



An Acument™ Global Technologies Company



Instruction Manual

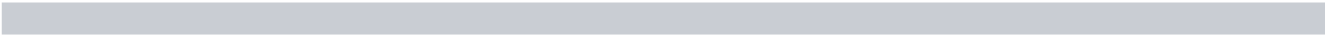
Pass onto user to read and keep for reference



Pneumatic Power Tool

0761 type

07611 - 07613 - 07614



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 0761 TYPE TOOL

AIR PRESSURE	■	Minimum - Maximum	■	5 - 7 bar	■	70 - 100 lbf/in ²
FREE AIR VOLUME REQUIRED	■	@ 5.4 bar / 80 lbf/in ²	■	3.5 litres	■	0.12 ft ³
STROKE	■	07611 Minimum	■	25.4 mm	■	0.95 in
	■	07613/4 Minimum	■	17.3 mm	■	0.68 in
PULL FORCE	■	07611 @ 4.8 bar / 70 lbf/in ²	■	10.91 kN	■	2450 lbf
	■	07613/4 @ 5.4 bar / 80 lbf/in ²	■	18.68 kN	■	4200 lbf
CYCLE TIME	■	07611/3 Approximately	■	1.5 seconds	■	
	■	07614 Approximately	■	1.3 seconds	■	
NOISE LEVEL	■	07611	■	73 dB(A)	■	
	■	07613/4 Less than	■	70 dB(A)	■	
WEIGHT	■	07611 Without nose equipment	■	2.7 kg	■	6 lb
	■	07613/4 Without nose equipment	■	3 kg	■	6.6 lb
VIBRATION	■	07611/4	■	2.6 m/s ²	■	8.5 f/s ²
	■	07613 Less than	■	2.5 m/s ²	■	8 f/s 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.

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

⚠ 0761 TOOLS MUST BE FITTED WITH AN UNDAMAGED STEM DEFLECTOR OR STEM CATCHER BEFORE OPERATING. IF THE TOOL IS FITTED WITH A STEM CATCHER, IT MUST BE EMPTIED WHEN HALF FULL.

⚠ IF THE 0761 TOOL IS FITTED WITH A STEM DEFLECTOR, IT SHOULD BE ROTATED UNTIL THE APERTURE IS FACING AWAY FROM THE OPERATOR AND OTHER PERSON(S) WORKING IN THE VICINITY.

⚠ WHEN USING THE TOOL, THE WEARING OF SAFETY GLASSES IS REQUIRED BOTH BY THE OPERATOR AND OTHERS IN THE VICINITY TO PROTECT AGAINST FASTENER PROJECTION, 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 TO AVOID INADVERTENT OPERATION OF THE TOOL.

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

CONTENT OF USE

The hydro-pneumatic 0761 MkII type tool has three models each designed to place at high speed a different type of fastener as shown in the table below, making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

Throughout this manual we refer to the different models without adding 'Mk II' after the model number. It is important to remember that all models described in this manual are Mk II models and supersede original models. The MK II model for the 07611 starts at serial number 400 and at serial number 3001 for the 07613 and 07614 models.

All three models are supplied standard with a stem deflector and the option of a stem collector. For more details see the 'Accessories' section.

A complete tool is fitted with a fixed straight nose assembly suited to the fastener you wish to place and a priming pump is also included. See the Priming section for more details. It is also possible to order the base tool only, which is supplied without a nose assembly or a priming pump. For more details on the base tools, see the respective general assembly drawings and part lists.

To select the part number of a major item use the table below. For more component details of nose assemblies, see the 'Nose Assemblies' section.

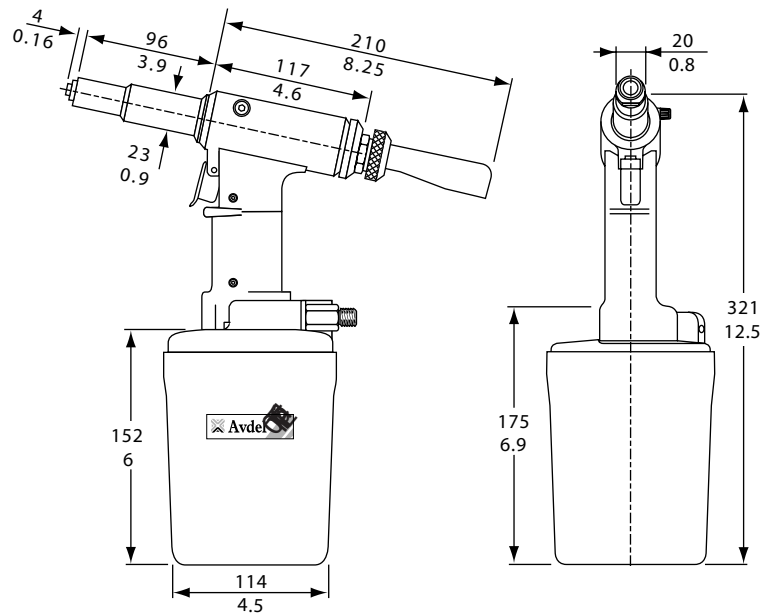
0761 TOOL SELECTION						
TOOL MODEL	FASTENER			BASE TOOL PART N°	NOSE ASSEMBLY PART N°	COMPLETE TOOL PART N°
	TYPE	SIZE *	MATERIAL			
07611	AVTAINER	9.5 3/8	STEEL	07611-00200	07498-00800	07611-00001
07613	MAXLOK	4.8 3/16	STEEL & ALUMINIUM	07613-00200	07610-02000	07613-00001
		6.4 1/4	STEEL & ALUMINIUM	07613-00200	07610-02100	07613-00002
07614	HEMLOK	6.4 1/4	STEEL & ALUMINIUM	07614-02000	07612-02000	07614-00002

* Sizes in bold are millimetres. Other sizes are in inches.

Dimensions on the opposite page, particularly around the nose assembly area, will help you assess the accessibility of your application.

