

# Nose Equipment Manual

## Original Instruction



ProSet® XT1 Blind Rivet Tool – 76001  
ProSet® XT2 Blind Rivet Tool – 76002

# Hydro-Pneumatic Power Tool

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

## 1. SAFETY DEFINITIONS

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.



**DANGER:** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING:** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION:** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**CAUTION:** Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

***Improper operation or maintenance of this product could result in serious injury and property damage. Read and understand all warnings and operating instructions before using this equipment. When using power tools, basic safety precautions must always be followed to reduce the risk of personal injury.***

### SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

#### **WARNING:**

- DO NOT use outside the design intent of Placing STANLEY Engineered Fastening Blind Rivets.
- Use only parts, fasteners, and accessories recommended by the manufacturer.
- DO NOT modify the tool in any way. Any modification to the tool is undertaken by the customer and will be the customer's entire responsibility and void any applicable warranties.
- Prior to use, check for misalignment or binding of moving parts, breakage of parts, and any other condition that affects the tool's operation. If damaged, have the tool serviced before using. Remove any adjusting key or wrench before use.
- The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained personnel. Any dismantling procedure will be undertaken only by trained personnel. Do not dismantle this tool without prior reference to the maintenance instructions.
- The operating supply air must not exceed 7 bar (100 PSI).
- Operators and others in work area must wear approved safety glasses with side shields. Always wear safety glasses and ear protection during operation.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- DO NOT operate a tool that is directed towards any person(s).
- DO NOT operate tool with the nose casing removed.
- Adopt a firm footing or a stable position before operating the tool.
- Prior to use, inspect airlines for damage, all connections must be secure. Do not drop heavy objects on Hoses. A sharp impact may cause internal damage and lead to premature hose failure.
- DO NOT lift the placing tool by the hose. Always use the placing tool handle.
- Vent holes must not become blocked or covered.
- Disconnect the air hose from the tool before performing any maintenance, attempting to adjust, fit or remove a nose assembly.
- Keep tool handles dry, clean, and free from oil and grease.
- When carrying the tool from place to place keep hands away from the trigger to avoid inadvertent activation.

- Never leave operating tool unattended. Disconnect air hose when tool is not in use.
- Adequate clearance is required for the tool operator's hands before proceeding.
- DO NOT abuse the tool by dropping or using it as a hammer.

**STANLEY Engineered Fastening policy is one of continuous product development and improvement and we reserve the right to change the specification of any product without prior notice**

## **2. SAFETY RULES**

**This technical datasheet must be read with particular attention to the safety warnings and operating instructions listed in the ProSet XT1 and ProSet XT2 Instruction Manual, by any person fitting or operating the nose assemblies and hand tools.**

