Avdel®

Instruction Manual

Original Instruction

07265

Hydro-Pneumatic Power Tool

Contents

Safety Rules

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

1 Do not use outside the design intent.

2 Do not use equipment with this tool/machine other than that recommended and supplied by Avdel UK Limited.

3 Any modification undertaken by the customer to the tool/machine, nose assemblies, accessories or any equipment supplied by Avdel UK Limited or their representatives, shall be the customer's entire responsibility. Avdel UK Limited will be pleased to advise upon any proposed modification.

4 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 UK Limited procedures. Do not dismantle this tool/machine without prior reference to the maintenance instructions. Please contact Avdel UK Limited with your training requirements.

5 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 Act 1974" applies. Any question regarding the correct operation of the tool/machine and operator safety should be directed to Avdel UK Limited.

6 The precautions to be observed when using this tool/machine must be explained by the customer to all operators.

7 Always disconnect the airline from the tool/machine inlet before attempting to adjust, fit or remove a nose assembly.

8 Do not operate a tool/machine that is directed towards any person(s) or the operator.

9 Always adopt a firm footing or a stable position before operating the tool/machine.

10 Ensure that vent holes do not become blocked or covered.

11 The operating pressure shall not exceed 7 bar.

12 Do not operate the tool if it is not fitted with a complete nose assembly unless specifically instructed otherwise.

13 Care shall be taken to ensure that spent stems are not allowed to create a hazard.

14 If the tool is fitted with a stem collector,it must be emptied when half full.

15 If the tool is fitted with a stem deflector, it should be rotated until the aperture is facing way from the operator and other person(s) working in the vicinity.

16 When using the tool, the wearing of safety glasses is required both by the operator and others in the vicinity to protect against fastener ejection, should a fastener be placed 'in air'. We recommend wearing gloves if there are sharp edges or corners on the application.

17 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.

18 When carrying the tool from place to place keep hands away from the trigger/lever to avoid inadvertent start up.

19 Excessive contact with hydraulic fluid oil should be avoided. To minimize the possibility of rashes, care should be taken to wash thoroughly.

20 C.O.S.H.H. data for all hydraulic oils and lubricants is available on request from your tool supplier.

Specifications

Tool Specification

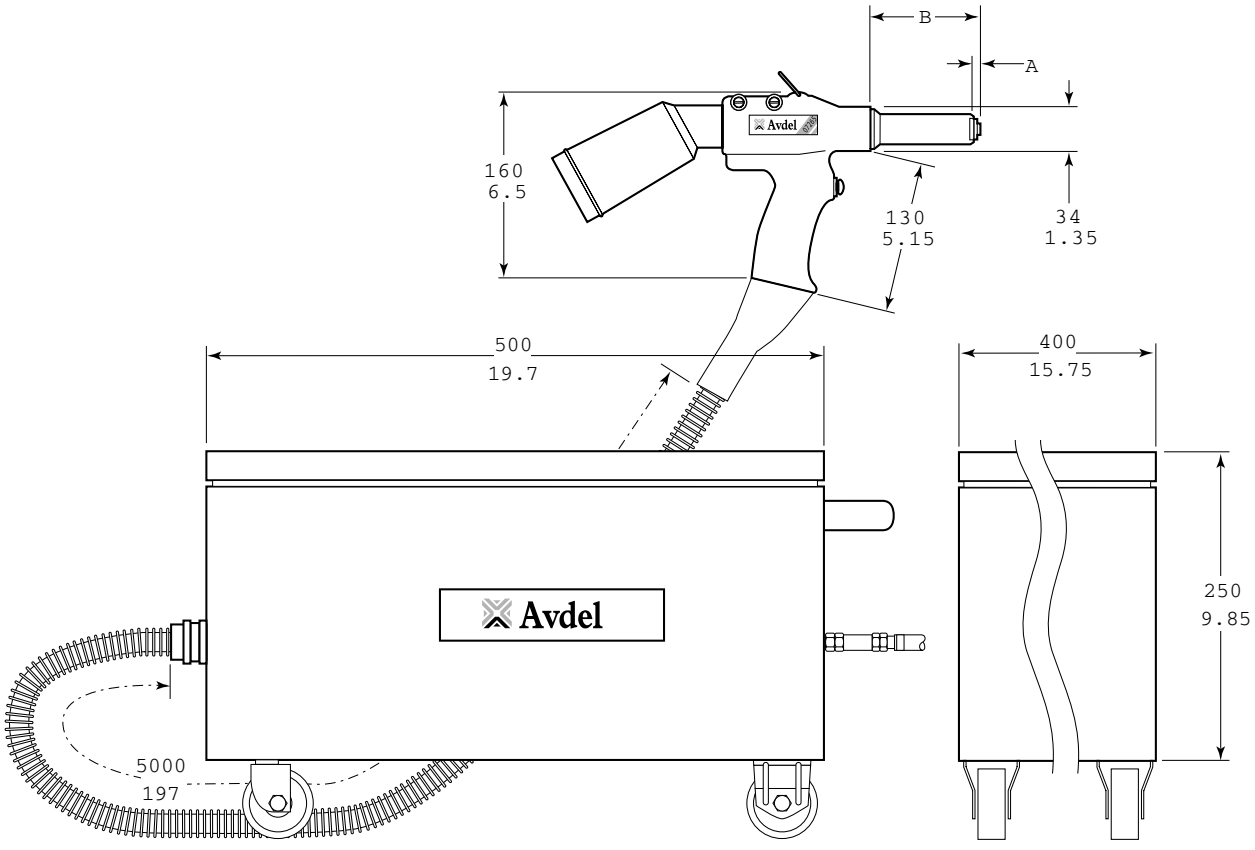
Air Pressure	Minimum - Maximum	5-7 bar (72.5 - 101.5 psi)
Free Air Volume Required	@ 5.5 bar	2.1 litres
Stroke	Minimum	26.2mm (1.03in)
Pull Force	@ 5.5 bar	12.47 KN
Cycle time	Approximately	1.7 second
Noise Level		70 dB(A)
Pistol Weight		3.1 kg (6.82 lb)
Total Weight	Pistol and Intensifier	37 kg (81.4 lb)
Vibration	Less than	2.5 m/s^2 (8.2 ft/s^2)

Tool Dimensions

Features include an on/off switch for a vacuum facility and an adjustable air restrictor to control the amount of vacuum according to which fastener is being used.

Spent stems are collected in a stem catcher.

The vacuum is also used to retain fastener in the nose tip prior to its installation.



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

Intent of Use

The hydro-pneumatic 07265 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 07265 is of the remote intensifier or split tool concept, (see page 5).
Pistol Grip type head fitted with a stem catcher is the standard tool for which a stem deflector is available (see details page 9). It is also possible to order the base tool only (part number 07265-00300) which will not be fitted with a nose assembly.