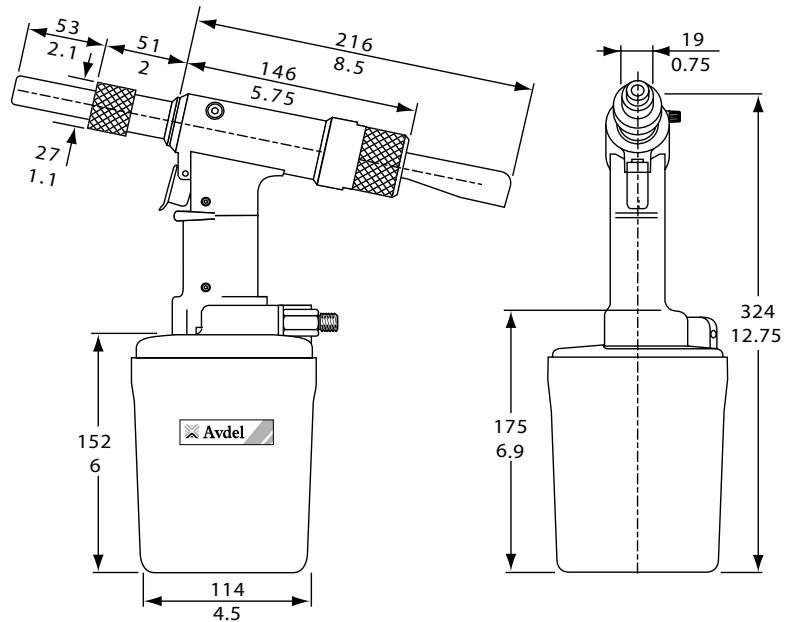
07611 - for AVTAINER fasteners

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



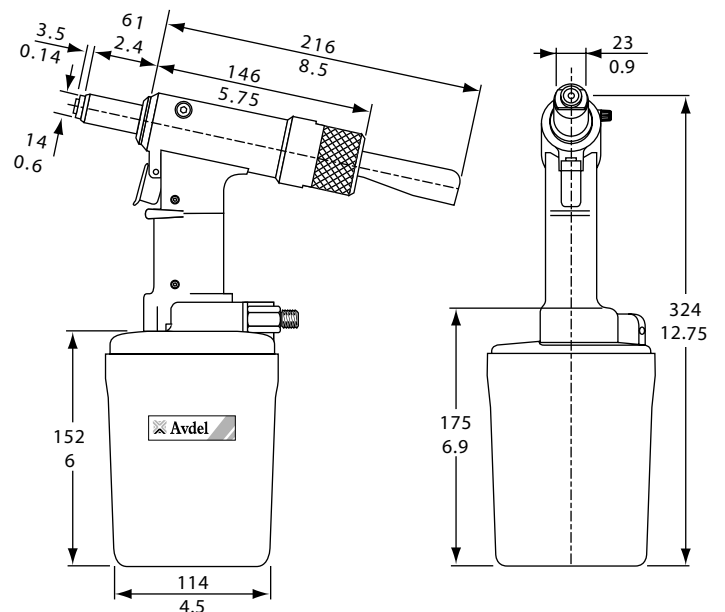
07613 - for MAXLOK fasteners

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



07614 - for HEMLOK fasteners

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

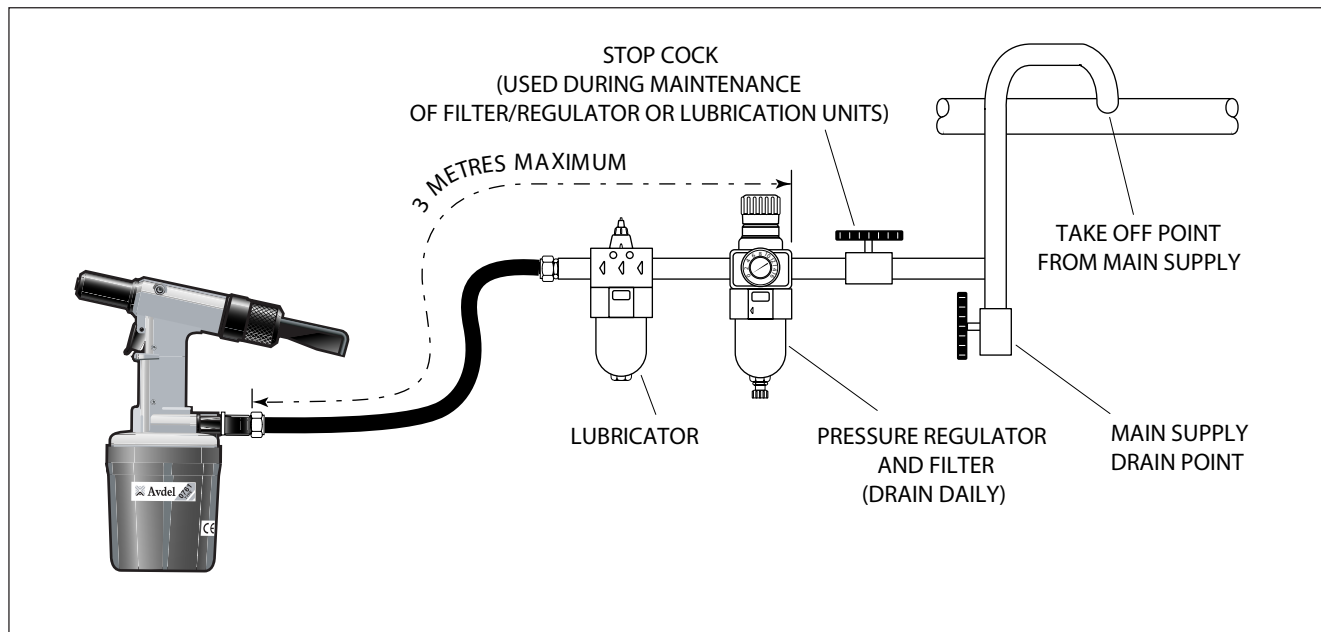


AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.4 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 10.