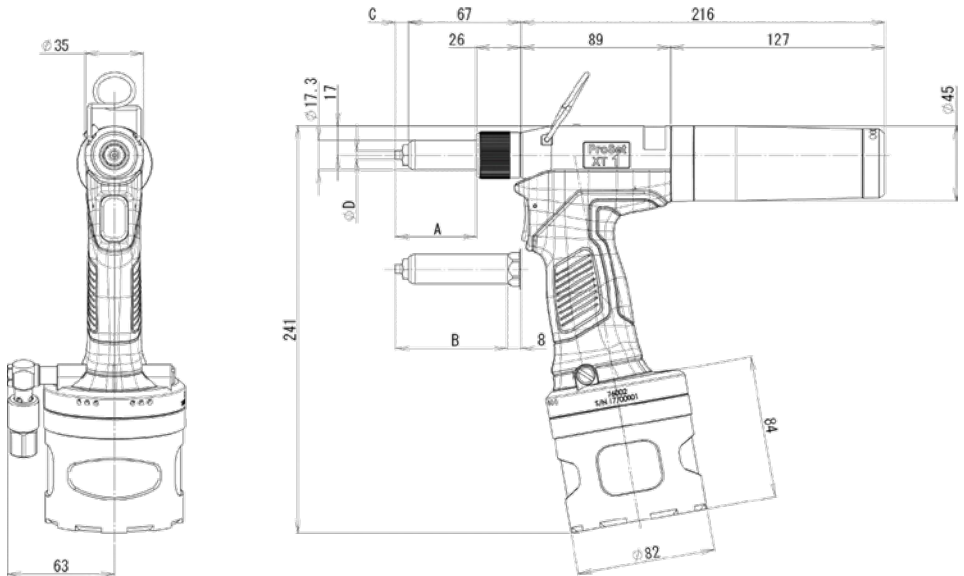
## **3. INTENT OF USE**

The nose equipment in combination with the ProSet XT1 and ProSet XT2 tools are designed for placing Stanley Engineered Fastening blind rivets only. The correct placing tool and nose assembly must be selected for each for each rivet type and size as shown in the tables on pages 5 and 7.

#### 4. NOSE EQUIPMENT FOR ProSet® XT1

Nose equipment varies according to the rivet type being installed. Each nose assembly represents a unique set of components which can be ordered individually. For assembly dimensions 'A', 'B', 'C' and 'D' refer to Nose Equipment tables on page 5. We recommend maintaining some stock of spares as items will need regular replacement if worn.

Fig. 1



Dimensions in millimetres (mm) – Illustration shown with the standard nose assembly TRM00360 and nose tip PRN414 fitted. Tool appearance will vary with different nose assemblies fitted.

