinding remains an important step in the professional brake job. Precision grinding helps cure squeal, grabbing and pulling, spongy pedal, and other erratic brake problems. It also helps compensate for worn, irregular, and even warped shoe cores. It provides correct lining-to-drum contact. And precision grinding provides near perfect brakes without "wear-in."

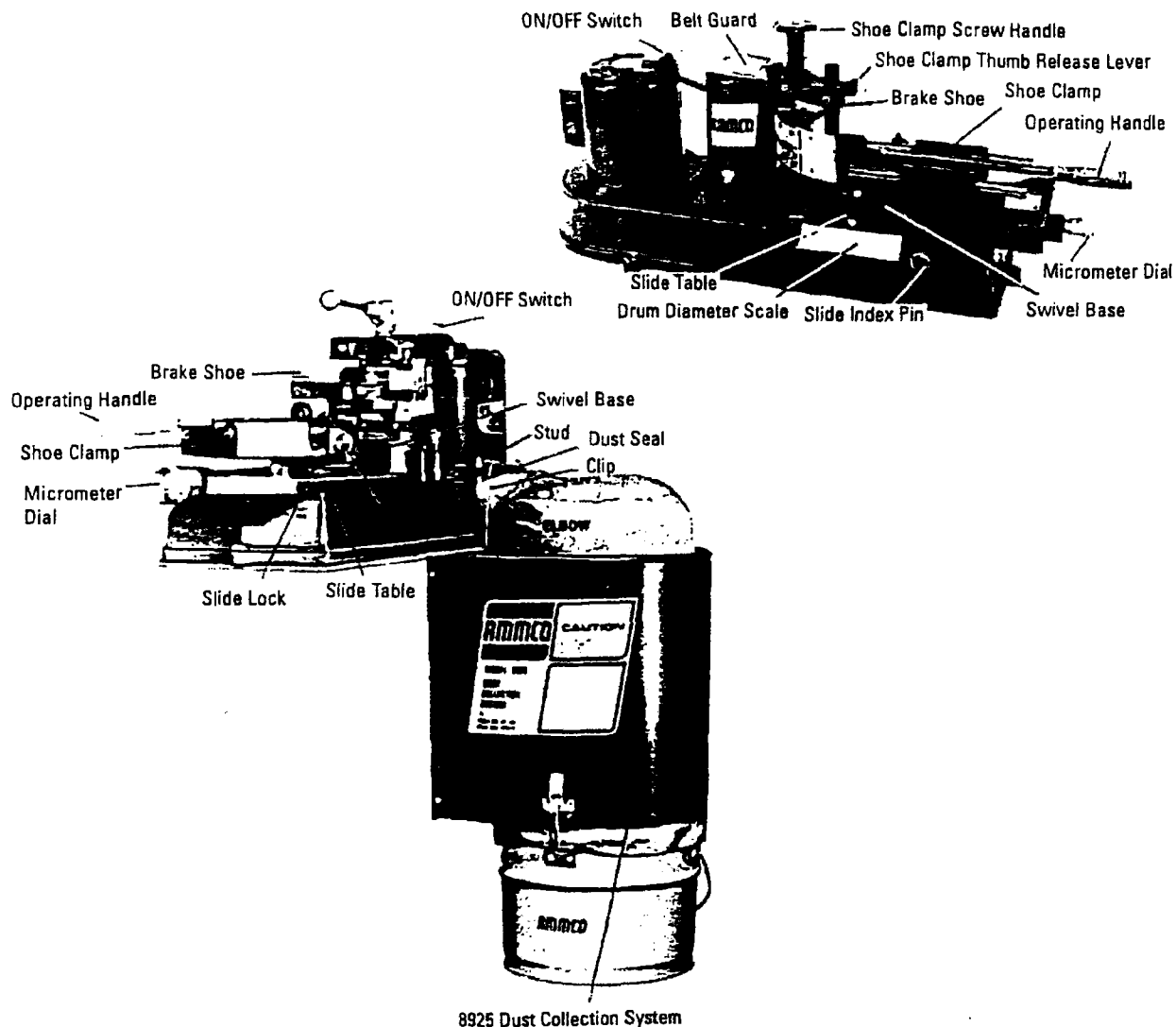
The 8000 is recommended for car dealers, independent garages, brake specialists, tire dealers, and other facilities that custom grind shoes to match a specific set of drums. - a must for shoes with oversized linings.

The 8925 Dust Collection System is standard with the 8000. In operation, it exceeds Federal Clean Air Standards set by the Occupational Safety and Health Act of 1972.

The dust collection system provides a highly efficient means of collecting, containing, and disposing of dangerous asbestos dust. The powerful suction fan built into the 8000 pulls dust from the surface of the brake shoe and deposits it in a sealable plastic bag. After proper installation, the 8925 requires only periodic replacement of the plastic disposal bag to maintain safe operating conditions.

Review Figure 1 for the location of the basic operating parts of the 8000 grinder.

Figure 1 - (Below) Basic Operating Parts (with 8050 Universal Shoe Clamp)



Electrical Requirements

Grounding

The 8000 should be electrically grounded to protect the operator from shock.

Cord Connected Grinders

The 8000 is equipped with an approved 3-conductor cord and a 3-prong grounding-type plug to fit the proper grounding-type receptacle. The green conductor in the cord is the grounding wire. Never connect the green wire to a live terminal. If your 8000 is for use on less than 150 volts, it has a plug as illustrated in Figure 2. There is not an adapter for 230 volt plugs or outlets.

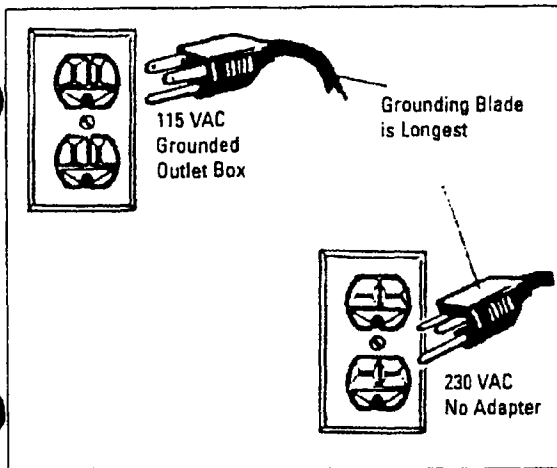


Figure 2 - Plugs and Outlets

Use only 3-wire extension cords which have 3-prong grounding-type plugs and 3-pole receptacles which accept the 8000's plug.