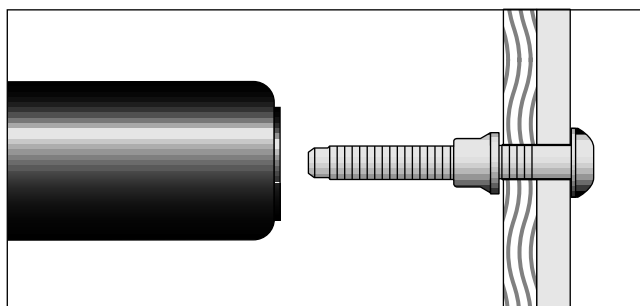
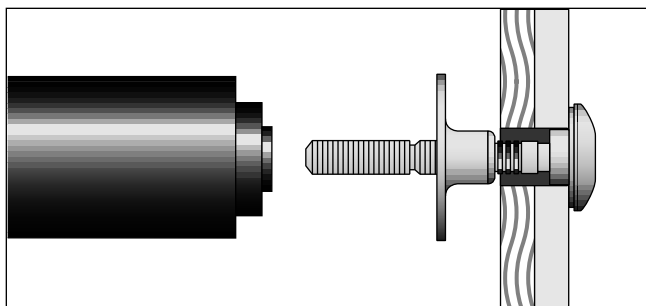
OPERATING PROCEDURE

07611 model for AVTAINER

- Ensure that the correct nose assembly is fitted.
- Connect the tool to the air supply.
- Push the Avtainer through the prepared hole in the application.
- Slide the collar over the stem (orientation as shown below).
- Keeping the head of the Avtainer against the application, place the nose assembly of the tool over the protruding stem.
- Fully operate the trigger. One cycle will ensure that the collar is forced over the lock grooves of the stem and that the stem breaks at the breaker groove.
- Release the trigger. The tool completes its cycle by pushing itself off the collar and ejecting the spent stem at the rear.

07613 model for MAXLOK

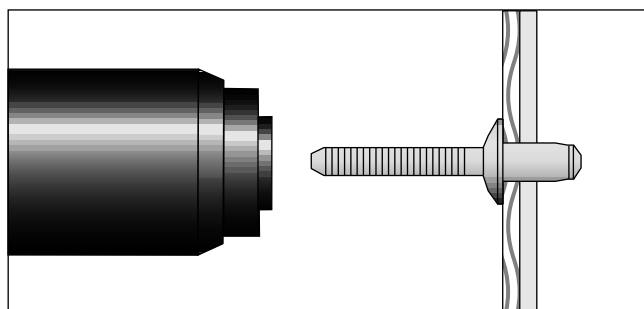
- Ensure that the correct nose assembly is fitted.
- Connect the tool to the air supply.
- Push the Maxlok stem through the application hole.
- Place the collar on the stem (orientation as shown below).
- Keeping the head of the stem against the application, push the tool onto the protruding stem.
- Fully depress the trigger. One cycle will ensure that the collar is swaged into the lock grooves of the stem and the stem breaks at the breaker groove.
- Release the trigger. The tool completes its cycle by pushing itself off the collar and ejecting the spent stem at the rear.



07614 model for HEMLOK

When placing Hemlok, two different approaches may be used, both resulting in equal quality placing. OPTION 1 brings the tool to the fastener already positioned in the application hole while OPTION 2 positions the fastener in the tool, or specifically in its nose assembly, then brings them together to the application.

Use which ever suits your environment and application.



OPTION 1

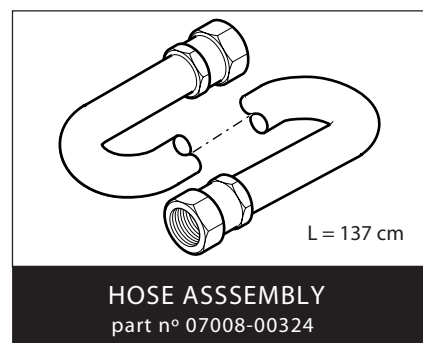
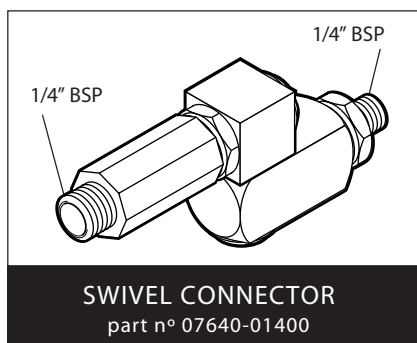
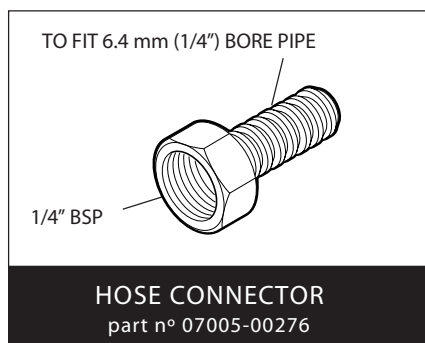
- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener body squarely into the prepared hole of the application as shown right.
- Apply the tool to the protruding fastener stem.
- Fully operate the trigger. The tool cycle will ensure the fastener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

ACCESSORIES

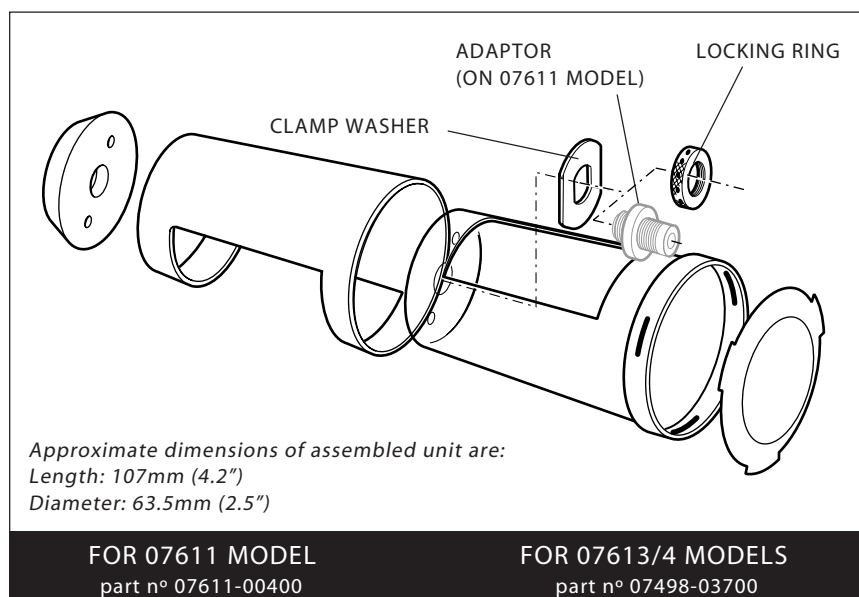
Three different accessories are available to make the connection to your air supply:



STEM COLLECTOR

To better control waste, a stem collector can be fitted as an alternative to the standard stem deflector.