Tool Selection

07265 TOOL SELECTION

FASTENER			NOSE (see drawing above for A & B)							
NAME & HEAD	Ø	MATERIAL/ DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART Nº	ADAPTOR PART Nº	COMPLETE TOOL PART Nº
AVEX® Snap Head	3/16"	Steel	Standard	3.3	61	.13	2.4	07381-04800	-	07265-00030
TLR®	3/16"	Al. Alloy	Standard	4.1	61	.16	2.4	07498-02000	-	07265-00008
	1/4"	Al. Alloy	Standard	4.0	99	.156	3.6	07498-01100	-	07265-00010
AVSEAL®	8mm	Al. Alloy	Standard	5.6	99	.22	3.9	07340-08000	-	07265-00040
		Al. Alloy	Extended	7.2	99	.285	3.9	07498-08800	-	07265-00045
	9mm	Al. Alloy	Standard	5.6	99	.22	3.9	07340-08100	-	07265-00041
		Al. Alloy	Extended	7.2	99	.285	3.9	07498-08900	-	07265-00046
	10mm	Al. Alloy	Standard	5.6	99	.22	3.9	07340-08200	-	07265-00042
		Al. Alloy	Extended	7.2	99	.285	3.9	07498-09000	-	07265-00047
MONOBOLT® Protruding Head & 100° csk * The nose tip actually remains the same, it is the nose casing that is longer. See nose assemblies on page 10 for details.	3/16"	Al. Alloy	Standard	4.1	61	.16	2.4	07498-04700	-	07265-00012
		Steel	Standard	4.1	61	.16	2.4	07498-04700	-	07265-00012
		St. Steel	Standard	4.1	61	.16	2.4	07498-04700	-	07265-00012
	1/4"	Al. Alloy	Standard	4.0	61	.156	2.4	07498-04600	-	07265-00014
		Steel	Standard	4.0	61	.156	2.4	07498-04600	-	07265-00014
		St. Steel	Standard	4.0	61	.156	2.4	07498-04600	-	07265-00014
		Al. Alloy	Extended *	4.0	99	.156	3.9	07498-00500 *	-	07265-00016
		Steel	Extended *	4.0	99	.156	3.9	07498-00500 *	-	07265-00016
		St. Steel	Extended *	4.0	99	.156	3.9	07498-00500 *	-	07265-00016
AVINOX® BE61	3/16"	St. Steel	Standard	3.3	61	.13	2.4	07347-03700	-	07265-00036
AVTAINER®	3/8"	Al. Alloy	Standard	4.1	188	.16	7.4	07498-00700	-	07265-00006
MAXLOK® Brazier Head & 90° csk	3/16"	Al. Alloy	Standard	3.6	51	.14	2.0	07610-02000	07265-02900	07265-00001
		Steel	Standard	3.6	51	.14	2.0	07610-02000	07265-02900	07265-00001
	1/4"	Al. Alloy	Standard	3.6	53	.14	2.1	07610-02100	07265-02900	07265-00002
		Steel	Standard	3.6	53	.14	2.1	07610-02100	07265-02900	07265-00002
HEMLOK® Protruding Head	1/4"	Al. Alloy	Standard	3.6	61	.14	2.4	07612-02000	-	07265-00004
		Steel	Standard	3.6	61	.14	2.4	07612-02000	-	07265-00004

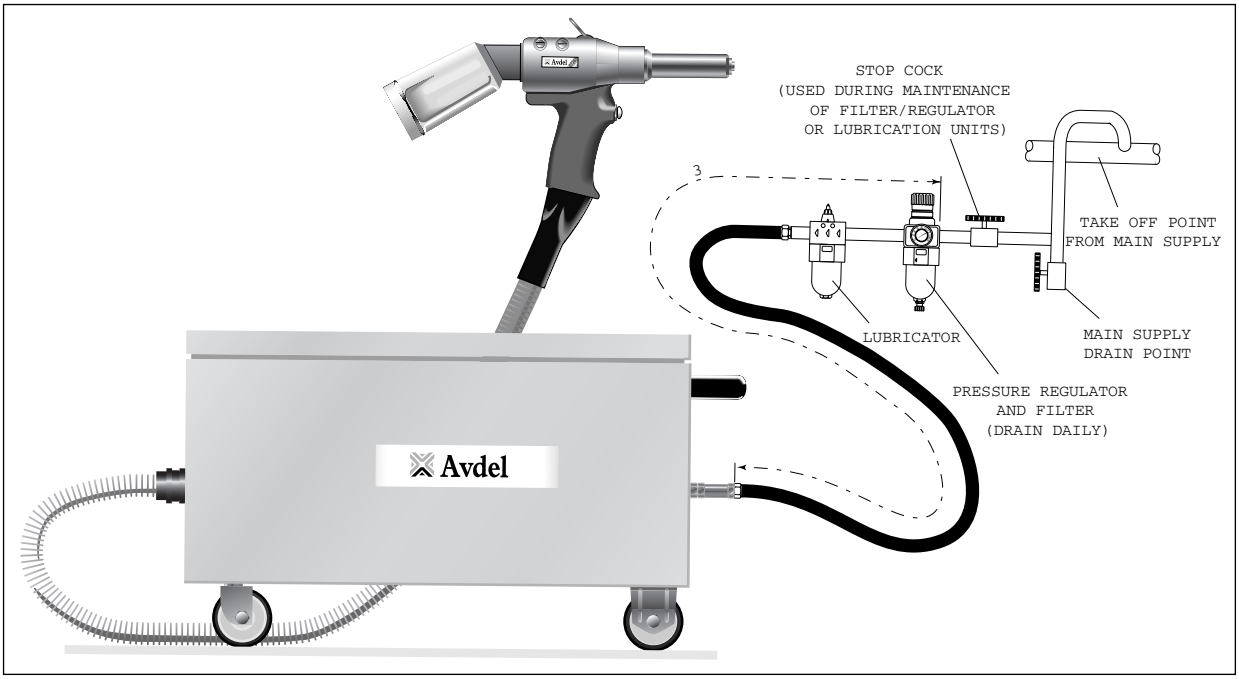
Putting into Service

Air Supply

All tools are operated with compressed air at an optimum pressure of 5.5 bar. We recommend the use of pressure regulators and automatic 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 daily servicing details page 12.



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 protuding fastener stem.
- Fully operate the trigger. The tool cycle will ensure the fastener is placed.
- Check that stems are projected into the stem catcher unit. If not refer to the Vacuum Stem Extraction Switch paragraph on page 14 in the Maintenance section.

