

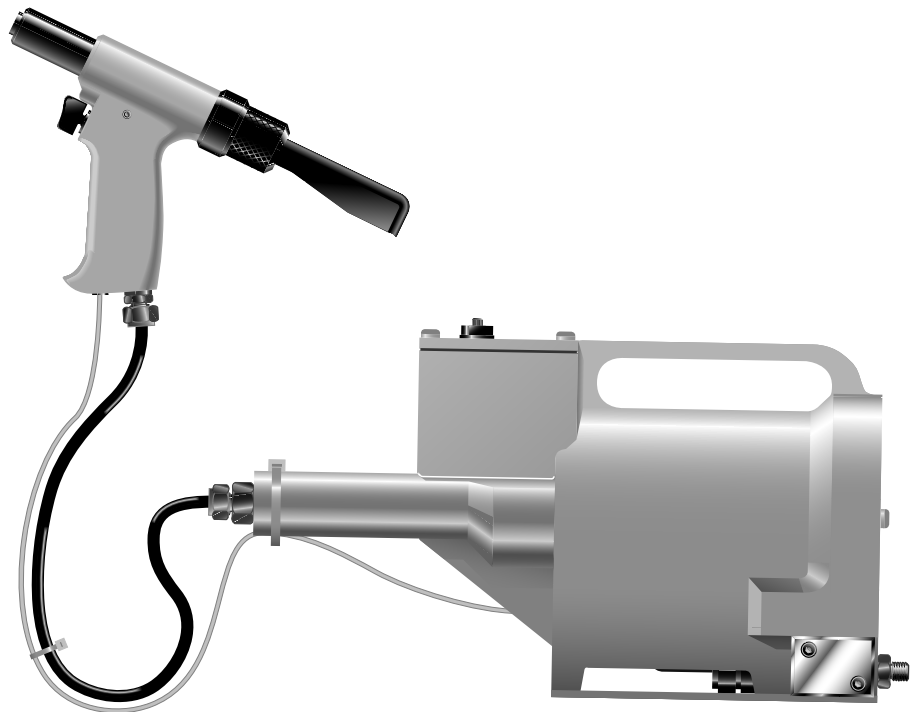


An Acument™ Global Technologies Company



Instruction Manual

Pass onto user to read and keep for reference



Hydro-Pneumatic Power Tool

0724 type

07241-07242-07243-07244-07245



AVDEL policy is one of continuous development. Specifications shown in this document may be subject to changes which may be introduced after publication. For the latest information always consult Avdel.

SPECIFICATIONS FOR 0724 TOOL			
AIR PRESSURE	Minimum - Maximum	5 - 7 bar	70 - 100 lbf/in ²
FREE AIR VOLUME REQUIRED	@ 5.5 bar / 80 lbf/in ²	9 litres	.32 ft ³
STROKE	07241 / 4 / 5 Minimum	18.54 mm	.73 in
	07242 / 3 Minimum	15.9 mm	.63 in
PULL FORCE	@ 5.5 bar / 80 lbf/in ²	10.20 kN	2250 lbf
CYCLE TIME	Approximately	1 second	
NOISE LEVEL		70.3 dB(A)	
WEIGHT	Without nose equipment	0.76 kg	1.7 lb
VIBRATION	Less than	2.5 m/s ²	8 ft/s ²

SPECIFICATIONS FOR 0724 INTENSIFIER			
AIR PRESSURE	Minimum - Maximum	5 - 7 bar	70 - 100 lbf/in ²
INTENSIFICATION RATIO	50:1 @ 80 lbf/in ²		

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This instruction manual must be read with particular attention to the following safety rules, by any person installing, operating or servicing this tool.

❗ DO NOT USE OUTSIDE THE DESIGN INTENT.

❗ DO NOT USE EQUIPMENT WITH THIS TOOL/MACHINE OTHER THAN THAT RECOMMENDED AND SUPPLIED BY AVDEL.

❗ ANY MODIFICATION UNDERTAKEN BY THE CUSTOMER TO THE TOOL/MACHINE, NOSE ASSEMBLIES, ACCESSORIES OR ANY EQUIPMENT SUPPLIED BY AVDEL OR THEIR REPRESENTATIVES, SHALL BE THE CUSTOMER'S ENTIRE RESPONSIBILITY. AVDEL WILL BE PLEASED TO ADVISE UPON ANY PROPOSED MODIFICATION.

❗ THE TOOL/MACHINE MUST BE MAINTAINED IN A SAFE WORKING CONDITION AT ALL TIMES AND EXAMINED AT REGULAR INTERVALS FOR DAMAGE AND FUNCTION BY TRAINED COMPETENT PERSONNEL. ANY DISMANTLING PROCEDURE SHALL BE UNDERTAKEN ONLY BY PERSONNEL TRAINED IN AVDEL PROCEDURES. DO NOT DISMANTLE THIS TOOL/MACHINE WITHOUT PRIOR REFERENCE TO THE MAINTENANCE INSTRUCTIONS. CONTACT AVDEL WITH YOUR TRAINING REQUIREMENTS.

❗ THE TOOL/MACHINE SHALL AT ALL TIMES BE OPERATED IN ACCORDANCE WITH RELEVANT HEALTH AND SAFETY LEGISLATION. IN THE U.K. THE "HEALTH AND SAFETY AT WORK ETC. ACT 1974" APPLIES. ANY QUESTION REGARDING THE CORRECT OPERATION OF THE TOOL/MACHINE AND OPERATOR SAFETY SHOULD BE DIRECTED TO AVDEL.

❗ THE PRECAUTIONS TO BE OBSERVED WHEN USING THIS TOOL/MACHINE MUST BE EXPLAINED BY THE CUSTOMER TO ALL OPERATORS.

❗ ALWAYS DISCONNECT THE AIRLINE FROM THE TOOL/MACHINE INLET BEFORE ATTEMPTING TO ADJUST, FIT OR REMOVE A NOSE ASSEMBLY.

❗ DO NOT OPERATE A TOOL/MACHINE THAT IS DIRECTED TOWARDS ANY PERSON(S).

❗ ALWAYS ADOPT A FIRM FOOTING OR A STABLE POSITION BEFORE OPERATING THE TOOL/MACHINE.

❗ ENSURE THAT VENT HOLES DO NOT BECOME BLOCKED OR COVERED AND THAT HOSES ARE ALWAYS IN GOOD CONDITION.

In addition to the general safety rules opposite, the following specific safety points must also be observed:

⚠ THE OPERATING PRESSURE SHALL NOT EXCEED 7 BAR - 100 LBF/IN².

⚠ DO NOT OPERATE THE TOOL WITHOUT FULL NOSE EQUIPMENT IN PLACE. 07242 AND 07243 TOOLS SHOULD NOT BE OPERATED IF THE GUARD IS DAMAGED IN ANY WAY.

⚠ CARE SHALL BE TAKEN TO ENSURE THAT SPENT STEMS ARE NOT ALLOWED TO CREATE A HAZARD.

⚠ 07241 & 07244 TOOLS MUST BE FITTED WITH AN UNDAMAGED PINTAIL DEFLECTOR OR STEM CATCHER BEFORE OPERATING.

⚠ IF THE 07241 OR 07244 TOOL IS FITTED WITH A PINTAIL DEFLECTOR AND IS USED IN THE VERTICAL NOSE DOWNWARD POSITION, THE PINTAIL DEFLECTOR SHOULD BE ROTATED UNTIL THE APERTURE IS FACING AWAY FROM THE OPERATOR AND OTHER PERSON(S) WORKING IN THE VICINITY.

⚠ THE INTENSIFIER RETAINING RING MUST BE ASSEMBLED WITH THE RETAINING PLATE SPECIFIED.

⚠ WHEN USING THE TOOL, THE WEARING OF SAFETY GLASSES IS REQUIRED BOTH BY THE OPERATOR AND OTHERS IN THE VICINITY TO PROTECT AGAINST RIVET EJECTION, SHOULD A FASTENER BE PLACED 'IN AIR'. WE RECOMMEND WEARING GLOVES IF THERE ARE SHARP EDGES OR CORNERS ON THE APPLICATION.

⚠ TAKE CARE TO AVOID ENTANGLEMENT OF LOOSE CLOTHES, TIES, LONG HAIR, CLEANING RAGS ETC. IN THE MOVING PARTS OF THE TOOL WHICH SHOULD BE KEPT DRY AND CLEAN FOR BEST POSSIBLE GRIP.

⚠ WHEN CARRYING THE TOOL FROM PLACE TO PLACE KEEP HANDS AWAY FROM THE TRIGGER/LEVER TO AVOID INADVERTENT START UP.

⚠ EXCESSIVE CONTACT WITH HYDRAULIC OIL SHOULD BE AVOIDED. TO MINIMIZE THE POSSIBILITY OF RASHES, CARE SHOULD BE TAKEN TO WASH THOROUGHLY.

INTENT OF USE

The hydro-pneumatic 0724 type tool is designed to place Avdel breakstem rivets at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

The 07241 and 07244 fitted with pin tail deflectors are the standard tools. A stem catching or full vacuum extraction option is available for the 7241 (see page 11). The 07244 tool has forward stem ejection nose equipment fitted when supplied as a complete tool. It is also possible to order just the base tool part number 07241-00200 which will not be fitted with a nose assembly.

The 07245 is fitted with vacuum stem extraction and a stem catcher as standard. It is possible to order the base tool only, part number 07245-00200, which is shown on page 22.

The base tool part number for the other two tools of this type, the 07242 and 07243, is 07242-00200 shown on page 22.

07241 TOOL SELECTION

FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk head except 07241-00024 large flange only	1/8"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-02000	07241-00001
		Al. Alloy	Extended	12.9	58.4	.510	2.3	07241-02100	07241-00002
		Steel	Standard	3.3	61	.130	2.4	07241-02600	07241-00008
		Al. Alloy	Hd. Forming	3.3	61	.130	2.4	07241-03300	07241-00021
	3mm	Al. Alloy	Standard	3.3	61	.130	2.4	07241-02500	07241-00006
	5/32"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-02600	07241-00008
		Al. Alloy	Extended	11.4	58.4	.450	2.3	07241-02700	07241-00009
		Steel	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
		Al. Alloy	Hd. Forming	3.3	61	.130	2.4	07241-03400	07241-00022
	3/16"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
		Al. Alloy	Extended	10.0	58.4	.395	2.3	07241-03100	07241-00016
		Al. Alloy	Hd. Forming	4.1	61	.160	2.4	07241-03500	07241-00023
		Al. Alloy/L.Flange	Standard	4.1	61	.162	2.4	07241-03600	07241-00024
		Steel	Standard	3.3	61	.130	2.4	07241-03700	07241-00026
MONOBOLT *	3/16"	Al. Alloy & Steel	Standard	4.1	61	.160	2.4	07241-04200	07241-00031
BULBEX	5/32"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-02600	07241-00008
	3/16"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
	5/32"	Al. Alloy	Extended	11.4	58.4	.450	2.3	07241-02700	07241-00009
	3/16"	Al. Alloy	Extended	10.0	58.4	.395	2.3	07241-03100	07241-00016
AVSEAL	4mm	Al. Alloy	Standard	4.5	61	.177	2.4	07241-05000	07241-00064
		Al. Alloy	Extended	6.7	61	.264	2.4	07241-05500	07241-00074
	5mm	Al. Alloy	Standard	4.5	61	.179	2.4	07245-03100	07241-00065
		Al. Alloy	Extended	6.7	61	.264	2.4	07245-04100	07241-00075
	6mm	Al. Alloy	Standard	5.3	61	.208	2.4	07245-03200	07241-00066
		Al. Alloy	Extended	7.2	61	.283	2.4	07245-04200	07241-00076
	6.5mm	Al. Alloy	Standard	5.3	61	.208	2.4	07241-04900	07241-00062
		Al. Alloy	Extended	7.2	61	.283	2.4	07241-05400	07241-00072
	7mm	Al. Alloy	Standard	5.3	61	.208	2.4	07245-03400	07241-00067
		Al. Alloy	Extended	7.2	61	.283	2.4	07245-04400	07241-00077
TLR	3/16"	Al. Alloy	Standard	4.1	61	.160	2.4	07241-04800	07241-00058
AVINOX BE11 & BE61	1/8"	Stainless Steel	Standard	3.3	61	.130	2.4	07241-02600	07241-00008
	5/32"	Stainless Steel	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
	3/16"	Stainless Steel	Standard	3.3	61	.130	2.4	07241-03800	07241-00027
AVDEL Snap head & 100° csk & 120° csk	1/8"	St. Steel & Titanium	Standard	3.3	56	.130	2.2	07241-02200	07241-00003
		Al. Alloy	Standard	2.5	56	.100	2.2	07241-02400	07241-00005
		Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-03900	07241-00028
	5/32"	St. Steel & Titanium	Standard	3.3	56	.130	2.2	07241-02800	07241-00010
		Al. Alloy	Standard	2.5	56	.100	2.2	07241-02900	07241-00012
		Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-04000	07241-00029
	3/16"	Al. Alloy	Standard	2.5	56	.100	2.2	07241-03200	07241-00019
		Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-04100	07241-00030
MBC Universal head & 100° csk	1/8"	Al. Alloy	Standard	4.7	61	.185	2.4	07241-04300	07241-00051
		Al. Alloy oversize	Standard	4.8	56	.190	2.2	07241-04600	07241-00054
		Stainless Steel	Standard	4.7	56	.185	2.2	07241-06800	07241-00045
	5/32"	Stainless Steel	Standard	4.9	56	.192	2.2	07241-06900	07241-00046
		Al. Alloy	Standard	4.9	61	.192	2.4	07241-04400	07241-00052
		Al. Alloy oversize	Standard	4.9	61	.192	2.4	07241-04700	07241-00055
	3/16"	Al. Alloy	Standard	5.0	61	.196	2.4	07241-04500	07241-00053
		Stainless Steel	Standard	5.0	61	.196	2.4	07241-07000	07241-00047
AVIBULB Low profile	1/8"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-02600	07241-00008
	5/32"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
	3/16"	Al. Alloy	Standard	3.3	61	.130	2.4	07241-03800	07241-00027
T-LOK Snap head	4.3mm	Steel	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
	4.3mm	Steel	Extended	10.0	58.4	.395	2.3	07241-07100	07241-00014
	3/16"	Steel	Standard	3.3	61	.130	2.4	07241-03000	07241-00015
	3/16"	Steel	Extended	10.0	58.4	.395	2.3	07241-07100	07241-00014