- To fit the stem collector, unscrew the end cap and remove together with the stem deflector (items 9 and 10 of page 14 to 17).
- Assemble the stem collector as shown on the drawing opposite.
- Push the assembly onto the cylinder end plug (item 11 of page 14 to 17).
- Secure by finger tightening the previously removed adaptor on the 07611 model or the locking ring supplied for the 07613 and 07614 models over the clamp washer.
- Rotate the stem collector body until the opening is in the desired position.
- Fully tighten the adaptor or locking ring.



IMPORTANT

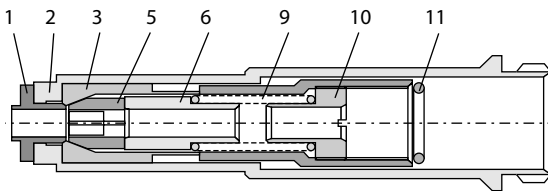
The stem collector **MUST** be emptied frequently, approximately when half full or every 120 placings.

NOSE ASSEMBLIES

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 can order a complete new nose assembly using the selection table page 4 or you can order individual components using the tables below.

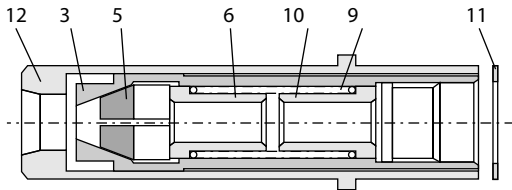
COMPONENT PART NUMBERS

AVTAINER nose assembly 07498-00800



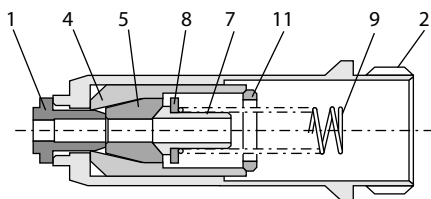
ITEM	COMPONENT	PART N°	QTY
1	NOSE TIP	07498-00802	1
2	NOSE CASING	07498-00501	1
3	CHUCK COLLET	07498-00801	1
5	JAWS	07220-02302	1 SET
6	FRONT SPRING GUIDE	07498-00803	1
9	SPRING	07500-02005	1
10	REAR SPRING GUIDE	07498-00503	1
11	LOCKING RING	07340-00327	1

MAXLOK nose assemblies 07610-02000 & 07610-02100



ITEM	COMPONENT	3/16"	1/4"	QTY
12	ANVIL	07610-02001	07610-02101	1
3	CHUCK COLLET	07610-02002	07610-02102	1
5	JAWS	07610-02003	07610-02103	1 SET
6	FRONT SPRING GUIDE	07220-02104	07220-02104	2
9	SPRING	07610-02107	07610-02107	1
10	REAR SPRING GUIDE	07610-02004	07610-02004	1
11	LOCKING RING	07220-02104	07220-02104	1

HEMLOK nose assembly 07612-02000



ITEM	COMPONENT	PART N°	QTY
1	NOSE TIP	07612-02001	1
2	NOSE CASING	07340-00306	1
4	JAW HOUSING	07612-02003	1
5	JAWS	07612-02002	1 SET
7	JAW SPREADER	07498-04502	1
8	BUFFER	07498-03003	1
9	SPRING	07500-00418	1
11	LOCKING RING	07340-00327	1

FITTING INSTRUCTIONS

IMPORTANT

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

These instructions apply to all three models. Simply ignore instructions relating to items that do not exist in your particular nose assembly.

- Lightly coat jaws 5 with Moly lithium grease.
- Drop jaws 5 into jaw housing 4 or chuck collet 3.
- Insert jaw spreader 7 into jaw housing 4 (locating in the 'V' shape formed by the jaws) or insert front spring guide 6 into chuck collet 3.
- Locate buffer 8 on jaw spreader 7.
- Locate spring 9 onto jaw spreader 7 or onto front spring guide 6.
- Screw or drop rear spring guide 10 into chuck collet 3.
- Fit locking ring 11 onto the jaw spreader housing of the tool, item 24 pages 14 to 17.
- Holding tool pointing down, screw the assembled jaw housing or chuck collet onto the jaw spreader housing and tighten with spanner.
- Screw nose tip 1 into nose casing 2.
- Place nose casing 2 over jaw housing 4 and screw onto tool, tightening with spanner or place anvil 12 over chuck collet 3 and lock into place with the anvil nut, item 25 page 16 and 17.

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.
- Particularly check wear on jaws.
- Check spring 9 is not distorted.
- Assemble according to fitting instructions.

SERVICING THE TOOL

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.
- If there is no filter on the pressure regulator, bleed the air line to clear it of accumulated dirt or water before connecting air hose to tool. If there is a filter, drain it.
- Check that the nose equipment is correct.
- Ensure either a stem collector or a spent stem deflector is fitted to the tool.
- Check the stroke of the tool meets the minimum specification (inside front page). It is the difference in the measurement between the front face of the jaw spreader housing assembly and the front face of the head before pressing the trigger and when it is fully depressed.

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 opposite.

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 07900-04990.

SERVICE KIT					
PART N°	DESCRIPTION	QTY	PART N°	DESCRIPTION	QTY
07001-00092	SCREW	6	07900-00163	⁵ / ₆₄ " ALLEN KEY	1
07900-00001	SPRING COMPRESSION TOOL	1	07900-00004	RIGHT ANGLE CIRCLIP PLIERS	1
07900-00006	'O' RING ASSEMBLING TOOL	1	07900-00249	PRIMING PUMP ASSEMBLY	1
07900-00008	⁷ / ₁₆ " x ¹ / ₂ " SPANNER	1	07900-00252	SEAL EXTRACTOR	1
07900-00009	³ / ₃₂ " ALLEN KEY	1	07900-00382	SCREWDRIVER	1
07900-00012	⁹ / ₁₆ " x ⁵ / ₈ " ALLEN KEY	1	07900-00421	¹³ / ₁₆ " RING SPANNER	1
07900-00013	¹ / ₈ " ALLEN KEY	1	07900-00432	PLASTIC CASE	1
07900-00015	⁵ / ₈ " x ¹¹ / ₁₆ " SPANNER	1	07992-00020	80 g TIN MOLYLITHIUM GREASE EP 3753	1
07900-00078	⁵ / ₃₂ " ALLEN KEY	1	07900-00539	SPANNER	1
07900-00137	TOMMY BAR	1	07900-00540	SPANNER	1
07900-00429	SPANNER ASSEMBLY FOR HEAD PISTON	1	03201-00615	PIN	1
07900-00158	PIN PUNCH	1	07900-00236	SPANNER	1
07900-00159	⁷ / ₁₆ " x ¹ / ₂ " SPANNER	1	07900-00628	HEAD PISTON ROD SEAL ENTRY GUIDE	1
07900-00160	NOSE BULLET	1	07900-00629	HEAD PISTON ROD INSTALLATION TOOL	1
07900-00164	CIRCLIP PLIERS	1	07900-00630	PISTON SEAL ENTRY GUIDE	1

NOTE: Spanner sizes are measured 'across flats' unless otherwise specified.