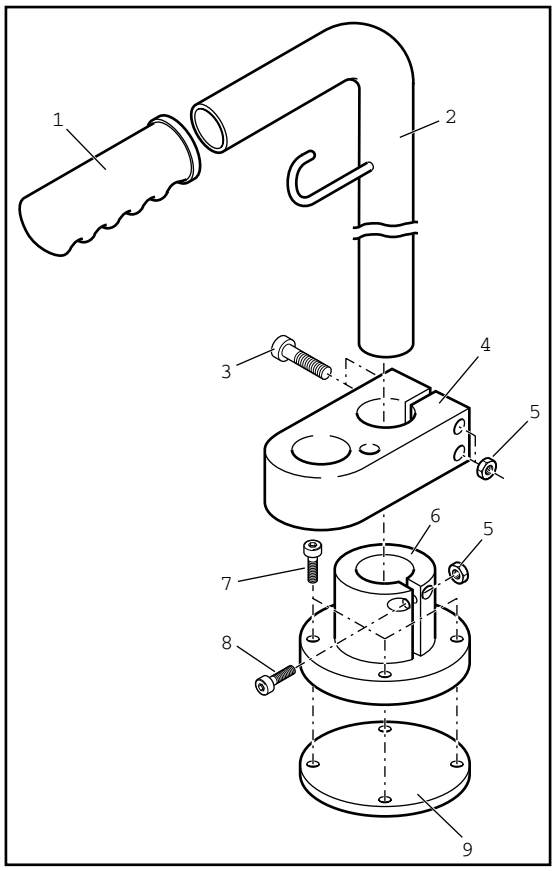
OPTION 2

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener stem into the nose of the tool.
- Insert the tool with the fastener squarely into the prepared hole of the application.
- Fully operate the trigger. The tool cycle will ensure the fastener is placed.
- Check that stems are projected into the stem catcher unit. If not refer to the Vacuum Stem Extraction Valve paragraph on page 14 in the Maintenance section.

Accessories

Handling and Holster Kit

This kit enables an easier handling of the cabinet around the workplace and allows the tool pistol to be stored in a convenient position.

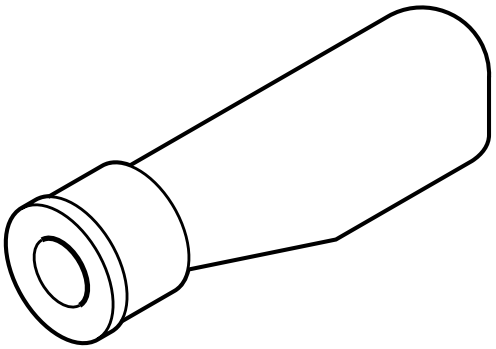


07265-09500 PARTS LIST				
ITEM	PART Nº	DESCRIPTION	QTY	SPARES
1	07265-09501	RUBBER HANDLE	1	-
2	07265-09502	TUBE WITH HOOK	1	-
3	07265-09504	M5 BOLTS	2	-
4	07265-09503	HOLSTER	1	-
5	07265-09505	M5 NUTS	3	-
6	07265-09508	BASE	1	-
7	07265-09507	M5 BOLT	4	-
8	07265-09506	M5 BOLT	1	-
9	07265-09509	PLATE	1	-

Pin Tail Deflector

Item numbers in **bold** refer to the general assembly and parts list on pages 16 and 17.

- To replace the stem catcher with a pin tail deflector remove stem catcher end cap **38** and silencer **39**.
- Unscrew screws **36** and remove stem catcher assembly together with end cover **40**.
- Unscrew screws **15** and remove adaptor **14**.
- Push pin tail deflector onto the boss on stop cover **13**.

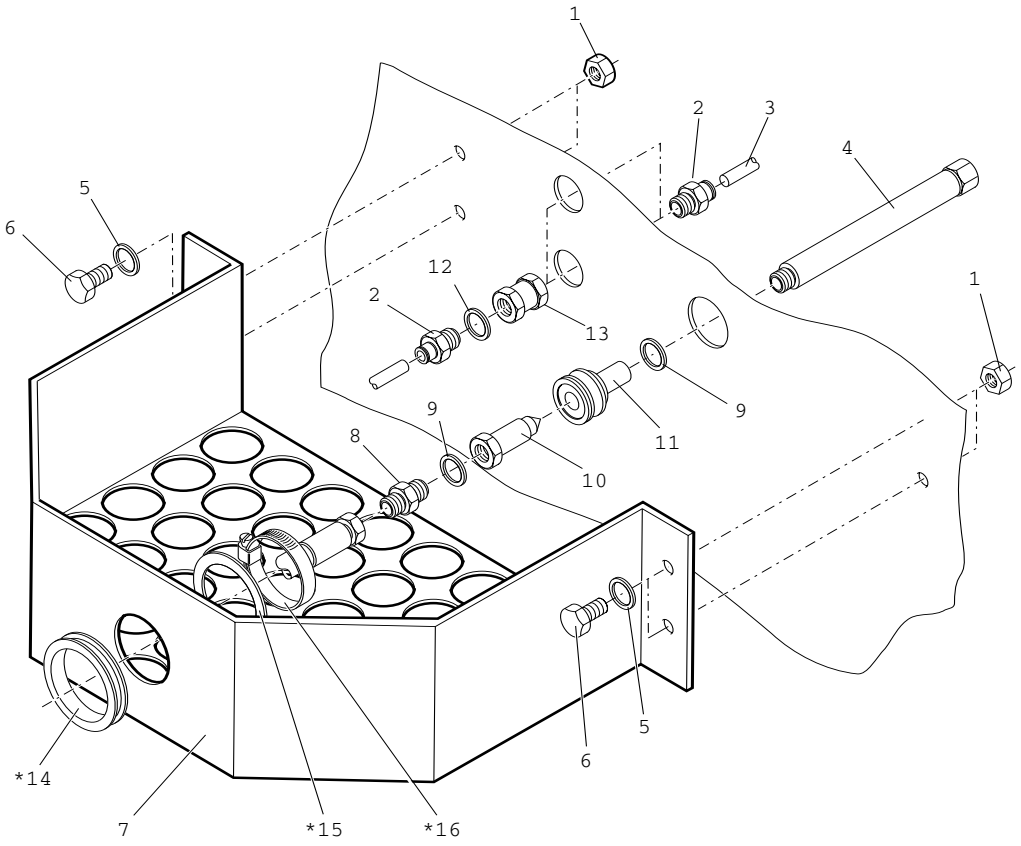


Pin Tail Deflector Part No 07220-00215

Accessories

Quick Connect Kit

This kit enables rapid connection of the handle and hose to the cabinet.