Replace or repair damaged or worn cords immediately.

Permanently Connected Grinders

The 8000 may be connected to a grounded, metal-enclosed wiring system such as that installed by a licensed electrician. A separate grounding conductor (wire) should be connected to the equipment grounding terminal on the grinder motor.

Grinder and Dust Collector Set-Up

The 8000 and the 8925 are mounted on the right hand end of the bench and, since the 8925 is attached to the bench end panel, the 8000 should not be bolted down until both units are properly positioned.

1. Set the 8000 on the bench top close to the right hand edge and just in from the front edge so that it is still comfortable to reach brake shoes in the clamp.
2. Assemble the 8925 Dust Collection System according to the instructions included with it.
3. Attach it to the 8000's exhaust port temporarily. Be sure to support it as necessary.
4. Turn the 8000 on to inflate the dust bag. Adjust the position of both until to ensure that there is no air restriction or unnecessary strain on the bag.

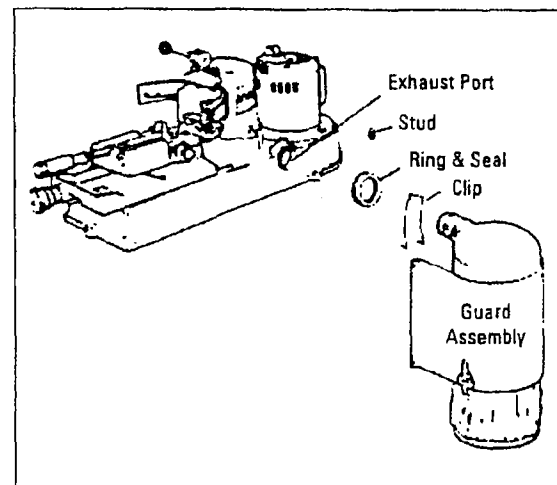


Figure 3 - Attaching the 8925

5. Slip the ring and seal onto the collector elbow and join the 8925 to the 8000's exhaust port.
6. Position the clip over the elbow behind the 2 protruding lugs.
7. Clip the feet of the clip under the 8000's base.
8. Snap the clip over the stud.

NOTE: The feet of the clip hook under the 8000's base to provide the necessary grip to seal the 2 units together when the clip is snapped over the stud.

9. Push the dust bag and rubber seal down through the guard to hang above the pail.
10. Press a plastic disposal bag into the bottom of the pail and unfold the excess over the top edge.

11. Lift the pail up under the guard assembly and press it against the rubber seal to seat it in the ring.
12. Clamp the pail to the system.

Abrasive Belts

1. Remove the 2 thumb screws and lift off the abrasive belt guard.
2. Remove the 2 allen screws from the retaining clip.
3. Remove the hold down clip.
4. Pull the retaining clip up and away from the belt, or slip the belt and clip of the arbor together.

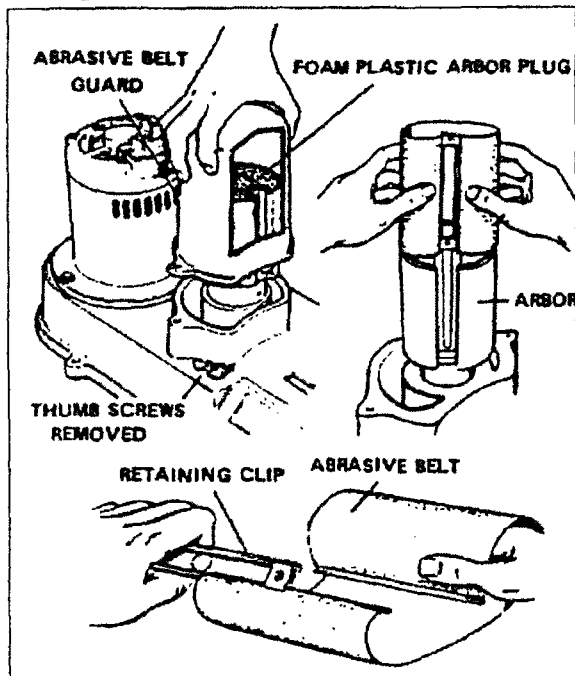


Figure 4 - Abrasive Belts

5. Remove the clip from the belt.
6. Place a new belt on the retaining clip by sliding the molded ends of the belt into the groove.
7. Slip the belt and clip over the arbor with the back of the belt contact the arbor first.
8. Work the belt onto the arbor from the back, forward and down, until the belt contacts the lower lip of the arbor completely around the circumference.
9. Replace the allen screws and the hold down clip working any looseness out of the belt by hand until it is snug on the arbor.

IMPORTANT: Do not overtighten the screws.

10. Replace the belt guard to assure proper removal of asbestos dust. Breathing of asbestos dust may cause serious bodily harm.

NOTE: The foam plastic arbor plug does not have to be removed from the arbor to replace the belt. If it is removed, be sure to replace it in the arbor.

Replacement abrasive belts are available from your AMMCO jobber in the following range of quantities and grits:

No. 8007	Standard Grit for General Service Package of 10
No. 8006	Production Grit for High Volume Work Package of 25



CAUTIONS



Use only AMMCO abrasive belts for positive results.

Do not let the shoe clamp hit the abrasive belt when a brake shoe is not loaded in it.

Do not tamper unnecessarily with the set screws on the micrometer dial.

Let the motor do the work for you. Do not remove more than 0.005" on any one cut - more will only slow the motor and reduce dust collection efficiency, thereby exposing the operator to unnecessarily excessive amounts of asbestos dust. Breathing asbestos dust may cause serious bodily harm.

Do not attempt to operate the grinder without a disposal bag in the pail of the dust collector.

Before starting the grinder, always check to be certain the entire dust collection system is correctly assembled to the grinder.