TOTAL MAINTENANCE

Every 500,000 cycles the tool should be completely dismantled and new components should be used where worn, damaged or when recommended. All 'O' rings and seals should be renewed and lubricated with Moly Lithium grease EP 3753 before assembling.

IMPORTANT

Safety Instructions appear on pages 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 general assembly drawing and parts list pages 14 to 17.

Before proceeding with dismantling, remove screw 22 and seal 56 and empty oil from the tool 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 'Fitting Instructions' page 9.

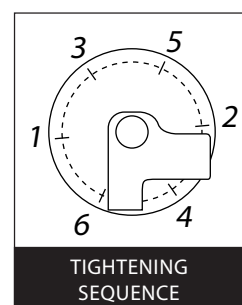
For total tool servicing we advise that you proceed with dismantling of sub-assemblies in the order shown pages 12 and 13.

HYDRAULIC PISTON ASSEMBLY

- Remove stem deflector¹⁰ and end cap ⁹.
 - On 07611 model, remove adaptor ¹⁵ using spanner* and washer ¹⁶.
 - On 07613 model only, unscrew anvil adaptor ²⁶ and anvil nut ²⁵.
 - With spring compressor tool* held in vice, compress spring ⁶, applying clamp screw ball-end to cylinder end plug ¹¹.
 - Using right angle circlip pliers* remove internal circlip or collar ⁸.
 - Unscrew the compression tool and remove cylinder end plug ¹¹ and spring ⁶.
 - Unscrew jaw spreader housing assembly ²⁴ or ^{24b} with spanner* and special spanner assembly*, then withdraw hydraulic piston ⁵.
 - On 07611 model, remove piston stop ²¹ and using circlip pliers* remove head piston stop ³ and lip seal ².
 - On 07613/4 models remove head retaining plate ³.
 - Using circlip pliers* remove internal circlip ³⁹.
 - Remove lip seal ² and wiper ring ²³.
 - Remove piston seal/lip seal ⁴ from piston ⁵.
-
- Before assembling inspect the piston diameters and the cylinder bore for wear and damage.
 - Insert the head piston rod seal entry guide* into the hydraulic bore.
 - With lip seal ² on the rod seal installation tool* push the seal into its housing with the lip of the seal towards the back of the tool.
 - Remove the installation tool and seal entry guide and confirm that the seal is properly seated in its housing.
 - On 07611 model, replace head piston stop ³ using circlip pliers*.
 - On 07613 & 07614 models, fit circlip ³⁹ using circlip pliers*. Replace the head retaining plate ³ inside bore.
 - Screw nose bullet* onto end of piston rod.
 - Insert piston seal entry guide* into the hydraulic bore.
 - Ensuring correct orientation, position piston/lip seal ⁴ onto hydraulic piston ⁵ and insert the piston into the hydraulic bore.
 - Remove nose bullet*.
 - On 07611 model, fit head piston stop ³.
 - Fit new wiper ring ²³.
 - Always screw on a new jaw spreader housing and tighten to achieve a maximum gap of 8.5 millimetres (0.335 inches) between its rear face and the front face of the head and handle assembly ¹.
 - Discard old jaw spreader housing.
 - Complete assembly in reverse order to dismantling.

PNEUMATIC PISTON ASSEMBLY

- Remove bleed screws ²² and ⁴¹ from head and handle assembly ¹ and drain oil into a suitable container.
- With the tool connected to the air supply, depress the trigger and remove the tool from the air supply.
- Remove connector⁵⁴, washer ⁵⁵ and silencer ²⁸.
- Actuate the trigger several times.
- Using Allen key*, remove screws ⁴⁸, ONE AT A TIME, and install the service screws*. The order of screw removal and replacement is important and must follow the sequence shown in the diagram (right).
- Withdraw head and handle assembly ¹ to full extent of service screws.
- Check pneumatic piston assembly ⁴² is at top of pneumatic cylinder ⁵⁰ before finally dismantling.
- Remove the six service screws and withdraw head and handle assembly ¹ and air piston assembly ⁴² from air cylinder ⁵⁰.
- Remove 'O' ring ⁵² from air piston assembly ⁴².
- Remove gasket ⁴⁷.
- Using Allen key*, remove eight screws ¹⁷ securing retaining plate ¹⁸.
- Using seal extractor*, withdraw seal housing ¹⁴.



* refers to items included in the Avdel service kit. For complete list see page 11.

- To replace 'O' ring 52 use 'O' ring assembling tool*.
- Inspect intensifier rod 43 and buffers 45 & 51. If damaged replace using tommy bar* and kit spanner assembly for head piston*.
- Lubricate bores with Moly Lithium grease EP 3753*.
- Insert seal housing 14 into head and handle sub-assembly 12 with 'O' rings 13.
- Attach the retaining plate with the eight screws tightened to a torque of 30 lb/in (3.39 Nm).
- Insert intensifier rod through the seal housing into the handle assembly.
- Fit new gasket 47.
- If nut 46 is removed, it MUST be replaced by a new one.
- Assemble handle to air cylinder and complete assembly in reverse order to dismantling.

AIR VALVE ASSEMBLY

- Remove plastic handle covers 57 and 59 using Allen key* to release screws 58.
- Unscrew end plug 29, remove spring 30 and withdraw valve spool 31.
- Using Allen key*, remove screws 36 securing silencer retainer 34 and withdraw silencer 28.
- Clean all parts particularly silencer and bush 33.
- Complete assembly in reverse order to dismantling.

TRIGGER ASSEMBLY

- Remove plastic handle covers 57 and 59 using Allen key*.
- Using Allen key*, remove two screws 36 releasing crank pin retainer 37, crank pin pivot 38, silencer retainer 34 and crank pin 35.
- Knock out pin 20 using pin punch*.
- Remove trigger assembly 19 from head and handle assembly 1.
- Complete assembly in reverse order to dismantling.