07265-01250 PARTS LIST				
ITEM	PART N…	DESCRIPTION	QTY	SPARES
1	07265-03206	NUT	4	–
2	07265-03269	CONNECTION	4	–
3	07265-03295	AIR HOSE EXTENSION	2	–
4	07265-09296	OIL HOSE EXTENSION	1	–
5	07265-03204	WASHER	4	–
6	07265-03205	SCREW	4	–
7	07265-03297	TRAY	1	–
8	07265-03258	NIPPLE	1	–
9	07265-03259	WASHER	2	–
10	07265-02056	QUICK FITTING NIPPLE	1	–
11	07265-02055	QUICK FITTING COUPLER	1	–
12	07265-03272	WASHER	2	–
13	07265-03221	CONNECTOR	2	–
*14	07265-03290	RUBBER RING	1	–
*15	07265-03291	SPACER WASHER	1	–
*16	07265-03292	CLAMP	1	–

***** These items are part of the Base Tool and are not part of the Quick Connect Kit

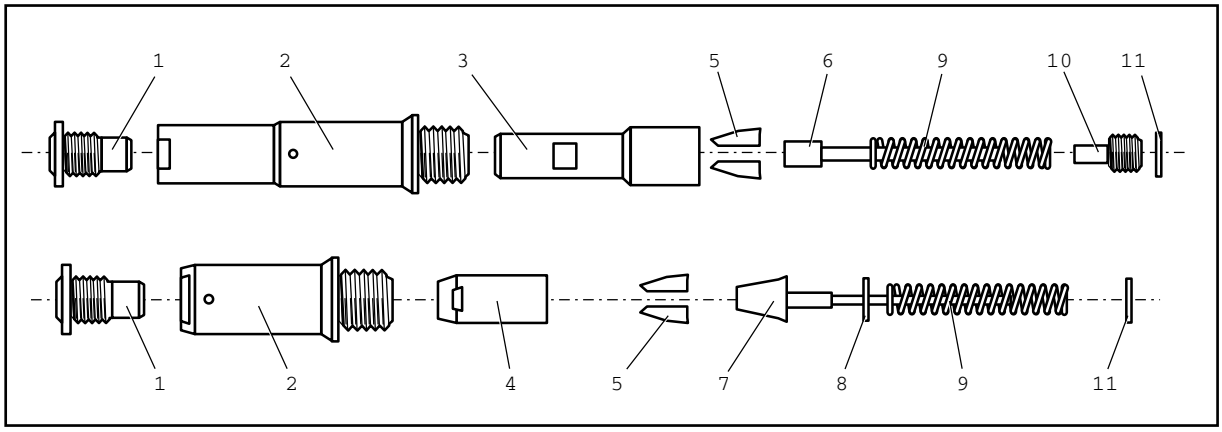
Nose Assemblies

Fitting Instructions

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 on page 6.

I M P O R T A N T
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 **5** into jaw housing **4** or chuck collet **3**, depending on whether you have a short or long nose assembly (see table opposite for identification).
- Insert jaw spreader **7** into jaw housing **4** (locating in the 'V' shape formed by the jaws) or insert front spring guide **6** into chuck collet **3**.
- Locate buffer **8** on jaw spreader **7**.
- Locate spring **9** onto jaw spreader **7** or onto front spring guide **6**.
- On long nose assemblies, screw rear spring guide **10** into chuck collet **3**.
- Fit locking ring **11** onto the end plug of the tool.
- Holding tool pointing down, screw on the assembled jaw housing or chuck collet onto the end plug and tighten with spanner.
- Screw nose tip **1** into nose casing **2**.
- Place nose casing **2** over jaw housing **4** or chuck collet **3** and screw onto tool, tightening with spanner.
- To fit Avtainer nose assembly, remove end plug **33** part number 07265-03015 from piston rod **16** and replace with adaptor part number 07265-02900.

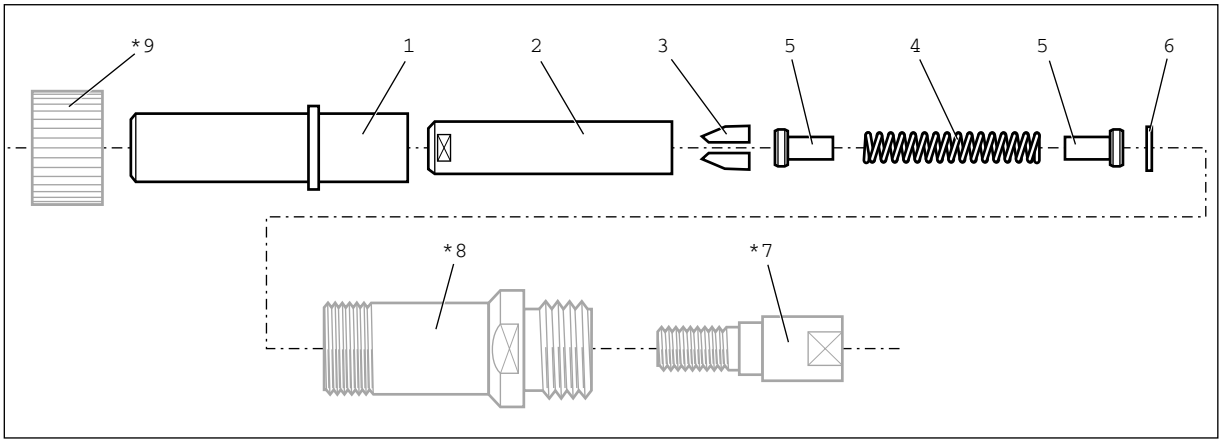


Fitting Instructions for Maxlok® Nose Assemblies

If the tool is fitted with end plug 07265-03015 (item 33 on pages 16 and 17) this will need to be removed.

- Using appropriate spanners* unscrew end plug **33** from piston **16**.
- Screw end plug **7** (see illlustration on page 11) onto the tool piston and tighten using appropriate spanners*.
- Screw Maxlok adaptor casing item **8** over the end plug **7** and into the handle of the tool.
- Lightly coat the jaws with Moly Lithium grease.
- Drop the jaws **3** into the chuck collet **2**.
- Drop spring guide **5** into chuck collet **2**, followed by spring **4** so that it locates around the spring guide.
- Drop second spring guide **5** into chuck collet **2** so that it locates in spring **4**.
- Locate friction ring **6** on end plug **7**.
- Screw on previously assembled items **2**, **3**, **4** and **5** onto end plug **7**.
- Slide anvil **1** over chuck collet **2**.
- Secure anvil **1** by sliding nose retaining collar over anvil and screwing it onto adaptor casing **8**.

Nose Assemblies



***** These items make up the Adaptor Kit, Part No 07265-02900, and are not part of the Maxlok® nose assembly.

Servicing Instructions

Nose assemblies should 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 **7** (where fitted) or front spring guide **6** is not distorted.
- Check spring **9** is not distorted.
- Assemble according to fitting instructions.

07285 Nose Assembly Components

This table lists the components which make up 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. All nose assemblies also include a locking ring 11 part number 07340-00327 (see illustration opposite).