Seal and replace a disposal bag when it is half full. Do not empty and reuse a disposal bag. Do not subject yourself or others to exposure to breathing asbestos dust. Read and understand the disposal bag replacement instructions on the label of the guard assembly.

IMPORTANT: The AMMCO 5399 Dust Disposal Bags have been specifically designed to comply with the OSHA standards for safe disposal of asbestos waste to safeguard the health of the operator, and must not be reused or substituted.

In general, keep a clean work area. For your environmental safety, do not allow asbestos dust to accumulate anywhere but in the AMMCO disposal bag.

Lubrication

Clean all exposed metal parts frequently with an oiled rag.

Lubricate the grease fitting on the swivel base periodically with a multi-purpose chassis grease.

Add a few drops of oil through the lubrication holes provided on the grinder as needed.

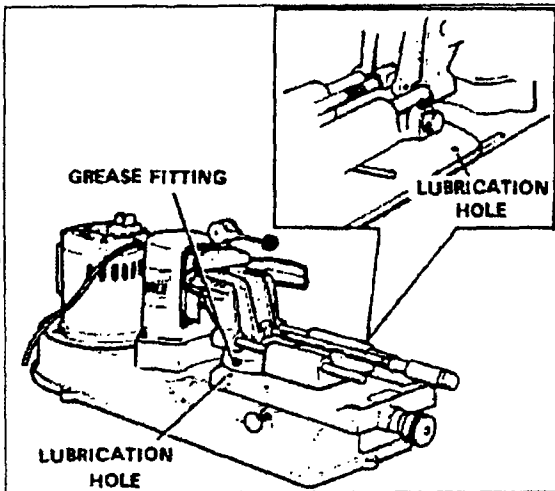


Figure 5 - Lubrication Points

Operating Instructions

1. Measure the inside diameter of the finished brake drum in which the shoe is to fit. Use a brake drum micrometer.

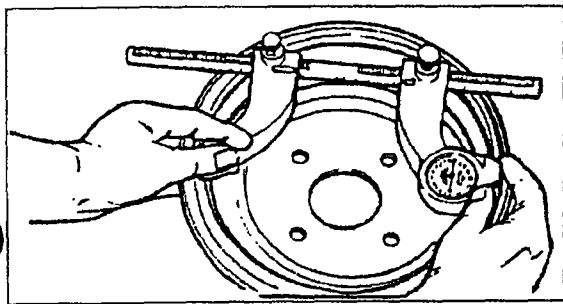


Figure 6 - Measure Inside Diameter

2. Release the slide lock.
3. Adjust the micrometer dial to zero.
4. Pull the slide index pin outward and slide the table to the proper drum diameter is indicated on the drum diameter scale.

NOTE: Drum diameters of 6" to 16" (150mm to 400mm).

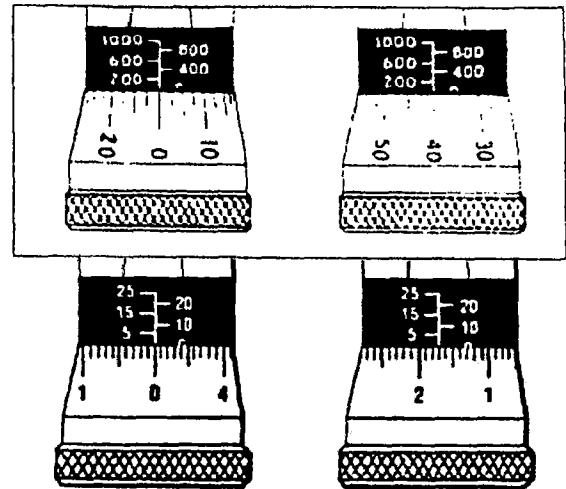


Figure 7 - Micrometer settings

Top - Inches; Set to Zero and Set to 0.040"

Bottom - Metric; Set to Zero and Set to 1.7mm

5. Set the micrometer dial to the exact drum diameter measure required: 0.000" to 1.000" (0.000mm to 25.000mm).

NOTE: The dial has a range of 1" (25mm) and thus can be set for any intermediate dimension. Each full revolution of the dial changes the diameter 0.200" (5mm).

IMPORTANT: The grinder is factory calibrated to grind 0.060" (1.5mm) **SMALLER** than the actual drum diameter. This is done automatically - you set the micrometer dial to the **EXACT** drum diameter required.

6. Tighten the slide lock by pulling the lever towards you.
7. Place the lined shoe in the shoe clamp and visually center the LINING in the clamp - not the entire shoe.
8. When shoe is fully seated, tighten the clamp.

Grinding

Before starting the motor, be sure the dust collection system and abrasive belt are correctly installed and in proper working order. The dust collector works automatically each time the grinder is turned on.

1. Lift the operating handle out of the half nut and push the clamp with the mounted shoe toward the abrasive belt. Stop when the shoe is just barely clear of the belt.
2. Lower the operating handle back into the half nut.
3. Swing the handle away from you (towards the dust collector).
4. Start the motor.

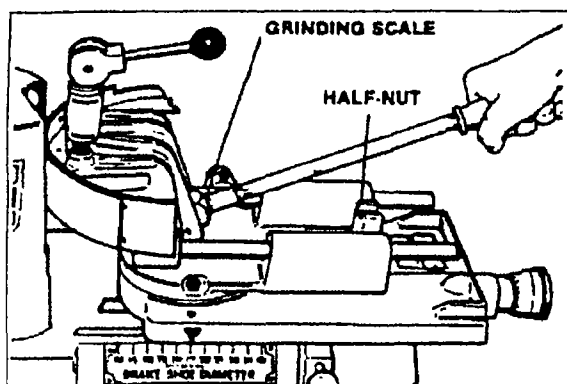


Figure 8 - Using Operating Handle

Twisting the operating handle clockwise advances the shoe into the abrasive belt. The grinding scale at the forward end of the handle is graduated in thousandths for operator convenience and is read to set the amount of grind for each swing of the handle. It is also read to keep the lining thickness of each set of brake shoes the same.

5. Advance the shoe no more than 0.005" (one graduation on metric models) at a time. Advance the shoe only when the operating handle is on the dust bag side of the grinder. This provides a smooth cut.
6. Use the handle to move the shoe across the abrasive surface at an even rate. Move the entire surface across the belt. Do not grind too fast.