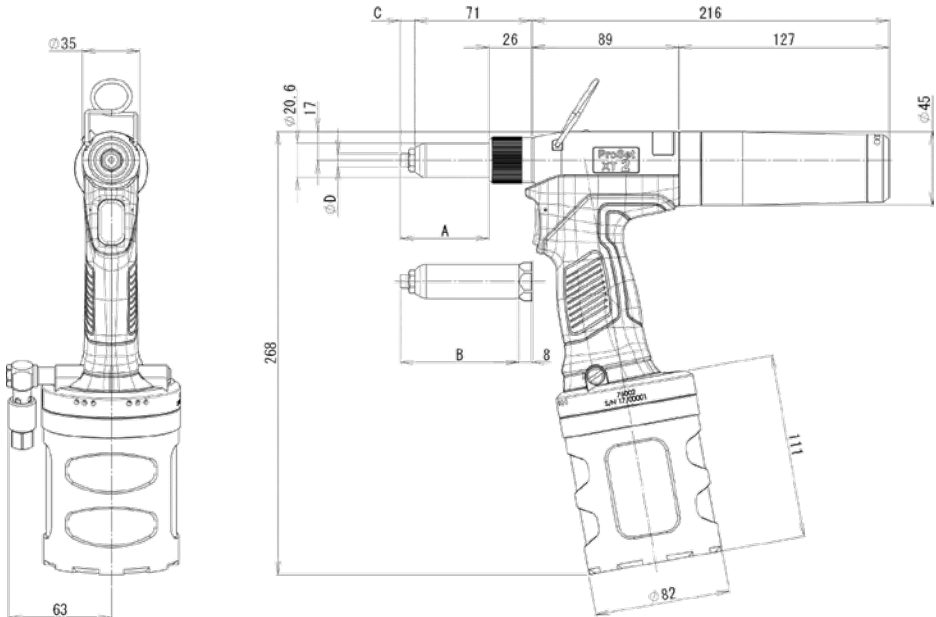
RIVET TYPE	RIVET DIAMETER		RIVET MATERIAL	NOSE ASSEMBLY	NOSE TIP	JAW PUSHER	MANDREL GUIDE	DIMENSION (mm)				NOTES
	A	B						C	D			
OPEN END	2,4	3/32	AL. ALLOY STEEL BODY	TRM00360	PRN314	TP144-117	TP144-178	49,9	67,9	8,9	4,6	
	3,2	1/8		TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
OPEN END	5,0	-										
	3,2	1/8	STAINLESS BODY	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32										
4,8	3/16											
CLOSED END	3,2	1/8	AL. ALLOY BODY	TRM00360	PRN424	TP144-117	TP144-120	48,6	66,6	7,6	5,3	
	4,0	5/32		TRM00360	PRN524	TP144-117	TP144-120	49,4	67,4	8,4	6,7	
	4,8	3/16										
CLOSED END	3,2	1/8	STAINLESS BODY	TRM00360	PRN434	TP144-117	TP144-120	48,6	66,6	7,6	5,3	
	4,0	5/32										
	4,8	3/16										
BHM RIVET	2,4	3/32	AL. ALLOY STEEL BODY	TRM00360	PRN314	TP144-117	TP144-178	49,9	67,9	8,9	4,6	
	3,2	1/8		TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
BHM RIVET	2,4	3/32	STAINLESS BODY									
	3,2	1/8		TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32										
TLrivets*	4,8	3/16										
	4,0	5/32	AL. ALLOY BODY	TRM003601)	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
PEEL RIVET	4,8	3/16										
	3,2	1/8	AL. ALLOY BODY	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
4,8	3/16											
HRrivets*	3,2	1/8	AL. ALLOY BODY	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32		TRM00360	PRN5K	TP144-117	TP144-120	48,5	66,5	7,5	6,1	
	4,8	3/16		AL. ALLOY STEM								
HRrivets*	3,2	1/8	AL. ALLOY BODY STEEL STEM	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
HRrivets*	3,2	1/8	STEEL BODY	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
HRrivets*	3,2	1/8	STAINLESS BODY	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
T-RIVET	4,8	3/16	ALL									
AVEX*	3,2	1/8	AL. ALLOY BODY	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
AVEX*	3,2	1/8	STEEL BODY	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
STAVEX*	3,2	1/8	ALL	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
AVINOX*	3,2	1/8	ALL	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
AVIBULB*	3,2	1/8	ALL	TRM00360	PRN4K	TP144-117	TP144-120	48,0	66,0	7,0	5,0	
	4,0	5/32										
	4,8	3/16										
BULBEX*	4,0	5/32	ALL	TRM003601)	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
T-LOK*	4,0	5/32	ALL									
	4,8	3/16										
AVDEL SR*	3,2	1/8	ALL	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32		TRM00360	PRN514	TP144-117	TP144-120	49,9	67,9	8,9	6,7	
	4,8	3/16										
INTERLOCK*	4,8	3/16	ALL									
MONOBOLT*	4,8	3/16	ALL									
Q RIVET*	3,2	1/8	ALL	TRM00360	PRN414	TP144-117	TP144-120	49,9	67,9	8,9	5,3	
	4,0	5/32										
	4,8	3/16										
KLAMP-TITE*	4,8	3/16	ALL									
	4,0	-										
	5,0	-										
	6,0	-										
	7,0	-										
AVSEALE® II	4,0	-	AL. ALLOY STEEL BODY									
	5,0	-										
	6,0	-										
	7,0	-										
	8,0	-										

1) XT1 cannot place rivet in one stroke.

## 5. NOSE EQUIPMENT FOR ProSet® XT2

Nose equipment varies according to the rivet type being installed. Each nose assembly represents a unique set of components which can be ordered individually. For assembly dimensions 'A', 'B', 'C' and 'D' refer to Nose Equipment table on page 7. We recommend maintaining some stock of spares as items will need regular replacement if worn.

Fig. 2



Dimensions in millimetres (mm) – Illustration shown with the standard nose assembly TRM00361 and nose tip PRN614 fitted. Tool appearance will vary with different nose assemblies fitted.