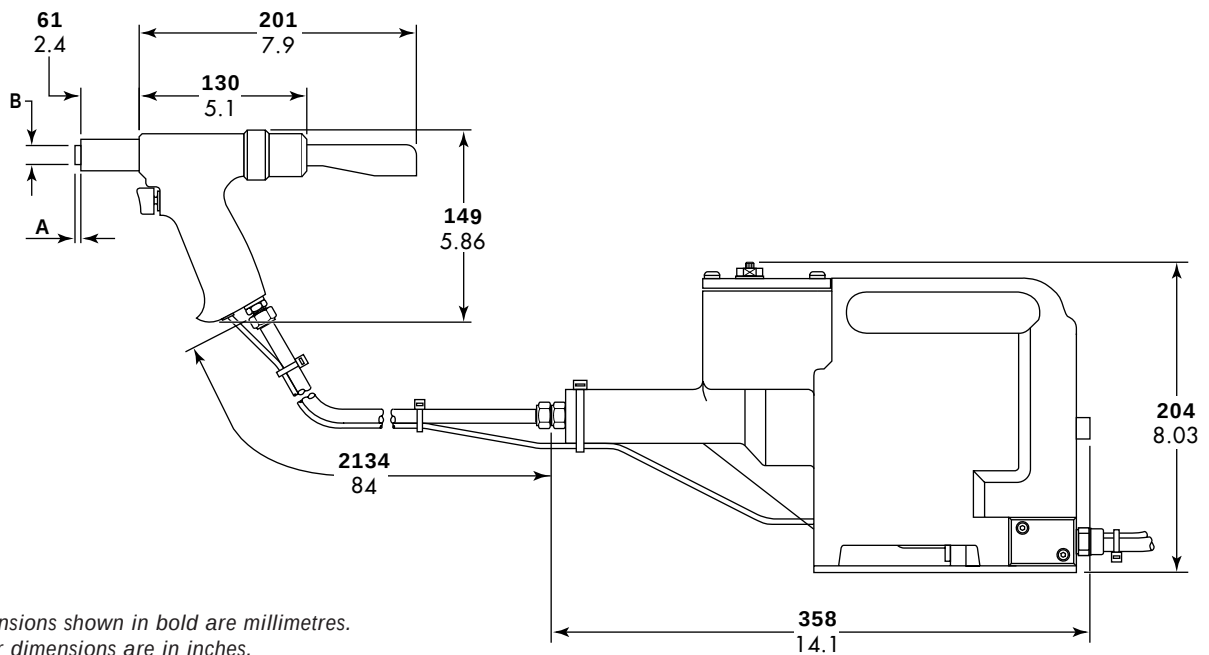
* Protruding head & 100° csk

07241 & 07244 - FIXED NOSE ASSEMBLIES

The 07241 and 07244 are both fitted with fixed straight nose assemblies suitable where access is unrestricted. 07241 tools eject spent stems through the rear of the pistol whilst the type of nose assemblies fitted to 07244 tools results in forward stem ejection.

Use the selection charts below and opposite to select a complete 07241 or 07244 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 12 and 13.

'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.
Other dimensions are in inches.

07244 TOOL SELECTION

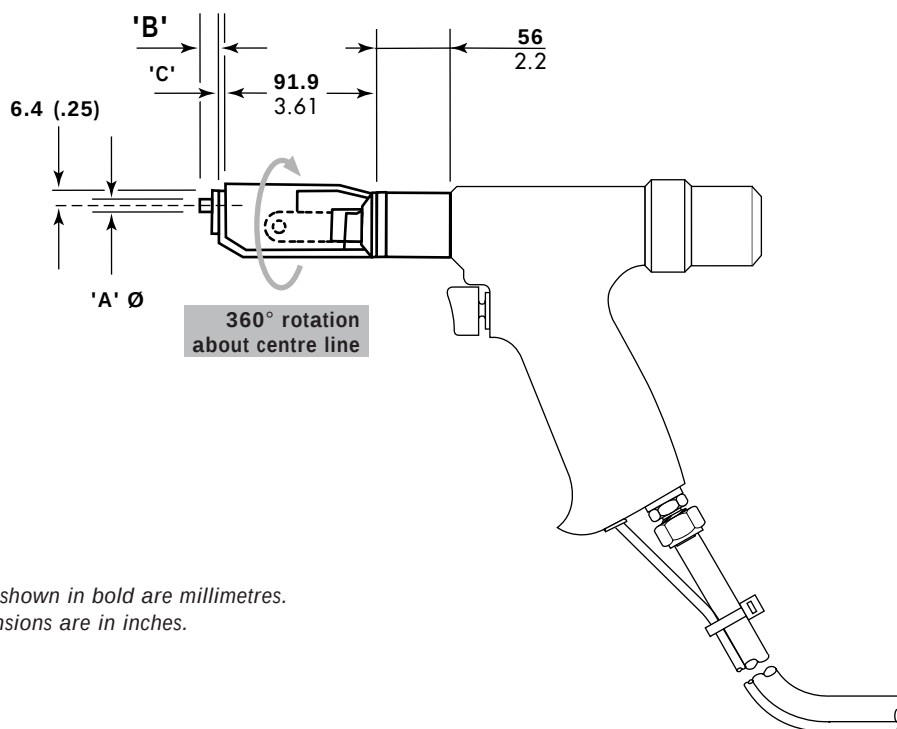
FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE TOOL PART N°
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	
AVEX Snap head & 120° csk	1/8"	Al. Alloy	Standard	3.55	13	.140	.5	07244-02001	07241-00001
		Steel	Standard	3.43	13	.135	.5	07244-02001	07241-00001
	5/32"	Al. Alloy	Standard	3.43	13	.135	.5	07244-02001	07241-00001
		Steel	Standard	3.05	13	.120	.5	07244-02001	07241-00001
	3/16"	Al. Alloy	Standard	3.05	13	.120	.5	07244-02001	07241-00001
		Steel	Standard	6.35	13	.250	.5	07244-02200	07241-00002
AVINOX BE11 & BE61	1/8"	Al. Alloy	Standard	3.55	13	.140	.5	07244-02001	07241-00001
		Al. Alloy	Standard	3.55	13	.140	.5	07245-02200	07241-00003
	5/32"	Al. Alloy	Standard	3.55	13	.140	.5	07244-02001	07241-00001
		Al. Alloy	Standard	3.55	13	.140	.5	07244-02300	07241-00004
	3/16"	Al. Alloy	Standard	3.55	13	.140	.5	07244-02800	07241-00005
BULBEX	5/32"	Al. Alloy	Standard	3.43	13	.135	.5	07244-02001	07241-00001
	3/16"	Al. Alloy	Standard	3.05	13	.120	.5	07244-02001	07241-00001
AVIBULB Low profile	1/8"	Al. Alloy	Standard	3.43	13	.135	.5	07245-02200	07241-00003
	5/32"	Al. Alloy	Standard	3.05	13	.120	.5	07244-02300	07241-00004
	3/16"	Al. Alloy	Standard	3.55	13	.140	.5	07244-02800	07241-00005

07242 - STRAIGHT SWIVEL NOSE ASSEMBLY

The 07242 tool is fitted with a "straight" swivel type of nose assembly for use on applications with restricted access.

It will place all the fasteners listed in the selection table below. Use this table to select a complete 07242 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 15 and 16.

'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.
Other dimensions are in inches.

07242 TOOL SELECTION

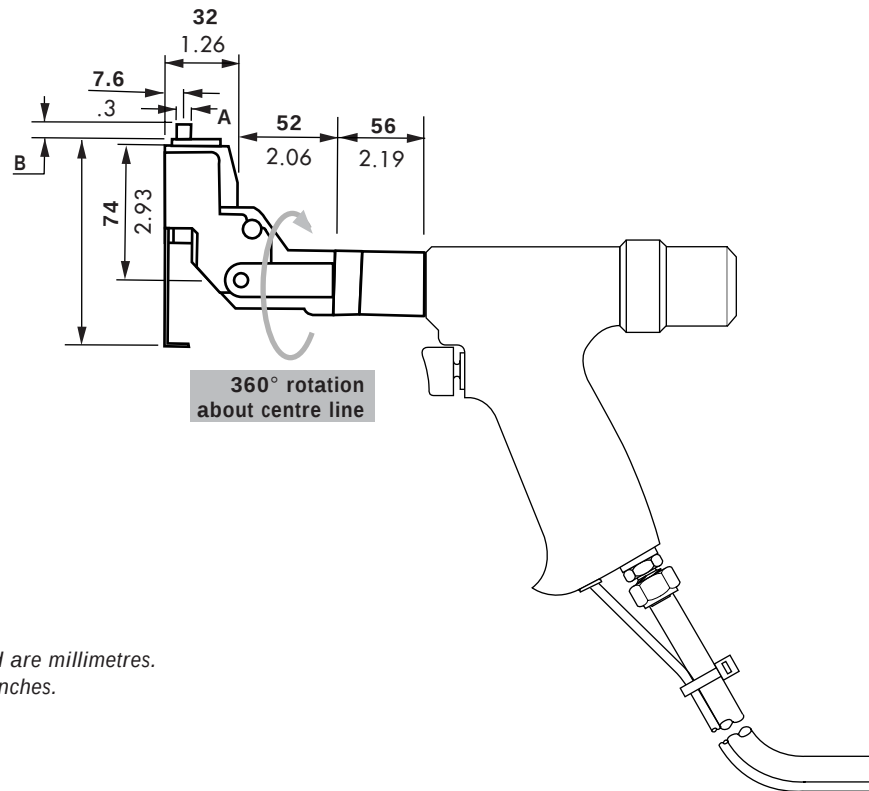
FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03000	07242-00004
		Steel	Standard	7.87	3.81	.310	.150	07345-03100	07242-00005
	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03100	07242-00005
		Steel	Standard	7.87	3.81	.310	.150	07345-03200	07242-00006
	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07242-00006
BULBEX	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07242-00006
AVSEAL	4mm	Al. Alloy	Short	6.35	1.95	.250	.077	07494-06000	07242-00064
		Al. Alloy	Extended	6.35	4.11	.250	.162	07494-06100	07242-00065
	5mm	Al. Alloy	Short	7.62	2.00	.300	.079	07494-07000	07242-00074
		Al. Alloy	Extended	7.62	4.11	.300	.162	07494-07100	07242-00075
AVINOX BE11 & BE61	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03100	07242-00005
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03200	07242-00006
AVDEL Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	5.08	1.17	.200	.046	07345-03300	07242-00014
		Al. Alloy oversize	Standard	5.08	1.17	.200	.046	07494-03600	07242-00017
		St. Steel & Titanium	Standard	5.08	3.81	.200	.150	07494-03000	07242-00024
	5/32"	Al. Alloy	Standard	6.6	.84	.260	.033	07345-03400	07242-00015
		Al. Alloy oversize	Standard	6.6	.84	.260	.033	07494-03700	07242-00018
	3/16"	Al. Alloy	Standard	8.13	.25	.320	.010	07345-03500	07242-00016
		Al. Alloy oversize	Standard	8.13	.25	.320	.010	07494-03700	07242-00019
		Stainless Steel	Standard	5.08	1.27	.200	.050	07494-03400	07242-00023
MBC Universal head & 100° csk	1/8"	Al. Alloy/St. Steel	Standard	4.75	2.4	.187	.094	07345-04000	07242-00051
		Al. Alloy oversize	Standard	4.75	2.4	.187	.094	07345-04300	07242-00054
	5/32"	Al. Alloy/St. Steel	Standard	6.35	2.4	.250	.094	07345-04100	07242-00052
		Al. Alloy oversize	Standard	6.35	2.4	.250	.094	07345-04400	07242-00055
	3/16"	Al. Alloy	Standard	7.92	2.4	.312	.094	07345-04200	07242-00053