Continue grinding until the shoe lining cleans up across its full arc, then stop. Additional grinding will only waste lining material.

The brake shoe has now been "cam ground" and its radius is 0.060" (1.5mm) smaller than the inside radius of the finished drum. This grind provides a slight toe and heel clearance at the very ends of the shoe lining segment of about 0.005" to 0.008" (0.001mm to 0.002mm).

V-Belt Tension Adjustment

The V-belt should operate with approximately 1/4" (6mm) of slack. Adjustment requires that the grinder be turned upside down. Remount the grinder to the bench properly after the adjustment and before operating the grinder.

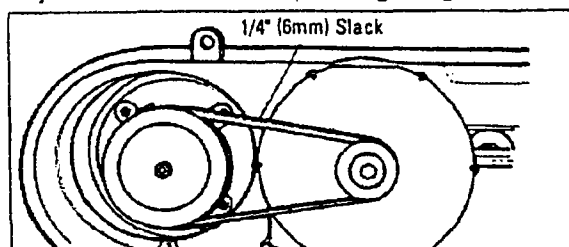


Figure 9 - V-Belt Tension

Calibration Check and Adjustment

To ensure accurate grinding to specified diameters, follow these instructions to check the calibration of the micrometer dial.

1. Pull out the slide index pin and move the slide to the 6" (150mm) setting.
2. Set the micrometer dial to zero.

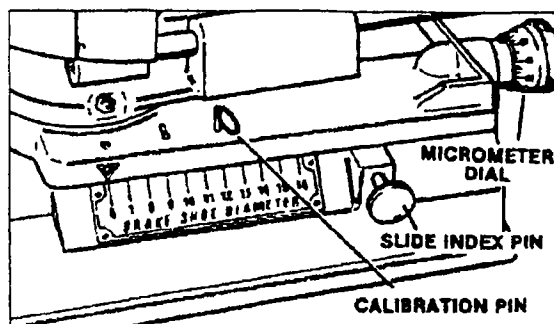


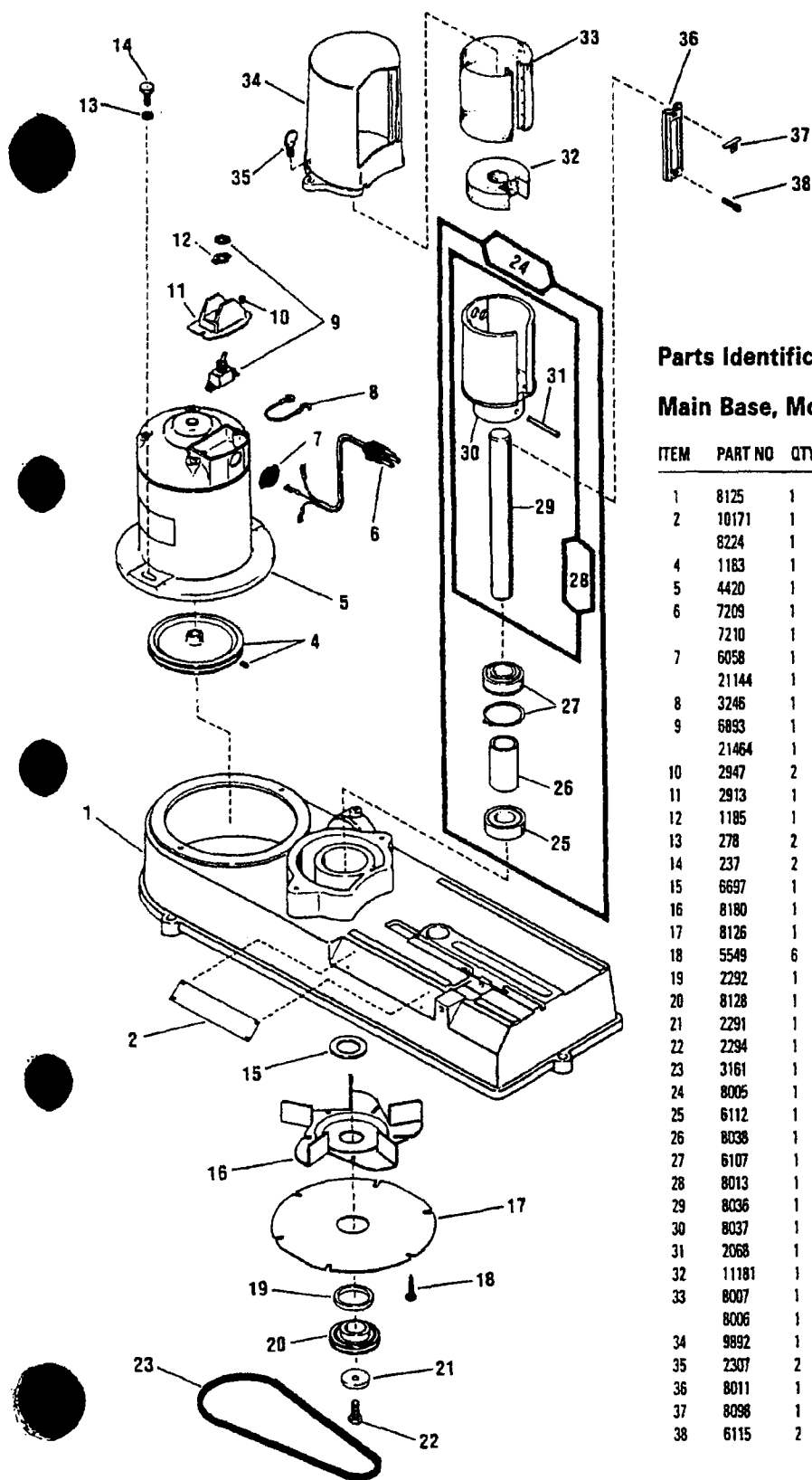
Figure 10 - Calibration Check

3. Start the 3/16" (4.762mm) diameter calibration pin (furnished with the grinder) into the hole in the slide.
4. While exerting only slight pressure against the pin, turn the micrometer dial gently back and forth until the pin drops through the hole.