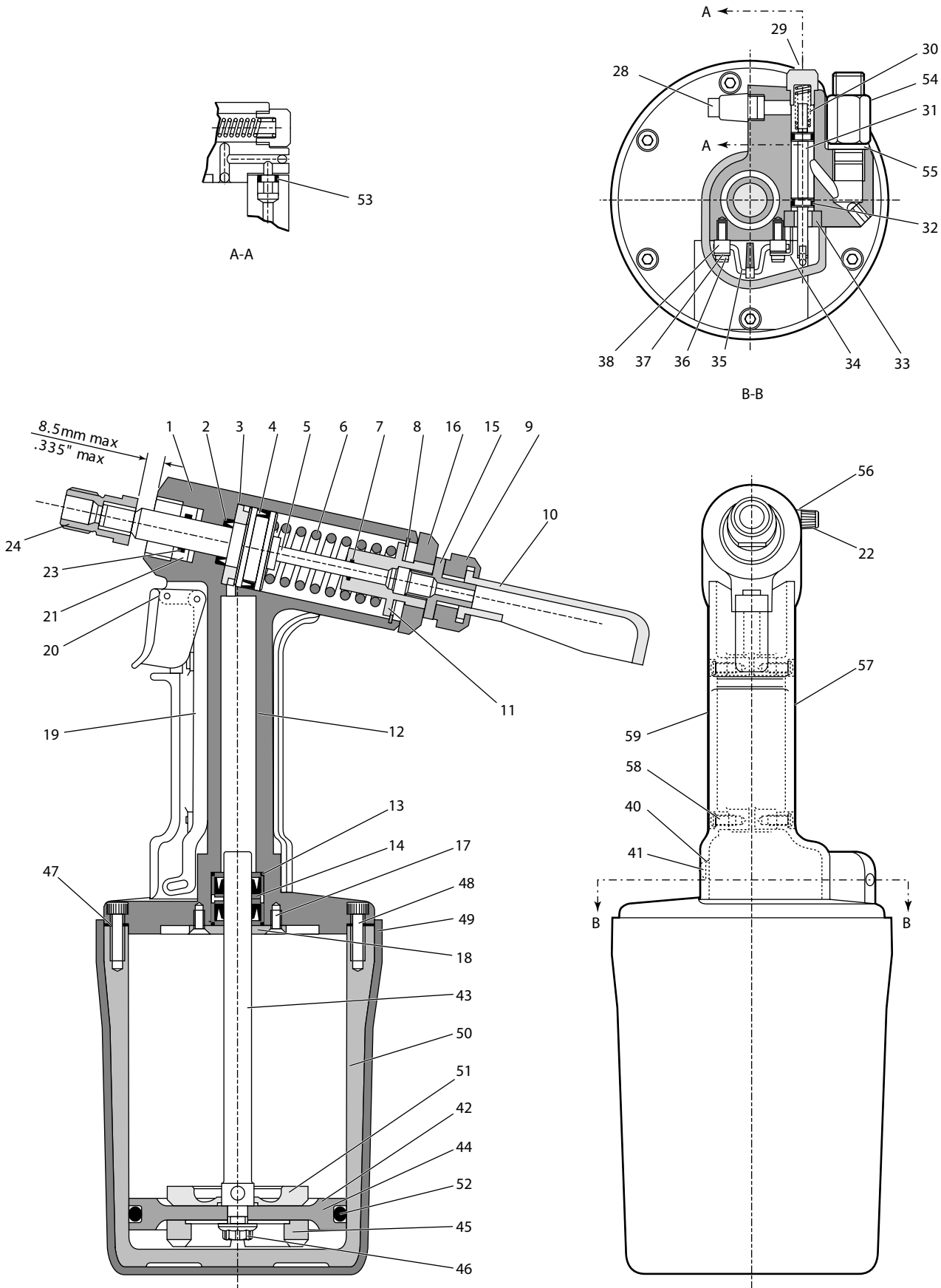
I M P O R T A N T

Check the tool against daily and weekly servicing.

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

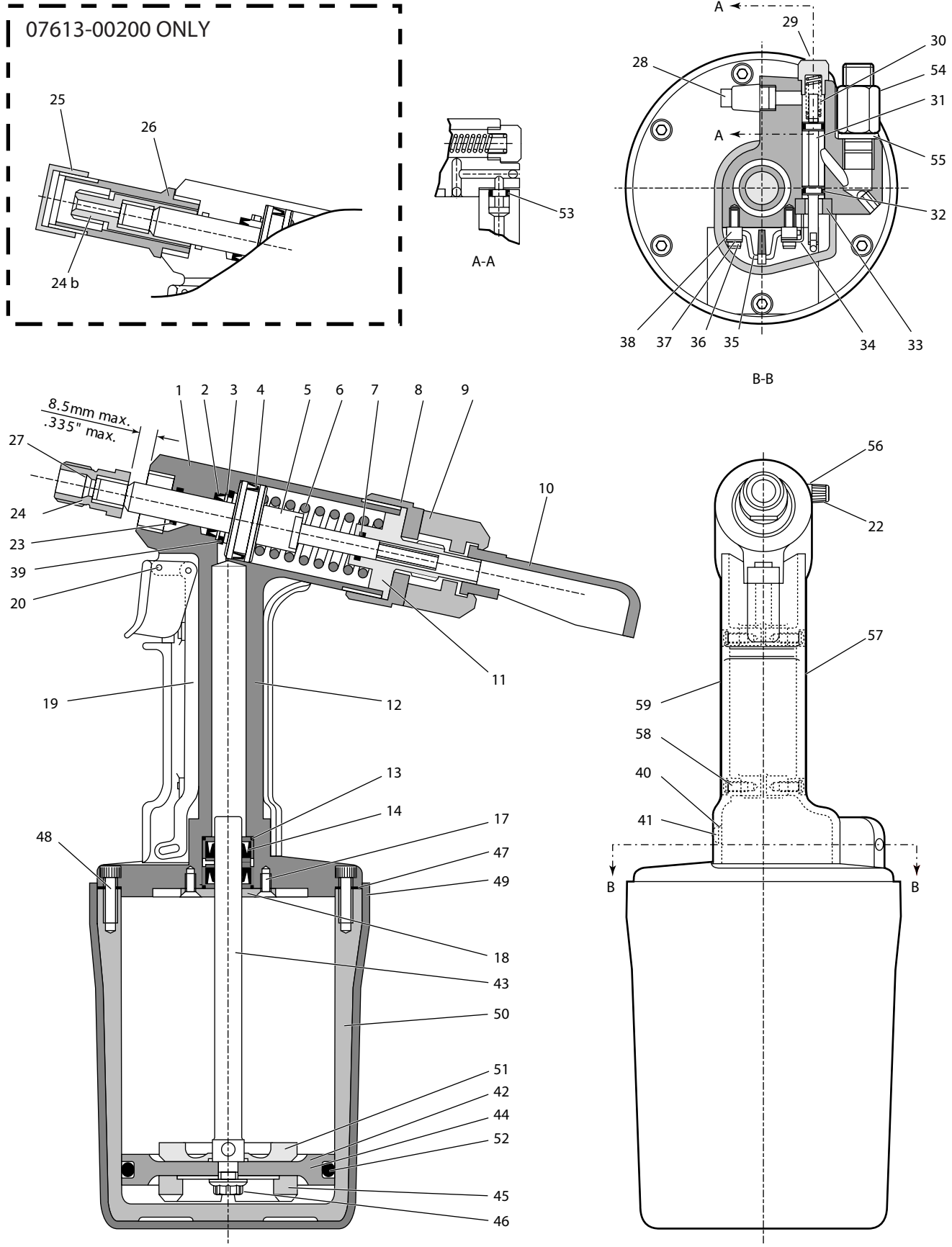
* refers to items included in the Avdel service kit. For complete list see page 11.

