



Pneumatic Rivet Buster

#550610, JCT-2610

#550611, JCT-2611

#550612, JCT-2612



JCT-2611 shown

Operation & Parts Manual

M-550610

Edition 1

07/2016



Stock No.:	
Serial No.:	
Purchased from:	
Date purchased:	

JET

427 New Sanford Road

LaVergne, TN 37086

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www.jettools.com

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Safety warnings

General air tool warnings

1. Read and understand this entire manual before attempting assembly or operation.
2. Read and understand all warnings posted on the tool and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. Do not use this tool for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
5. Always wear approved safety glasses or face shield while using this tool. (Everyday eyeglasses only have impact resistant lenses; they are *not* safety glasses.)
6. Wear ear protectors (plugs or muffs) if the noise exceeds safe levels.
7. Wear gloves and protective clothing if operation produces sparks or flying particles. Gloves should be tight-fitting, without frayed fingers or hanging threads. Keep hands and body away from the working area of tool.
8. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - Lead from lead based paint.
 - Crystalline silica from bricks, cement and other masonry products.
 - Arsenic and chromium from chemically treated lumber.
9. Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
9. Do not operate an air tool continually at full throttle without a work load on the tool.
10. The air tool must be properly lubricated before operating.
11. Never start a percussion type air tool (chipper, breaker, buster, etc.) without securing the tooling in the retainer and placing the tip against the work surface.
12. Do not operate air tool without its guards in place. Do not modify the tool.
13. Do not operate this tool while tired or under the influence of drugs, alcohol, or any medication.
14. Adopt a comfortable posture with proper balance, and maintain secure footing at all times. Non-slip footwear or anti-skid floor strips are recommended.
15. Do not wear loose clothing or jewelry. Confine long hair.
16. Excessive air pressure and too much free rotation may decrease life of the tool and may cause a hazardous situation.
17. Check air hoses for wear, and keep them away from heat and sharp edges. Repair or replace damaged air hose immediately. Do not carry tool by the air hose.
18. Air hose may cause tripping hazards; keep hose away from traffic areas.
19. Do not use this tool near flammable objects, or in potentially explosive environments. Do not use near live electrical wires.

20. Do not use power tools in damp or wet location, or expose them to rain. Keep work area well lighted.
21. Do not leave a connected tool unattended. When not in use, disconnect tool from air source.
22. Shut off air supply and discharge any residual pressure from tool before removing hose, making adjustments, changing accessories, or storing tool.
23. Make sure tool is switched off, and your finger off the trigger, before connecting to air supply.
24. Remove adjusting keys and wrenches before turning on tool.
25. Keep visitors a safe distance from the work area. *Keep children away.*
26. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
27. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
28. Repetitive motions and/or exposure to constant vibration can be harmful to hands and arms. Take frequent breaks and relax hands during extended operation. Change posture to avoid discomfort or fatigue.
29. Compressed air can be harmful if directed toward sensitive areas of the body, and may propel small particles caught in the air stream. Exercise proper caution.
30. Use only recommended accessories; improper accessories may be hazardous.
31. Maintain tools with care. Keep air tool clean and oiled for best and safest performance.
32. Do not use combustible gases, carbon dioxide, oxygen or any bottled gas as an air source for the tool. These can present risk of explosion and serious injury.
33. Do not lubricate the tool with combustible liquids, such as kerosene, diesel or jet fuel.
34. Do not dispose of this tool with normal household waste. Never dispose of the air tool into fire.

Specific warnings for Rivet Busters

35. This rivet buster is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a pneumatic rivet buster, do not use until proper training and knowledge have been obtained.
36. Use only correct working steel with proper shank and dimensions for this rivet buster, and that have a sharp cutting edge. Make sure steel is secured in rivet buster before pressing throttle lever.
37. Disconnect machine from air supply before changing working steel.
38. Do not point working steel toward yourself or bystanders.
39. Hold steel firmly against work surface before pressing throttle lever.
40. Always grip rivet buster with both hands.
41. Direct tool exhaust away from yourself and others.
42. A working steel may become hot and cause burns if touched. Allow steel to cool before removal or adjustments.