The micrometer dial should read zero.

If the dial does not read zero, adjust the micrometer dial this way:

1. Leave the calibration pin in place and the slide locked.
2. Loosen the 2 allen set screws in the dial until the dial rotates freely.
3. Turn the micrometer dial to zero.
4. Hold the dial in place and tighten the set screws evenly.
5. Release the slide lock and remove the calibration pin.
6. Perform the calibration check again to verify the adjustment.



Parts Identification

Main Base, Motor, Abrasive Drive

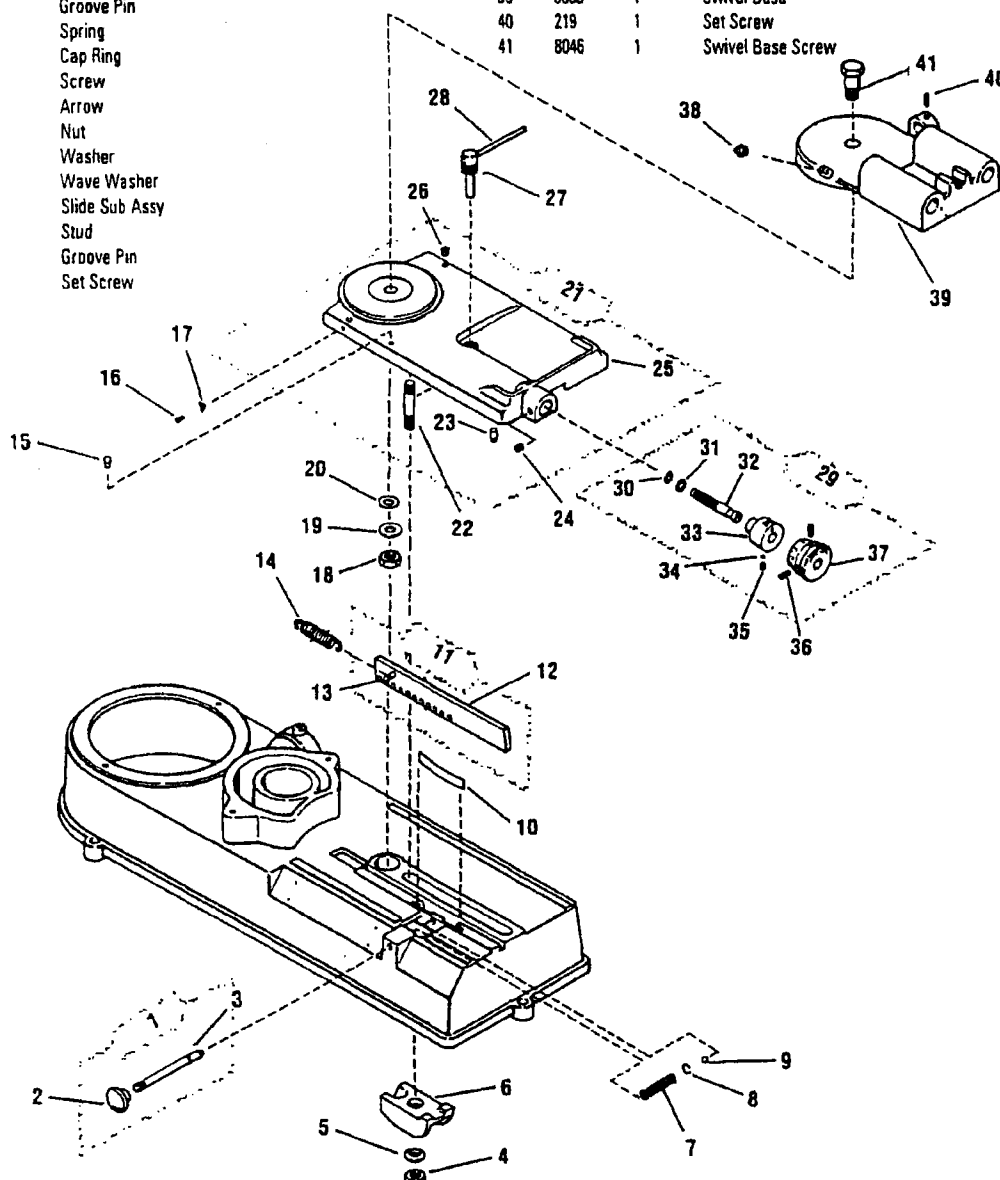
ITEM	PART NO	QTY	DESCRIPTION
1	8125	1	Main Base
2	10171	1	Diameter Setting Plate, English
	8224	1	Diameter Setting Plate, Metric
4	1183	1	"V" Pulley & Set Screw
5	4420	1	Motor
6	7209	1	Electric Cord Set, 110V
	7210	1	Electric Cord Set, 220V
7	6058	1	Cord Grip, 110V
	21144	1	Cord Grip, 220V
8	3246	1	Jumper Wire
9	6893	1	On/Off Switch & Nut, 110V
	21464	1	On/Off Switch & Nut, 220V
10	2947	2	Binding Head Machine Screw
11	2913	1	Switch Mounting Plate
12	1185	1	Switch Plate
13	278	2	Washer
14	237	2	Cap Screw
15	6697	1	Washer
16	8180	1	Exhaust Fan
17	8126	1	Exhaust Fan Cover
18	5549	6	Screw
19	2292	1	Dust Seal
20	8128	1	Spindle Pulley
21	2291	1	Washer
22	2294	1	Left Hand Bolt
23	3161	1	"V" Belt
24	8005	1	Arbor, Spindle & Bearing Assembly
25	6112	1	Ball Bearing
26	8038	1	Bearing Spacer
27	6107	1	Ball Bearing with Snap Ring
28	8013	1	Arbor & Spindle Assy. <i>Sold as Assembly Only!</i>
29	8036	1	Spindle
30	8037	1	Arbor
31	2068	1	Roll Pin
32	11181	1	Arbor Plug
33	8007	1	Replacement Abrasive Belt - Std.
	8006	1	Replacement Abrasive Belt - Prod.
34	9892	1	Abrasive Belt Guard
35	2307	2	Thumbscrew
36	8011	1	Abrasive Belt Retainer
37	8098	1	Hold Down Clip
38	6115	2	Nylock Socket Head Cap Screw