RIVET TYPE	RIVET DIAMETER	RIVET MATERIAL	NOSE ASSEMBLY	NOSE TIP	JAW PUSHER	MANDREL GUIDE	DIMENSION				NOTES	
							A	B	C	D		
OPEN END	2,4	3/32	AL ALLOY STEEL BODY	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	3,2	1/8		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
OPEN END	3,2	1/8	STAINLESS BODY	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361(1)	PRN424	TRM00355	TRM00261	52,6	70,6	7,6	5,3	
CLOSED END	3,2	1/8	AL ALLOY BODY	TRM00361	PRNS24	TRM00355	TRM00261	53,4	71,4	8,4	6,7	
	4,0	5/32		TRM00361	PRN624	TP144-050	TP144-052	53,6	71,6	8,6	8,1	
	4,8	3/16		TRM00361	PRN624	TP144-050	TP144-052	53,6	71,6	8,6	8,1	
	4,8	3/16		TRM00361(2)	PRN634	TP144-050	TP144-052	53,6	71,6	8,6	8,1	
BHM RIVET	2,4	3/32	AL ALLOY STEEL BODY	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	3,2	1/8		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
BHM RIVET	2,4	3/32	STAINLESS BODY	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	3,2	1/8		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
TLrivets*	2,4	3/32	AL ALLOY BODY	TRM00361(3)	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	3,2	1/8		TRM00361(3)	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,8	3/16		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
PEEL RIVET	2,4	3/32	AL ALLOY BODY	TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	3,2	1/8		TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
Hrivets*	3,2	1/8	AL ALLOY BODY AL ALLOY STEM	TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
	4,0	5/32		TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,8	3/16		TRM00361	PRN6K	TP144-050	TP144-052	52,0	70,0	7,0	7,8	
	4,0	5/32		TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
Hrivets*	3,2	1/8	AL ALLOY BODY STEEL STEM	TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,0	5/32		TRM00361	PRN6K	TP144-050	TP144-052	52,0	70,0	7,0	7,8	
	4,8	3/16		TRM00361	PRN6K	TP144-050	TP144-052	52,0	70,0	7,0	7,8	
	4,0	5/32		TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
Hrivets*	3,2	1/8	STEEL BODY	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
Hrivets*	3,2	1/8	STAINLESS BODY	TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,0	5/32		TRM00361	PRN6K	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,8	3/16		TRM00361	PRN6K	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,0	5/32		TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
T-RIVET	4,8	3/16	ALL	TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	3,2	1/8		TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	07381-04701	TP144-050	TP144-052	47,8	65,8	2,8	12,7	
AVEX*	3,2	1/8	STEEL BODY	TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
	4,0	5/32		TRM00361	PRNSK	TRM00355	TRM00261	52,5	70,5	7,5	6,1	
	4,8	3/16		TRM00361	PRN6K	TP144-050	TP144-052	52,0	70,0	7,0	7,8	
	4,0	5/32		TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
STAVEX*	3,2	1/8	ALL	TRM00361	PRNSK	TP144-050	TP144-052	52,5	70,5	7,5	6,1	
