

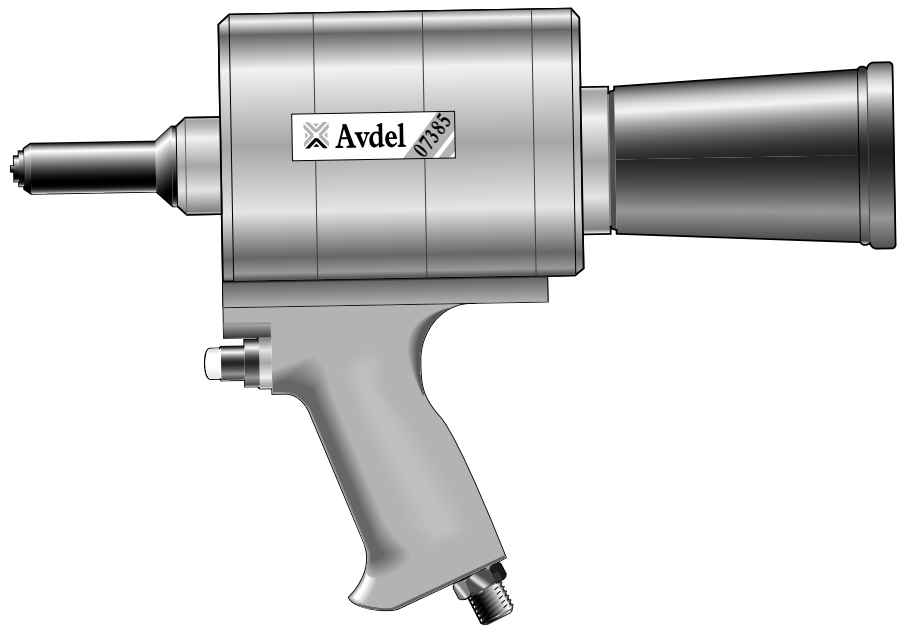


An Acument™ Global Technologies Company



## Instruction Manual

Pass onto user to read and keep for reference



**P n e u m a t i c P o w e r T o o l**

**07385**

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.

### S P E C I F I C A T I O N S   F O R   0 7 3 8 5   T O O L

AIR PRESSURE	■	Minimum - Maximum	■	5 - 8 bar	■	70 - 120 lbf/in <sup>2</sup>
FREE AIR VOLUME REQUIRED	■	@ 5.5 bar / 80 lbf/in <sup>2</sup>	■	2.3 litres	■	.08 ft <sup>3</sup>
STROKE	■	Minimum	■	15.9 mm	■	.625 in
PULL FORCE	■	@ 4.8 bar / 70 lbf/in <sup>2</sup>	■	5.5 kN	■	1225 lbf
CYCLE TIME	■	Approximately	■	1 second	■	
NOISE LEVEL	■		■	78.5 dB(A)	■	
WEIGHT	■	Without nose equipment	■	2.11 kg	■	4.65 lb
VIBRATION	■	Less than	■	2.5 m/s <sup>2</sup>	■	8 ft/s <sup>2</sup>

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# S A F E T Y

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.

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

THE OPERATING PRESSURE SHALL NOT EXCEED 8 BAR - 120 LBF/IN<sup>2</sup>.

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.

07385 TOOLS MUST BE FITTED WITH AN UNDAMAGED PINTAIL DEFLECTOR OR STEM CATCHER BEFORE OPERATING.

WHEN 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.

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.