NOSE ASSY	1	2	3	5	6	9	10
07340-08000	07340-08001	07498-00501	07498-00502	07497-03002	07498-00507	07500-02005	07498-00503
07340-08100	07340-08101	07498-00501	07498-00502	07497-03002	07498-00507	07500-02005	07498-00503
07340-08200	07340-08201	07498-00501	07498-00502	07497-03002	07498-00507	07500-02005	07498-00503
07498-00500	07497-03202	07498-00501	07498-00502	07497-03002*	07498-00507	07500-02005	07498-00503
07498-00700 **	07498-00802	07498-00501	07498-00801	07220-02302	07498-00803	07500-02005	07498-00503
07498-01100	07498-01101	07498-00501	07498-00502	07498-03002*	07498-00507	07500-02005	07498-00503
07498-08800	07498-08801	07498-00501 e	07498-00502	07497-03002*	07498-00507	07500-02005	07498-00503
07498-08900	07498-08901	07498-00501 e	07498-00502	07497-03002*	07498-00507	07500-02005	07498-00503
07498-09000	07498-09001	07498-00501 e	07498-00502	07497-03002*	07498-00507	07500-02005	07498-00503
07498-00700	07498-00802	07498-00501	07498-00801	07220-02302	07498-00803	07500-02005	07498-00503

NOSE ASSY	1	2	4	5	7	8	9
07498-02000	07605-00220	07340-00306	07498-04503	07498-04501*	07498-04900	07498-03003	07100-04003
07498-04600	07497-03202	07340-00306	07340-00304	07498-04501*	07498-04502	07498-03003	07100-04003
07498-04700	07498-03001	07340-00306	07498-04503	07498-04501*	07498-04900	07498-03003	07100-04003
07381-04800	07490-04401	07340-00306	07340-00304	07340-07502	07381-04801	07498-03003	07100-04003
07347-03700	07498-01401	07340-00306	07340-00304	07340-07502	07381-04801	07498-03003	07100-04003
07612-02000	07612-02001	07340-00306	07612-02003	07612-02002	07612-04502	07498-03003	07500-00418

There are normally two jaws:

* Indicates three nose jaws

e Indicates a long nose assembly

** Indicates a nose assembly specifically for Avtainer® fasteners and includes a side ejection adaptor, part number 07498-00900.

NOSE ASSY	1	2	3	4	5	6	*7	*8	*9
07610-02000	07610-02001	07610-02002	07610-02003	07610-02107	07220-02104	07610-02004	07265-02039	07265-02040	07265-02041
07610-02100	07610-02101	07610-02102	07610-02103	07610-02107	07610-02104	07610-02004	07265-02039	07265-02040	07265-02041

Servicing the Tool

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

I M P O R T A N T
Read Safety Instructions on page 4.
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 tool shall be examined regularly for damage and malfunction.

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 oil level in intensifier's reservoir. If necessary top up with the prescribed priming oil.

Weekly

- Dismantle and clean nose assembly, with special attention to the jaws. Lubricate with Moly Lithium grease EP 3753 before assembling.
- Check for oil leaks and air leaks in the air supply hose and fittings.

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:

Ensure the individual drinks 30ml Milk of Magnesia, preferably in a cup of milk.

EYES:

Irritant but not harmful. Irrigate with water and seek medical attention.

Fire

FLASH POINT: Above 220°C.

Not classified as flammable.

Suitable extinguishing media: CO_2, Halon or water spray if applied by an experienced operator.

Environment

Scrape up for burning or disposal on approved site.

Handling

Use barrier cream or oil resistant gloves

Storage

Away from heat and oxidising agent.

Service Kit

SERVICE KIT		
ITEM PART Nº	**DESCRIPTION**	**Nº OFF**
07265-09301	PISTON INSERTION BUSH	1
07265-09302	BULLET	1
07265-00619	BUSH	1
07900-00618	PUSHER	1

For all servicing we recommend the use of the service kit, part number 07265-09300.

Servicing the Tool

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.

I M P O R T A N T
Read Safety Instructions on page 4.
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 tool shall be examined regularly for damage and malfunction.

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 on spages 16 and 17.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section on pages 10 and 11.

Remove bleed screw **3** and washer **2** from the tool handle and drain oil from tool.

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

To disconnect oil hose **42**/**43** and air delivery and return hoses from the tool handle, sleeve **22** to gain access to the hoses.

Disconnect air hoses by pushing and releasing the quick release connectors. Using two spanners, undo oil hose at connector **21**, leaving the connector attached to the tool handle. Remove the tool handle.

Stem Catcher Unit

To remove stem catcher assembly from the tool handle, remove end cap **38** and silencer **39** from inner body **35**.

- Remove two screws **36** and remove inner body **35**, outer body **37** and end cover **40**.
- Remove three screws **15** from adaptor **14** and remove adaptor.
- Assemble in reverse order of dismantling.

Piston Assembly

- Grip tool handle **19** in a vice fitted with soft jaws and, using a spanner on the flats of the protrusion on stop cover **13**, unscrew stop cover, together with 'O' rings **11** and **12**.
- Undo screws **9** from stop cover **13** and remove piston stop **10**.
- Remove 'O' rings **11** from their grooves on outer surface of stop cover **13**, and hook out 'O' rings **12** from inside stop cover **13**.
- Withdraw buffer **8** from piston **16**.
- Push piston **16** as far forward as possible to allow a thin spanner to locate the flats on nose end of piston **16**. Using another suitable spanner, unscrew end plug **33** and withdraw from piston **16**.
- Withdraw scraper ring **32**.
- Push piston **16** out of rear of tool (some oil will be ejected from tool during this action).
- Using circlip pliers, remove circlip **17** from tool handle and withdraw seal **18**.
- Remove seal **7** and seal **6** from piston **16**.
- Assemble in reverse order of dismantling, ensuring that seals **7** and **6** are assembled in the correct way round as shown and in the correct order, also ensure scraper ring **32** is inserted right way round.
- Use piston insertion tool* to install the piston.

Servicing the Tool

Trigger Assembly

- Using a spanner, undo locknut **30** and remove trigger **31**, 'O' ring **29**, and spring **28** from handle **19**.
- Assemble in reverse order of dismantling.

Vacuum Stem Extraction Switch

- The tool is fitted with a vacuum stem extraction system. To dismantle, remove vacuum switch screw **5**, washer **4**, and withdraw vacuum switch **25**.
- Remove 'O' rings **23** and **26** and ring **27** from vacuum switch **25**.
- Remove rear suction adjustment screw **24** and remove 'O' ring **23**.
- Assemble in reverse order of dismantling.
- Adjust to ensure sufficient vacuum is achieved to enable the rivet stem is projected into the stem catcher unit. This is achieved in the following way:
    - Adjust vacuum switch **25** to ensure air flow for stem extraction.
    - Adjust suction adjustment screw **24** to maintain the fastener in the nose tip prior to placing and that sufficient vacuum is produced to suck the stem into the stem catcher unit**.**

Item numbers in **bold** refer to the General Assembly drawing and Parts List on pages 16-17.

