



An Acument™ Global Technologies Company



## Instruction Manual

Pass onto user to read and keep for reference



**Hydro-Pneumatic Power Tool**

**0764 type**

07640 - 07641 - 07642

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 0764 TOOL

AIR PRESSURE	■	Minimum - Maximum	■ 4.8 - 7 bar	■ 70 - 100 lbf/in <sup>2</sup>
FREE AIR VOLUME REQUIRED	■	@ 5.5 bar / 80 lbf/in <sup>2</sup>	■ 3.8 litres	■ .13 ft <sup>3</sup>
STROKE	■	07640 Minimum	■ 15.6 mm	■ .625 in
PULL FORCE	■	@ 4.8 bar / 70 lbf/in <sup>2</sup>	■ 6.7 kN	■ 1506 lbf
CYCLE TIME	■	Approximately	■ 1 second	■
NOISE LEVEL	■	Less than	■ 70 dB(A)	■
WEIGHT	■	Without nose equipment	■ 1.5 kg	■ 3.3 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.

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/IN<sup>2</sup>.
- ⚠ DO NOT OPERATE THE TOOL WITHOUT FULL NOSE EQUIPMENT IN PLACE.
- ⚠ DO NOT OPERATE THE TOOL UNLESS THE BASE COVER IS FULLY SEATED ON THE TOOL BASE, ENSURING THAT THE RETAINING RING (ITEM 28 ON GENERAL ASSEMBLY) IS CORRECTLY INSTALLED.
- ⚠ CARE SHALL BE TAKEN TO ENSURE THAT SPENT STEMS ARE NOT ALLOWED TO CREATE A HAZARD.
- ⚠ 07640 TOOLS MUST BE FITTED WITH AN UNDAMAGED PINTAIL DEFLECTOR OR STEM CATCHER BEFORE OPERATING.
- ⚠ IF THE 07640 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.
- ⚠ 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 0764 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 07640 fitted with a stem catcher is the standard tool for which a pintail deflector option is available (see details on page 9). It is also possible to order the base tool only (part number 07640-00200) which will not be fitted with a nose assembly.

The base tool part number for the other two tools of this type, the 07641 and 07642, is 07641-00200. Differences with the 07640-00200 are on the general assembly and parts lists pages 18 and 19.

## 07640 TOOL SELECTION

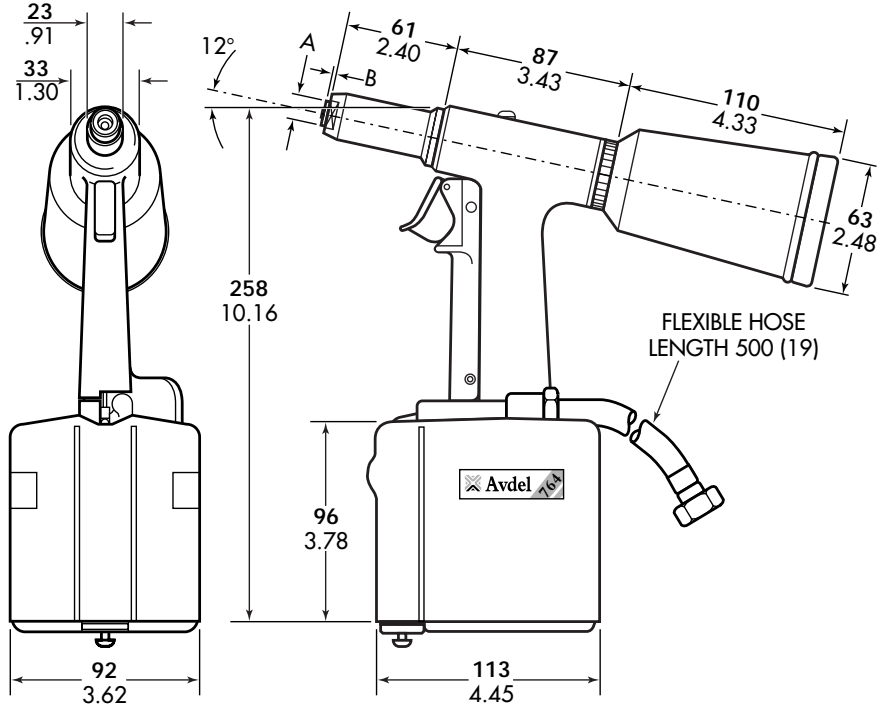
FASTENER		NOSE (see drawing opposite for A & B)						COMPLETE	
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk head except 07640-00019 large flange only.	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03000	07640-00001
		Al. Alloy	Extended	9.5	12.9	.375	.510	07490-01000	07640-00002
		Al. Alloy	Hd. Forming	12.7	3.3	.500	.130	07347-03400	07640-00003
	5/32"	Steel	Standard	12.7	3.3	.500	.130	07347-03200	07640-00008
		Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03200	07640-00008
		Al. Alloy	Extended	9.5	11.4	.375	.450	07490-01700	07640-00009
		Al. Alloy	Hd. Forming	12.7	3.3	.500	.130	07347-03500	07640-00010
		Steel	Standard	12.7	3.3	.500	.130	07347-03300	07640-00015
		Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03300	07640-00015
	3/16"	Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07640-00016
		Al. Alloy	Hd. Forming	12.7	4.1	.500	.160	07347-03600	07640-00017
		Steel	Standard	12.7	3.3	.500	.130	07381-04800	07640-00018
		Al. Alloy L/flange	Standard	19.0	4.1	.750	.160	07490-05000	07640-00019
	3mm	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03100	07640-00006
MONOBOLT	3/16"	Al. Alloy & Steel	Standard	12.7	4.1	.500	.160	07498-04500	07640-00031
BULBEX	5/32"	Al. Alloy	Standard	12.7	11.4	.500	.130	07347-03200	07640-00008
		Al. Alloy	Extended	9.5	3.3	.375	.450	07490-01700	07640-00009
	3/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03300	07640-00015
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07640-00016
AVSEAL	4mm	Al. Alloy	Short	12.7	4.5	.500	.177	07340-07600	07640-00064
	5mm	Al. Alloy	Short	12.7	4.5	.500	.177	07640-02100	07640-00065
	6mm	Al. Alloy	Short	12.7	5.3	.500	.208	07640-02200	07640-00066
	6.5mm	Al. Alloy	Short	12.7	5.3	.500	.208	07340-08300	07640-00062
	7mm	Al. Alloy	Short	12.7	5.3	.500	.208	07640-02400	07640-00067
	4mm	Al. Alloy	Extended	12.7	6.7	.500	.264	07498-08400	07640-00074
	5mm	Al. Alloy	Extended	12.7	6.7	.500	.264	07640-03100	07640-00075
	6mm	Al. Alloy	Extended	12.7	7.2	.500	.283	07640-03200	07640-00076
	6.5mm	Al. Alloy	Extended	12.7	7.2	.500	.283	07498-09100	07640-00072
	7mm	Al. Alloy	Extended	12.7	7.2	.500	.283	07640-03400	07640-00077
TLR	3/16"	Al. Alloy	Standard	12.7	4.1	.500	.160	07498-01600	07640-00058
AVINOX II	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07347-03200	07640-00008
	5/32"	Stainless Steel	Standard	12.7	3.3	.500	.130	07381-04700	07640-00032
	3/16"	Stainless Steel	Standard	12.7	3.3	.500	.130	07347-03700	07640-00033
AVDEL Snap head 100° csk & 120° csk	1/8"	St. Steel & Titanium	Standard	12.7	3.3	.500	.130	07344-02100	07640-00011
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02300	07640-00005
		Al. Alloy <i>Oversize</i>	Standard	12.7	2.5	.500	.100	07344-02900	07640-00007
	5/32"	St. Steel & Titanium	Standard	12.7	2.5	.500	.100	07344-02400	07640-00014
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02600	07640-00012
		Al. Alloy <i>Oversize</i>	Standard	12.7	2.5	.500	.100	07344-03000	07640-00013
	3/16"	Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02700	07640-00021
		Al. Alloy <i>Oversize</i>	Standard	12.7	2.5	.500	.100	07344-03100	07640-00020

## 07640 - FIXED NOSE ASSEMBLY

The 07640 is fitted with a fixed straight nose assembly suitable where access is unrestricted.