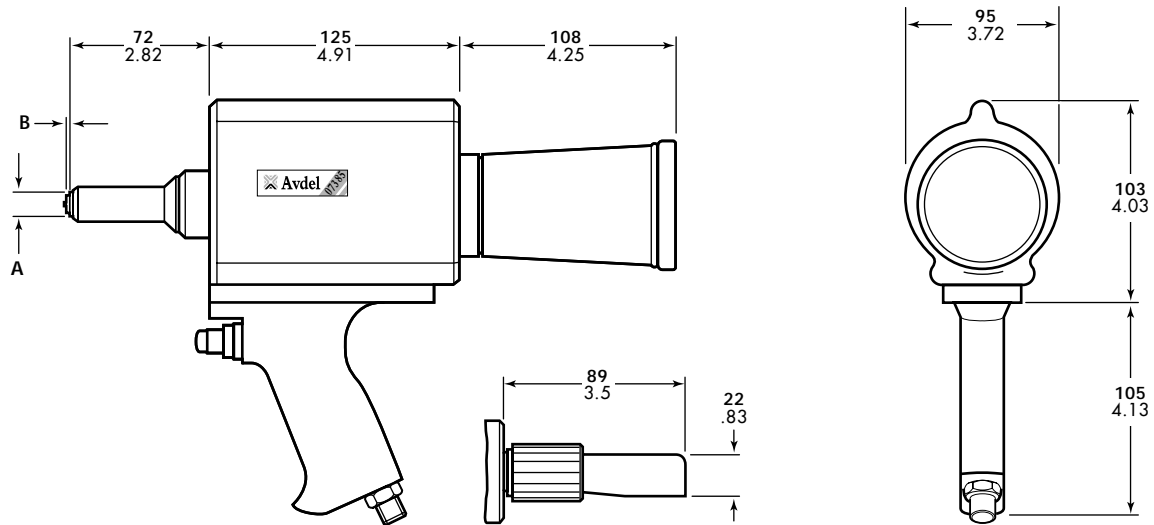
# INTENT OF USE

The hydro-pneumatic 07385 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 07385 fitted with a stem catcher is the standard tool, a pintail deflector is also supplied but not fitted. Use the selection chart opposite to select a complete 07385 tool which will include the correct nose assembly for a selected fastener. 'A' and 'B' dimensions will help you assess the accessibility of your application.

It is also possible to order the base tool only (part number 07385-00200).

It is essential that a nose assembly be fitted prior to operating the tool. For details of Nose Assemblies see page 8 and 9.