07243 - RIGHT ANGLE SWIVEL NOSE ASSEMBLY

The 07243 tool is fitted with a "right angle" swivel type of nose assembly for use on applications with no direct access to the fixing point.

It will place all the fasteners listed in the selection table below. Use this table to select a complete 07243 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 15 and 16.

'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.
Other dimensions are in inches.

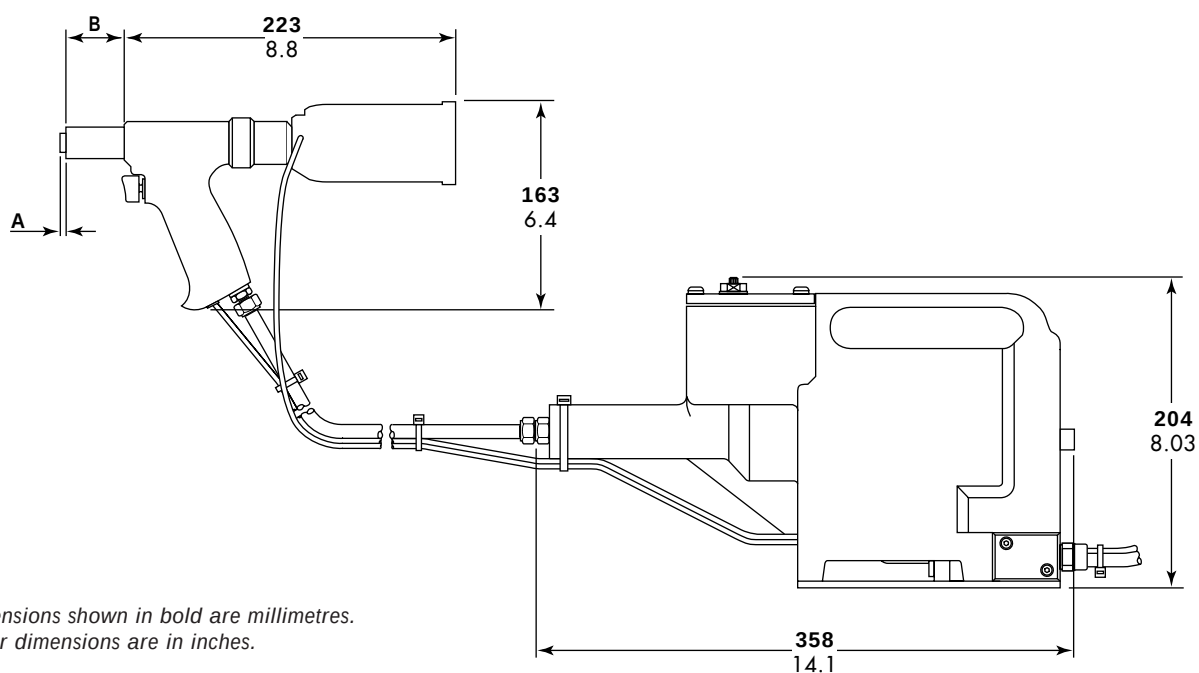
07243 TOOL SELECTION										
FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE	
NAME & HEAD	Ø	MATERIAL / DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°	
AVEX Snap head & 120° csk	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03000	07243-00004	
		Steel	Standard	7.87	3.81	.310	.150	07346-03100	07243-00005	
	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03100	07243-00005	
		Steel	Standard	7.87	3.81	.310	.150	07346-03200	07243-00006	
	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07243-00006	
BULBEX	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07243-00006	
AVSEAL	4mm	Al. Alloy	Short	6.35	1.95	.250	.077	07495-06000	07243-00064	
		Al. Alloy	Extended	6.35	4.11	.250	.162	07495-06100	07243-00065	
	5mm	Al. Alloy	Short	7.62	2.00	.300	.079	07495-07000	07243-00074	
		Al. Alloy	Extended	7.62	4.11	.300	.162	07495-07100	07243-00075	
AVINOX BE11 & BE61	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03100	07243-00005	
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03200	07243-00006	
AVDEL Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	5.08	1.17	.200	.046	07346-03300	07243-00014	
		Al. Alloy oversize	Standard	5.08	1.17	.200	.046	07495-03600	07243-00017	
		St. Steel & Titanium	Standard	5.08	3.81	.200	.150	07495-03000	07243-00024	
	5/32"	Al. Alloy	Standard	6.6	.84	.260	.033	07346-03400	07243-00015	
		Al. Alloy oversize	Standard	6.6	.84	.260	.033	07495-03700	07243-00018	
	3/16"	Al. Alloy	Standard	8.13	.25	.320	.010	07346-03500	07243-00016	
		Al. Alloy oversize	Standard	8.13	.25	.320	.010	07495-03800	07243-00019	
		Stainless Steel	Standard	5.08	1.27	.200	.050	07495-03400	07243-00023	
		Al. Alloy / St. Steel	Standard	4.75	2.4	.187	.094	07346-04000	07243-00051	
MBC Universal head & 100° csk	1/8"	Al. Alloy oversize	Standard	4.75	2.4	.187	.094	07346-04300	07243-00054	
	5/32"	Al. Alloy / St. Steel	Standard	6.35	2.4	.250	.094	07346-04100	07243-00052	
		Al. Alloy oversize	Standard	6.35	2.4	.250	.094	07346-04400	07243-00055	
	3/16"	Al. Alloy	Standard	7.92	2.4	.312	.094	07346-04200	07243-00053	

07245 - VACUUM EXTRACTION

The 07245 fitted with both vacuum extraction and a stem catcher unit is fitted with a fixed straight nose assembly for use where access is unrestricted.

Use the selection chart, opposite, to select a complete 07245 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 12 & 13.

'A' and 'B' dimensions will help you assess the accessibility of your application.



07245 TOOL SELECTION

FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk head except 07245-00024 large flange only	1/8"	Al. Alloy	Standard	3.3	61	.130	2.4	07245-02000	07245-00001
		Al. Alloy	Extended	12.9	58.4	.510	2.3	07241-02100	07245-00002
	3mm	Steel	Standard	3.3	61	.130	2.4	07245-02200	07245-00008
		Al. Alloy	Hd. Forming	3.3	61	.130	2.4	07245-02400	07245-00021
		Al. Alloy	Standard	3.3	61	.130	2.4	07245-02100	07245-00006
		Al. Alloy	Standard	3.3	61	.130	2.4	07245-02200	07245-00008
	5/32"	Al. Alloy	Extended	11.4	58.4	.450	2.3	07241-02700	07245-00009
		Steel	Standard	3.3	61	.130	2.4	07245-02300	07245-00015
		Al. Alloy	Hd. Forming	3.3	61	.130	2.4	07245-02500	07245-00022
		Al. Alloy	Standard	3.3	61	.130	2.4	07245-02300	07245-00015
		Al. Alloy	Extended	10.0	58.4	.395	2.3	07241-03100	07245-00016
		Al. Alloy	Hd. Forming	4.1	61	.160	2.4	07245-02600	07245-00023
		Al. Alloy/L.Flange	Standard	4.1	61	.162	2.4	07241-03600	07245-00024
		Steel	Standard	3.3	61	.130	2.4	07244-02200	07245-00026
MONOBOLT *	3/16"	Al. Alloy & Steel	Standard	4.1	61	.160	2.4	07241-04200	07245-00031
BULBEX	5/32"	Al. Alloy	Standard	3.3	61	.130	2.4	07245-02200	07245-00008
	3/16"	Al. Alloy	Standard	3.3	61	.130	2.4	07245-02300	07245-00015
	5/32"	Al. Alloy	Extended	11.4	58.4	.450	2.3	07241-02700	07245-00009
	3/16"	Al. Alloy	Extended	10.0	58.4	.395	2.3	07241-03100	07245-00016
AVSEAL	4mm	Al. Alloy	Standard	4.5	61	.177	2.4	07241-05000	07245-00064
		Al. Alloy	Extended	6.7	61	.264	2.4	07241-05500	07245-00074
	5mm	Al. Alloy	Standard	4.5	61	.179	2.4	07245-03100	07245-00065
		Al. Alloy	Extended	6.7	61	.264	2.4	07245-04100	07245-00075
	6mm	Al. Alloy	Standard	5.3	61	.208	2.4	07245-03200	07245-00066
		Al. Alloy	Extended	7.2	61	.283	2.4	07245-04200	07245-00076
	6.5mm	Al. Alloy	Standard	5.3	61	.208	2.4	07241-04900	07245-00062
		Al. Alloy	Extended	7.2	61	.283	2.4	07241-05400	07245-00072
	7mm	Al. Alloy	Standard	5.3	61	.208	2.4	07245-03400	07245-00067
		Al. Alloy	Extended	7.2	61	.283	2.4	07245-04400	07245-00077
TLR	3/16"	Al. Alloy	Standard	4.1	61	.160	2.4	07241-04800	07245-00058
AVINOX BE11 & BE61	1/8"	Stainless Steel	Standard	3.3	61	.130	2.4	07245-02200	07245-00008
	5/32"	Stainless Steel	Standard	3.3	61	.130	2.4	07245-02300	07245-00015
	3/16"	Stainless Steel	Standard	3.3	61	.130	2.4	07245-02800	07245-00027
AVDEL Snap head & 100° csk head & 120° csk head	1/8"	St. Steel & Titanium	Standard	3.3	56	.130	2.2	07241-02200	07245-00003
		Al. Alloy	Standard	2.5	56	.100	2.2	07241-02400	07245-00005
	5/32"	Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-03900	07245-00028
		St. Steel & Titanium	Standard	3.3	56	.130	2.2	07241-02800	07245-00010
		Al. Alloy	Standard	2.5	56	.100	2.2	07241-02900	07245-00012
		Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-04000	07245-00029
	3/16"	Al. Alloy	Standard	2.5	56	.100	2.2	07241-03200	07245-00019
		Al. Alloy oversize	Standard	2.5	56	.100	2.2	07241-04100	07245-00030
		Al. Alloy	Standard	4.7	61	.185	2.4	07241-04300	07245-00051
MBC Universal head & 100° csk head	1/8"	Al. Alloy oversize	Standard	4.8	56	.190	2.2	07241-04600	07245-00054
		Stainless Steel	Standard	4.7	56	.185	2.2	07241-06800	07245-00045
	5/32"	Stainless Steel	Standard	4.9	56	.192	2.2	07241-06900	07245-00046
		Al. Alloy	Standard	4.9	61	.192	2.4	07241-04400	07245-00052
		Al. Alloy oversize	Standard	4.9	61	.192	2.4	07241-04700	07245-00055
		Al. Alloy	Standard	5.0	61	.196	2.4	07241-04500	07245-00053
	3/16"	Stainless Steel	Standard	5.0	61	.196	2.4	07241-07000	07245-00047
		Al. Alloy	Standard	3.3	61	.130	2.4	07245-02200	07245-00008
AVIBULB Low profile	1/8"	Al. Alloy	Standard	3.3	61	.130	2.4	07244-02300	07245-00033
	5/32"	Al. Alloy	Standard	3.3	61	.130	2.4	07245-02800	07245-00027
	3/16"	Al. Alloy	Standard	3.3	61	.130	2.4	07245-02800	07245-00027
T-LOK Snap head	4.3mm	Steel	Standard	3.3	61	.130	2.4	07241-07200	07245-00013
	4.3mm	Steel	Extended	10.0	58.4	.395	2.3	07241-07100	07245-00014
	3/16"	Steel	Standard	3.3	61	.130	2.4	07241-07200	07245-00013
	3/16"	Steel	Extended	10.0	58.4	.395	2.3	07241-07100	07245-00014