Use the selection chart below and opposite to select a complete 07640 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 10 and 11.

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



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

### 07640 TOOL SELECTION (Continued)

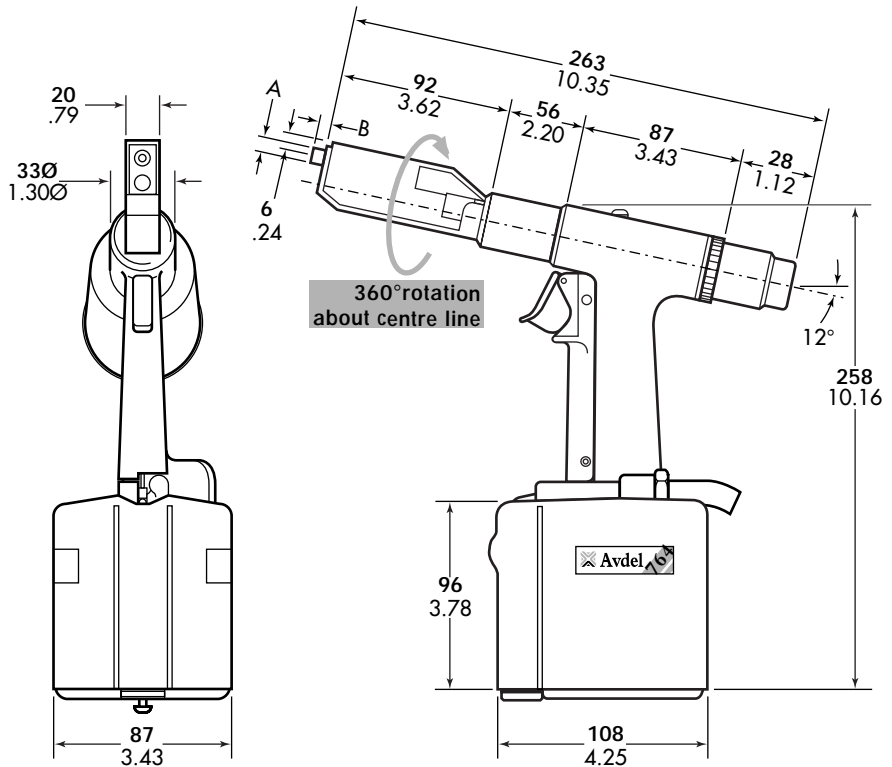
FASTENER		MATERIAL/DETAIL	NOSE TIP TYPE	NOSE (see drawing opposite for A & B)				NOSE ASSY PART N°	COMPLETE TOOL PART N°
NAME & HEAD	Ø			A (mm)	B (mm)	A (in)	B (in)		
STANDARD MBC Universal Hd & 100° csk	1/8"	Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02400	07640-00045
		Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06700	07640-00051
	5/32"	Al. Alloy <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07498-07000	07640-00054
		Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02500	07640-00046
		Al. Alloy	Standard	12.7	4.7	.500	.187	07347-03900	07640-00052
		Al. Alloy <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07344-03200	07640-00055
3/16"	Al. Alloy	Standard	12.7	4.7	.500	.187	07347-04000	07640-00053	
LOCK CREATOR MBC Universal Hd & 100° csk	1/8"	Al. Alloy	Standard	12.7	4.7	.500	.187	07498-07600	07640-00035
		Al. Alloy <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07498-07600	07640-00035
	5/32"	St. Steel	Standard	12.7	4.7	.500	.187	07344-04700	07640-00036
		Hybrid <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07498-07300	07640-00037
		Al. Alloy	Standard	12.7	4.7	.500	.187	07344-05100	07640-00038
		Al. Alloy <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07344-05100	07640-00038
		Stainless Steel	Standard	12.7	4.7	.500	.187	07344-04700	07640-00036
		Hybrid <i>Oversize</i>	Standard	12.7	4.7	.500	.187	07344-05300	07640-00040
3/16"	Al. Alloy	Standard	12.7	4.7	.500	.187	07498-07800	07640-00041	
T-LOK	4.3mm	Steel	Standard	12.7	3.3	.500	.130	07241-07400	07640-00022
		Steel	Extended	9.5	10.0	.375	.395	07241-07300	07640-00023
	3/16"	Steel	Standard	12.7	3.3	.500	.130	07241-07400	07640-00022
		Steel	Extended	9.5	10.0	.375	.395	07241-07300	07640-00023
AVIBULB Low profile Hd	5/32"	Steel	Standard	12.7	3.3	.500	.130	07381-04700	07640-00032
	3/16"	Steel	Standard	12.7	3.3	.500	.130	07347-03700	07640-00033
AVDEL SR Raised Hd 120° csk	1/8"	All Materials	Standard	12.7	3.3	.500	.130	07347-03000	07640-00001
	5/32"	All Materials	Standard	12.7	3.3	.500	.130	07347-03200	07640-00008
	3/16"	All Materials	Standard	12.7	3.3	.500	.130	07640-06800	07640-00004

## 07641 - STRAIGHT SWIVEL NOSE ASSEMBLY

The 07641 is fitted with a "straight" swivel nose 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 07641 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.

### 07641 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	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03000	07641-00004
		Steel	Standard	7.87	3.81	.310	.150	07345-03100	07641-00005
	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03100	07641-00005
		Steel	Standard	7.87	3.81	.310	.150	07345-03200	07641-00006
	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07641-00006
		Steel	Standard	7.87	4.19	.310	.165	07494-04000	07641-00036
BULBEX	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07641-00006
AVSEAL	4mm	Al. Alloy	Short	6.35	1.95	.250	.077	07494-06000	07641-00064
	5mm	Al. Alloy	Short	7.62	2.00	.300	.079	07494-06100	07641-00065
	4mm	Al. Alloy	Extended	6.35	4.11	.250	.162	07494-06600	07641-00074
	5mm	Al. Alloy	Extended	7.62	4.11	.300	.162	07494-06700	07641-00075
AVINOX	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03100	07641-00005
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03200	07641-00006
AVDEL Snap head 100° csk & 120° csk	1/8"	St. Steel & Titanium	Standard	5.08	3.81	.200	.150	07494-03000	07641-00024
		Al. Alloy	Standard	5.08	1.17	.200	.046	07345-03300	07641-00014
		Al. Alloy <i>Oversize</i>	Standard	5.08	1.17	.200	.046	07494-03600	07641-00017
	5/32"	St. Steel & Titanium	Standard	6.60	0.84	.260	.033	07494-03100	07641-00025
		Al. Alloy	Standard	6.60	0.84	.260	.033	07345-03400	07641-00015
		Al. Alloy <i>Oversize</i>	Standard	6.60	0.84	.260	.033	07494-03700	07641-00018
	3/16"	Al. Alloy	Standard	8.13	0.25	.320	.010	07345-03500	07641-00016
		Al. Alloy <i>Oversize</i>	Standard	8.13	0.25	.320	.010	07494-03800	07641-00019
	3/32"	Stainless Steel	Standard	5.08	1.27	.200	.050	07494-03400	07641-00023
STANDARD MBC Universal Hd 100° csk	1/8"	Al. Alloy & St. Steel	Standard	4.75	2.40	.187	.093	07345-04000	07641-00051
		Al. Alloy <i>Oversize</i>	Standard	4.75	2.40	.187	.093	07345-04300	07641-00054
	5/32"	Al. Alloy & St. Steel	Standard	6.35	2.40	.250	.093	07345-04100	07641-00052
		Al. Alloy <i>Oversize</i>	Standard	6.35	2.40	.250	.093	07345-04400	07641-00055
	3/16"	Al. Alloy	Standard	7.92	2.40	.312	.093	07345-04200	07641-00053