	4,0	5/32		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
AVINOX*	3,2	1/8	ALL	TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
	4,0	5/32		TRM00361	PRNS14	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
AVIBULB*	3,2	1/8	ALL	TRM00361	PRN4K	TRM00355	TRM00261	52,0	70,0	7,0	5,0	
	4,0	5/32		TRM00361	PRNS14	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361(3)	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
BULBEX*	4,8	3/16	ALL	TRM00361(3)	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	07381-04701	TP144-050	TP144-052	47,8	65,8	2,8	12,7	
AVDEL SR*	3,2	1/8	ALL	TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
	4,0	5/32		TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,0	5/32		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
INTERLOCK*	4,8	3/16	ALL	TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	71210-16020	TP144-050	TP144-052	49,1	67,1	4,1	12,7	
	3,2	1/8		TRM00361	PRN414	TRM00355	TRM00261	53,9	71,9	8,9	5,3	
Q RIVET*	4,0	5/32	ALL	TRM00361	PRNS14	TRM00355	TRM00261	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	07381-04701	TP144-050	TP144-052	47,8	65,8	2,8	12,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
	4,8	3/16		TRM00361	PRN614	TP144-050	TP144-052	53,9	71,9	8,9	6,7	
KLAMP-TITE*	4,0	AL ALLOY STEEL BODY	76002-16100 4)	71219-11346	07498-04502	-		494	67,4	4,4	12,7	1mm extended nose tip
				50,5				68,5	5,5	12,7	2mm extended nose tip	
				56,5				74,5	11,5	12,7	8mm extended nose tip	
				49,4				67,4	4,4	12,7	1mm extended nose tip	
				50,5				68,5	5,5	12,7	2mm extended nose tip	
				56,5				74,5	11,5	12,7	8mm extended nose tip	
				47,5				65,5	2,5	12,7	Flush nose tip	
				49,4				67,4	4,4	12,7	1mm extended nose tip	
	5,0	AL ALLOY STEEL BODY	76002-16100 4)	71219-11347	07498-04502	-		49,4	67,4	4,4	12,7	1mm extended nose tip
				50,5				68,5	5,5	12,7	2mm extended nose tip	
				56,5				74,5	11,5	12,7	8mm extended nose tip	
				47,5				65,5	2,5	12,7	Flush nose tip	
				49,4				67,4	4,4	12,7	1mm extended nose tip	
				50,5				68,5	5,5	12,7	2mm extended nose tip	
				56,5				74,5	11,5	12,7	8mm extended nose tip	
				47,5				65,5	2,5	12,7	Flush type nose tip	
6,0	AL ALLOY STEEL BODY	76002-16100 4)	71219-11348	07498-04502	-		49,4	67,4	4,4	12,7	1mm extended nose tip	
			50,5				68,5	5,5	12,7	2mm extended nose tip		
			56,5				74,5	11,5	12,7	8mm extended nose tip		
			47,5				65,5	2,5	12,7	Flush type nose tip		
			49,4				67,4	4,4	12,7	1mm extended nose tip		
			50,5				68,5	5,5	12,7	2mm extended nose tip		
			56,5				74,5	11,5	12,7	8mm extended nose tip		
			47,5				65,5	2,5	12,7	Flush type nose tip		
7,0	AL ALLOY STEEL BODY	76002-16100 4)	71219-11349	07498-04502	-		49,4	67,4	4,4	12,7	1mm extended nose tip	
			50,5				68,5	5,5	12,7	2mm extended nose tip		
			56,5				74,5	11,5	12,7	8mm extended nose tip		
			47,5				65,5	2,5	12,7	Flush type nose tip		