* Protruding head & 100° csk

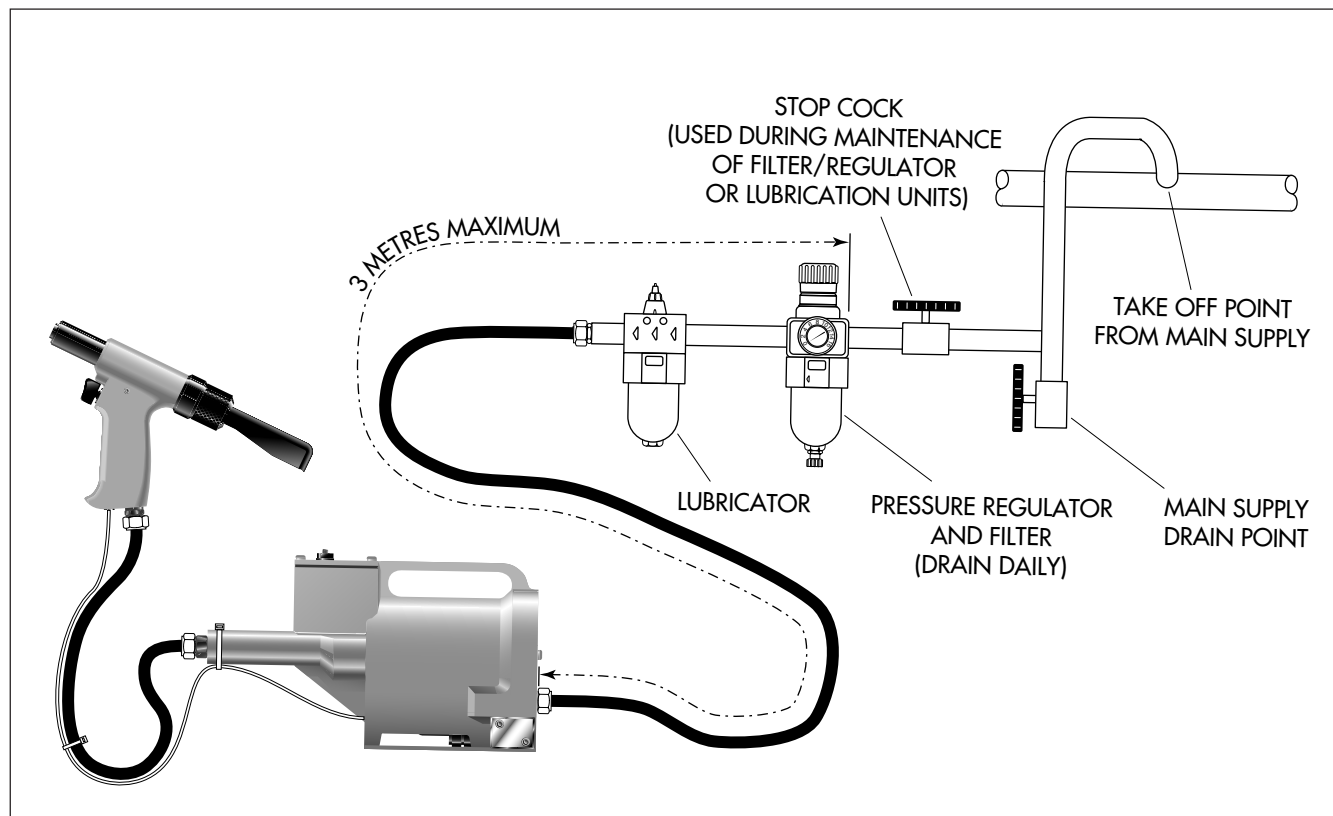
PUTTING INTO SERVICE

AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.5 bar. We recommend the use of pressure regulators and automatic oiling/filtering systems on the main air supply. These should be fitted within 3 metres of the tool (see diagram below) to ensure maximum tool life and minimum tool maintenance.

Air supply hoses should have a minimum working effective pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest. Air hoses should be oil resistant, have an abrasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged. All air hoses MUST have a minimum bore diameter of 6.4 millimetres or $\frac{1}{4}$ inch.

Read servicing daily details page 17.



OPERATING PROCEDURE

OPTION 1

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener body squarely into the prepared hole of the application.
- Apply the tool to the protruding rivet stem.
- Fully operate the trigger. The tool cycle will ensure the rivet is placed.

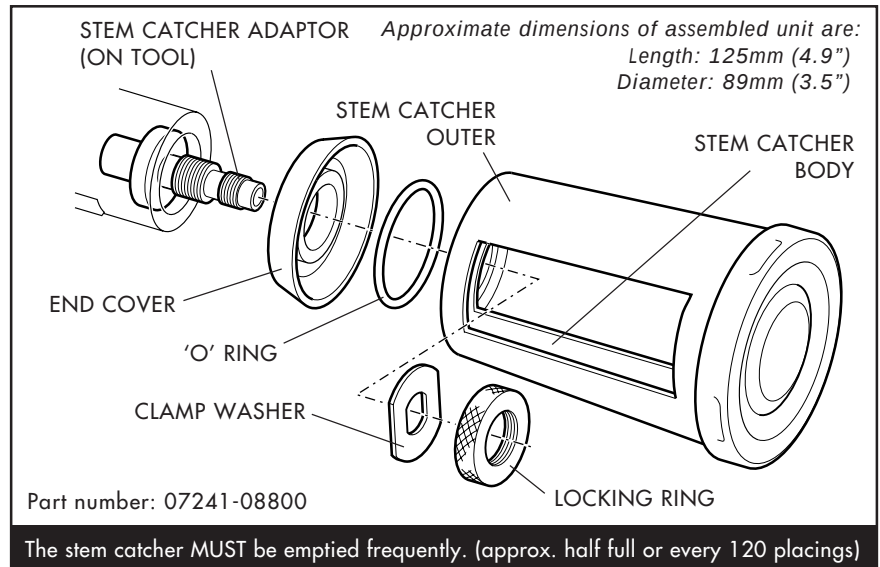
OPTION 2

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener stem into the nose of the tool.
- Insert the tool with the fastener squarely into the prepared hole of the application.
- Fully operate the trigger. The tool cycle will ensure the rivet is placed.

ACCESSORIES

STEM CATCHER UNIT

- To replace the pintail deflector with the stem catcher unit unscrew the end cap and remove together with pintail deflector (items 11 and 26 of pages 22 and 23).
- Assemble all items in the order shown on the diagram opposite.
- Offer the assembly to the stem catcher adaptor (item 12 of pages 22 & 23).
- Start tightening the locking ring onto stem catcher adaptor.
- Rotate the stem catcher body until the opening is in the desired position.
- Fully tighten the locking ring.

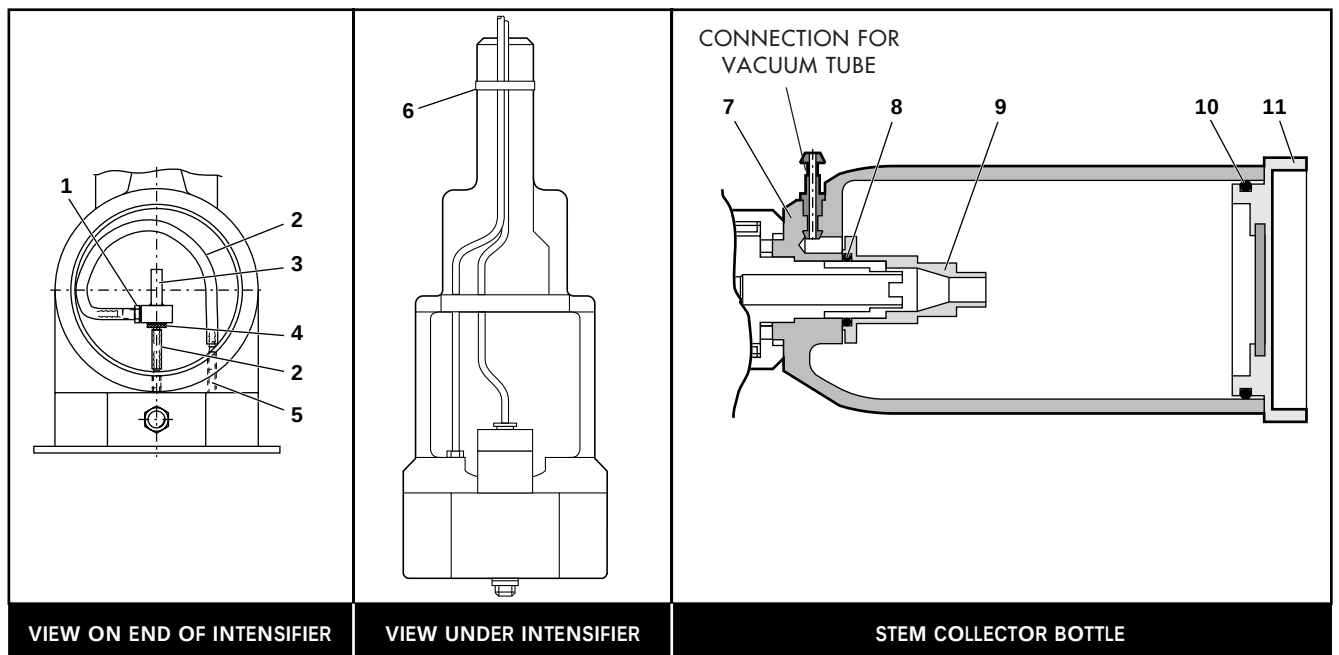


There is a conversion kit, part number 07241-09600 for use on 07241-00200 base tools to convert to 07245 vacuum extraction tool.

VACUUM EXTRACTION CONVERSION KIT

- For intensifier conversion, remove filter cover 15 and foam silencer 14 (see parts list on pages 24 & 25).
- Assemble kit as shown on intensifier elevations below.
- Remove end cap 11 and pintail deflector 26 (see parts lists pages 22 and 23).
- Assemble stem collector bottle as shown.
- Connect and cut vacuum tube from intensifier to stem collector bottle.
- Bind to hose using cable clips 12.

VACUUM EXTRACTION CONVERSION KIT			
ITEM	DESCRIPTION	PART N°	QTY
1	MALE HOSE CONNECTOR	07005-00647	2
2	4mm I/D (PU4) BLACK PLASTIC TUBE	07005-00597	300cm
3	VACUUM INJECTOR HOUSING	07245-00101	1
4	VACUUM INJECTOR	07245-00102	1
5	VACUUM CONNECTOR	07245-00103	2
6	CABLE TIE	07007-00392	1
7	STEM COLLECTOR BODY	07245-00300	1
8	'O' RING	07003-00058	1
9	BOTTLE RETAINING NUT	07245-00202	1
10	'O' RING	07003-00218	1
11	STEM COLLECTOR END CAP	07245-00302	1
12	CABLE CLIP	07007-00319	9



NOSE ASSEMBLIES

There are three types of nose assemblies which are used with the 0724 type of tooling and three base tools (07241-00200, 07242-00200 & 07245-00200). The applied combination produces five models: 07241, 07244, 07242, 07243 and 07245. If you have purchased a complete tool, it will already be fitted with the correct nose assembly for your fastener.