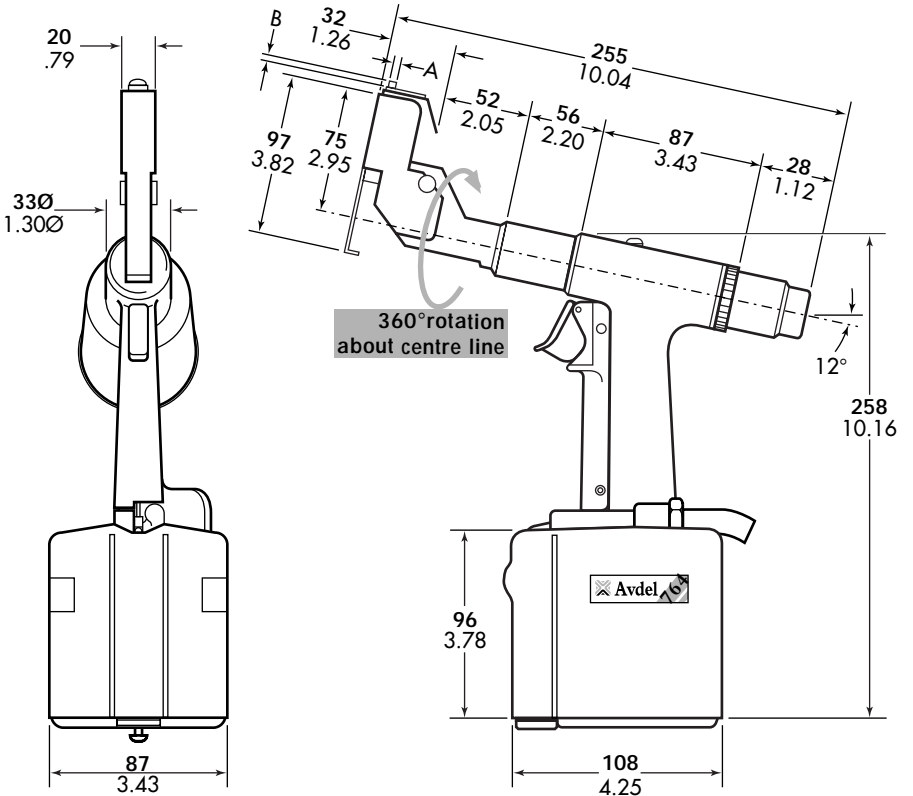


## 07642 - RIGHT ANGLE SWIVEL NOSE ASSEMBLY

The 07642 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 07642 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.

### 07642 TOOL SELECTION

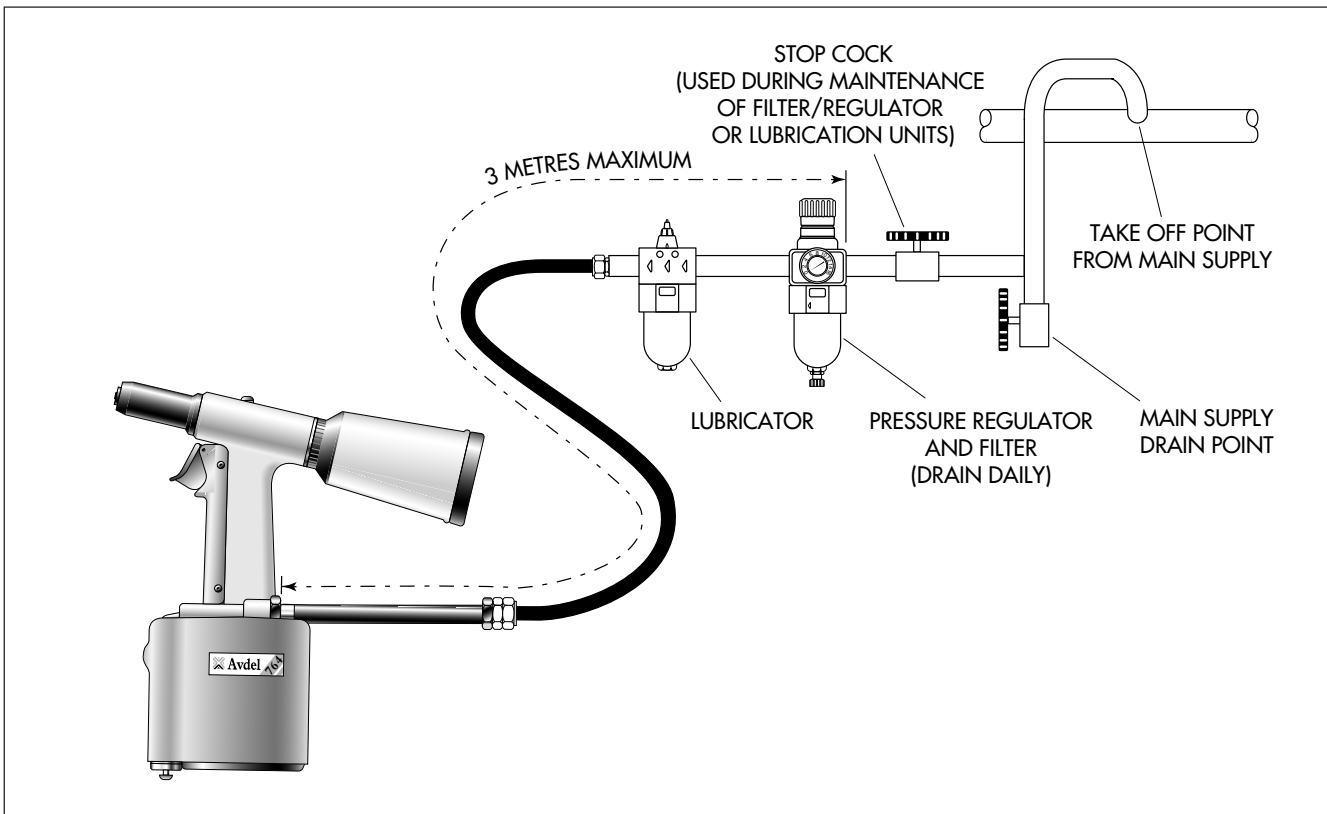
FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE	
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°	
AVEX Snap head & 120° csk head	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03000	07642-00004	
	5/32"	Steel	Standard	7.87	3.81	.310	.150	07346-03100	07642-00005	
		Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03100	07642-00005	
	3/16"	Steel	Standard	7.87	3.81	.310	.150	07346-03200	07642-00006	
		Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07642-00006	
	Steel	Standard	7.87	4.19	.310	.165	07495-03500	07642-00036		
BULBEX	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07642-00006	
AVSEAL	4mm	Al. Alloy	Short	6.35	1.95	.250	.077	07495-04000	07642-00064	
	5mm	Al. Alloy	Short	7.62	2.00	.300	.079	07495-04100	07642-00065	
	4mm	Al. Alloy	Extended	6.35	4.11	.250	.162	07495-04700	07642-00074	
	5mm	Al. Alloy	Extended	7.62	4.11	.300	.162	07495-04800	07642-00075	
AVINOX	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03100	07642-00005	
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03200	07642-00006	
AVDEL Snap head 100° csk & 120° csk	1/8"	St. Steel & Titanium	Standard	5.08	3.81	.200	.150	07495-03000	07642-00024	
		Al. Alloy	Standard	5.08	1.17	.200	.046	07346-03300	07642-00014	
	5/32"	Al. Alloy <i>Oversize</i>	Standard	5.08	1.17	.200	.046	07495-03600	07642-00017	
		St. Steel & Titanium	Standard	6.60	0.84	.260	.033	07495-03100	07642-00025	
		Al. Alloy	Standard	6.60	0.84	.260	.033	07346-03400	07642-00015	
	3/16"	Al. Alloy <i>Oversize</i>	Standard	6.60	0.84	.260	.033	07495-03700	07642-00018	
		Al. Alloy	Standard	8.13	0.25	.320	.010	07346-03500	07642-00016	
	3/32"	Al. Alloy <i>Oversize</i>	Standard	8.13	0.25	.320	.010	07495-03800	07642-00019	
		Stainless Steel	Standard	5.08	1.27	.200	.050	07495-03400	07642-00023	
STANDARD MBC Universal Hd 100° csk	1/8"	Al. Alloy & St. Steel	Standard	4.75	2.40	.187	.093	07346-04000	07642-00051	
		Al. Alloy <i>Oversize</i>	Standard	4.75	2.40	.187	.093	07346-04300	07642-00054	
	5/32"	Al. Alloy & St. Steel	Standard	6.35	2.40	.250	.093	07346-04100	07642-00052	
		Al. Alloy <i>Oversize</i>	Standard	6.35	2.40	.250	.093	07346-04400	07642-00055	
	3/16"	Al. Alloy	Standard	7.92	2.40	.312	.093	07346-04200	07642-00053	