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

## 07385 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 07385-00019 large flange only.	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-03000	07385-00001	
		Al. Alloy	Standard	12.7	3.3	.500	.130	*07381-04500	07385-00037	
		Al. Alloy	Extended	9.5	12.9	.375	.510	07381-03100	07385-00002	
		Al. Alloy	Head Forming	12.7	3.3	.500	.130	07381-03200	07385-00003	
	3 mm	5/32"	Steel	Standard	12.7	3.3	.500	.130	07381-03400	07385-00008
			Steel	Standard	12.7	3.3	.500	.130	*07381-04600	07385-00038
			Al. Alloy	Standard	12.7	3.3	.500	.130	07381-03300	07385-00006
			Al. Alloy	Standard	12.7	3.3	.500	.130	07381-03400	07385-00008
		3/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	*07381-04600	07385-00038
			Al. Alloy	Extended	9.5	11.4	.375	.450	07381-03500	07385-00009
			Al. Alloy	Head Forming	12.7	3.3	.500	.130	07381-03600	07385-00010
			Steel ■	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015
	5/16"	Steel	Standard	12.7	3.3	.500	.130	*07381-04700	07385-00039	
		Al. Alloy	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015	
		Al. Alloy	Standard	12.7	3.3	.500	.130	*07381-04700	07385-00039	
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07385-00016	
		Al. Alloy	Head Forming	12.7	4.1	.500	.160	07490-04300	07385-00017	
		Steel ▲	Standard	12.7	3.3	.500	.130	07490-04900	07385-00018	
		Steel	Standard	12.7	3.3	.500	.130	*07381-04800	07385-00040	
		Al. Alloy L/flange	Standard	19.0	4.1	.750	.162	07490-05000	07385-00019	
AVDEL Snap head & 100° csk & 120° csk	1/8"	St. Steel & Titanium	Standard	12.7	3.3	.500	.130	07381-03700	07385-00021	
		Al. Alloy	Standard	12.7	2.5	.500	.100	07381-03800	07385-00024	
		Al. Alloy Oversize	Standard	12.7	2.5	.500	.100	07344-02900	07385-00026	
	5/32"	St. Steel & Titanium ▲	Standard	12.7	3.3	.500	.130	07344-02400	07385-00029	
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02600	07385-00030	
		Al. Alloy Oversize	Standard	12.7	2.5	.500	.100	07344-03000	07385-00031	
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02700	07385-00034	
3/16"	Al. Alloy Oversize	Standard	12.7	2.5	.500	.100	07344-03100	07385-00035		
	Al. Alloy & Steel ▲	Standard	12.7	4.1	.500	.160	07498-04500	07385-00011		
MONOBOLT Protuding head & 100° csk	3/16"	Al. Alloy & Steel ▲	Standard	12.7	4.1	.500	.160	07498-04500	07385-00011	
BULBEX	5/32"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-03400	07385-00008	
		Al. Alloy	Standard	12.7	3.3	.500	.130	*07381-04600	07385-00038	
	3/16"	Al. Alloy	Extended	9.5	11.4	.375	.450	07381-03500	07385-00009	
		Al. Alloy	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015	
		Al. Alloy	Standard	12.7	3.3	.500	.130	*07381-04700	07385-00039	
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07385-00016	
AVSEAL	4mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07381-04900	07385-00064	
		Al. Alloy	Extended	12.7	6.7	.500	.264	07381-05000	07385-00074	
	5mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07640-02100	07385-00065	
		Al. Alloy	Extended	12.7	6.7	.500	.264	07640-03100	07385-00075	
	6mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07640-02200	07385-00066	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07640-03200	07385-00076	
	6.5mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07340-08300	07385-00062	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07498-09100	07385-00072	
	7mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07640-02400	07385-00067	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07640-03400	07385-00077	
	TLR	3/16"	Al. Alloy	Standard	12.7	4.1	.500	.160	07498-01600	07385-00058
	AVINOX BE11 & BE61	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07381-03400	07385-00008
Stainless Steel			Standard	12.7	3.3	.500	.130	*07381-04600	07385-00038	
5/32"		Stainless Steel ■	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
		Stainless Steel ■	Standard	12.7	3.3	.500	.130	*07381-04700	07385-00039	
T-LOK Snaphead	4.3mm	Stainless Steel	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015	
		Stainless Steel	Extended	9.5	10.0	.375	.395	07241-07300	07385-00014	
	3/16"	Stainless Steel	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015	
		Stainless Steel	Extended	9.5	10.0	.375	.395	07241-07300	07385-00014	
AVIBULB Low Profile	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07381-03400	07385-00008	
	5/32"	Stainless Steel	Standard	12.7	3.3	.500	.130	07490-02300	07385-00015	