Familiarize yourself with the following safety notices used in this manual:



WARNING This means that if precautions are not heeded, it may result in serious, or even fatal, injury.



CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible tool damage.

About this manual

This manual is provided by JET, covering the safe operation and maintenance procedures for a JET Model JCT-2610 series Rivet Buster. This manual contains instructions on safety precautions, general operating procedures, maintenance procedures and parts breakdown. Your tool has been designed and constructed to provide consistent, long-term operation if used in accordance with the instructions set forth in this document.

The instructions and warnings in this manual may not encompass all possible workplace environments. The operator is expected to take appropriate precautions and exercise common sense. As with any tool operation, safety of operator and bystanders should be first priority.

If there are questions or comments, please contact your local supplier or JET. JET can also be reached at our web site: www.jettools.com.

Record the serial number and purchase information of your tool on the cover of this manual for quick access. Retain this manual for future reference. If the tool transfers ownership, the manual should accompany it.

Register your product online -

<http://www.jettools.com/us/en/service-and-support/warranty/registration/>

Tool specifications

Model number	JCT-2610	JCT-2611	JCT-2612
Stock number	550610	550611	550612
Bore	1-3/16 in. (30mm)		
Piston stroke	11 in. (279mm)	8 in. (203mm)	6 in. (153mm)
Impact rate (blows per minute)	850	1,140	1,560
Rivet capacity	1-1/4 in.	1-1/8 in.	1-1/16 in.
Energy per blow @90psi	80 lbf•ft	60 lbf•ft	45 lbf•ft
Average air consumption	44 CFM	44 CFM	50 CFM
Air inlet	1/2 in. NPT		
Air hose minimum inside diameter	1/2 in.		
Required air pressure	90 psi (6.2 bar)		
Vibration value	14 m/s ²	15 m/s ²	15 m/s ²
Noise level ¹	95-100 dB		
Overall length	25-1/2 in. (279mm)	22-1/2 in. (572mm)	20-1/2 in. (522mm)
Handle	D-style, drop-forged		
Retainer style	Jumbo 11X		
Housing material	Steel		
Required oil	Air Tool Oil (or ISO VG32/SAE 10W equivalent)		
Net weight	33 lb. (15 kg)	30 lb. (14kg)	26 lb. (12 kg)
Shipping weight	35 lb. (15.9 kg)	32 lb. (13.6 kg)	28 lb. (12.7 kg)

¹ The specified values are emission levels and are not necessarily to be seen as safe operating levels. As workplace conditions vary, this information is intended to allow the user to make a better estimation of the hazards and risks involved only.

Specifications were current at time of publication, but because of our policy of continuous improvement, JET reserves the right to change specifications at any time and without prior notice, without incurring obligations.

Setup and Assembly

Any missing parts or damage should be reported immediately to your JET® distributor. Do not use a damaged tool. Read this instruction manual thoroughly for operation, maintenance and safety instructions.

Box contents:

- 1 Rivet buster
- 1 Screw clamp
- 1 Operation and parts manual
- 1 Warranty card



Figure 1

1. Rotate exhaust deflector (Figure 1) until exhaust holes point away from operator and bystanders.
2. Install screw clamp on exhaust deflector to secure its position.

Operation

CAUTION The rivet buster must be properly lubricated before operation. See “Lubrication” section.

1. Install working steel (not provided) as follows. See Figure 2.
2. Place screwdriver or other tool in triangular end of retainer spring, and pull spring out of groove.
3. Slide retainer off cylinder. If needed, insert screwdriver into slot and use as wedge to help loosen retainer.
4. Lubricate shank of working steel with grease. Insert steel through rear of retainer. (Make

sure upper sleeve is fitted into cylinder, and lower sleeve and bumper are fitted into retainer.)

5. Slide steel and retainer onto cylinder. Shank of steel should be fully inserted into cylinder, and retainer slot should align with groove on cylinder.



Figure 2 (chisel not provided)

6. Install spring by feeding it into groove until completely installed. If needed, spray lubricant into groove to facilitate spring insertion. Tug sharply on the working steel to ensure it is secure.