## 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 14.



## 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 depress the trigger. The tool cycle will ensure the rivet is placed.

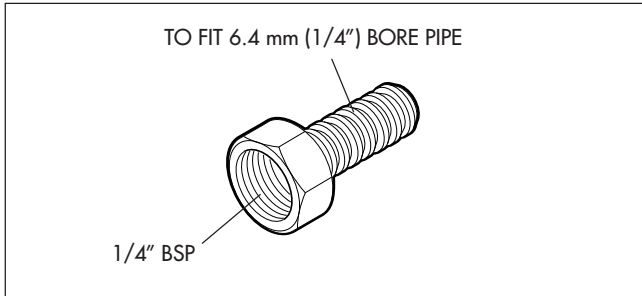
### OPTION 2

- 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 depress the trigger. The tool cycle will ensure the rivet is placed.

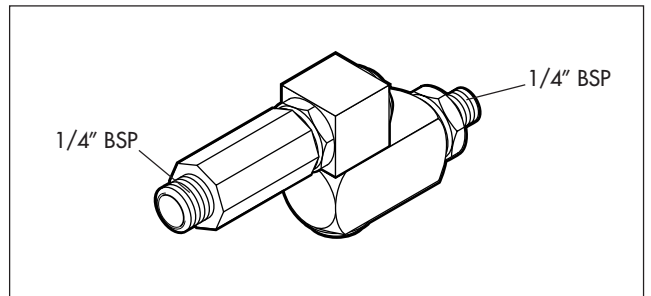
## ACCESSORIES

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

Hose Connector  
part n° 07005-00276



Swivel Connector assembly  
part n° 07640-01400

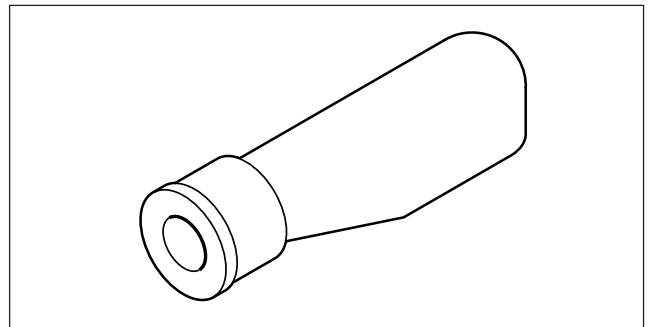


You may want to consider two more accessories to improve efficiency. Item numbers in **bold** refer to the general assembly page 19.

### PIN TAIL DEFLECTOR



Pin Tail Deflector  
part n° 07220-00215



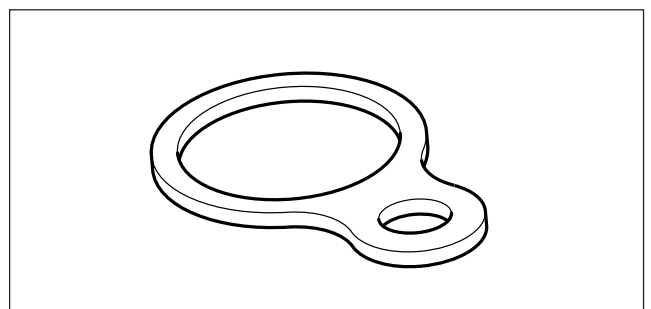
### SUSPENSION RING

For situations where it is necessary to suspend the tool in the work place, a suspension ring (part number 07640-00501) can be fitted.

The suspension ring fits between the end cap **14** and either the stem catcher assembly or pin deflector **60**.

- First remove either the stem catcher (as detailed above) or pin deflector **60**.
- Position suspension ring over end cap **14**.
- Re-fit stem catcher or pin deflector **60**, tightening retaining nut **63** to secure.

Suspension Ring  
part n° 07640-00501



# NOSE ASSEMBLIES

There are three types of nose assemblies which are used with the 0764 type of tooling and thus three models 07640, 07641 and 07642. 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 pages 4, 5, 6 and 7 according to the tool model you are using.

## 0 7 6 4 0 M O D E L

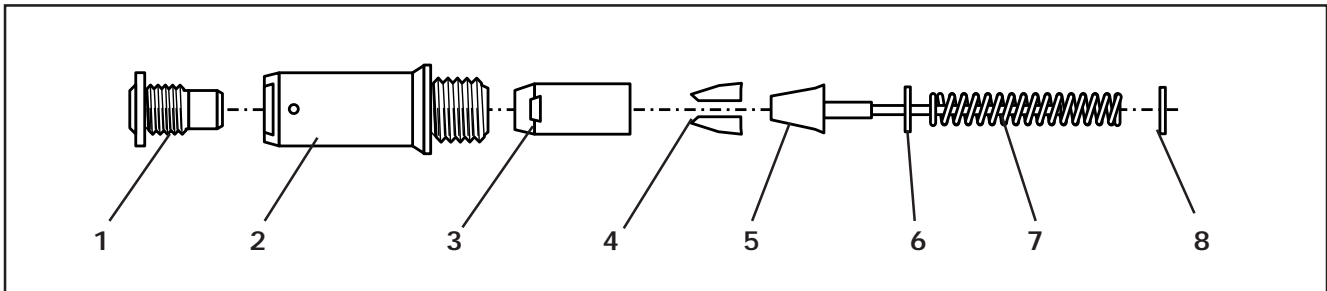
The 07640 tool always uses a fixed nose assembly. Nose assemblies and components vary according to the type of fastener being placed (see dimensions 'A' & 'B' on pages 4 and 5). Check part numbers on component tables.