Minimum Pressure required

■ 5.1 BAR / 75 lbf/in<sup>2</sup>

▲ 5.4 BAR / 80 lbf/in<sup>2</sup>

● 6.1 BAR / 90 lbf/in<sup>2</sup>

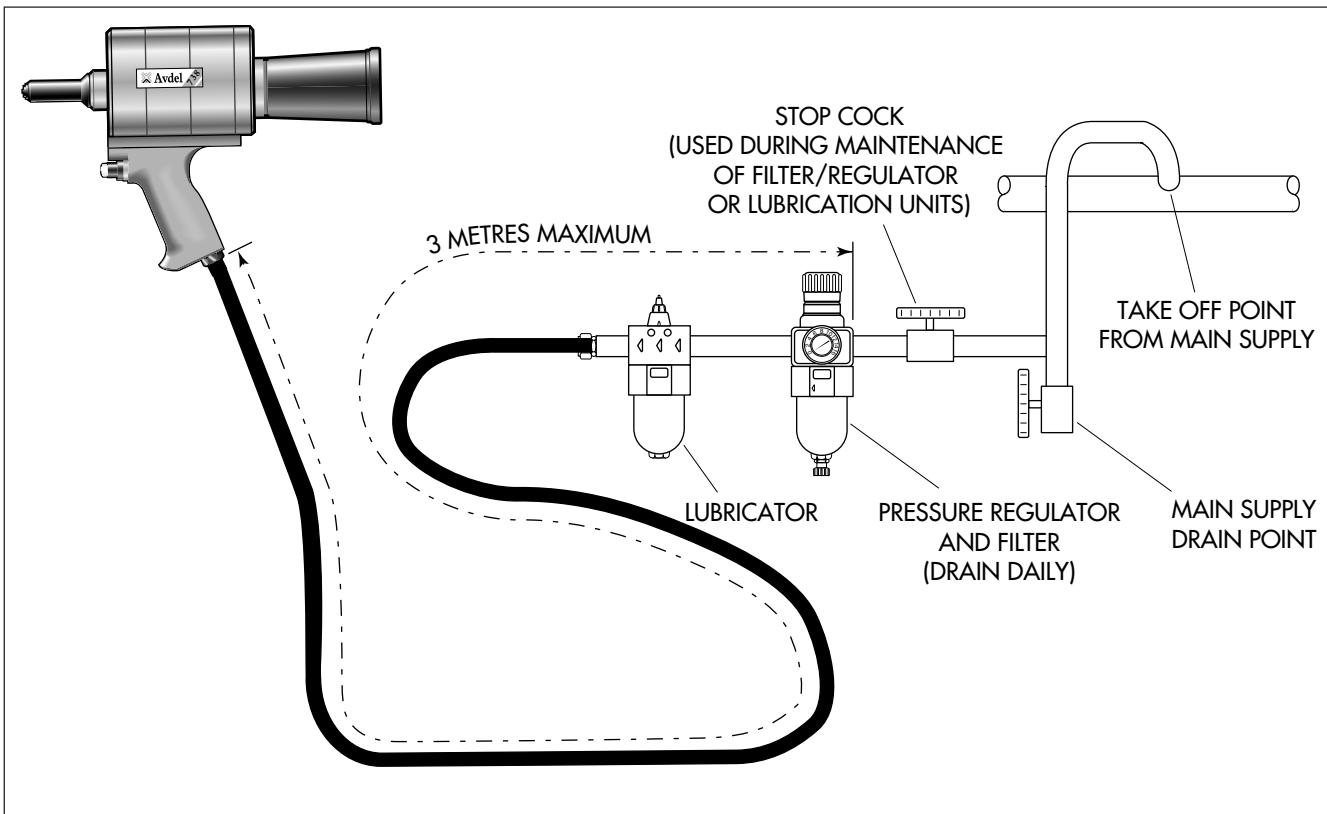
\* These nose assemblies are forward stem release nose assemblies.

## 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 1/4 inch.

Read servicing daily details page 10.



## 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

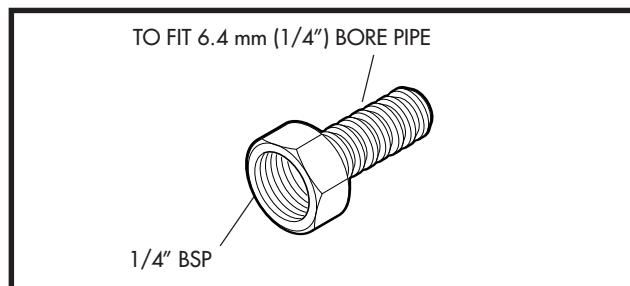
- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener stem into the nose of the tool.
- Insert the tool with the fastener squarely into the prepared hole of the application.
- Fully operate the trigger. The tool cycle will ensure the rivet is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