It is essential that the correct nose assembly is fitted prior to operating the tool. By knowing your original complete tool part number or the details of the fastener to be placed, you will be able to order a new complete nose assembly using the selection tables on pages 4 to 9 according to the tool model you are using.

07241 / 4 / 5 MODELS

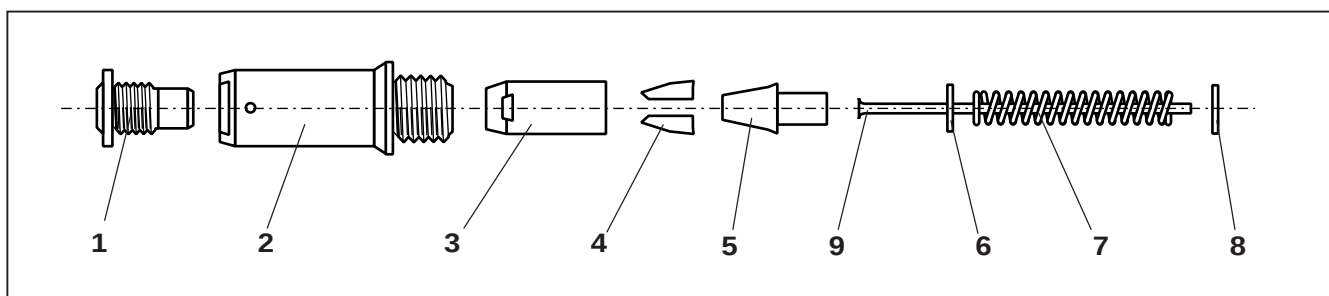
The 02741, 02744 and 02745 tools always use fixed nose assemblies. Nose assemblies and components vary according to the type of fastener being placed (see dimensions 'A' & 'B' on pages 4, 5 and 9). Check part numbers on component tables.

FITTING INSTRUCTIONS

IMPORTANT

The air supply must be disconnected when fitting or removing nose assemblies unless specifically instructed otherwise.

- Insert guide tube 9 into jaw spreader housing assembly of tool.
- Lightly coat the jaws with Moly lithium grease.
- Drop jaws 4 into jaw housing 3.
- Insert jaw spreader 5 into jaw housing 3 (locating in the 'V' shape formed by the jaws).
- Locate buffer 6 on jaw spreader 5.
- Locate spring 7 onto jaw spreader 5.
- Fit locking ring 8 onto the jaw spreader housing assembly of the tool.
- Holding tool pointing down, screw on the assembled jaw housing or chuck collet onto the jaw spreader housing assembly and tighten with spanner.
- Screw nose tip 1 into nose casing 2.
- Place nose casing 2 over jaw housing 3 screw onto tool, tightening with spanner.



SERVICING INSTRUCTIONS

Nose assemblies should be serviced at weekly intervals.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting instructions'.
- Any worn or damaged part should be replaced by a new part.
- Particularly check wear on jaws.
- Check spring 7 is not distorted.
- Assemble according to fitting instructions.

07241 & 07244 NOSE ASSEMBLY COMPONENTS

Each nose assembly represents a unique assembly of components which can be ordered individually. Component numbers refer to the illustration on the opposite page. We recommend some stock as items will need regular replacement. Read the Nose Assemblies servicing instructions opposite carefully. All nose assemblies also include a locking ring part number 07340-00327 (see illustration opposite).

07241							
NOSE ASSY	1	2	3	4	5	6	9
07241-02000	07340-06000	07340-00306	07340-00304	07340-00213	07241-02002	07241-02001	07241-02003
07241-02100	07340-02805	07340-02804 e	07340-00304	07340-00213	07241-02002	07241-02001	07241-02003
07241-02200	07344-02101	07344-02001	07340-00304	07340-00213	07241-02202	07241-02001	07241-03003
07241-02400	07140-02104	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-02500	07340-06300	07340-00306	07340-00304	07340-00222	07241-02002	07241-02001	07241-02003
07241-02600	07340-06100	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-03003
07241-02700	07340-02806	07340-02804 e	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-02800	07344-02401	07344-02001	07340-00304	07340-00213	07241-02002	07241-02001	07241-03003
07241-02900	07140-02105	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-03000	07340-06200	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03100	07340-02807	07340-02804 e	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03200	07140-02106	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-03300	07340-06400	07340-00306	07340-00304	07340-00213	07241-02002	07241-02001	07241-02003
07241-03400	07340-06500	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-03500	07340-06600	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03600	07340-04800	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03700	07490-04400	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07241-03800	07498-01400	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	-
07241-03900	07344-02901	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04000	07344-03001	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04100	07344-03101	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04200	07498-03001	07340-00306	07498-04503	07498-04501	07241-04202	07241-02001	07241-03003
07241-04300	07340-06701	07344-02001	07340-00304	07340-00229	07241-02602	07241-02001	07241-02603
07241-04400	07340-06801	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04500	07340-06901	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04600	07340-07001	07344-02001	07340-00304	07498-00229	07241-02602	07241-02001	07241-02603
07241-04700	07340-07101	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04800	07605-00220	07340-00306	07498-04503	07498-04501*	07241-04202	07241-02001	07241-03003
07241-04900	07340-08301	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07241-05000	07340-07601	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-05400	07498-09101	07340-00306 e	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07241-05500	07498-08401	07340-00306 e	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-06800	07340-06701	07344-02001	07498-04503	07498-04501*	07241-06802	07241-02001	07241-02603
07241-06900	07340-06801	07344-02001	07498-04503	07498-04501*	07241-06802	07241-02001	07241-03003
07241-07000	07340-06901	07498-02601	07340-04503	07498-04501*	07241-04202	07241-02001	07241-03003
07241-07100	07241-07101	07340-02804 e	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07245-03100	07340-07701	07340-00306	07340-00304	07100-08203	07241-03702	-	07241-03003
07245-03200	07340-07801	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-03400	07340-07901	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-04100	07498-08501	07340-00306 e	07340-00304	07100-08203	07241-03702	-	07341-03003
07245-04200	07498-08601	07340-00306 e	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-04400	07498-08701	07340-00306 e	07340-00304	07340-07502*	07241-03702	07241-02001	07241-03003

07244							
NOSE ASSY	1	2	3	4	5	6	9
07244-02100	07381-04501	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-02603
07244-02200	07244-02202	07244-02201	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07244-02300	07381-04701	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-02603
07245-02200	07381-04601	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-03003
07245-02800	07498-01401	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	-

The number of jaws is normally two.

* indicates three jaws.

'e' indicates extended nose casing.

07245 NOSE ASSEMBLY COMPONENTS

Each nose assembly represents a unique assembly of components which can be ordered individually. Component numbers refer to the illustration on page 12. We recommend some stock as items will need regular replacement. Read the Nose Assemblies servicing instructions (page 16) carefully. All nose assemblies also include a locking ring part number 07340-00327 (see illustration page 12).

07245							
NOSE ASSY	1	2	3	4	5	6	9
07241-02100	07340-02805	07340-02804 e	07340-00304	07340-00213	07241-02002	07241-02001	07241-02003
07241-02200	07344-02101	07344-02001	07340-00304	07340-00213	07241-02202	07241-02001	07241-03003
07241-02400	07140-02104	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-02700	07340-02806	07340-02804 e	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-02800	07344-02401	07344-02001	07340-00304	07340-00213	07241-02002	07241-02001	07241-03003
07241-02900	07140-02105	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-03100	07340-02807	07340-02804 e	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03200	07140-02106	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-03600	07340-04800	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-03900	07344-02901	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04000	07344-03001	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04100	07344-03101	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04200	07498-03001	07340-00306	07498-04503	07498-04501	07241-04202	07241-02001	07241-03003
07241-04300	07340-06701	07344-02001	07340-00304	07340-00229	07241-02602	07241-02001	07241-02603
07241-04400	07340-06801	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04500	07340-06901	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04600	07340-07001	07344-02001	07340-00304	07498-00229	07241-02602	07241-02001	07241-02603
07241-04700	07340-07101	07344-02001	07340-00304	07340-00229	07241-02202	07241-02001	07241-03003
07241-04800	07605-00220	07340-00306	07498-04503	07498-04501*	07241-04202	07241-02001	07241-03003
07241-04900	07340-08301	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07241-05000	07340-07601	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-05400	07498-09101	07340-00306 e	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07241-05500	07498-08401	07340-00306 e	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07241-06800	07340-06701	07344-02001	07498-04503	07498-04501*	07241-06802	07241-02001	07241-02603
07241-06900	07340-06801	07344-02001	07498-04503	07498-04501*	07241-06802	07241-02001	07241-03003
07241-07000	07340-06901	07498-02601	07340-04503	07498-04501*	07241-04202	07241-02001	07241-03003
07241-07100	07241-07101	07340-02804 e	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07241-07200	07340-06201	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07244-02200	07244-02202	07244-02201	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07244-02300	07381-04701	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-02603
07245-02000	07381-04501	07340-00306	07340-00304	07340-00213	07241-02002	07241-02001	07241-02003
07245-02100	07340-06301	07340-00306	07340-00304	07340-00222	07241-02002	07241-02001	07241-02003
07245-02200	07381-04601	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07245-02300	07381-04701	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-03003
07245-02400 **	07340-06401	07340-00306	07340-00304	07340-00229	07241-02202	07241-02001	07241-02003
07245-02500	07340-06501	07340-00306	07340-00304	07340-00213	07241-02602	07241-02001	07241-02603
07245-02600	07340-06601	07340-00306	07340-00304	07340-00213	07241-03002	07241-02001	07241-03003
07245-02800	07498-01401	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	-
07245-03100	07340-07701	07340-00306	07340-00304	07100-08203	07241-03702	-	07241-03003
07245-03200	07340-07801	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-03400	07340-07901	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-04100	07498-08501	07340-00306 e	07340-00304	07100-08203	07241-03702	-	07341-03003
07245-04200	07498-08601	07340-00306 e	07340-00304	07340-07502	07241-03702	07241-02001	07241-03003
07245-04400	07498-08701	07340-00306 e	07340-00304	07340-07502*	07241-03702	07241-02001	07241-03003

The number of jaws is normally two.

* indicates three jaws .

** also has shim 07340-01305 .

'e' indicates an extended nose casing.

07242 & 07243 MODELS

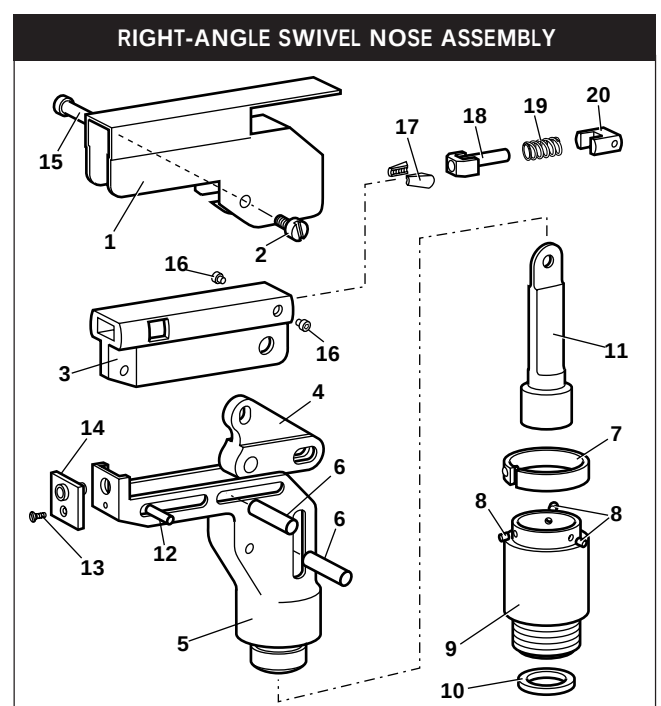
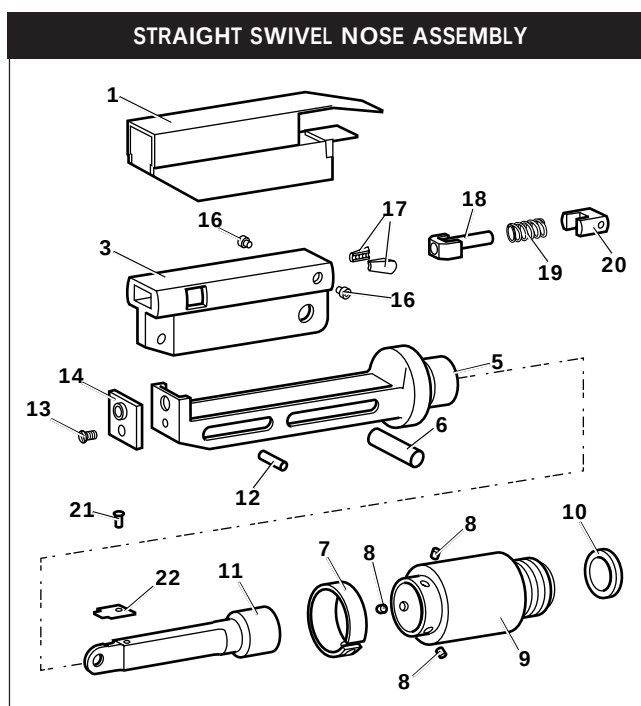
As described on pages 6 and 7 the fitting of a straight swivel nose assembly to a 07242-00200 base tool will create a 07242 tool model and the fitting of a right-angle swivel nose assembly to the same base tool will create a 07243 tool model. The fitting and servicing procedures are almost identical because the two nose assemblies are similar. Differences in procedures are highlighted by the grey tint.