### FITTING INSTRUCTIONS

#### IMPORTANT

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

- 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.
- Ensure jaw spreader assembly tube 5 is not distorted.
- Check spring 7 is not distorted.
- Assemble according to fitting instructions.

## NOSE ASSEMBLY COMPONENTS

Each nose assembly represents a unique assembly of components which can be ordered individually. Component numbers refer to the text and 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).

<b>07640</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>
07241-07300	07241-07101	07340-02804	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502
07241-07400	07340-06201	07340-00306	07340-00304	07340-00213	07347-03301	07498-03003	07100-04003
07340-07600	07340-07601	07340-00306	07340-00304	07340-00213	07344-01400	07340-01304	07340-01303
07340-08300	07340-08301	07340-00306	07340-00304	07490-04602	07498-03002	07498-03003	07100-04003
07344-02100	07344-02101	07344-02001	07340-00304	07340-00213	07344-01400	07340-01304	07340-01303
07344-02300	07140-02104	07344-02001	07340-00304	07340-00229	07344-01400	07340-01304	07340-01303
07344-02400	07344-02401	07344-02001	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502
07344-02600	07140-02105	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502
07344-02700	07140-02106	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502
07344-02900	07344-02901	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502
07344-03000	07344-03001	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502
07344-03100	07344-03101	07344-02001	07340-00304	07498-04401	07344-02002	07340-01503	07340-01502
07344-04700	07344-04701	07498-02601	07498-04503	07498-04501*	07498-04800	07498-03003	07100-04003
07344-05100	07340-04701	07498-02601	07340-00304	07340-00229	07498-03002	-	07100-04003
07344-05300	07344-04701	07498-02601	07498-04503	07498-04501*	07498-04502	07241-	07100-04003
07347-03000	07340-06001	07340-00306	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303
07347-03100	07340-06301	07340-00306	07340-00304	07340-00222	07340-02000	07340-01304	07340-01303
07347-03200	07340-06101	07340-00306	07340-00304	07340-00213	07340-05700	07340-01304	07340-01303
07347-03300	07381-04701	07340-00306	07340-00304	07340-00213	07347-03301	07498-03003	07100-04003
07347-03400	07340-06401	07340-00306	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303
07347-03500	07340-06501	07340-00306	07340-00304	07340-00213	07340-05700	07340-01304	07340-01303
07347-03600	07340-06601	07340-00306	07498-00304	07340-00213	07340-01501	07340-01503	07340-01502
07381-04700	07381-04701	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502
07381-04800	07490-04401	07340-00306	07340-00304	07340-07502	07381-04801	07498-03003	07100-04003
07490-01000	07340-02805	07340-02804	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303
07490-01700	07340-02806	07340-02804	07340-00304	07340-00213	07340-05700	07340-01304	07340-01303
07490-02400	07340-02807	07340-02804	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502
07490-05000	07340-04800	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502
07498-01600	07605-00220	07340-00306	07498-04503	07498-04501*	07498-04502	07498-03003	07100-04003
07498-02400	07340-06701	07344-02001	07340-00304	07498-04401	07340-01300	07340-01304	07340-01303
07498-02500	07340-06801	07344-02001	07498-04503	07498-04501*	07498-04800	07498-03003	07100-04003
07498-04500	07498-03001	07340-00306	07498-04503	07498-04501*	07498-04502	07498-03003	07100-04003
07498-06700	07340-06701	07344-02001	07340-00304	07340-00229	07344-01400	07340-01304	07340-01303
07498-06800	07340-06801	07344-02001	07340-00304	07340-00229	07344-02002	-	07498-06801
07498-06900	07340-06901	07344-02001	07340-00304	07340-00229	07344-02002	07241-	07498-06801
07498-07000	07340-07001	07344-02001	07340-00304	07340-00229	07344-02002	-	07498-06801
07498-07300	07344-04701	07498-02601	07498-04503	07498-04501*	07498-04800	-	07100-04003
07498-07600	07344-04701	07498-02601	07340-00304	07340-00229	07344-01500	-	07100-04003
07498-07800	07344-04701	07498-02601	07340-00304	07340-07502	07498-07801	07241-	07100-04003
07498-08400	07498-08401	07340-00306	07340-00304	07340-00213	07241-03702	07340-01304	07340-01303
07498-09100	07498-09101	07340-00306	07340-00304	07490-04602	07498-03002	07498-03003	07100-04003
07640-02100	07340-07701	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301
07640-02200	07340-07801	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301
07640-02400	07340-07901	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301
07640-03100	07498-08501	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301
07640-03200	07498-08601	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301
07640-03400	07498-08701	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301

The number of jaws is normally two. \* indicates three jaws.

## 0 7 6 4 1 & 0 7 6 4 2 M O D E L S

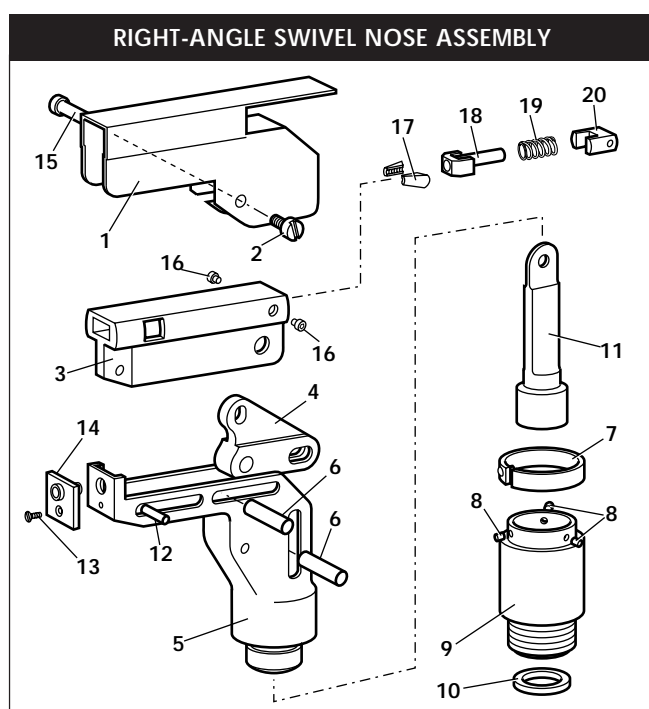
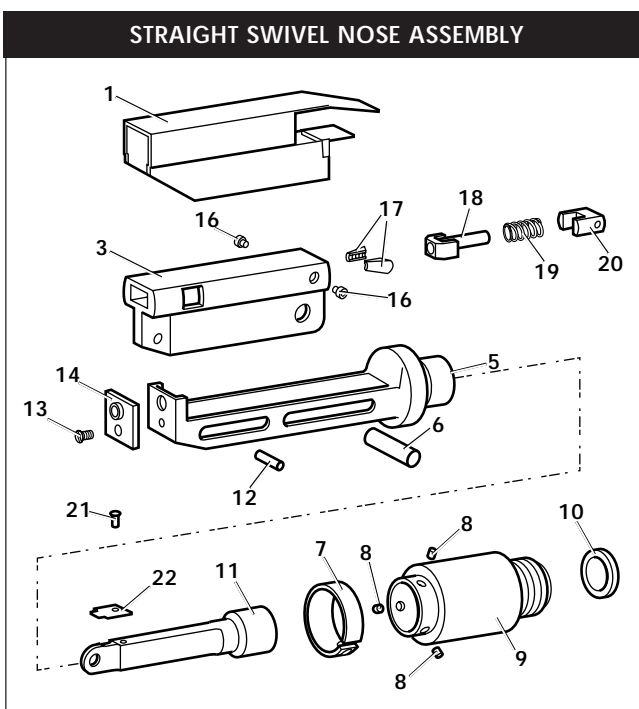
As described on pages 6 and 7 the fitting of a straight swivel nose assembly to a 07641-00200 base tool will create a 07641 tool model and the fitting of a right-angle swivel nose assembly to the same base tool will create a 07642 tool model. Because there are few differences between the two nose assemblies, the fitting and servicing procedures are almost identical. Differences clearly refer to the model they apply to.