GENERAL ASSEMBLY OF BASE TOOL 07611-00200



07611-00200 PARTS LIST- Spares are minimum recommended levels				
ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07611-00500	HEAD & HANDLE ASSEMBLY	1	-
2	07003-00245	● LIP SEAL	1	-
3	07498-02302	● HEAD PISTON STOP	1	-
4	07003-00244	● LIP SEAL	1	-
5	07611-00501	● HYDRAULIC PISTON	1	-
6	07490-03002	● SPRING	1	-
7	07003-00030	● 'O' RING	1	3
8	07004-00022	● CIRCLIP	1	1
9	07340-00332	● END CAP	1	1
10	07340-00342	● STEM DEFLECTOR	1	1
11	07610-00305	● CYLINDER END PLUG	1	-
12	07498-02800	● HEAD & HANDLE	1	-
13	07003-00100	● 'O' RING	2	4
14	07498-02200	● SEAL HOUSING	1	-
15	07611-00301	● ADAPTOR	1	-
16	07498-00204	● WASHER	1	1
17	07001-00339	● SCREW	8	8
18	07498-00301	● RETAINING PLATE	1	2
19	07490-00600	● TRIGGER ASSEMBLY	1	2
20	07007-00301	● PIN	1	-
21	07498-02304	● PISTON STOP	1	1
22	07498-00206	● SCREW	1	-
23	07003-00156	● WIPER RING	1	4
24	07490-00700	● JAW SPREADER HOUSING	1	-
28	07007-00311	● SILENCER	1	-
29	07490-03506	● END PLUG	1	-
30	07340-01303	● SPRING	1	2
31	07490-03507	● VALVE SPOOL	1	-
32	07003-00001	● 'O' RING	2	4
33	07490-03800	● SILENCER & BUSH	1	-
34	07490-03501	● SILENCER RETAINER	1	-
35	07490-03503	● CRANK PIN	1	-
36	07001-00109	● SCREW	2	2
37	07490-03504	● CRANK PIN RETAINER	2	-
38	07490-03502	● CRANK PIN PIVOT	2	2
40	07003-00033	● SEAL	2	5
41	07001-00114	● SCREW	1	2
42	07498-02900	PNEUMATIC PISTON ASSEMBLY	1	-
43	07498-02901	● INTENSIFIER ROD	1	1
44	07490-03601	● PISTON	1	-
45	07490-03104	● PISTON BUFFER (BOTTOM)	1	-
46	07002-00017	● NUT	1	2
47	07490-00209	GASKET	1	2
48	07001-00108	SCREW	6	6
49	07611-00201	CYLINDER SLEEVE	1	1
50	07498-00600	PNEUMATIC CYLINDER	1	-
51	07490-00201	PISTON BUFFER (TOP)	1	-
52	07003-00131	'O' RING	1	4
53	07003-00029	'O' RING	1	4
54	07490-02201	CONNECTOR	1	1
55	07005-00015	WASHER	1	1
56	07003-00033	SEAL	1	5
57	07490-00206	HANDLE COVER-LEFT	1	-
58	07001-00130	SCREW	4	4
59	07490-00205	HANDLE COVER-RIGHT	1	-
60	07900-00437	INSTRUCTION MANUAL	1	1