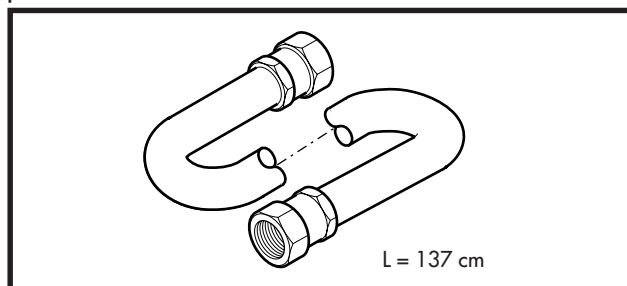
## ACCESSORIES

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

Hose Connector  
part n° 07005-00276



Hose Assembly  
part n° 07008-000324



# NOSE ASSEMBLIES

There are two types of nose assemblies for the 07385 tool, standard nose assemblies and forward stem release 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 will be able to order a new complete nose assembly using the selection table page 5.

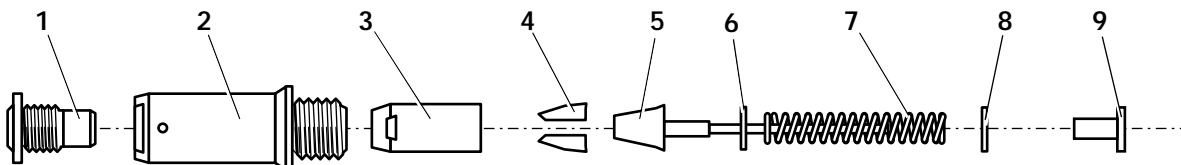
## FITTING INSTRUCTIONS

### IMPORTANT

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

- 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 as well as stop 9 on forward stem release nose assembly.
- Holding tool pointing down, screw on the assembled jaw housing or onto the jaw spreader housing assembly and tighten with spanner.
- Place nose casing 2 over jaw housing 3 and screw onto tool, tightening with spanner.
- Screw nose tip 1 into nose casing 2.

Item 9 only exists on Forward Stem Release Nose Assemblies (see capability table page 5)



## 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.
- Ensure that the tube of jaw spreader assembly 5 (where fitted) is not distorted.
- Check spring 7 is not distorted.
- Assemble according to fitting instructions.

## NOSE ASSEMBLY COMPONENTS

This table lists all nose assemblies. 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. Forward Stem Release nose assemblies, except nose assembly 07381-04800, also include a pin stop part number 07381-04502 (see illustration opposite). To identify which nose assemblies are forward stem release refer to the compatibility table page 5.

<b>07385 NOSE ASSEMBLY COMPONENTS</b>								
<b>NOSE ASSY</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>
07241-07300	07241-07101	07340-02804	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07340-08300	07340-08301	07340-00306	07340-00304	07490-04602	07498-03002	07498-03003	07100-04003	07340-00327
07344-02400	07344-02401	07344-02001	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07344-02600	07140-02105	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-02700	07140-02106	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-02900	07344-02901	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-03000	07344-03001	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-03100	07344-03101	07344-02001	07340-00304	07498-04401	07344-02002	07340-01503	07340-01502	07340-00327
07381-03000	07340-06000	07340-00306	07340-00304	07340-00213	07381-01700	07340-01304	07340-01303	07340-00327
07381-03100	07340-02805	07340-02804	07340-00304	07340-00213	07381-01700	07340-01304	07340-01303	07340-00327
07381-03200	07340-06400	07340-00306	07340-00304	07340-00213	07381-01700	07340-01304	07340-01303	07340-00327
07381-03300	07340-06300	07340-00306	07340-00304	07340-00222	07381-01900	07340-01304	07340-01303	07340-00327
07381-03400	07340-06100	07340-00306	07340-00304	07340-00213	07381-01800	07340-01304	07340-01303	07340-00327
07381-03500	07340-02806	07340-02804	07340-00304	07340-00213	07381-01800	07340-01304	07340-01303	07340-00327
07381-03600	07340-06500	07340-00306	07340-00304	07340-00213	07381-01800	07340-01304	07340-01303	07340-00327
07381-03700	07344-02101	07344-02001	07340-00304	07340-00213	07381-02000	07340-01304	07340-01303	07340-00327
07381-03800	07140-02104	07344-02001	07340-00304	07340-00229	07381-02000	07340-01304	07340-01303	07340-00327
07381-04500	07381-04501	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07381-04600	07381-04601	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07381-04700	07381-04701	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07381-04800	07490-04401	07340-00306	07340-00304	07340-07502	07381-04801	07498-03003	07100-04003	07340-00327
07381-04900	07340-07601	07340-00306	07340-00304	07340-00213	07381-02000	07340-01304	07340-01303	07340-00327
07490-02300	07340-06200	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-02400	07340-02807	07340-02804	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-04300	07340-06600	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-04900	07490-04400	07340-00306	07340-00304	07340-07502	07340-07503	07340-01503	07340-01502	07340-00327
07490-05000	07340-04800	07340-00306	07304-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07498-01600	07605-00220	07340-00306	07498-04503	07498-04501	07498-04502	07498-03003	07100-04003	07340-00327
07498-04500	07498-03001	07340-00306	07498-04503	07498-04501	07498-04502	07498-03003	07100-04003	07340-00327
07498-09100	07498-09101	07340-00306	07340-00304	07490-04602	07498-03002	07498-03003	07100-04003	07340-00327
07640-02100	07340-07701	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301	07340-00327
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07640-03100	07498-08501	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301	07340-00327
07640-03200	07498-08601	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327
07640-03400	07498-08701	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327