FITTING INSTRUCTIONS

The following procedure will allow you to fit either of the swivel nose assemblies (as illustrated below) to the tool. If you order a complete nose assembly rather than individual components, you will only need to start at stage ■.

All moving parts should be lubricated. Unless stated otherwise use Moly lithium grease (details page 16). When on grey tint, instructions refer only to the right-angle nose assembly fitted to 07243 models.

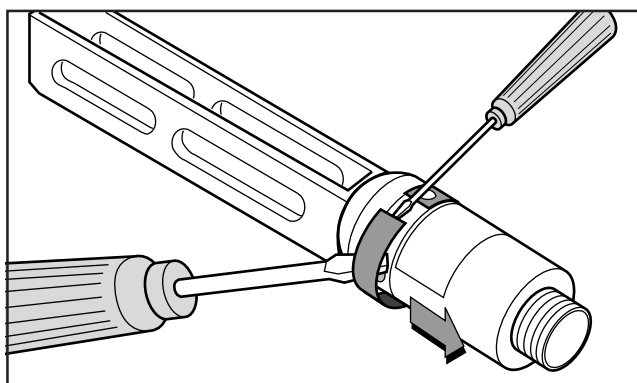
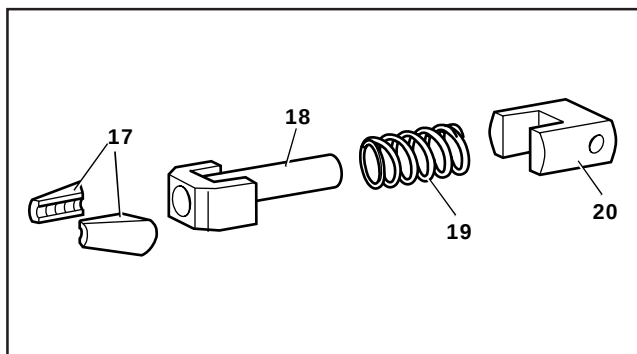
- Fit locking ring 10 over jaw spreader assembly of tool (item 1 page 21).
- Coat screw 13 with thread locking adhesive and use to secure nose tip 14 onto body 5.
- Lightly lubricate items 17,18,19,20 and insert into jaw carrier 3 as shown. Secure with screws 16.
- Position lever 4 into body 5 and hold in place with pin 15 through the hole of body 5 (not a slot).
- Lubricate the sides of the jaw carrier assembly and insert into body 5.
- Lubricate rollers 8 and ENSURE that they will freely rotate in the holes of adaptor 9. If necessary ream the holes.
- Position spring clip 7 over adaptor 9 past the holes for the rollers and rotate until the locating peg is aligned with the corresponding hole in adaptor 9 (smallest hole).
- Fit adaptor 9 over the end of body 5 and drop rollers 8 into place. Push spring clip 7 over rollers 8.
- Insert spindle 11 through adaptor 9 into jaw carrier 3 until the hole lines up with slot in body 5. Temporarily hold in place with pin 6.
- Insert pin 12 through the front slot of body 5 into jaw carrier 3.
- Hold the assembly vertical to prevent all pins dropping and slide the jaw carrier assembly back and forth a few times to ensure free movement.
- Push pin(s) 6 out and let spindle 11 drop out. Screw spindle 11 onto the jaw spreader housing of the tool, leaving the small screw fixing hole uppermost for straight swivel nose assemblies. Tighten gently with a tommy bar.
- Screw the assembly over spindle 11 onto the tool handle. Replace pin(s) 6.
- On straight swivel nose assemblies attach platform 22 onto the top of the spindle with screw 21. Deburr the back end of platform 22 so that it cannot catch on guard 1.
- Snap guard 1 over the assembly, carefully sliding cut-out around the head of screw 15 and secure with screw 2.



SERVICING INSTRUCTIONS

Nose assemblies should be serviced at weekly intervals.
Item numbers refer to both illustrations on page 15 and opposite.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting instructions'.
- If guard 1 is at all damaged it must be replaced by a new one.
- Any worn or damaged parts should be replaced.
- Pay particular attention to jaw carrier items in the upper illustration opposite as follows:
Check wear on jaws 17.
Check that jaw spreader tube 18 is not distorted.
Check that spring 19 is neither broken or distorted.
Check that spring guide 20 is not damaged.
- Check that spring clip 7 is not distorted. When removing spring clip 7, use two screwdrivers as shown in the lower illustration opposite.
- Check for excessive wear on slots of body 5.
- Assemble according to fitting instructions.



07242 & 07243 NOSE ASSEMBLY COMPONENTS

Nose tips and jaws will vary for each nose assembly while other components remain the same as shown in the tables below. Jaws are always in pairs.

CONSTANT COMPONENTS				VARYING COMPONENTS					
	ITEM	07242	07243	NOSE ASSY	NOSE TIP(14)	JAWS(17)	NOSE ASSY	NOSE TIP(14)	JAWS(17)
1	GUARD	7494-05000	07495-03003	07345-03000	07345-03600	07340-00213	07346-04200	07165-00703	07498-04401
2	BLADE SCREW	-	07210-02015	07345-03100	07345-03700	07340-00213	07346-04300	07165-00801	07340-00229
3	JAW CARRIER	07494-03026	07494-03026	07345-03200	07345-03800	07490-04602	07346-04400	07165-00802	07498-04401
4	LEVER	-	07495-03004	07345-03300	07345-03301	07340-00229	07494-03000	07494-03011	07340-00213
5	BODY	07494-03015	07495-03002	07345-03400	07345-03401	07340-00229	07494-03400	07494-03401	07340-00222
6	PIVOT PIN	07343-02207	07343-02207	07345-03500	07345-03501	07498-04401	07494-03600	07494-03601	07340-00229
7	SPRING CLIP	07495-03900	07495-03900	07345-04000	07165-00701	07340-00229	07494-03700	07494-03701	07340-00229
8	ROLLER	07007-00039	07007-00039	07345-04100	07165-00702	07340-00229	07494-06000	07494-06001	07340-00213
9	ADAPTOR	07345-03001	07345-03001	07345-04200	07165-00703	07498-04401	07494-06100	07494-06101	07340-00213
10	LOCKING RING	07345-03003	07345-03003	07345-04300	07165-00801	07340-00229	07494-06600	07494-06601	07340-00213
11	SPINDLE	07345-03002	07345-03002	07345-04400	07165-00802	07498-04401	07494-06700	07494-06701	07340-00213
12	DOWEL PIN	07007-00038	07007-00038	07346-03000	07345-03600	07340-00213	07495-03000	07494-03011	07340-00213
13	SCREW	07342-02207	07342-02207	07346-03100	07345-03700	07340-00213	07495-03400	07494-03401	07340-00222
15	PIVOT PIN	-	07495-03005	07346-03200	07345-03800	07490-04602	07495-03600	07494-03601	07340-00229
16	SCREW	07494-03028	07494-03028	07346-03300	07345-03301	07340-00229	07495-03700	07494-03701	07340-00229
18	JAW SPREADER	07166-01100	07166-01100	07346-03400	07345-03401	07340-00229	07495-04000	07494-06001	07340-00213
19	SPRING	07166-01102	07166-01102	07346-03500	07345-03501	07498-04401	07495-04100	07494-06101	07340-00213
20	SPRING GUIDE	07494-03027	07494-03027	07346-04000	07165-00701	07340-00229	07495-04700	07494-06601	07340-00213
21	CSK. SCREW	07001-00368	-	07346-04100	07165-00702	07340-00229	07495-04800	07494-06701	07340-00213
22	PLATFORM	07345-00401	-						

Regular servicing should be carried out and a comprehensive inspection performed annually or every 500000 cycles, whichever is sooner.

IMPORTANT

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.
The operator should not be involved in maintenance or repair of the tool unless properly trained.

DAILY

- Daily, before use or when first putting the tool into service, pour a few drops of clean, light lubricating oil into the air inlet of the tool if no lubricator is fitted on air supply. If the tool is in continuous use, the air hose should be disconnected from the main air supply and the tool lubricated every two to three hours.
- Check for air leaks. If damaged, hoses and couplings should be replaced by new items.
- If there is no filter on the pressure regulator, bleed the air line to clear it of accumulated dirt or water before connecting the air hose to the tool. If there is a filter, drain it.
- Check that the nose equipment is correct.
- Ensure a pintail deflector or stem catcher is fitted to tool.

WEEKLY

- Dismantle and clean the nose assembly with special attention to the jaws. Lubricate with Moly lithium grease before assembling.
- Check for oil leaks and air leaks in the air supply hose and fittings.

Grease can be ordered as a single item, the part number is shown in the service kit below.

MOLY LITHIUM GREASE EP 3753 SAFETY DATA	
FIRST AID SKIN: As the grease is completely water resistant it is best removed with an approved emulsifying skin cleaner. INGESTION: Make the individual drink 30ml Milk of Magnesia, preferably in a cup of milk. EYES: Irritant but not harmful. Irrigate with water and seek medical attention. ENVIRONMENT Scrape up for burning or disposal on approved site.	FIRE FLASH POINT: Above 220°C. Not classified as flammable. Suitable extinguishing media: CO ₂ , Halon or water spray if applied by an experienced operator. HANDLING Use barrier cream or oil resistant gloves STORAGE Away from heat and oxidising agent.

For all servicing we recommend the use of the service kit below (part number 07900-02440) supplied in its own plastic case.

SERVICE KIT		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00002	SPANNER	1
07900-00004	CIRCLIP PLIERS	1
07900-00012	9/16 x 5/8 A/F SPANNER	1
07900-00013	1/8 A/F ALLEN KEY	1
07992-00020	80g TIN MOLY LITHIUM GREASE EP3753	1
07900-00224	4mm ALLEN KEY	1
07900-00488	SPANNER	1
07900-00225	5mm ALLEN KEY	1

SERVICE KIT (Continued)		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00473	NON - RETURN VALVE	1
07900-00001	SPRING COMPRESSOR	1
07900-00237	SPANNER	1
07900-00351	3mm ALLEN KEY	1
07900-00517	ASSEMBLY BULLET	1
07900-00520	3/8 Ø ROD	1
07900-00521	1/4 Ø ROD	1
07900-00469	2.5mm A/F ALLEN KEY	1

MAINTENANCE

Every 500000 cycles the tool should be completely dismantled and new components should be used where worn, damaged or recommended. All 'O' rings and seals should be renewed and lubricated with Moly Lithium grease EP 3753 before assembling.

IMPORTANT

Safety Instructions appear on page 2 & 3.

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.

The operator should not be involved in maintenance or repair of the tool unless properly trained.

The airline must be disconnected before any servicing or dismantling is attempted unless specifically instructed otherwise.

It is recommended that any dismantling operation be carried out in clean conditions.

Item **numbers in bold** refer to the tool general assembly and parts list page 22 and 23 and the intensifier general assembly and parts list page 24 and 25.

Before proceeding with dismantling, empty the oil from the tool. Remove bleed screw **23** and seal **24** from the handle assembly and drain the oil into a suitable container.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, pages 12 to 16.