Cabinet

- The cabinet comprises an intensifier **3**, a pilot valve **38**, a pressure regulator and filtering unit **19** and an air pressure indicating assembly **23** together with the air hoses internal to the cabinet.
- Servicing is limited to removal/replacement of complete assemblies and the renewal of seals within the pilot valve.
- To dismantle the cabinet it is necessary to extract the base plate **46** and the components installed on it. This is possible after disconnecting all hoses and removing items restricting the withdrawal of the base plate.

Intensifier

- To remove the intensifier **3** and oil reservoir, disconnect the oil hose using two spanners, (be prepared for oil spillage from hose/ intensifier), then remove the hoses (quick release connectors) connecting the intensifier to the pilot valve.
- Using a spanner, remove the two nuts and associated washers securing the intensifier to the baseplate.
- Lift intensifier clear of cabinet.
- Replacement is in reverse order of removal.

Item numbers in **bold** refer to the General Assembly drawing and Parts List on pages 18-19.

* Item included in the service kit.

Servicing the Tool

Pilot Valve

- Servicing of the valve is limited to the removal/replacement of 'O' rings.
- Remove screws **60** and remove pilot assembly.
- Remove pilot valve **36** and discard 'O' rings **40**, **47**, **41** and **42**.
- Remove end cap screws **57** and **62** and remove end caps **58** and **61**.
- Withdraw pistons **54** and **49** and remove 'O' rings **44** and **46** from pistons.
- Withdraw spool **52** from bore, taking care not to damage surface of spool and remove location washers **53** and **50**, 'O' ring **45**, spacers **51** and 'O' ring **43** from each end of valve body.
- Remove the five interface 'O' rings.
- Discard ALL 'O' rings removed.
- Clean all parts with paraffin or white spirit (DO NOT USE SOLVENTS) and dry all parts.
- Lightly smear bores of valve body **59**, pilot valve body **55**, both end caps **58** and **61** and all replacement 'O' rings with "CENTOPLEX 2" grease.
- Fit new seals **47**, **41** and **42** to pilot valve piston **48** and insert into pilot valve body.
- Fit new seals **40**, **42** and **43** to pilot valve body, place top cap **56** in position and secure pilot valve assembly to the main valve body **59** with screws **25**. Ensure that the interface seal housing faces upward with the G1/4 at the bottom. Ensure orientation of pilot valve **6** is correct.
- With main valve body **59** in the same position, fit green location washer **53** to the left hand side of the valve assembly.
- Starting from the right hand side of the valve, assemble alternately the 'O' rings **45** and spacers **57** (**6** 'O' rings and **5** spacers) and finally complete the stack assembly with white location washer **1**.
- Lightly smear spool 52 with "CENTOPLEX 2" grease and slide spool through seal/spacer stack.
- Fit seals **46** and **45** to respective pistons **54** and **49**, fit seals **43** to ends of main valve body **59**.
- Insert pistons into end caps **58** and **61** and assemble end caps to valve, taking care to locate piston shafts into holes in the ends of the spool **52**.
- Secure end cap assemblies to main valve body **59** with screws **57** and **62**.
- Fit interface 'O' ring into their housings in the main valve body.
- If the pipe connection to the pilot assembly is damaged, replace the plastic collet **38** and lift out the 'O' ring from the cartridge **37**. Fit new 'O' ring **39** and insert plastic collet 38 into the cartridge.

Pressure Regulator and Filtering Assembly

- To remove the assembly from the cabinet, disconnect the two air hoses **47** and **42** at the regulator.
- Remove the two screws, spacers, washers and nuts **19** securing the regulator to the cabinet.
- Remove assembly from the cabinet.
- Replacement is in reverse order of removal.

Air Pressure Indicator Assembly

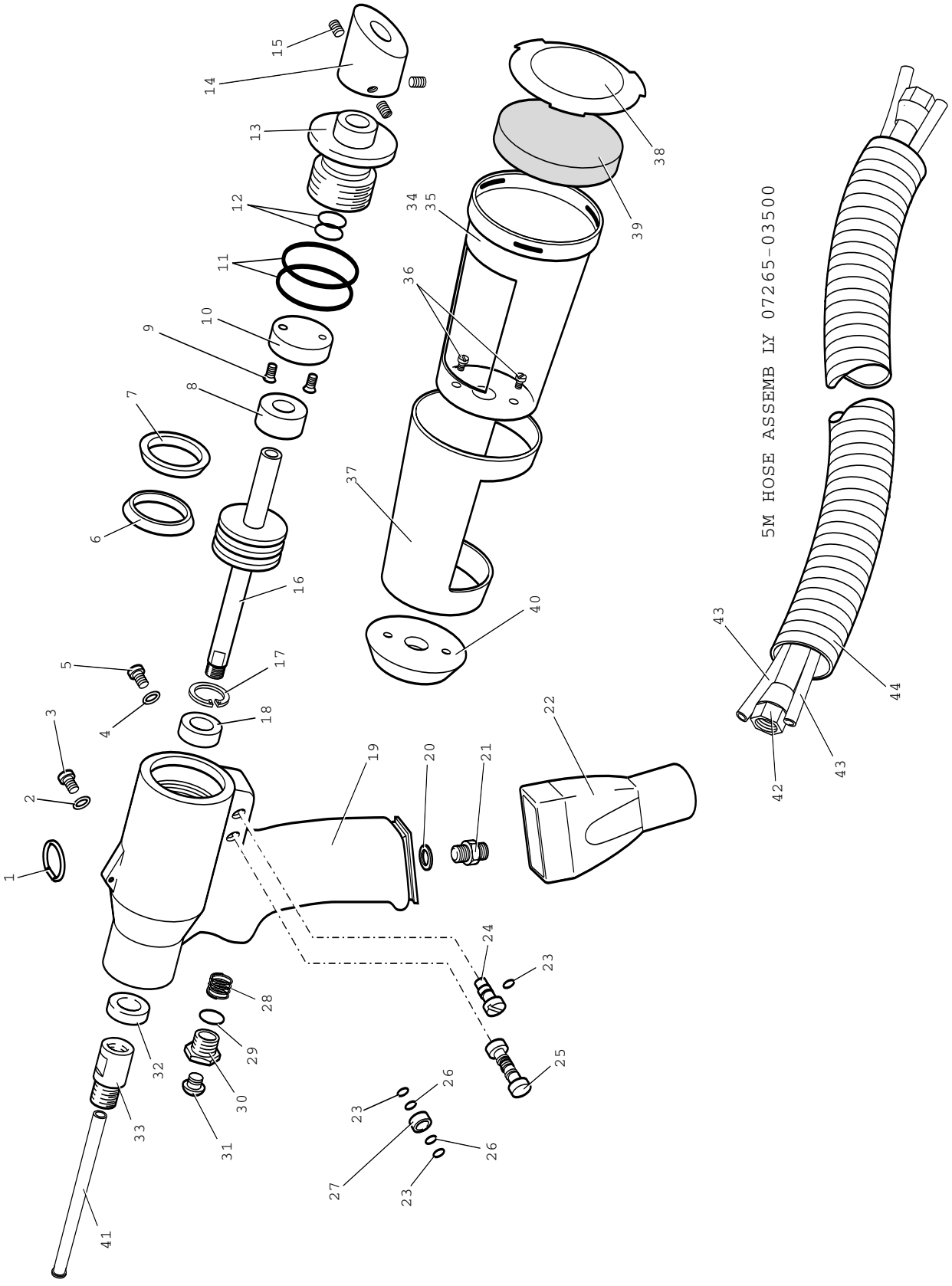
- To remove the assembly **23**, remove the air hose **42** from the rear of the gauge.
- Remove the clamp from the rear of the gauge and withdraw gauge from front of the cabinet.
- Replacement is in reverse order of removal.