WARNING An unsecured steel can be ejected from the cylinder with force, causing injury. Retainer and retainer spring must be properly installed before using rivet buster.

7. Remove protective cap from air inlet (Figure 1). If an in-line oiler is not being used, add 4 or 5 drops of air tool oil (not included) into the air inlet.
8. Blow out air line to remove any dirt or moisture, then connect air supply hose to tool. Set air pressure to 90 psi.

IMPORTANT: Connecting a quick-change coupling directly to the tool is not recommended, as vibration may cause the connection to fail. Instead, add a leader hose and install any quick-change couplings farther down the line.

9. Hold rivet buster firmly with both hands. Place end of tool in contact with work surface, and press throttle lever. Do not push too hard; allow tool to do the work.
10. Release throttle lever to stop tool.

Important: Do NOT raise air pressure above maximum rating for this rivet buster. If tool is not accomplishing task at maximum air pressure and flow, use a larger tool or different means to achieve task.

Maintenance

Inspect rivet buster before each use. Ensure that working steel is secured inside retainer. After use, wipe down the tool with a rag. Periodically apply light coat of oil to exposed metal surfaces to inhibit rust.

Lubrication

The rivet buster should be lubricated daily (or before each use) with air tool oil through the air inlet. During continual operation, it should be re-oiled every 1 to 2 hours. This can be done with an in-line oiler, or manually. If done manually, proceed as follows:

1. Disconnect air hose from tool.
2. Place 4 or 5 drops of air tool oil into air inlet.

NOTE: Air tool oil not provided; it is available at most major hardware and tool stores. SAE #10 oil or sewing machine oil may be used as a substitute. Do not use detergent oil.

3. Re-connect air. Run rivet buster at low throttle without load for a few seconds to distribute the oil throughout the tool.

When you are finished operating rivet buster, turn off air supply and press throttle lever to bleed residual air. Disconnect air hose. Wipe off housing with a dry cloth. Place 4 or 5 drops of air tool oil into air inlet; re-connect air and run the tool for a few seconds to distribute oil. Bleed residual air again and disconnect air hose.

Storage

Avoid storing the rivet buster in very humid locations which promotes rusting of internal mechanisms. Always oil the tool and disconnect air hose before storage.

Air system requirements

1. Use proper air hose size (refer to tool specifications). The hose should be just long enough to serve the working area. Excessive hose length will cause pressure drop.

2. Make sure air compressor supplies clean, dry air at correct CFM for the angle grinder.
3. Set air pressure to 90 psi.



Excess air pressure and/or unclean air will shorten the tool's life and may create a hazardous situation.

4. Drain water from air compressor tank daily, as well as any condensation from air lines. Water in the air line may enter the tool and cause damage.
5. Change filters on the air system on a regular basis.
6. Air-line pressure may be increased accordingly to compensate for extra-long air hoses (usually over 25 feet). Inside diameter of hose should be minimum 1/2-inch.

General Air Tool Information

If the air tool is not performing according to specifications, the following are among the most common causes. (See also "Troubleshooting" section.)

- Contaminated air such as a dirty air system or water in the system.
- Using wrong size tool for the job.
- Poor maintenance practices, such as using excessive air pressure or air volume.
- Improper or no lubrication.

Rule of Thumb

If it takes more than 8 seconds to tighten or loosen a bolt or nut with an air impact wrench, the air wrench is too small or the air compressor CFM is not powerful enough for the job. Continued use in either capacity will cause damage to the tool.

Tool Pressure

JET Air Tools operate on 70-to-100 psi (pounds per square inch) air pressure measured at the tool when the tool is operating. Set tool to 90 psi unless indicated otherwise. Pressure in excess of 100 psi will shorten the life of the tool.

Air System Recommendations

Equip the air compressor intake with a replaceable air filter that can be easily cleaned.

Use safety shut-off valves so air flow can be stopped quickly in case of a line break.

When using multiple hoses, air hoses should be larger than leader hose. Join multiple hoses directly, rather than with quick connect fittings which may cause pressure drops and tool power reduction.