For total tool servicing we advise that you proceed with dismantling of sub-assemblies in the order shown below. The procedure is the same for all tools once the nose assembly has been removed.

PISTON & HEAD ASSEMBLY

- On 07241 tool unscrew and remove end cap **11** together with pin tail deflector **26**. If fitted with collector bottle option, remove bottle by unscrewing the retaining nut inside the bottle using spanner*.
- On 07242 tool unscrew and remove end cap **11**.
- On 07245 tool remove bottle retaining nut **32** and remove the stem collector bottle.
- Disconnect trigger airline at base of tool by depressing outer collet and withdrawing airline.
- Using a spanner*, disconnect the hose at base of pistol unit.
- Using an Allen key*, remove screw **23** and bonded seal **24** and drain the oil into a suitable container.
- With spring compressor* held in vice, engage jaw spreader housing **1** and stem catcher adaptor **12** and compress spring **9**.
- Unscrew end cap **10**.
- Unscrew the clamp and remove stem catcher adaptor **12**, and spring **9**.
- Locate spanner* onto piston **8** through piston bore (hold spanner* in vice) and remove jaw spreader assembly **1**.
- Using spanner*, withdraw piston **8** and piston stop **25** (07241) or **2** (02742) or **27** (07245).
- Remove 'O' ring **13** from stem catcher adaptor **12**.
- Remove 'O' ring **6** and backup ring **7** from piston **8**.
- Remove wiper ring **3** and piston stop **2** from piston **8**.
- Remove backup ring **4** and 'O' ring **5** from handle assembly **17**.

TRIGGER ASSEMBLY

- Unscrew trigger sleeve **22** using a spanner*.
- Remove 'O' ring **21**, spring **18** and button **20**.
- Use bullet* to replace piston in piston head.
- A new jaw spreader assembly **MUST** always be fitted and tightened to 20 lbs.ft. torque to achieve a dimension of 8.51 mm (0.335 in) maximum between jaw spreader assembly **1** and front face of handle assembly **17**.
- Complete assembly in reverse order of dismantling.

INTENSIFIER UNIT

- Disconnect air supply.
- Disconnect the trigger airline from the intensifier valve **35** by depressing the outer collet and withdrawing the airline.
- Using an Allen key*, remove four screws **34** and washers **33**. Remove cover plate **3** and gasket **32**.
- Drain oil into a suitable container.
- Using an open ended spanner*, remove hydraulic hose coupling together with double male connector **28** and bonded seal **29**.
- Using an Allen key*, undo fixing screws **24** and remove protection plate **23**.
- Remove intensifier valve **35** by removing the three fixing screws using an Allen key*.
- Remove screw **17** using an Allen key* and remove filter cover **15**, foam silencer **14**, spacer **18** and retaining plate **19**.
- Using a screwdriver, carefully remove the internal retaining ring **13**.
- Using extractor*, insert the male threaded end into the end cover **11**.
- Withdraw end cover **11**.
- Insert a length of $\frac{3}{8}$ in. dia. rod* through the double male connector **28** orifice at the front of intensifier body and tap out intensifier piston rod **8**, intensifier air piston **9**.
- Remove plug **6** using a spanner*.
- Insert a length of $\frac{1}{4}$ in. dia. rod* through the double male connector **28** orifice at the front of intensifier body and push out seal cluster comprising seal housing washer **30**, 'O' ring **26**, **27** and **5**, seal housing **4**, air seal **25**.
- Remove the valve housing assembly **31** and non-return valve from the body assembly **7** using a spanner*.
- Remove intensifier piston rod **8** from intensifier air piston **9**, gripping the rod in a vice fitted with soft jaws* so as not to mark or damage the working surface. Note that the first 20 mm (0.75in) of the rod adjacent to the air piston is the best position to grip.
- Unscrew the nut **16** using an open ended spanner*.
- Ensure that seal cluster comprising seal housing washer **32**, 'O' ring **26**, **27** and **5**, seal housing **4**, air seal **25** are assembled in correct sequence.
- When refitting valve housing assembly **31** into body assembly **7**, apply thread sealing agent 'Loctite 577'.
- Complete assembly in reverse order of dismantling.

IMPORTANT

Check the tool against daily and weekly servicing.

Priming is **ALWAYS** necessary after the tool has been dismantled and prior to operating.

* refers to items included in the Avdel service kit. For complete list see page 18.

IMPORTANT

The retaining plate 19 must be correctly fitted inside the internal retaining ring 13.

The tool **MUST NOT** be operated if retaining plate 19 has been omitted from the assembly.

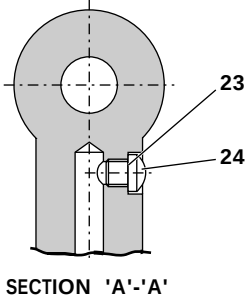
INTENSIFIER VALVE

- Servicing of the valve is limited to the removal/replacement of 'O' rings contained in spares kit (part number 07900-01538).
- Remove screws 69 and remove pilot assembly .
- Remove pilot valve 52 and discard 'O' rings 62, 63, 64, and 65.
- Remove end cap screws 67 & 68 and remove end caps 49 & 50.
- Withdraw pistons 53 & 54 and remove 'O' rings 59 & 60 from pistons.
- Withdraw spool 55 from bore, taking care not to damage surface of spool and remove location washers 57 & 58, 'O' ring 61, spacers 56 and 'O' ring 66 from each end of valve body.
- Remove the five interface 'O' rings.
- Discard ALL 'O' rings removed.

- Clean all parts with paraffin or white spirit. DO NOT USE SOLVENTS.

- Lightly smear bores of valve body 47, pilot valve body 48, both end caps 49 & 50 and all replacement 'O' rings with "CENTOPLEX 2" grease, supplied in spares kit.
- Fit new seals 63, 64, and 65 to pilot valve spool 52 and insert into pilot valve body.
- Fit new seals 62, 63 and 66 to pilot valve body, place top cap 51 in position and secure pilot valve assembly to the main valve body 47 with screws 69. Ensure that the interface seal housing faces upward with the G¹/₄ at the bottom. Ensure orientation of pilot valve 52 is correct.
- With main valve body 47 in the same position, fit green location washer 58 to the left hand side of the valve assembly.
- Starting from the right hand side of the valve, assemble alternately the 'O' rings 61 and spacers 56 (6 seals and 5 spacers) and finally complete the stack assembly with white location washer 57.
- Lightly smear spool 55 with "CENTOPLEX 2" grease and slide spool through seal/spacer stack.
- Fit seals 59 & 60 to respective pistons 53 & 54, fit seals 66 to ends of main valve body 47.
- Insert pistons into end caps 49 & 50 and assemble end caps to valve, taking care to locate piston shafts into holes in the ends of the spool 55.
- Secure end cap assemblies to main valve body 47 with screws 67 & 68.
- Fit interface 'O' ring into their housings in the main valve body.
- If the pipe connection to the pilot assembly is damaged, replace the plastic collet 70 and lift out the 'O' ring from the cartridge. Fit new 'O' ring 71 and insert plastic collet 70 into the cartridge.

* refers to items included in the Avdel service kit. For complete list see page 18.

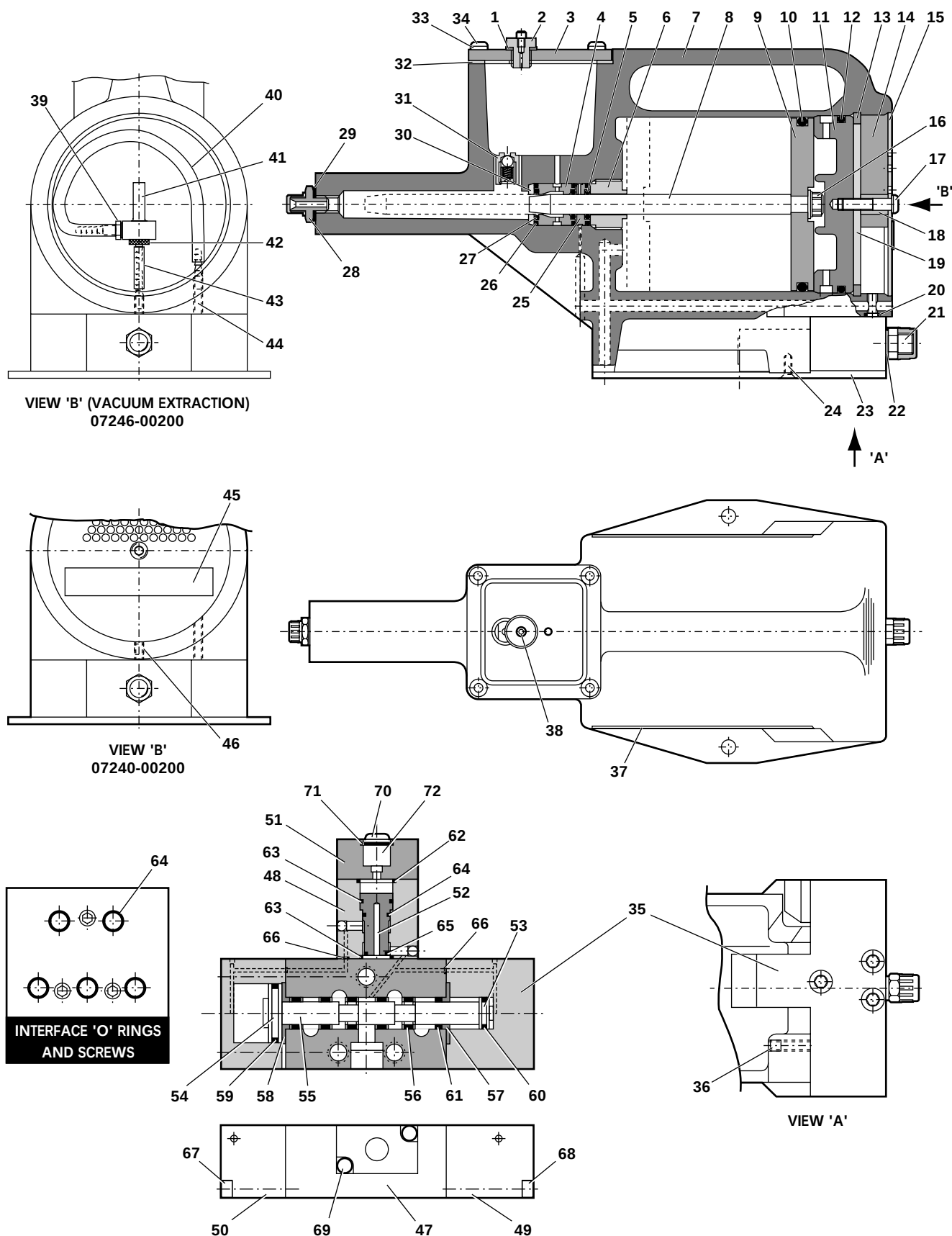


07241-00200 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07241-00600	JAW SPREADER ASSEMBLY	1	1	15	07005-00406	CONNECTOR	1	-
3	07003-00156	WIPER RING	1	1	16	07005-00599	'O' RING	1	1
4	07003-00193	BACK UP RING	1	1	17	07241-00700	HANDLE ASSEMBLY	1	-
5	07003-00187	'O' RING	1	1	18	07125-00215	SPRING	1	-
6	07003-00184	'O' RING	1	1	19	07241-00208	BUTTON STEM	1	-
7	07003-00192	BACK UP RING	1	1	20	07007-00300	BUTTON	1	-
8	07241-00203	PISTON	1	-	21	07003-00022	'O' RING	1	1
9	07340-00324	SPRING	1	-	22	07220-00803	TRIGGER SLEEVE	1	-
10	07241-00209	END CAP	1	1	23	07001-00114	SCREW	1	1
11	07241-00206	END CAP	1	-	24	07003-00033	BONDED SEAL	1	3
12	07245-00201	STEM CATCHER ADAPTOR	1	-	25	07241-00207	PISTON STOP	1	-
13	07003-00029	'O' RING	1	1	26	07340-00342	PIN TAIL DEFLECTOR	1	-
14	07003-00142	BONDED SEAL	1	1					