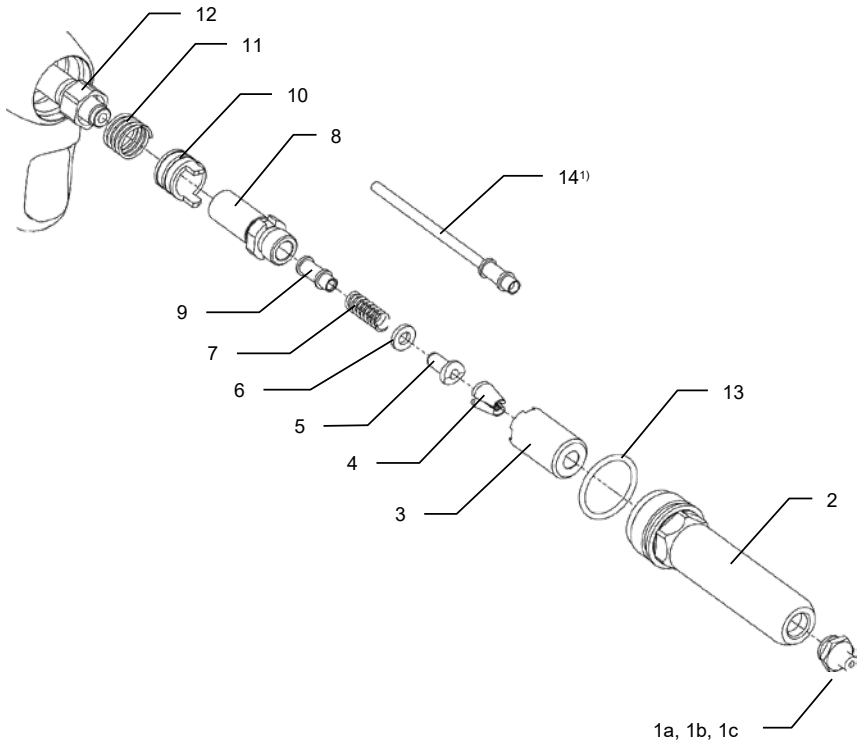
- 1) When the mandrel



## 6. BLIND RIVET NOSE ASSEMBLIES FOR ProSet® XT1

TRM00360

Fig. 3



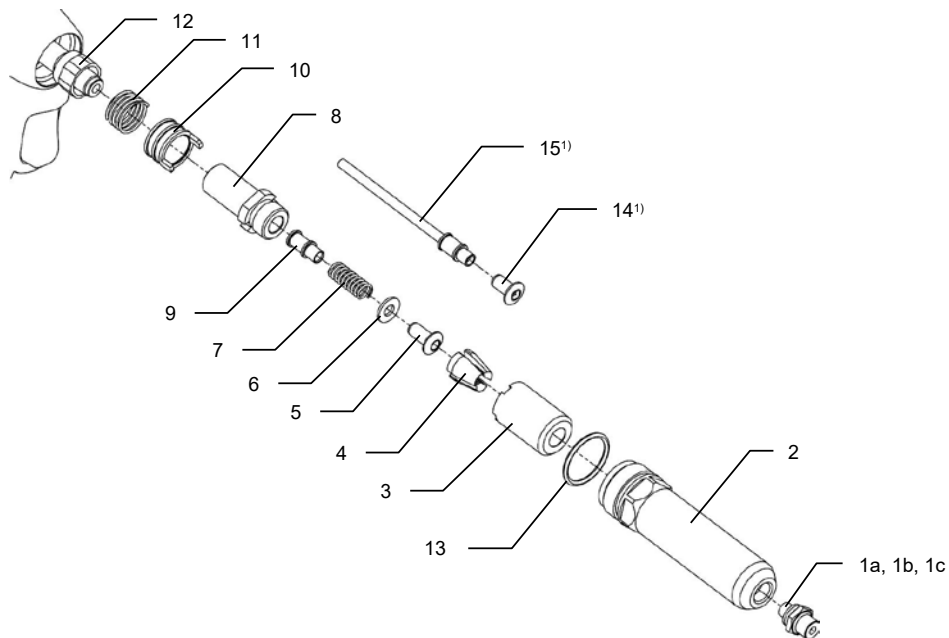
1) For rivet diameters of 2.4mm, use TP144-178 (Mandrel Guide Assembly).

Part Number: TRM00360			
Item	Part Number	Description	Qty
1a	PRN414	Nose Piece	1
1b	PRN314	Nose Piece	1
1c	PRN514	Nose Piece	1
2	TP144-111	Nose Housing	1
3	DPN239-006	Jaw Guide	1
4	PRG402-8A	Jaws	1set
5	TP144-117	Jaw Pusher	1
6	TP144-118	Urethane Washer	1
7	TP144-119	Jaw Pusher Spring	1
8	TRM00167	Pulling Head	1
9	TP144-120	Mandrel Guide	1
10	TP144-113	Jaw Guide Lock	1
11	TP144-114	Jaw Guide Lock Spring	1
12	TP144-115	Lock Nut	1
13	TP144-091	O-Ring	1
14	TP144-178	Mandrel Guide Assembly	1

## 7. BLIND RIVET NOSE ASSEMBLIES FOR ProSet® XT2

TRM00361

Fig. 4



1) For rivet diameters of 3.2 or 4.0, use TRM00355 (Jaw Pusher) and TRM00261 (Mandrel Guide Assembly).