Use anti-whip devices across hose couplings to prevent hose from whipping in the event of a hose failure or coupling disconnect.

Always use moisture traps at the compressor for the main distribution line. Use moisture traps and in-line oilers on each downline that is to be used

for air tools. (See Figure 4). Place oiler as close to air tool as possible for best lubrication.

Lubrication

Use a light oil containing rust inhibitors, identified as "Air Tool Oil," or an ISO VG32 (SAE 10W) equivalent. Many JET air tools have integral oil reservoirs, which should be kept filled when in-line oilers are not used.

If greasing is required, use a grease that is highly water resistant for the front case components on air impact wrenches, grinders and sanders.

Recycling

Protect the environment. Your tool contains materials which can be recovered or recycled. When its useful life has expired, please leave tool at a specialized facility.

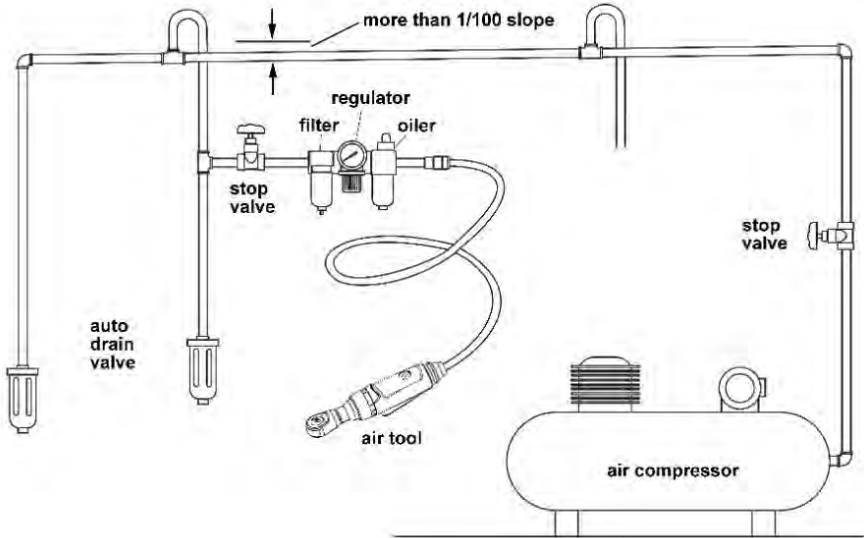


Figure 3

Recommended arrangement of air piping and air line system

Troubleshooting JCT-2610 series Rivet Busters

Any disassembly of the tool should be done by qualified service personnel. For problems not addressed below, contact JET technical service at 800-274-6846.

Problem	Possible cause	Remedy
Tool will not start.	Air valve closed or obstructed.	Open valve; clear any obstructions.
	Dirt or gum deposits on components.	Flush tool with gum solvent. If problem persists, disassemble, clean and lubricate internal parts.
	Throttle lever malfunction.	Clean throttle lever mechanism to ensure free movement. Replace mechanism if needed.
	Piston seized due to improper lubrication.	Lubricate tool according to instructions.
Starts immediately as soon as air is connected without lever being pressed.	Throttle valve malfunction.	Inspect and repair throttle valve.
Excessive or abnormal vibration.	Improper lubrication.	Lubricate properly according to instructions in this manual.
Loss of power; erratic action.	Low air pressure or air volume.	Verify compressor has proper CFM rating for tool. Check compressor regulator setting; set air pressure to 90 psi. Check for loose connections at air inlet, o-rings, etc.
	Moisture or obstruction in air hose.	Air supply must be clean and dry. Clean out air hose(s) and remove any kinks or bends.
	Improper size of air transmission lines, hoses, fittings, or couplings. Or, air supply line too long.	Use appropriate-sized air lines/hoses. Verify proper fittings, couplings. Use shorter supply line if needed.
	Dirt or gum deposits on components.	Flush tool with gum solvent. Check and clean air filter on compressor. Clean external areas of tool. If problem persists, disassemble, clean and lubricate internal parts.
	Bumper or upper/lower sleeves excessively worn.	Replace elements as needed.
	Loss of impact, or loss of blows per minute.	Check clearance between piston and cylinder. Maximum clearance should be 0.005 in. (0.13mm). Check that piston moves freely and is not seized.
	Throttle valve seizing.	Inspect; clean or replace elements.