07242-00200 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07241-00600	JAW SPREADER ASSEMBLY	1	1	13	07003-00029	'O' RING	1	1
2	07242-00203	PISTON STOP	1	-	14	07003-00142	BONDED SEAL	1	1
3	07003-00156	WIPER RING	1	1	15	07005-00406	CONNECTOR	1	-
4	07003-00193	BACK UP RING	1	1	16	07005-00599	'O' RING	1	1
5	07003-00187	'O' RING	1	1	17	07241-00700	HANDLE ASSEMBLY	1	-
6	07003-00184	'O' RING	1	1	18	07125-00215	SPRING	1	-
7	07003-00192	BACK UP RING	1	1	19	07241-00208	BUTTON STEM	1	-
8	07241-00203	PISTON	1	-	20	07007-00300	BUTTON	1	-
9	07340-00324	SPRING	1	-	21	07003-00022	'O' RING	1	1
10	07241-00209	END CAP	1	1	22	07220-00803	TRIGGER SLEEVE	1	-
11	07241-00206	END CAP	1	-	23	07001-00114	SCREW	1	1
12	07245-00201	STEM CATCHER ADAPTOR	1	-	24	07003-00033	BONDED SEAL	1	3

07245-00200 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07241-00600	JAW SPREADER ASSEMBLY	1	1	17	07241-00700	HANDLE ASSEMBLY	1	-
3	07003-00156	WIPER RING	1	1	18	07125-00215	SPRING	1	-
4	07003-00193	BACK UP RING	1	1	19	07241-00208	BUTTON STEM	1	-
5	07003-00187	'O' RING	1	1	20	07007-00300	BUTTON	1	-
6	07003-00184	'O' RING	1	1	21	07003-00022	'O' RING	1	1
7	07003-00192	BACK UP RING	1	1	22	07220-00803	TRIGGER SLEEVE	1	-
8	07241-00203	PISTON	1	-	23	07001-00114	SCREW	1	1
9	07340-00324	SPRING	1	-	24	07003-00033	BONDED SEAL	1	3
10	07241-00209	END CAP	1	1	27	07241-00207	PISTON STOP	1	-
12	07245-00201	STEM CATCHER ADAPTOR	1	-	28	07245-00300	STEM COLLECTOR BODY ASSY	1	-
13	07003-00029	'O' RING	1	1	29	07003-00058	'O' RING	1	1
14	07003-00142	BONDED SEAL	1	1	30	07003-00218	'O' RING	1	1
15	07005-00406	CONNECTOR	1	-	31	07245-00302	STEM COLLECTOR END CAP	1	-
16	07005-00599	'O' RING	1	1	32	07245-00202	BOTTLE RETAINING CAP	1	-

GENERAL ASSEMBLY OF INTENSIFIER 07240-00200 / 07246-00200



07240-00200 / 07246-00200 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07003-00037	SEAL	1	1	24	07001-00390	SCREW	4	-
2	07240-00211	SCREW	1	-	25	07240-00203	AIR SEAL	1	1
3	07240-00210	COVER PLATE	1	-	26	07003-00153	'O' RING	3	3
4	07240-00202	SEAL HOUSING	1	-	27	07003-00179	'O' RING	2	2
5	07003-00181	'O' RING	1	1	28	07005-00406	CONNECTOR	1	-
6	07240-00204	PLUG	1	-	29	07003-00142	BONDED SEAL	1	1
7	07240-00300	BODY ASSEMBLY	1	-	30	07240-00201	WASHER	1	1
8	07240-00205	INTENSIFIER PISTON ROD	1	-	31	07240-00400	VALVE HOUSING ASSEMBLY	1	-
9	07240-00206	INTENSIFIER AIR PISTON	1	-	32	07240-00209	GASKET	1	1
10	07003-00182	'O' RING	1	1	33	07002-00073	WASHER	4	1
11	07240-00207	END COVER	1	-	34	07001-00416	SCREW	4	1
12	07003-00183	'O' RING	1	1	35	07005-00590	VALVE	1	-
13	07004-00069	RETAINING RING	1	1	36	07001-00408	SCREW	1	1
14	07240-00213	FOAM SILENCER	1	1	37	07240-00212	LABEL	2	-
15	07240-00214	FILTER COVER	1	-	38	07001-00418	SCREW	1	1
16	07002-00017	NUT	1	1	39	07005-00647	CONNECTOR	1	-
17	07001-00417	SCREW	1	1	40	07005-00597	4mm BLACK PLASTIC TUBE	22 _{cm}	-
18	07240-00215	SPACER	1	-	41	07245-00101	VACUUM INJECTOR HOUSING	1	-
19	07240-00216	RETAINING PLATE	1	-	42	07245-00102	VACUUM INJECTOR	1	-
20	07003-00042	'O' RING	1	1	43	07005-00597	4mm BLACK PLASTIC TUBE	3 _{cm}	-
21	07005-00041	CONNECTOR	1	-	44	07245-00103	VACUUM CONNECTOR	2	-
22	07005-00015	WASHER	1	1	45	07240-00217	LABEL	1	-
23	07240-00220	PROTECTION PLATE	1	-	46	07001-00421	SCREW	1	1

07005-00590 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
47	-	BODY (MAIN VALVE)	1	-	*60	08005-00127	'O' RING	1	-
48	-	BODY (PILOT VALVE)	1	-	*61	07003-00105	'O' RING	6	-
49	-	END CAP (SMALL AREA)	1	-	*62	07003-00204	'O' RING	1	-
50	-	END CAP (LARGE AREA)	1	-	*63	07003-00017	'O' RING	2	-
51	-	TOP CAP (PILOT VALVE)	1	-	*64	07003-00103	'O' RING	6	-
52	-	PISTON (PILOT VALVE)	1	-	*65	07003-00042	'O' RING	1	-
53	-	PISTON (SMALL AREA)	1	-	*66	07003-00121	'O' RING	4	-
54	-	PISTON (LARGE AREA)	1	-	67	-	SCREW	2	-
55	-	SPOOL	1	-	68	-	SCREW	2	-
56	-	SPACER	5	-	69	-	SCREW	2	-
57	-	LOCATION WASHER	1	-	*70	07005-00598	PLASTIC COLLET	-	-
58	-	LOCATION WASHER	1	-	*71	07005-00599	'O' RING	-	-
*59	07003-00178	'O' RING	1	-	72	-	CARTRIDGE	1	-

* Supplied in spares kit only, part number 07005-01538, for item 35. Available from Avdel Systems Ltd.
Other components listed are not supplied as spares.

Priming is ALWAYS necessary after the tool has been dismantled and prior to operating. It may also be necessary to restore the full stroke after considerable use, when the stroke may be reduced and rivets are not fully placed by one operation of the trigger.

OIL DETAILS

The recommended oil for priming is Hyspin VG32 available in 0.5l (part number 07992-00002) or one gallon containers (part number 07992-00006). Please find specific table and safety data below.

HYSPIN VG 32 OIL SAFETY DATA				
FIRST AID SKIN: Wash thoroughly with soap and water as soon as possible. Casual contact requires no immediate attention. Short term contact requires no immediate attention. INGESTION: Seek medical attention immediately. DO NOT induce vomiting. EYES: Irrigate immediately with water for several minutes. Although NOT a primary irritant, minor irritation may occur following contact. FIRE Suitable extinguishing media: CO ₂ , dry powder, foam or water fog. DO NOT use water jets.			ENVIRONMENT WASTE DISPOSAL: Through authorised contractor to a licenced site. May be incinerated. Used product may be sent for reclamation. SPILLAGE: Prevent entry into drains, sewers and water courses. Soak up with absorbent material. HANDLING Wear eye protection, impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area. STORAGE No special precautions.	
PROPERTIES	RESULT		PROPERTIES	RESULT
ISO oil type		HL	Foaming tendency/stability	
ISO viscosity grade		32		ml @ 24°C Trace/Nil
Kinematic viscosity				ml @ 93.5°C 20/Nil
	cS @ 40°C	32		ml @ 24°C after test @ 93.5°C Trace/Nil
	@ 100°C	5.3	Air release value	
Relative density	at 20°C	0.875	in minutes to 0.2% air content @ 50°C	4
Viscosity Index		95	Seal compatibility index	10
Pour point	°C	- 30	Water separation time	
Open Flash point	°C	232	in minutes to 40-40-0 @54°C	15
Neutralisation value mg KOH/g		1.5	@83°C	15

PROCEDURE

Item numbers in **bold** refer to the general assembly and parts list pages 22 and 23.

IMPORTANT

CONNECT AIR SUPPLY (this causes the piston to bottom, allowing more priming oil into the tool).

DO NOT OPERATE THE TRIGGER WHILE THE BLEED SCREW IS REMOVED.

All operations should be carried out on a clean bench, with clean hands in a clean area.

Check that the oil is perfectly clean and free from air bubbles.

Care **MUST** be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

- Remove bleed screw **23** and bonded seal **24** from the tool handle assembly **17**.
- Connect non-return valve* to bleed screw orifice, using bonded seal **24**.
- Place end of rubber tube from non-return valve into a suitable oil collecting receptacle.
- Remove filler screw **2** and seal **1** from intensifier unit and fill intensifier oil reservoir with Hyspin VG 32 oil.
- Depress trigger button - oil will be drawn into the system from the intensifier reservoir.
- Repeat this cycle of events until all air bubbles have been expelled via the non-return valve*.
- Hold the tool pistol unit below the level of the intensifier reservoir, remove the non-return valve* and replace the bleed screw and seal **23** & **24**.

Filling the intensifier unit.

- Connect the intensifier unit to the air supply. Remove screw from reservoir.
- Fill the oil reservoir with the recommended priming fluid.
- With a suitable tool, depress the button inside the quick action coupling until oil runs freely and without bubbles. Make provision for catching the expelled oil.
- Refill the oil reservoir with Hyspin VG 32 priming fluid.

Filling the tool and intensifier unit.

- Connect the pistol unit to the intensifier. Connect the intensifier unit to the air supply.
- Check the intensifier oil reservoir contents and fill if necessary with Hyspin VG 32 priming fluid.
- With the pistol unit held below the level of the intensifier unit, unscrew the bleed screw two turns using a suitable wrench and allow the oil to run freely into a suitable container.
- When the oil runs freely without any oil bubbles, tighten the bleed screw.
- Refill the intensifier unit oil reservoir with Hyspin VG 32 priming fluid.
- Cycle the tool until any air bubbles present are expelled from the oil into the oil reservoir.

* refers to items included in the Avdel service kit. For complete list see page 18.

FAULT DIAGNOSIS

FAULT DIAGNOSIS TABLE

SYMPTOM	POSSIBLE CAUSE	REMEDY
Several pulls required to set rivet	→ Low air pressure.	→ Increase air pressure.
	→ Lack of lubrication.	→ Lubricate tool at air inlet point.
	→ Worn or broken jaws.	→ New jaws.
	→ Oil level in tool low or air in oil.	→ Prime tool. (see page 26)
Jaws will not grip rivet stem	→ Worn or dirty jaws.	→ Clean or renew as necessary.
	→ Jaw housing loose.	→ Tighten against nylon locking ring.
	→ Weak or broken nose assembly spring.	→ Replace spring.
	→ Incorrect nose equipment fitted.	→ Replace as necessary.
Jaws will not release spent rivet stem.	→ Dirty jaws or jaw housing.	→ Clean.
	→ Jaw housing, nose tip or nose casing not properly seated.	→ Tighten nose equipment.
	→ Weak or broken spring around jaw spreader assembly.	→ New spring.
Spent rivet stem is jamming in tool.	→ Incorrect jaw spreader fitted.	→ Replace by correct part.
	→ Bent or dirty guide.	→ Renew and clean as applicable.
	→ Collector bottle too full (07245 tool).	→ Empty and ensure bottle never exceeds half full.
	→ Incorrect nose equipment fitted.	→ Replace with correct assembly.

Engineered Fastening and Assembly Systems

Declaration of Conformity

We, *Avdel UK Limited, Mundells, Welwyn Garden City, Herts, AL7 1EZ*

declare under our sole responsibility that the product

type 0724

Serial N°

to which this declaration relates is in conformity with the following standards or other formative documents

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

ISO PREN792 part 14

following the provisions of the Machine Directive 98/37/EC
This box contains a power tool which is in conformity with Machines Directive
98/37/EC. The 'Declaration of Conformity' is contained within.

Welwyn Garden City - date of issue



A. Seewraj
Product Engineering Manager - Automation Tools

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