# 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 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.
- 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 handle top bore before the trigger is operated and once it is fully pressed.

## WEEKLY

- Dismantle and clean the nose assembly with special attention to the jaws. Lubricate with Moly lithium grease before assembling.
- Check for 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<sub>2</sub>, 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 07900-03810) supplied in its own plastic case.

<b>SERVICE KIT</b>		
<b>ITEM PART N°</b>	<b>DESCRIPTION</b>	<b>N° OFF</b>
07900-00238	7/16" - 3/8" SPANNER	1
07900-00225	5mm ALLEN KEY	1
07900-00351	3mm ALLEN KEY	1
07900-00400	1 1/16" SPANNER	1
07992-00020	80g TIN MOLY LITHIUM GREASE EP3753	1
07900-00371	LOCTITE SUPERFAST SCREWLOCK 222 (10 ML BOTTLE)	1
07900-00422	7/16" RING SPANNER	1
07900-00423	7/16" SPANNER	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 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 and parts list page 14 and 15.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, pages 8 to 9.

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

## STEM CATCHER UNIT /PIN TAIL DEFLECTOR

- Rotate stem catcher outer 32 to expose nut 31.
- Unscrew nut 31 and remove the stem catcher comprising stem catcher body 1, stem catcher outer 32, stem catcher end cap 2 and clamp washer 3, or, if pin tail deflector is fitted, unscrew end cap 34 and remove pin tail deflector 33.
- Assemble in reverse order to dismantling.

## HANDLE AND TRIGGER VALVE ASSEMBLY

- Using an Allen key\*, remove screws 18.
- Remove handle 11.
- Remove the trigger valve by unscrewing adjuster 14 and lifting out button 16.
- Withdraw valve plunger 12, spring 17, valve plunger washer 15 and plunger seal 13. The design of the valve is such that a minimum of service is required during the tool life. Servicing should only be carried out if absolutely necessary.
- If so, unscrew retaining screw 6, then withdraw spring 7, 'O' ring 5 and ball 8.
- Assemble in reverse order to dismantling paying attention to the following:
  - Lubricate bores in trigger valve with Moly Lithium grease EP 3753.
  - Replace retaining screw 6 using a low strength anaerobic adhesive (e.g. Permabond A121 or A137). The adhesive should be spread under the head of retaining screw 6 for an approximate length of 3.2 mm (0.125 in) along the screw thread.
  - Before refitting handle 11 to cylinder set 23 inspect handle for cracks. If cracks are apparent renew handle. Lightly coat the mating surface of the cylinder set with sealing compound. Fit the handle and allow the sealing compound time to set.