Problem	Possible cause	Remedy
Severe air leakage. (Note: Minimal escape of air is often normal for air tools.)	Leakage from air inlet.	Change O-rings and check for loosening of air inlet nut.
	Leakage from throttle valve area.	Check for wear of throttle valve elements. Replace as needed.
Excessive heat develops in tool.	Improper lubrication.	Lubricate properly according to instructions in this manual.
	Worn internal parts.	Inspect and replace as needed.
Tool continues to operate after releasing throttle lever.	Throttle valve pin or bushing is damaged.	Inspect and replace elements as needed.
	Blockage in valve area.	Remove any foreign matter.
Steel tool is loose.	Steel shank does not match retainer bushing.	Use steel with correct shank type.
	Upper sleeve is worn.	Replace upper sleeve.

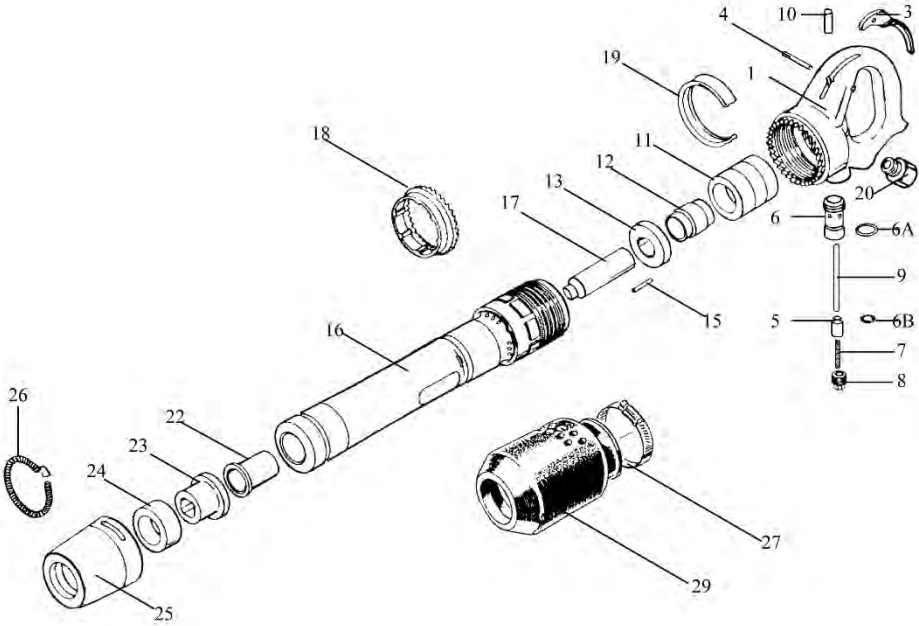
Replacement parts

Service parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Please have the stock number and serial number of your tool available when you call, so that we may serve you quickly and accurately.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET.

Some parts are shown for reference only, and may not be available individually.