Parts Identification

Swivel Base, Misc. Parts

ITEM	PART NO	QTY	DESCRIPTION
1	8009	1	Locating Pin & Knob Assy. <i>Sold as Assembly Only</i>
2	320	1	Knob
3	8048	1	Locking Pin
4	2309	1	Stop Nut
5	2031	1	Spherical Washer
6	2032	1	Slide Clamp Screw
7	2018	1	Locating Pin Spring
8	2304	1	Spring Retaining Ring
9	2130	1	Ball
10	2131	1	Leaf Spring
11	8008	1	Adjusting Key Assy. <i>Sold as Assembly Only</i>
12	8045	1	Slide Adjusting Key - English
	8223	1	Slide Adjusting Key - Metric
13	2366	1	Groove Pin
14	530	1	Spring
15	6895	1	Cap Ring
16	306	1	Screw
17	8095	1	Arrow
18	2309	1	Nut
19	3214	1	Washer
20	6120	1	Wave Washer
21	8003	1	Slide Sub Assy
22	2030	1	Stud
23	2365	1	Groove Pin
24	6117	1	Set Screw

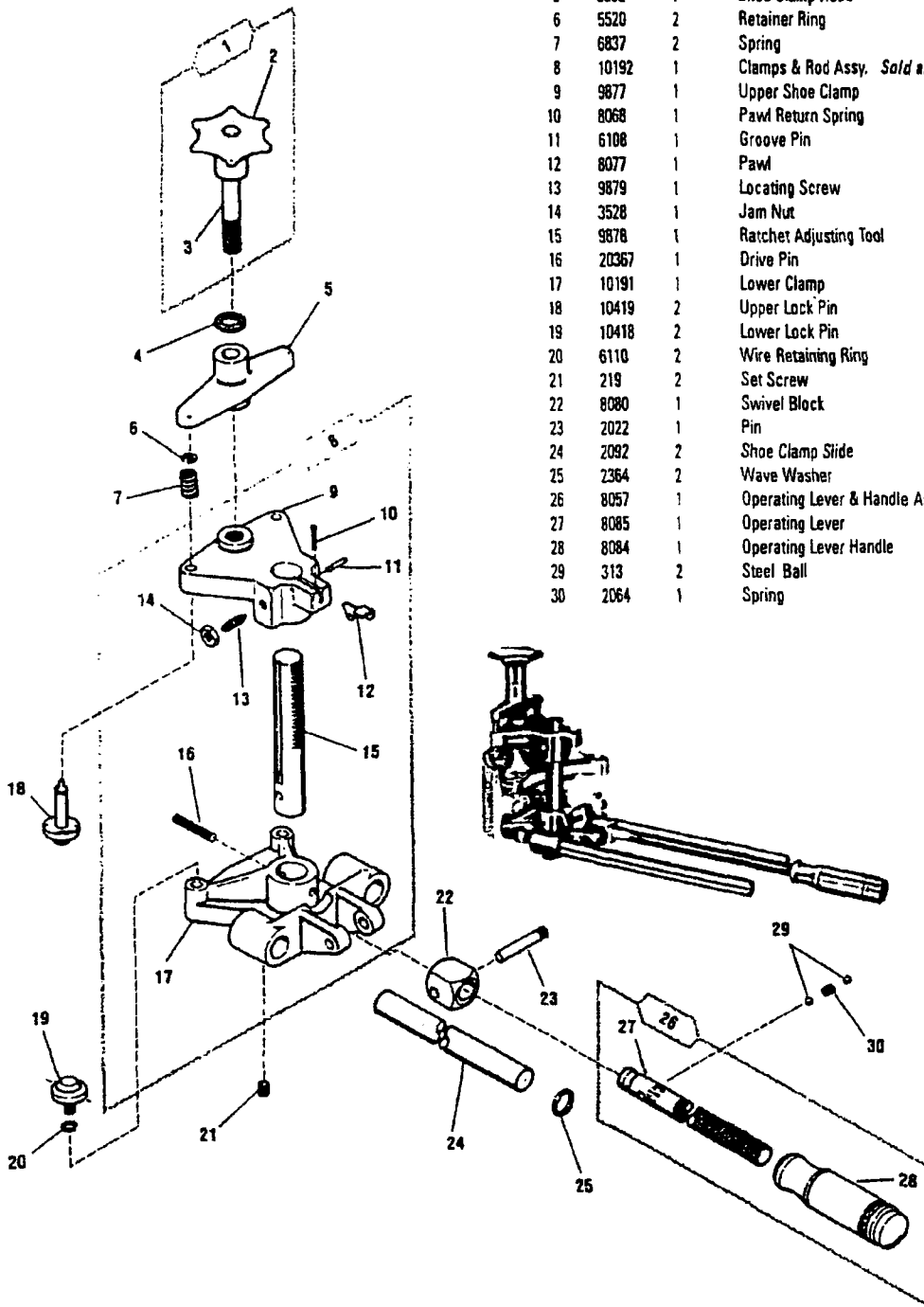
ITEM	PART NO	QTY	DESCRIPTION
25	8031	1	Slide
26	317	2	Gits Oiler
27	8024	1	Slide Clamp Stud
28	2029	1	Cross Pin
29	8096	1	Micrometer Dial & Screw Assy.
30	6113	1	Retaining Ring
31	6451	1	Washer
32	8027	1	Micrometer Screw - English
	8222	1	Micrometer Screw - Metric
33	8020	1	Micrometer Barrel - English
	8221	1	Micrometer Barrel - Metric
34	6407	1	Nylon Ball
35	6148	1	Set Screw
36	6117	2	Set Screw
37	8021	1	Micrometer Dial - English
	8225	1	Micrometer Dial - Metric
38	2999	1	Grease Fitting
39	8033	1	Swivel Base
40	219	1	Set Screw
41	8046	1	Swivel Base Screw