Part Number: TRM00361			
Item	Part Number	Description	Qty
1a	PRN614	Nose Piece	1
1b	PRN514	Nose Piece	1
1c	PRN414	Nose Piece	1
2	TP144-048	Nose Housing	1
3	DPN275-001	Jaw Guide	1
4	71210-15001	Jaws	1set
5	TP144-050	Jaw Pusher	1
6	TP144-088	Urethane Washer	1
7	TP144-081	Jaw Pusher Spring	1
8	TRM00165	Pulling Head	1
9	TP144-052	Mandrel Guide	1
10	TP144-051	Jaw Guide Lock	1
11	TP144-080	Jaw Guide Lock Spring	1
12	TP144-060	Lock Nut	1
13	TP144-091	O-Ring	1
14	TRM00355	Jaw Pusher	1
15	TRM00261	Mandrel Guide Assembly	1

**FITTING INSTRUCTIONS**

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE EQUIPMENT.**

Item numbers in bold refer to the components in figure 3 & 4 and the tables on pages 8 & 9.

- The air supply must be disconnected.
- Rotate Nose Housing (**2**) anti-clockwise and remove together with Nosepiece (**1**).
- Rotate Jaw Guide (**3**) anti-clockwise and remove together with Jaws (**4**).
- Remove Jaw Pusher (**5**) together with Urethane Washer (**6**), Jaw Pusher Spring (**7**) from Pulling Head (**8**).
- Remove Mandrel Guide (**9**) from Pulling Head (**8**).
- Insert "adapted Mandrel Guide" (**9**), Jaw Pusher Spring (**7**), Urethane Washer (**6**) and "adapted Jaw Pusher" (**5**) to Pulling Head (**8**).
- Lightly coat Jaws (**4**) with moly lithium grease.
- Drop Jaws (**4**) into the Jaw Guide (**3**).
- Pull back Jaw Guide Lock (**10**) and screw Jaw Guide (**3**) fully on to Pulling Head (**8**).
- Release Jaw Guide Lock (**10**) and then partially unscrew Jaw Guide (**3**) until Jaw Guide Lock (**10**) tooth clicks into the next slot on Jaw Guide (**3**).
- Rotate Nosepiece (**1**) anti-clockwise and remove from Nose Housing (**2**).
- Replace with the Nosepiece (**1**) specified for the rivet to be placed.
- Screw Nose Housing (**2**) together with Nosepiece (**1**) to tool.
- The tool is now ready to place the required rivet.