GENERAL ASSEMBLY OF BASE TOOL 07613-00200 & 07614-00200



07613-00200 AND 07614-00200 PARTS LIST- Spares are minimum recommended levels				
ITEM	PART Nº	DESCRIPTION	QTY	SPARES
1	07613-00700	HEAD & HANDLE ASSEMBLY	1	-
2	07003-00245	● LIP SEAL	1	-
3	07490-00316	● HEAD RETAINING PLATE	1	-
4	07003-00262	● LIP SEAL	1	-
5	07613-00305	● HYDRAULIC PISTON	1	-
6	07490-03002	● SPRING	1	1
7	07003-00030	● 'O' RING	1	2
8	07613-00303	● COLLAR	1	1
9	07498-00313	● END CAP	1	-
10	07340-00342	● STEM DEFLECTOR	1	2
11	07613-00302	● CYLINDER END PLUG	1	-
12	07613-00600	● HEAD & HANDLE	1	-
13	07003-00100	● 'O' RING	2	-
14	07498-02200	● SEAL HOUSING	1	-
17	07001-00339	● SCREW	8	-
18	07498-00301	● RETAINING PLATE	1	-
19	07490-00600	● TRIGGER ASSEMBLY	1	-
20	07007-00301	● TRIGGER PIN	1	2
22	07498-00206	● SCREW	1	-
23	07003-00156	● WIPER RING	1	2
24	07490-00700	● JAW SPREADER HOUSING	1	-
24b	07610-00500	● JAW SPREADER HOUSING	1	-
25	07610-00307	● ANVIL NUT	1	-
26	07610-00303	● ANVIL ADAPTOR	1	-
27	07614-00201	● GUIDE TUBE	1	1
28	07007-00311	● SILENCER	1	1
29	07490-03506	● END PLUG	1	1
30	07340-01303	● SPRING	1	1
31	07490-03507	● VALVE SPOOL	1	-
32	07003-00001	● 'O' RING	2	4
33	07490-03800	● SILENCER & BUSH	1	-
34	07490-03501	● SILENCER RETAINER	1	-
35	07490-03503	● CRANK PIN	1	1
36	07001-00109	● SCREW	2	4
37	07490-03504	● CRANK PIN RETAINER	2	-
38	07490-03502	● CRANK PIN PIVOT	2	2
39	07004-00033	● CIRCLIP	1	1
40	07003-00033	● SEAL	1	3
41	07001-00114	● SCREW	1	2
42	07498-02900	PNEUMATIC PISTON ASSEMBLY	1	1
43	07498-02901	● INTENSIFIER ROD	1	1
44	07490-03601	● PISTON	1	1
45	07490-03104	● PISTON BUFFER (BOTTOM)	1	1
46	07002-00017	● NUT	1	2
47	07490-00209	GASKET	1	1
48	07001-00108	SCREW	6	4
49	07611-00201	CYLINDER SLEEVE	1	-
50	07498-00600	PNEUMATIC CYLINDER	1	-
51	07490-00201	PISTON BUFFER (TOP)	1	-
52	07003-00131	'O' RING	1	4
53	07003-00029	'O' RING	1	4
54	07490-02201	CONNECTOR	1	1
55	07005-00015	WASHER	1	1
56	07003-00033	SEAL	1	3
57	07490-00206	HANDLE COVER-LEFT	1	-
58	07001-00130	SCREW	4	4
59	07490-00205	HANDLE COVER-RIGHT	1	-
60	07900-00437	INSTRUCTION MANUAL	1	1

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 fasteners 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.

HYPIN 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 minutes to		
Relative density	at 20°C	0.875		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

IMPORTANT

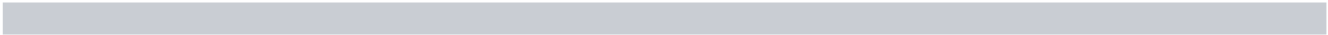
All operations should be carried out on a clean bench, with clean hands in a clean area.
 Ensure that the priming pump is free from foreign matter and that the oil is perfectly clean and free from air bubbles.
 Care **MUST** be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

Item numbers in bold refer to the general assembly and parts list pages 14 to 17.

- Clean the exterior of the tool and stand on clean bench.
- Disconnect the air supply.
- Fill the priming pump supplied with every complete tool or available in the service kit, with priming oil. Expel any air by applying pressure to the end of the pump or 'actuating' the pump. Spare threaded nipples are available part number 07900-00250.
- Remove filler screw 41 and seal 40 at the base of the handle and bleed screw 22 and seal 56 on the side of the head.
- Screw the priming pump into the hole left by screw 41.
- Actuate the priming pump several times until the air coming out of the bleed screw hole is free of air bubbles.
- Replace seal 56 and bleed screw 22.
- Lay the tool horizontally with the priming pump uppermost. Remove the priming pump.
- Replace seal 40 and filler screw 41.
- Reconnect the air supply and check that the stroke of the tool is within specification. If not, repeat priming procedure.

Item numbers in bold refer to the general assembly and parts list pages 14 to 17.

SYMPTOM	POSSIBLE CAUSE	REMEDY
More than one operation of the trigger needed to place fastener	→ Air leak	→ Tighten joints or replace components
	→ Broken gasket 47	→ Replace
	→ Insufficient air pressure	→ Adjust air pressure to within the specification
	→ Lack of lubrication	→ Lubricate tool at air inlet point
	→ Worn or broken jaws	→ Fit new jaws
	→ Low oil level or air present in oil	→ Prime tool
	→ Build up of dirt inside the nose assembly	→ Service the nose assembly
Tool will not grip stem of fastener	→ Worn or broken jaws	→ Fit new jaws
	→ Build up of dirt inside the nose assembly	→ Service the nose assembly
	→ Loose jaw housing/chuck collet	→ Tighten against locking ring
	→ Weak or broken spring in nose assembly	→ Fit new spring
	→ Incorrect component in nose assembly	→ Identify component and replace
Jaws will not release broken stem of fastener	→ Build up of dirt inside the nose assembly	→ Service the nose assembly
	→ Jaw housing/chuck collet, nose tip or nose casing not properly seated	→ Tighten nose assembly
	→ Weak or broken spring in nose assembly	→ Fit new spring
	→ Air or oil leak	→ Tighten joints or replace components
	→ Low oil level or air present in oil	→ Prime tool
	→ Build up of dirt inside the nose assembly	→ Service the nose assembly
	→ Broken head piston spring	→ Replace
Cannot feed new fastener	→ Broken stems jammed inside the tool	→ Empty stem catcher
		→ Incorrect jaw spreader/front spring guide
		→ Adjust air pressure to within the specification
Slow cycle	→ Lack of lubrication	→ Lubricate tool at air inlet point
	→ Low air pressure	→ Adjust air pressure to within the specification
	→ Build up of dirt inside the nose assembly	→ Service the nose assembly
	→ Dirty silencer 28	→ Clean
Tool fails to operate	→ No air pressure	→ Connect and adjust to within the specification
	→ Broken trigger mechanism	→ Service. See page 13
	→ Dirty silencer 28	→ Clean
Tool fails to break fastener stem	→ Insufficient air pressure	→ Adjust air pressure and volume to within the specification
	→ Incorrect length of fastener (MAXLOK)	→ Change to correct length
	→ Low oil level or air present in oil	→ Check seals and prime tool
	→ Dirty silencer 28	→ Clean
	→ Control valve dirty	→ Clean
Tool fails to swage collar (MAXLOK ONLY)	→ Insufficient air pressure	→ Adjust air pressure to within the specification
	→ Worn anvils	→ Replace
	→ Low oil level or air present in oil	→ Prime tool
	→ Anvil cracked	→ Replace
	→ Incorrect length of fastener	→ Change to correct length



Declaration of Conformity

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

declare under our sole responsibility that the product

type 0761

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/EEC

Welwyn Garden City - date of issue



A. Seewraj - Product Engineering Manager -
Automation Tools



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



BS EN ISO 9001 & 2:1994

FM 00317



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