PARTS IDENTIFICATION

8050 UNIVERSAL BRAKE SHOE CLAMP

ITEM	PART NO	QTY	DESCRIPTION
1	8056	1	Shoe Clamp Screw Assy. <i>Sold as Assembly Only</i>
2	2015	1	Shoe Clamp Knob
3	8082	1	Clamping Stud
4	7124	1	Fiber Washer
5	8062	1	Shoe Clamp Hood
6	5520	2	Retainer Ring
7	6837	2	Spring
8	10192	1	Clamps & Rod Assy. <i>Sold as Assembly Only</i>
9	9877	1	Upper Shoe Clamp
10	8068	1	Pawl Return Spring
11	6108	1	Groove Pin
12	8077	1	Pawl
13	9879	1	Locating Screw
14	3528	1	Jam Nut
15	9878	1	Ratchet Adjusting Tool
16	20367	1	Drive Pin
17	10191	1	Lower Clamp
18	10419	2	Upper Lock Pin
19	10418	2	Lower Lock Pin
20	6110	2	Wire Retaining Ring
21	219	2	Set Screw
22	8080	1	Swivel Block
23	2022	1	Pin
24	2092	2	Shoe Clamp Slide
25	2364	2	Wave Washer
26	8057	1	Operating Lever & Handle Assy <i>Sold as Assembly Only</i>
27	8085	1	Operating Lever
28	8084	1	Operating Lever Handle
29	313	2	Steel Ball
30	2064	1	Spring

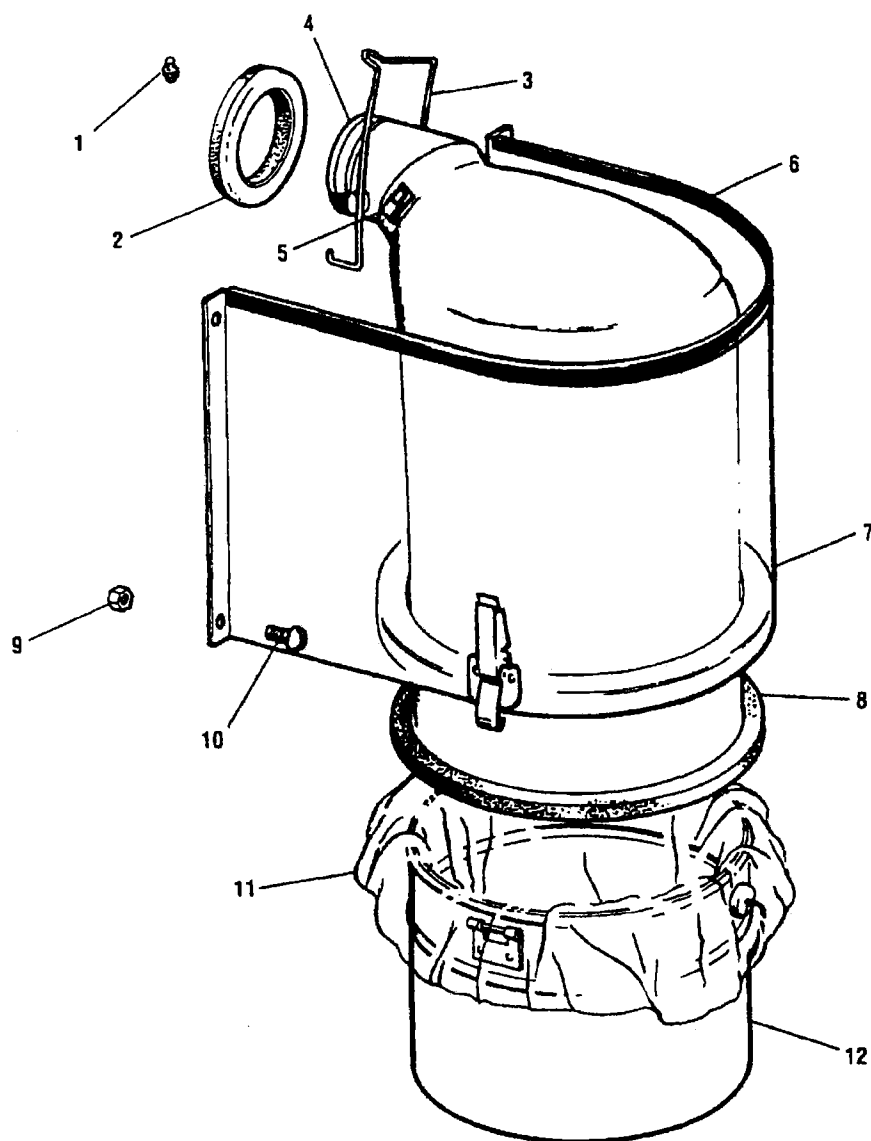


8000 Brake Shoe Grinder • 9

PARTS IDENTIFICATION

8925 Dust Collection System

ITEM	PART NO	QTY	DESCRIPTION
1	11192	1	Stud
2	11203	1	Ring & Seal Assembly
3	11197	1	Clip
4	11164	1	Dust Collector Elbow
5	11190	1	Hose Clamp
6	11207	1	Rubber Extension
7	11200	1	Ring & Guard Assembly
8	11199	1	Dust Bag & Seal
9	11213	1	Nut
10	6617	1	Screw
11	5399	1	Plastic Disposable Bags, Pkg. of 6
12	11214	1	Pail



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**FOR MOTOR CONNECTIONS,
SEE MOTOR NAMEPLATE**

Wire Size For 115 & 230 Volt Single Phase Circuits
Distance of Motor to Fuse or Meter Box in Feet

Motor HP	100 ft.		200 ft.		300 ft.		500 ft.	
	115 V	230 V	115 V	230 V	115 V	230 V	115 V	230 V
1	#8	#10	#6	#8	#4	#6		#4

RUNNING OVERLOAD PROTECTION

TIME DELAY FUSES AND THERMAL CUTOFFS — Use 125% of full load amps, as shown on the nameplate, for motors with 40 degree C rise or service factor over 1.0. Use 115% of full load amps, shown on the nameplate, for all other motors.

THERMAL PROTECTOR — Motors equipped with built-in thermal protection have the words "Thermally Protected" on the nameplate. Thermal protectors open the motor circuit electrically when the motor becomes too hot or is overloaded. Motors with a red button (manual) may be restarted by pressing the button after the motor cools. Motors with internal protectors (automatic) will reset themselves after the motor cools.