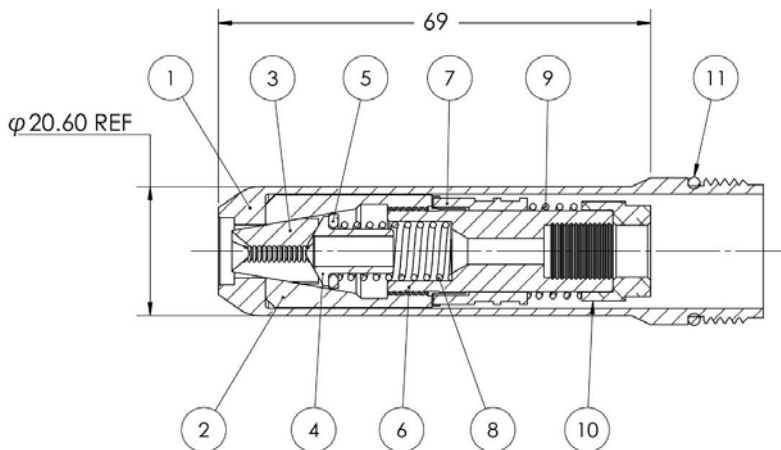
**SERVICING INSTRUCTIONS**

- Nose Equipments need to be serviced at weekly intervals or every 3,000 cycles. Hold some stock of all internal components of Nose Equipment and Nosepieces, they need regular replacement.
- The air supply must be disconnected.
- Remove Nose Housing (**2**), including Nosepiece (**1**), and O-Ring (**13**) from the tool.
- Pull back Jaw Guide Lock (**10**) against Jaw Guide Lock Spring (**11**) and then remove Jaw Guide (**3**).
- Remove the Jaws (**4**) from Jaw Guide (**3**).
- Remove Jaw Pusher (**5**), Urethane Washer (**6**), and Jaw Pusher Spring (**7**), from Pulling Head (**8**).
- Rotate Lock Nut (**12**) anti-clockwise and remove Pulling Head (**8**), Jaw Guide Lock (**10**), Jaw Guide Lock Spring (**11**) from the tool piston using spanners.
- Inspect all components. Any worn or damaged parts must be replaced by a new part.
- Particularly check wear Jaws (**4**).
- Clean all parts and apply moly lithium Grease (07992-00020) to Jaws (**4**) and taper bore of Jaw Guide (**3**).
- Assemble according to fitting instructions above.

## 8. AVSEAL NOSE ASSEMBLIES FOR ProSet® XT2

76002-16100

Fig. 5



Part Number: 76002-16100			
Item	Part Number	Description	Qty
1	76002-16001	Nose Casing	1
2	76002-16003	Jaw Guide	1
3	71210-16101	Jaws	1set
4	07498-04502	Jaw Spreader	1
5	71210-05001	Buffer	1
6	76002-16002	Pulling Head	1
7	TP144-051	Jaw Guide Lock	1
8	07500-00418	Jaw Spring	1
9	TP144-080	Jaw Guide Lock Spring	1
10	TP144-060	Lock Nut	1
11	TP144-091	O-Ring	1

### FITTING INSTRUCTIONS

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE ASSEMBLY.**

Item numbers in bold refer to the components in figure 5 and the table on pages 11.

- The air supply must be disconnected.
- Remove the complete nose assembly TRM00361 as described in the Proset XT2 instruction manual.
- Screw Pulling Head (6) together with Jaw Guide Lock (7), Jaw Guide Lock Spring (9) to the tool piston and then tighten Lock Nut (10) to Pulling Head (6).
- Attach Jaw Spreader (4) together with Buffer (5) and Jaw Spring (8) to Pulling Head (6).
- Install Jaw Guide (2) together with Jaws (3) to Pulling Head (6).
- Screw Nose Casing (1) together with required Nosepiece and O-Ring (11) to Handle Upper.
- The tool is now ready to place Avseal rivets.

## **SERVICING INSTRUCTIONS**

- Nose Equipments need to be serviced at weekly intervals or every 3,000 cycles. Hold some stock of all internal components of Nose Equipment and Nosepieces, they need regular replacement.
- The air supply must be disconnected.
- Remove Nose Casing (2), including Nosepiece, and O-Ring (11) from the tool.
- Pull back Jaw Guide Lock (7) against Jaw Guide Lock Spring (9) and then remove Jaw Guide (2).
- Remove Jaws (3) from Jaw Guide (2).
- Remove Jaw Spreader (4), Buffer (5), and Jaw Spring (8), from Pulling Head (6).
- Rotate Lock Nut (10) anti-clockwise and remove Pulling Head (6), Jaw Guide Lock (7), Jaw Guide Lock Spring (9) from the tool piston using spanners.
- Inspect all components. Any worn or damaged parts must be replaced by a new part.
- Particularly check wear Jaws (3).
- Clean all parts and apply moly lithium Grease (07992-00020) to Jaws (3) and taper bore of Jaw Guide (2).
- Assemble according to fitting instructions above.



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