### **I M P O R T A N T**

Check the tool against daily and weekly servicing.

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

## CYLINDER

- Unscrew screws 29 using an Allen key\*.
- Remove clamp plate 35 and conical spring 28.
- Using a box spanner\* and 5/8 x 9/16 A/F spanner\*, remove nut 27.
- Draw out spindle assembly 20 from the front of the tool.
- Separate and remove piston 22, distributor seals 25, shims 21 and buffers (front and rear) 24 by depressing piston spacer 26.
- Remove spacer 26.
  
- Assemble in reverse order to dismantling.
- Screws 18 and 29 must be tightened to a torque of 20 lb/ft and 60 lb/ft respectively.

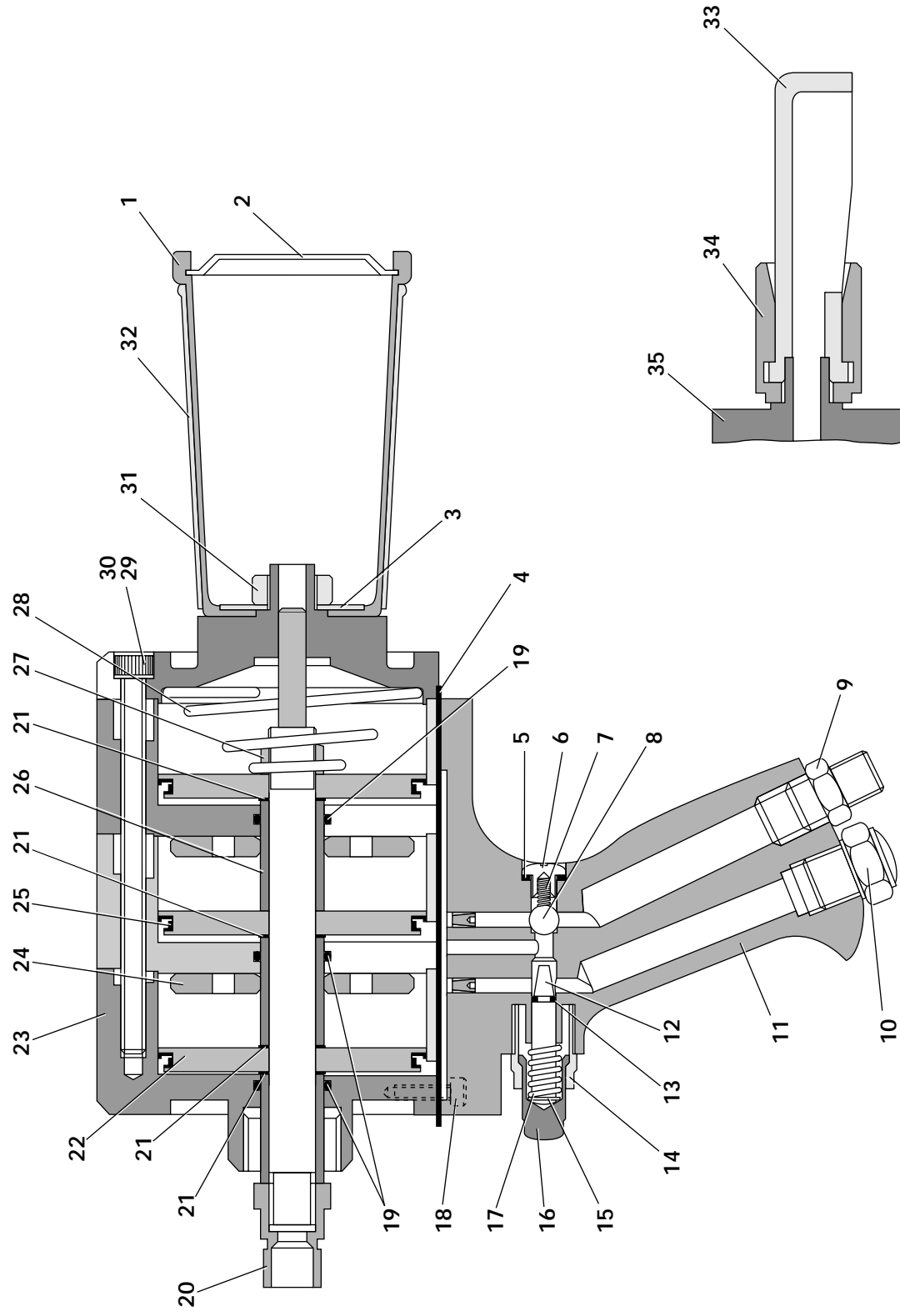
## SILENCER

- Remove silencer 10 from handle 11 using a suitable spanner.
- Blow through with airline or replace if necessary.
  
- Assemble in reverse order to dismantling.

### **I M P O R T A N T**

Check the tool against daily and weekly servicing.

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





**07385-00200 PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
01	07640-00241	STEM CATCHER BODY	1	-	19	07003-00032	'O' RING	3	3
02	07340-00335	STEM CATCHER END CAP	1	-	20	07381-02300	SPINDLE ASSEMBLY	1	-
03	07381-00205	CLAMP WASHER	1	-	21	07381-00408	SHIM	4	4
04	07381-01301	HANDLE GASKET	1	-	22	07381-00412	PISTON	3	-
05	07003-00042	'O' RING	1	1	23	07385-09000	CYLINDER SET	1	-
06	07150-00704	RETAINING SCREW	1	-	24	07381-00413	BUFFER ( FRONT & CENTRE )	2	2
07	07150-00706	SPRING	1	1	25	07003-00151	SEAL	3	3
08	07007-00457	BALL	1	1	26	07381-00407	SPACER	3	-
09	07005-00041	CONNECTOR	1	-	27	07002-00092	NUT	1	1
10	07007-00329	SILENCER	1	1	28	07385-00402	SPRING	1	-