WARNING: DISCONNECT POWER BEFORE WORKING ON MOTOR DRIVEN EQUIPMENT. MOTORS WITH AUTOMATIC THERMAL PROTECTORS WILL AUTOMATICALLY RESTART WHEN THE PROTECTOR TEMPERATURE DROPS SUFFICIENTLY. DO NOT USE MOTORS WITH AUTOMATIC THERMAL PROTECTORS IN APPLICATIONS WHERE AUTOMATIC RESTART WILL BE HAZARDOUS TO PERSONNEL OR EQUIPMENT.

INSTALLATION INSTRUCTIONS

WARNING: These instructions must be followed to ensure safe and proper operation of the motor or generator.

A. Before coupling a motor or generator to a load applying power:

1. Check for shipping or handling damage.
2. Check for proper wiring. Line wiring must be of sufficient size to carry the current required in accordance with the NATIONAL ELECTRIC CODE and local codes.
3. Check for proper fuse size as required by the NATIONAL ELECTRIC CODE and local codes.
4. Shaft must be free to turn by hand.
5. Line voltage and frequency must match the motor or generator nameplate voltage and frequency.

Motor must be electrically grounded per NATIONAL ELECTRIC CODE and local codes.

B. Before coupling the motor to the load, apply power to determine whether:

1. Motor runs properly.
2. Rotation is correct.

C. After coupling the motor or generator to the load and applying power, make sure the motor comes up to speed and is not overloaded.

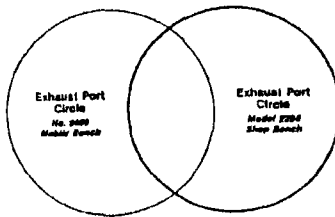
LUBRICATION

BALL BEARINGS — Sealed lubricated bearings require no attention during the life of the bearing. Motors with provisions for regreasing should have bearing grease added every 2000 hours of motor operation. Use Shell Oil Co. Alvania #2 or equivalent grease having a 200° safe operating temperature.

NOTE: If lubrication instructions are shown on the motor, they will supersede this general instruction.

REPAIR PARTS

Do not use unauthorized repair parts. These can affect the proper operation and safe operation if wrong. Use only authorized service stations and parts.



If mounting on other than AMMCO Model 2204 Shop Bench or No. 9890 Mobile Bench, align this circle with exhaust port on Shoe Grinder

FOLD ALONG THIS LINE IF MOUNTING ON AMMCO
MODEL 2204 SHOP BENCH OR NO. 9890 MOBILE BENCH

PLACE THIS EDGE UNDER TOP OF WORKBENCH OVERHANG

1-3/16"

#29 DRILL (.136 Dia.)
For Model 2204

7/32" DRILL
For No. 9890

12-5/8"

#29 DRILL (.136 Dia.)
For Model 2204

7/32" DRILL
For No. 9890



FULL SIZE DRILLING TEMPLATE MODEL 8925 DUST COLLECTION SYSTEM

DRILLING INSTRUCTIONS

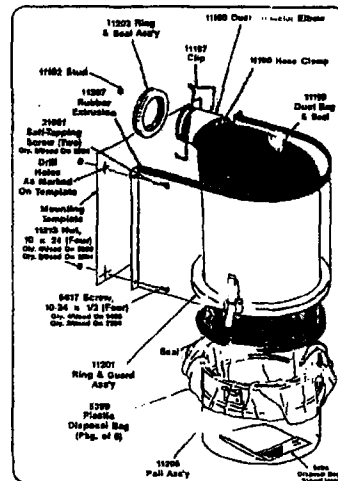
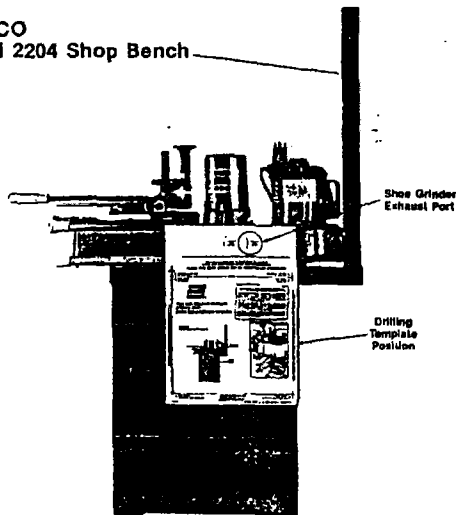
PLEASE READ ALL INSTRUCTIONS BEFORE INSTALLING
MODEL 8925 DUST COLLECTION SYSTEM

AMMCO Model 2204 Shop Bench: Fold the top edge of the drilling template along the dashed line and tape it in position on the end of the bench as illustrated. Be sure the Model 2204 exhaust port circle aligns with the exhaust port on the shoe grinder. Center punch all four mounting holes. Use a 7/32" bit to drill only the bottom two holes and a #29 drill bit to drill the top two holes. Mount the ring and guard assembly.

AMMCO No. 9890 Mobile Bench: Fold the top edge of the drilling template along the dashed line and tape it in position on the end of the bench as illustrated. Be sure the No. 9890 exhaust port circle aligns with the exhaust port on the shoe grinder. Center punch all four mounting holes. Use a 7/32" bit to drill all holes. Mount the ring and guard assembly.

Other Benches: Mounting hole locations can be established by taping the unfolded drilling template over the exhaust port of the Brake Shoe Grinder. Center punch and drill all four mounting holes. Use a 7/32" bit to drill all holes. Mount the ring and guard assembly.

AMMCO
Model 2204 Shop Bench



ALIGN EDGE OF PAPER WITH BACK EDGE OF WORKBENCH

This 13" Dimension Must Be Drilled Accurately To Properly Align The Mounting Holes.

13"

7/32" DRILL
For Both No. 9890 & Model 2204

AMMCO TOOLS, INC.
HOCKEY PARK
1000 N. CHICAGO, IL 60641 U.S.A.
(708) 441-1000

7/32" DRILL
For Both No. 9890 & Model 2204

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