#550610, JCT-2610 Rivet Buster 11in. – exploded view

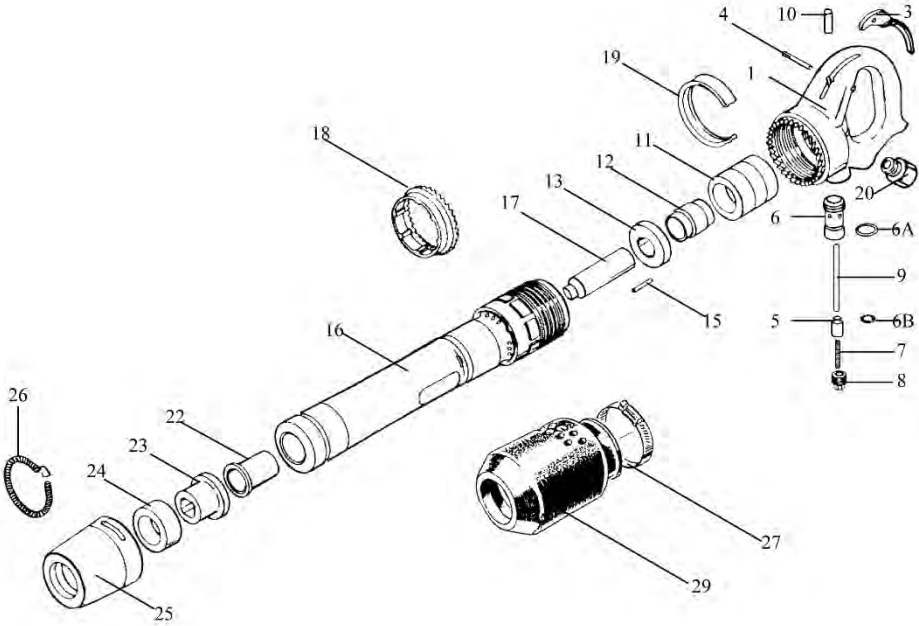


#550610, JCT-2610 Rivet Buster 11in. – parts list

Index	Part No.	Description	Qty
1	JCT2610-01	Handle	1
	JCT2610-HA	Handle assembly (#1-10)	1
3	JCT2610-03	Throttle lever	1
4	JCT2610-04	Throttle lever pin	1
5	JCT2610-05	Throttle valve	1
6	JCT2610-06	Throttle valve bushing	1
6A	JCT2610-06A	Throttle bushing O-ring	1
6B	JCT2610-06B	Throttle valve O-ring	1
7	JCT2610-07	Throttle valve spring	1
8	JCT2610-08	Throttle valve plug	1
9	JCT2610-09	Throttle valve pin	1
10	JCT2610-10	Valve pin bushing	1
	JCT2610-VA	Valve assembly (#11-15)	1
11	JCT2610-11	Valve case	1
12	JCT2610-12	Valve	1

Index	Part No.	Description	Qty
13	JCT2610-13	Valve cover front	1
15	JCT2610-15	Valve dowel pin	1
16	JCT2610-16	Cylinder 6in.	1
17	JCT2610-17	Piston	1
18	JCT2610-18	Clutch ring	1
19	JCT2610-19	Clutch band	1
20	JCT2610-20	Air inlet bushing 1/2in.NPT	1
22	JCT2610-22	Upper sleeve	1
23	JCT2610-23	Lower sleeve	1
24	JCT2610-24	Urethane bumper	1
25	JCT2610-25	Retainer	1
26	JCT2610-26	Retainer spring	1
27	JCT2610-27	Screw clamp	1
29	JCT2610-29	Exhaust deflector	1