11	07385-01300	HANDLE	1	-	29	07381-00416	SCREW	3	-
12	07150-00703	VALVE PLUNGER	1	-	30	07002-00093	WASHER	3	-
13	07150-00708	SEAL	1	1	31	07002-00097	LOCK NUT	1	-
14	07150-00711	ADJUSTER	1	-	32	07640-00239	STEM CATCHER OUTER	1	-
15	07150-00712	WASHER	1	-	33	07340-00342	PIN TAIL DEFLECTOR	1	1
16	07150-00710	BUTTON	1	-	34	07381-00204	END CAP	1	-
17	07150-00707	SPRING	1	1	35	07385-00403	CLAMP PLATE (INTEGRAL WITH ITEM 23)	1	REF ONLY
18	07001-00350	SCREW	6	6					

# 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.
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.
	→ Bent jaw spreader assembly tube preventing it from moving forward into jaw housing.	→ Replace jaw spreader assembly.
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 assembly.
	→ 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 jaw spreader assembly tube.	→ Renew or clean as applicable.
	→ Collector bottle too full.	→ Empty and ensure bottle never exceeds half full.
Slow tool operation	→ Low air pressure.	→ Increase air pressure.
	→ Lack of lubrication.	→ Lubricate tool at air inlet port.
Air leaks	→ Constant air leak from vent holes.	→ Replace distributor seal 25.
	→ Air leaks between cylinders on cylinder set 23.	→ Tighten screws 29.
	→ Air leaks between handle 11 and cylinder set 23.	→ Damaged gasket 4 or screws 18 loose. Retighten screws or replace gasket as necessary.
	→ Air leaking constantly from silencer.	→ Trigger valve worn or damaged renew.

**Declaration of Conformity**

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

declare under our sole responsibility that the product

*type 07385*

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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