I M P O R T A N T

Check the tool against daily and weekly servicing
Priming is ALWAYS necessary after the too has been dismantled and prior to operating.

* Item included in the service kit. For complete list see page 12.
Item numbers in **bold** refer to the General Assembly drawing and Parts List on pages 16-17.

General Assembly of Handle Tool 07285-03000



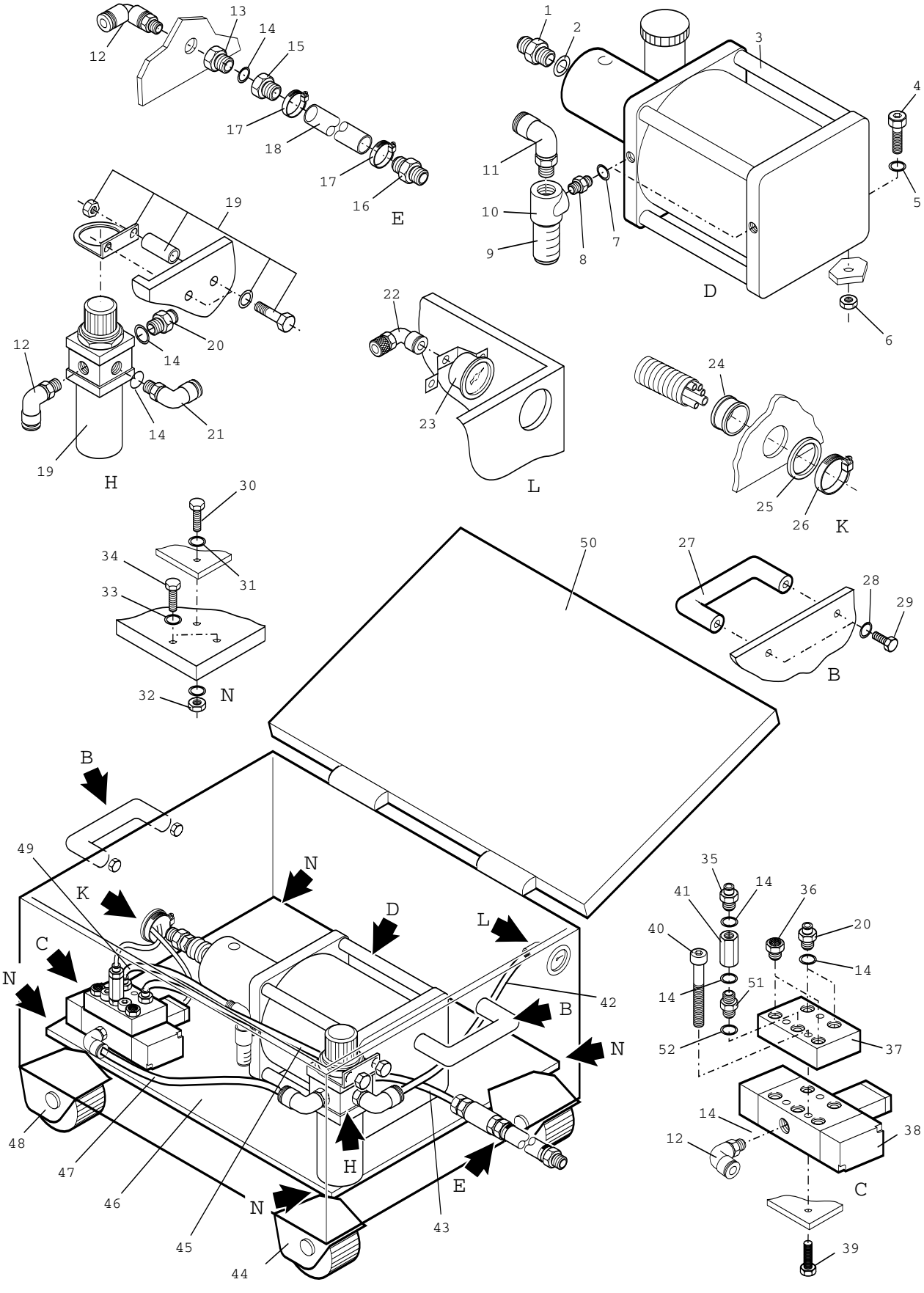
07265-03000 PARTS LIST

ITEM	PART N...	DESCRIPTION	QTY	SPARES	ITEM	PART N...	DESCRIPTION	QTY	SPARES
1	07265-03021	SUSPENSION RING	1	-	21	07265-02032	CONNECTOR	1	-
2	07265-02011	WASHER	1	-	22	07265-03029	SLEEVE	1	-
3	07265-02010	BLEED SCREW	1	-	23	07555-00502	'O' RING	3	-
4	07265-02003	WASHER	1	-	24	07265-02016	SUCTION ADJUSTMENT SCREW	1	-
5	07265-02035	VACUUM SWITCH SCREW	1	-	25	07265-02037	VACUUM SWITCH	1	-
6	07265-03006	SEAL	1	-	26	07265-02020	'O' RING	2	-
7	07265-03018	SEAL	1	-	27	07265-02019	RING	1	-
8	07265-02012	BUFFER	1	-	28	07555-09219	SPRING	1	-
9	07265-02047	SCREW	2	-	29	07265-03024	'O' RING	1	1
10	07265-02046	PISTON STOP	1	-	30	07265-03022	LOCKNUT	1	-
11	07265-02009	'O' RING	2	-	31	07265-03023	TRIGGER	1	-
12	07265-02007	'O' RING	2	-	32	07265-02017	SCRAPER RING	1	-
13	07265-02008	STOP COVER	1	-	33	07265-03059	END PLUG	1	-
14	07265-02042	ADAPTOR	1	-	34	07265-03800	STEM CATCHER UNIT	1	-
15	07265-02044	SCREW	3	-	35	07640-00241	INNER BODY	1	-
16	07265-03002	PISTON	1	-	36	07265-02013	SCREW	2	-
17	07265-02005	CIRCLIP	1	-	37	07640-00239	OUTER BODY	1	-
18	07265-02004	SEAL	1	-	38	07340-00335	END CAP	1	-
19	07265-03001	HANDLE	1	-	39	07265-02054	SILENCER	1	-
20	07265-02031	WASHER	1	-	40	07265-03051	END COVER	1	-
					41	07265-03058	GUIDE TUBE	1	-