#550611, JCT-2611 Rivet Buster 8in. – exploded view

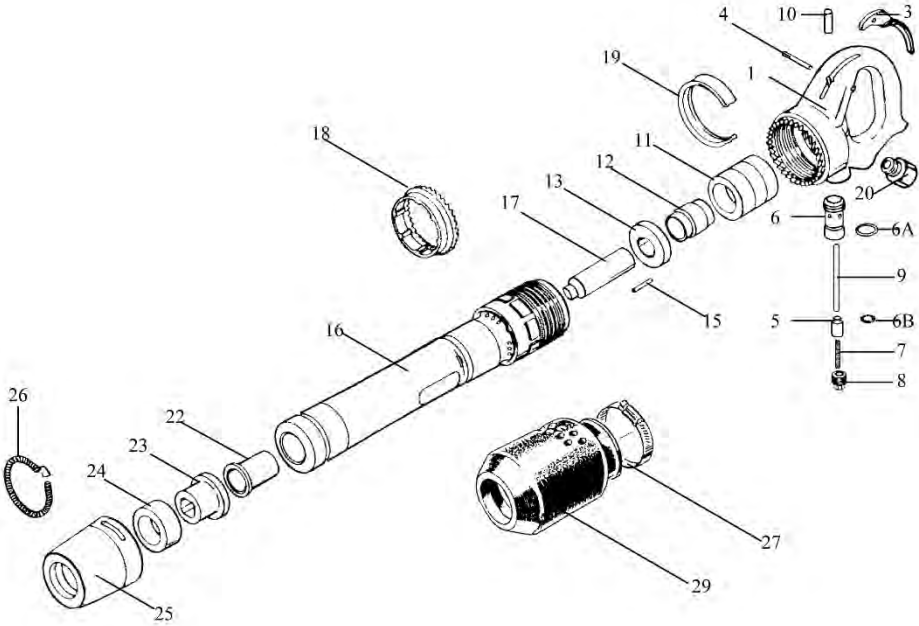


#550611, JCT-2611 Rivet Buster 8in. – parts list

Index	Part No.	Description	Qty
1	JCT2610-01	Handle	1
	JCT2610-HA	Handle assembly (#1-10)	1
3	JCT2610-03	Throttle lever	1
4	JCT2610-04	Throttle lever pin	1
5	JCT2610-05	Throttle valve	1
6	JCT2610-06	Throttle valve bushing	1
6A	JCT2610-06A	Throttle bushing O-ring	1
6B	JCT2610-06B	Throttle valve O-ring	1
7	JCT2610-07	Throttle valve spring	1
8	JCT2610-08	Throttle valve plug	1
9	JCT2610-09	Throttle valve pin	1
10	JCT2610-10	Valve pin bushing	1
	JCT2610-VA	Valve assembly (#11-15)	1
11	JCT2610-11	Valve case	1
12	JCT2610-12	Valve	1

Index	Part No.	Description	Qty
13	JCT2610-13	Valve cover front	1
15	JCT2610-15	Valve dowel pin	1
16	JCT2611-16	Cylinder 8in.	1
17	JCT2611-17	Piston	1
18	JCT2610-18	Clutch ring	1
19	JCT2610-19	Clutch band	1
20	JCT2610-20	Air inlet bushing 1/2in.NPT	1
22	JCT2610-22	Upper sleeve	1
23	JCT2610-23	Lower sleeve	1
24	JCT2610-24	Urethane bumper	1
25	JCT2610-25	Retainer	1
26	JCT2610-26	Retainer spring	1
27	JCT2610-27	Screw clamp	1
29	JCT2610-29	Exhaust deflector	1

#550612, JCT-2612 Rivet Buster 6in. – exploded view



#550612, JCT-2612 Rivet Buster 6in. – parts list

Index	Part No.	Description	Qty
1	JCT2610-01	Handle	1
	JCT2610-HA	Handle assembly (#1-10)	1
3	JCT2610-03	Throttle lever	1
4	JCT2610-04	Throttle lever pin	1
5	JCT2610-05	Throttle valve	1
6	JCT2610-06	Throttle valve bushing	1
6A	JCT2610-06A	Throttle bushing O-ring	1
6B	JCT2610-06B	Throttle valve O-ring	1
7	JCT2610-07	Throttle valve spring	1
8	JCT2610-08	Throttle valve plug	1
9	JCT2610-09	Throttle valve pin	1
10	JCT2610-10	Valve pin bushing	1
	JCT2610-VA	Valve assembly (#11-15)	1
11	JCT2610-11	Valve case	1
12	JCT2610-12	Valve	1

Index	Part No.	Description	Qty
13	JCT2610-13	Valve cover front	1
15	JCT2610-15	Valve dowel pin	1
16	JCT2612-16	Cylinder 11 in.	1
17	JCT2611-17	Piston	1
18	JCT2610-18	Clutch ring	1
19	JCT2610-19	Clutch band	1
20	JCT2610-20	Air inlet bushing 1/2inNPT	1
22	JCT2610-22	Upper sleeve	1
23	JCT2610-23	Lower sleeve	1
24	JCT2610-24	Urethane bumper	1
25	JCT2610-25	Retainer	1
26	JCT2610-26	Retainer spring	1
27	JCT2610-27	Screw clamp	1
29	JCT2610-29	Exhaust deflector	1

Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines, may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

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Product Listing with Warranty Period

90 Days – Parts; Consumable items
1 Year – Motors; Machine Accessories
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools; Air Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.

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