### 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 14). When on grey tint, instructions refer only to the right-angle nose assembly fitted to 07642 models.

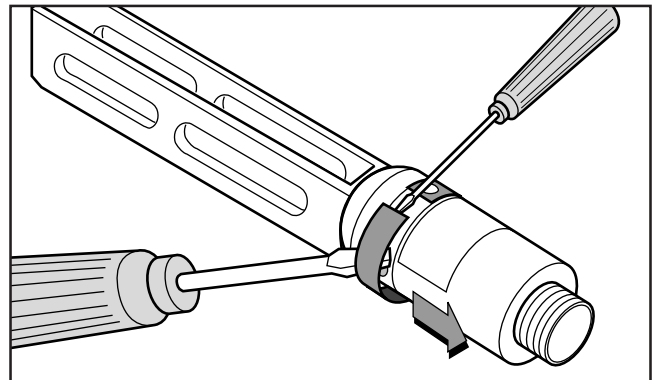
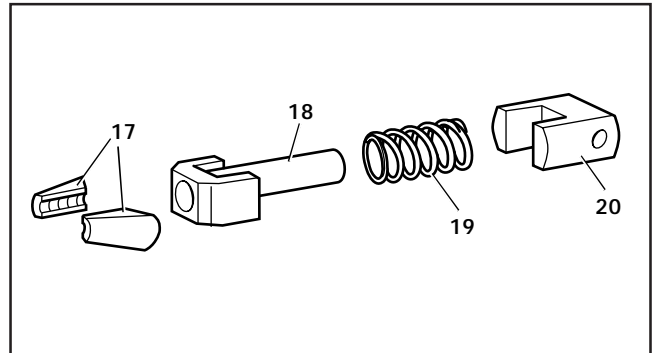
- Fit locking ring 10 over jaw spreader housing of tool (item 19 page 18).
- Coat screw 13 with thread locking adhesive and use to secure nose tip 14 onto body 5.
- Lightly lubricate items 17,18,19,20 and insert into jaw carrier 3 as shown. Secure with screws 16.
- Position lever 4 into body 5 and hold 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 12.

- 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 nor 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.



## 07641 & 07642 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	07641	07642	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	07494-03100	07494-03012	07340-00213
2	SCREW	-	07210-02015	07345-03100	07345-03700	07340-00213	07494-03200	07494-03013	07498-04401
3	JAW CARRIER	07494-03026	07494-03026	07345-03200	07345-03800	07490-04602	07494-03400	07494-03401	07340-00222
4	LEVER	-	07495-03004	07345-03300	07345-03301	07340-00229	07494-03600	07494-03601	07340-00229
5	BODY	07494-03015	07495-03002	07345-03400	07345-03401	07340-00229	07494-03700	07494-03701	07340-00229
6	PIVOT PIN	07343-02207	07343-02207	07345-03500	07345-03501	07498-04401	07494-03800	07494-03801	07498-04401
7	SPRING CLIP	07495-03900	07495-03900	07345-04000	07165-00701	07340-00229	07494-04000	07494-04001	07490-04602
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	07495-03100	07494-03012	07340-00213
15	PIVOT PIN	-	07495-03005	07346-03200	07165-03800	07490-04602	07495-03200	07494-03013	07498-04401
16	SCREW	07494-03028	07494-03028	07346-03300	07345-03301	07340-00229	07495-03400	07494-03401	07340-00222
18	JAW SPREADER	07166-01100	07166-01100	07346-03400	07345-03401	07340-00229	07495-03500	07494-04001	07490-04602
19	SPRING	07166-01102	07166-01102	07346-03500	07345-03501	07498-04401	07495-03600	07494-03601	07340-00229
20	SPRING GUIDE	07494-03027	07494-03027	07346-04000	07165-00701	07340-00229	07495-03700	07494-03701	07340-00229
21	SCREW	07001-00368	-	07346-04100	07165-00702	07340-00229	07495-03800	07494-03801	07498-04401
22	PLATFORM	07345-00401	-	07346-04200	07165-00703	07498-04401	07495-04000	07494-06001	07340-00213
				07346-04300	07165-00801	07340-00229	07495-04100	07494-06101	07340-00213
				07346-04400	07165-00802	07498-04401	07495-04700	07494-06601	07340-00213
				07494-03000	07494-03011	07340-00213	07495-04800	07494-06701	07340-00213

# 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 pressing the trigger and when it is fully depressed.
- On 07640 model, if stem extraction is required, check and set stem extraction adjustment as follows:
- Item numbers in bold refer to the general assembly and parts list page 18 and 19.  
With tool connected to compressed air supply, turn vacuum adjustment screw **11** clockwise until air flow from rear end of tool head ceases. With nose of tool pointing downwards, insert a rivet into nose tip and hold in position. Turn vacuum adjustment screw anti-clockwise until there is sufficient suction at nose tip to retain rivet. Fit stem catcher assembly and place rivet. If broken stem fails to eject, then increase vacuum by turning vacuum adjustment screw anti-clockwise.  
If stem extraction is not required, turn vacuum adjustment screw clockwise until air flow from rear end of tool head ceases. In this mode, plunger of valve plug assembly **67** will remain extended, making tool unstable when standing. This can be overcome by replacing valve plug assembly **67** with valve plug **69**.  
**Note:** When using stem extraction, ensure nose tip is **NOT** fitted with a stem retention device.  
Ensure either stem catcher or pin tail deflector are fitted as required.

## 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

<p><b>FIRST AID</b> SKIN: As the grease is completely water resistant it is best removed with an approved emulsifying skin cleaner.</p> <p>INGESTION: Make the individual drink 30ml Milk of Magnesia, preferably in a cup of milk.</p> <p>EYES: Irritant but not harmful. Irrigate with water and seek medical attention.</p> <p><b>ENVIRONMENT</b> Scrape up for burning or disposal on approved site.</p>	<p><b>FIRE</b> 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.</p> <p><b>HANDLING</b> Use barrier cream or oil resistant gloves</p> <p><b>STORAGE</b> Away from heat and oxidising agent.</p>
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For all servicing we recommend the use of the service kit below (part number 07900-06400) supplied in its own plastic case.

<b>SERVICE KIT</b>		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00164	CIRCLIP PLIERS	1
07900-00567	SLEEVE ( HEAD PISTON )	1
07900-00585	SLEEVE ( INTENSIFIER ROD SEAL )	1
07900-00569	ASSEMBLY BULLET ( REAR 'O' RING )	1
07900-00587	VALVE SPOOL BULLET ( SHORT )	1
07900-00571	TORQUE ADAPTOR	1
07900-00407	HEXAGON KEY 2.5mm A/F	1
07900-00002	SPANNER FOR HEAD PISTON	1
07900-00446	EXTRACTOR	1
07900-00012	$9/16 \times 5/8$ A/F SPANNER	

<b>SERVICE KIT (Continued)</b>		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00467	SPANNER 10mm x 8mm A/F	1
07900-00092	$3/4 \times 7/8$ A/F SPANNER	1
07992-00020	80g TIN MOLY LITHIUM GREASE EP3753	1
07900-00252	SEAL EXTRACTOR	1
07900-00524	SEAL ASSEMBLY TOOL	1
07900-00158	PIN PUNCH	1
07900-00525	ASSEMBLY BULLET	1
07900-00126	TORQUE WRENCH	1
07900-00586	SLEEVE ( PISTON RODSEAL)	1
07900-00588	VALVE SPOOL BULLET ( LONG )	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 general assembly and parts list page 18 and 19.

Before proceeding with dismantling, empty the oil from the tool. Remove 4 and bonded seal 5 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 10 to 13.

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.

## HYDRAULIC PISTON AND SEALS

- On the 07640 model, unscrew retaining nut 63 and pull off stem catcher outer 64, stem catcher body 66, end cover 62 and 'O' ring 57.
- On the 07641 model, remove P.V.C. cap 68.
- Unscrew end cap 14, together with 'O' ring 16, seal ring 17, 'O' ring 10, washer 9, vacuum adjustment screw 11 and spring 8.
- Engage spanner for head piston\* with flats on piston 51 and unscrew jaw spreader housing assembly 50.
- Push piston 51 to the rear and out of the head, taking care not to damage the cylinder bore.
- Using circlip pliers\* close down piston stop 3 and remove from the head.
- Remove 'O' ring 49.
- Push rod seal 2 to rear and out of the head, taking care not to damage the cylinder bore.
  
- Clean and inspect components, renewing any worn or damaged items.
  
- When assembling rod seals 2 use sleeve (piston rod seal)\*
- When fitting piston stop 3 use circlip pliers\*.
- When fitting new seals to hydraulic piston 51, use assembly bullet (rear 'O' ring)\* for rear seal 6.
- Fit assembly bullet\* onto piston 51 and push into position using sleeve (head piston).
- Complete assembly in reverse order to dismantling.

## AIR PISTON, INTENSIFIER ROD AND SEALS

- Unscrew screw 31 and remove base cover 29.
- Remove retaining ring 28 and pull out cylinder plug 26 using extractor\*.
- Engage extractor\* with intensifier rod 22 and pull out the air piston assembly.
- Unscrew lower seal housing 21 using seal assembly tool\* and remove.
- Remove rod seal 2 and washer 18 using seal extractor\*
- An alternative method of extracting rod seal 2 when the tool is still full of oil is to assemble intensifier rod 22 to extractor\*, then insert the intensifier rod through rod seal 2, Restrain the rearward motion of air piston 23 and push down until rod seal 2 is ejected from its seating.
  
- Clean and inspect components, renewing any worn or damaged items.
  
- On assembly, lubricate cylinder bore with Moly lithium grease EP3753.
- When assembling rod seal 2 use sleeve (intensifier rod seal)\*
- Use seal assembly tool\* to screw on lower seal housing 21.
- Complete assembly in reverse order to dismantling.
  
- NOTE: If base cover 29 will not seat flat on the tool base, spirolux retaining ring 28 is not correctly installed and compressed air MUST NOT be connected.

## AIR VALVE

- Remove base cover 29.
- On the 07640 model, unscrew valve plug assembly 67.
- On the 07641 model, unscrew valve plug 69.
- Tap out valve spool 37, push rod 42 and 'O' ring 40
  
- Clean and inspect components, renewing any worn or damaged items.
  
- Assemble in reverse order to dismantling.

## TRIGGER MECHANISM

- Using a pin punch \* drift out spring pin 43.
- Unscrew four screws 52 and remove trigger guard 45, together with trigger 47, trigger tie 46 and lever 41.
- Drift out spring pin 48 and detach trigger 47.
  
- Clean and inspect components, renewing any worn or damaged items.
  
- Assemble in reverse order to dismantling
- Check for free movement of the trigger linkage.

\* refers to items included in the Avdel service kit. For complete list see page 15.

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## DAMPER VALVE

- Remove the air piston and seals as described earlier.
- Empty hydraulic fluid from the tool.
- Screw male threaded end of extractor\* into bottom of damper valve **13**.
- Pull damper valve **13** from body. If the damper valve does not release easily, then end of extractor\* may be clamped in vice, and the body tapped gently.

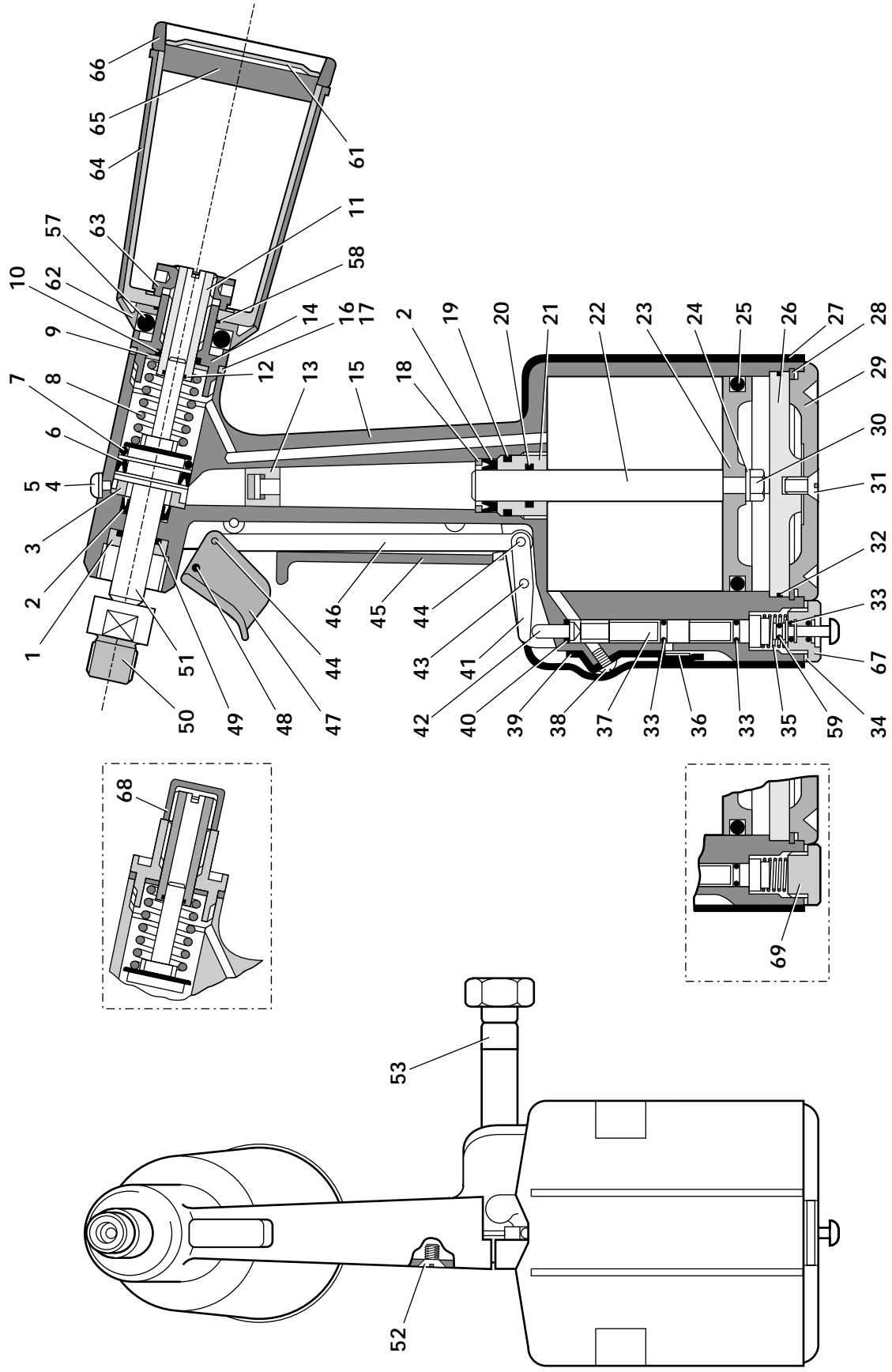
### IMPORTANT

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 15.

**GENERAL ASSEMBLY OF BASE TOOLS 07640-00200 & 07641-00200**  
 (MAIN DRAWING IS THE 07640-00200, DRAWING INSIDE DOTTED AREA SHOWS 07641-00200)



**07640-00200 & 07641-00200 PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
01	07640-00248	STOP	1	-	29	07640-00208	BASE COVER	1	-
02	07003-00222	ROD SEAL	2	2	30	07002-00054	FULL NUT	1	2
03	07640-00249	PISTON STOP	1	-	31	07001-00407	SCREW	1	1
04	07001-00405	SCREW	1	1	32	07003-00188	'O' RING	1	1
05	07003-00194	BONDED SEAL	1	-	33	07003-00189	'O' RING	3	3
06	07003-00223	PISTON SEAL	1	1	34	07640-00210	SEAL	1	1
07	07003-00184	'O' RING	1	1	35	07640-00211	VALVE SPRING	1	1
08	07640-00228	SPRING	1	-	36	07640-00235	EXHAUST SILENCER	1	1
09	07640-00226	WASHER	1	1	37	07640-00253	VALVE SPOOL	1	-
10	07003-00186	'O' RING	1	1	38	07640-00236	SCREW	1	1
11	07640-00203	VACUUM ADJUSTMENT SCREW	1	-	39	07640-00234	EXHAUST DEFLECTOR	1	-
12	07003-00190	'O' RING	1	1	40	07003-00022	'O' RING	1	1
13	07640-00600	DAMPER VALVE ASSEMBLY	1	-	41	07640-00214	LEVER MACHINED	1	-
14	07640-00205	END CAP	1	-	42	07640-00213	PUSH ROD	1	-
15	07640-01300	BODY ASSEMBLY	1	-	43	07007-00393	SPRING PIN	1	-
16	07003-00012	'O' RING	1	1	44	07007-00394	SPRING PIN	2	-
17	07640-00202	SEAL RING	1	1	45	07640-00217	TRIGGER GUARD	1	-
18	07640-00250	WASHER	1	1	46	07640-00216	TRIGGER TIE	1	-
19	07003-00212	'O' RING	1	1	47	07640-00223	TRIGGER	1	-
20	07003-00211	'O' RING	1	1	48	07007-00395	SPRING PIN	1	-
21	07640-00252	LOWER SEAL HOUSING	1	-	49	07003-00086	'O' RING	1	1
22	07640-00206	INTENSIFIER ROD	1	-	50	07490-00700	JAW SPREADER HOUSING ASSY.	1	1
23	07640-00227	AIR PISTON	1	-	51	07640-00251	PISTON	1	-
24	07002-00093	LOCK WASHER	1	2	52	07001-00428	SCREW	4	4
25	07003-00219	'O' RING	1	1	53	07005-00645	HOSE ASSEMBLY	1	-
26	07640-00225	CYLINDER PLUG	1	-	54	07900-00354	SAFETY LABEL	1	NOT SHOWN
27	07640-00245	CYLINDER COVER	1	-	55	07900-00439	PRIMING RESERVOIR	1	NOT SHOWN
28	07004-00066	RETAINING RING	1	1	56	07900-00444	TOOL INSTRUCTION MANUAL	1	NOT SHOWN

**07640-00200 PARTS LIST (cont)**

ITEM	PART N°	DESCRIPTION	QTY	SPARES
57	07003-00213	'O' RING	1	1
58	07003-00067	'O' RING	1	1
59	07003-00185	'O' RING	1	1
60	07220-00215	PIN TAIL DEFLECTOR	1	NOT SHOWN
61	07340-00335	STEM CATCHER END CAP	1	1
62	07640-00240	END COVER	1	-
63	07640-00243	RETAINING NUT	1	-
64	07640-00239	STEM CATCHER OUTER	1	1
65	07640-00244	SILENCER	1	1
66	07640-00241	STEM CATCHER BODY	1	1
67	07640-00400	VALVE PLUG ASSEMBLY	1	1

**07641-00200 PARTS LIST (cont)**

ITEM	PART N°	DESCRIPTION	QTY	SPARES
68	07007-00456	P.V.C. CAP	1	-
69	07641-00201	VALVE PLUG	1	1

# PRIMING

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.

H Y S P I N V G 3 2 O I L S A F E T Y D A T A			
<b>FIRST AID</b> 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. <b>FIRE</b> Suitable extinguishing media: CO <sub>2</sub> , dry powder, foam or water fog. DO NOT use water jets.		<b>ENVIRONMENT</b> <b>WASTE DISPOSAL:</b> Through authorised contractor to a licenced site. May be incinerated. Used product may be sent for reclamation. <b>SPILLAGE:</b> Prevent entry into drains, sewers and water courses. Soak up with absorbent material. <b>HANDLING</b> Wear eye protection, impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area. <b>STORAGE</b> 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	ml @ 24°C after test @ 93.5°C	Trace/Nil
	@ 100°C		
Relative density	0.875	Air release value	
Viscosity Index	95	in minutes to 0.2% air content @ 50°C	4
Pour point	°C - 30	Seal compatability index	10
Open Flash point	°C 232	Water separation time	
Neutralisation value mg KOH/g	1.5	in minutes to 40-40-0 @54°C	15
		@83°C	15

## PROCEDURE

Item numbers in bold refer to the general assembly and parts list pages 18 and 19.

### IMPORTANT

**ENSURE THAT THE TOOL IS CONNECTED TO AIR SUPPLY**

**LEAVE NOSE ASSEMBLY ON TOOL**

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

Ensure that the priming bottle 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.

- Remove button head screw **4** and bonded seal **5** from top of tool.
- Screw empty priming bottle, part number 07900-00439, into the priming hole.
- Unscrew the reservoir cap and lift out tray. Fill with oil above oil level line in reservoir.
- Replace tray and screw down reservoir cap.
- Operate and release trigger **47** drawing oil into the tool (once when re-priming, twice when priming from empty).
- Unscrew the priming bottle and refit button head screw **4** with bonded seal **5**, replacing worn or damaged parts.
- Check the stroke length of the tool.
- If necessary repeat procedure after emptying the old oil out of the reservoir into a suitable container.

## 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.	→ Re-prime tool. (see page 20)
	→ Build up of dirt on jaws.	→ Clean, check and replace jaws
Jaws will not grip rivet stem	→ Dirty or worn jaws.	→ Clean or renew as necessary.
	→ Jaw housing loose.	→ Tighten against nylon locking ring.
	→ Weak or broken jaw spreader spring.	→ Replace spring.
	→ Incorrect nose equipment fitted.	→ Replace as necessary.
	→ Dirty, bent or broken mandrel distorting jaw spreader assembly tube preventing it from moving forward.	→ Clean or replace jaw spreader assembly.
Jaws will not release spent rivet stem.	→ Dirty jaws or jaw housing.	→ Clean and re-lubricate.
	→ 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 with 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.
	→ Insufficient vacuum (at vacuum extractor)	→ Check air pressure and adjust vacuum
Slow stroking tool.	→ Lack of lubrication.	→ Lubricate tool at air inlet point.
	→ Low air pressure.	→ Check air pressure and increase.

## 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 0764*

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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