5M HOSE ASSEMBLY 07265-03500

ITEM	PART N...	DESCRIPTION	QTY	SPARES	ITEM	PART N...	DESCRIPTION	QTY	SPARES
42	07265-02061	OIL HOSE	1	-	44	07265-02066	PROTECTIVE SLEEVE	1	-
43	07265-02021	AIR HOSE	2	-					

General Assembly of Cabinet 07265-03200

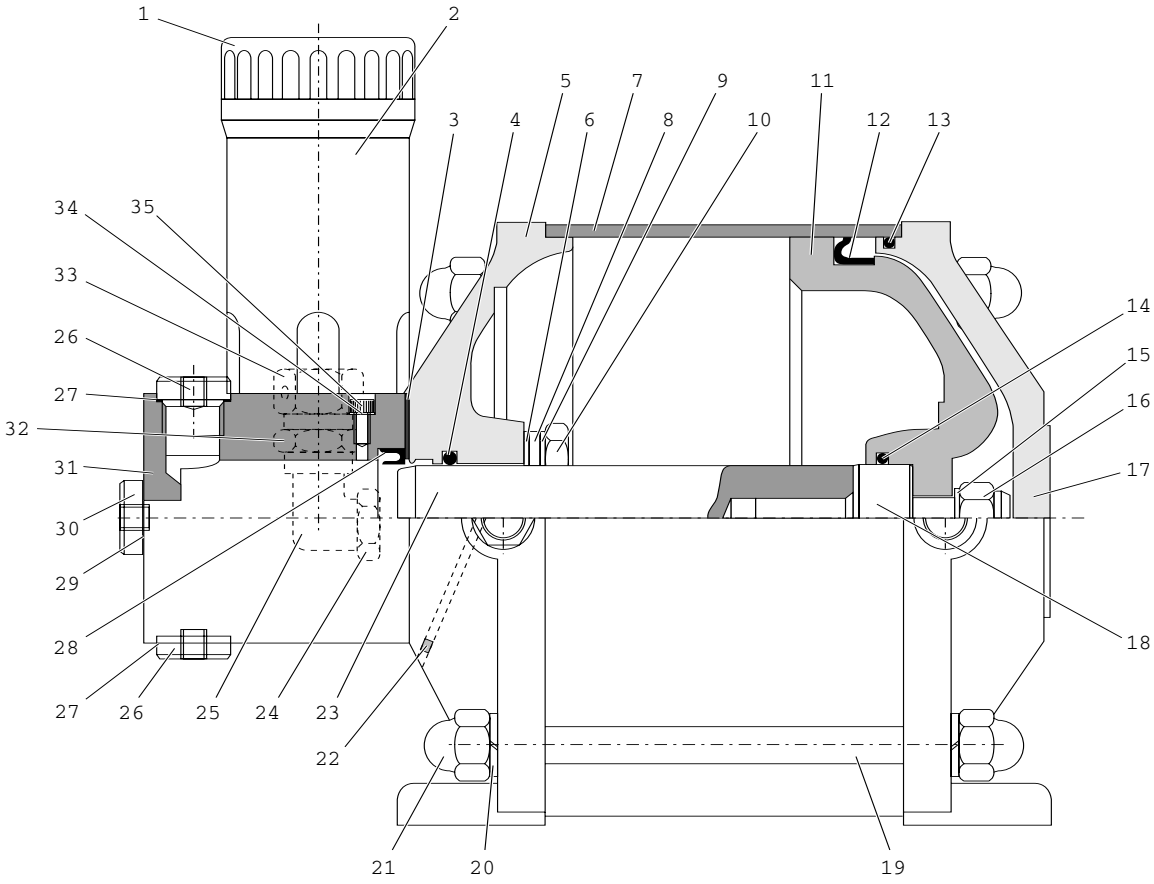


Parts List of Cabinet 07265-03200

07265-03200 CABINET PARTS LIST

ITEM	PART Nº	DESCRIPTION	QTY	SPARES
1	07265-03258	CONNECTOR	1	-
2	07265-03259	WASHER	1	-
3	07005-01650	INTENSIFIER	1	-
4	07265-02267	BOLT	2	-
5	07625-02268	WASHER	2	-
6	07265-02269	NUT	2	-
7	07265-03261	WASHER	4	-
8	07265-03260	CONNECTOR	2	-
9	07265-03263	SILENCER	2	-
10	07265-03225	EXHAUST	2	-
11	07265-03262	ELBOW CONNECTOR	2	-
12	07265-03257	ELBOW CONNECTOR	3	-
13	07265-03221	CONNECTOR	1	-
14	07265-03272	WASHER	8	-
15	07265-02053	CONNECTOR	1	-
16	07265-03253	CONNECTOR	1	-
17	07265-02076	CLAMP	2	-
18	07265-03219	18mm AIR HOSE (2500mm)	1	-
19	07265-03220	PRESSURE REG & FILTER ASSY	1	-
20	07265-03271	CONNECTOR	3	-
21	07265-03256	ELBOW CONNECTOR	1	-
22	07265-03255	ELBOW CONNECTOR	1	-
23	07265-03254	AIR PRESSURE INDICATOR ASSY	1	-
24	07265-03290	RUBBER RING	1	-
25	07265-03291	WASHER	1	-
26	07265-03292	CLAMP	1	-
27	07265-03202	HANDLE	2	-
28	07265-02284	WASHER	4	-
29	07265-02283	SCREW	4	-
30	07265-03231	SCREW	8	-
31	07265-03232	WASHER	8	-
32	07265-03206	NUT	8	-
33	07265-03204	WASHER	8	-
34	07265-03205	SCREW	8	-
35	07265-03269	CONNECTOR	1	-
36	07265-03270	SILENCER	4	-
37	07265-03222	SUB BASE	2	-
38	07005-00590	VALVE	2	-
39	07265-03294	SCREW	2	-
40	07265-03266	SCREW	3	-
41	07265-02059	NON-RETURN VALVE	1	-
42	07265-03216	6mm AIR HOSE (500 mm)	1	-
43	07265-03215	10mm AIR HOSE (100 mm)	1	-
44	07265-03203	WHEEL	2	-
45	07265-03265	10mm AIR HOSE (340 mm)	1	-
46	07265-03230	BASE PLATE	1	-
47	07265-03213	10mm AIR HOSE (410 mm)	1	-
48	07265-03207	WHEEL	2	-
49	07265-03264	10mm AIR HOSE (210 mm)	1	-
50	07265-03201	BOX (inc. Key)	1	-
51	07265-03267	CONNECTOR	1	-
52	07265-03268	WASHER	1	-

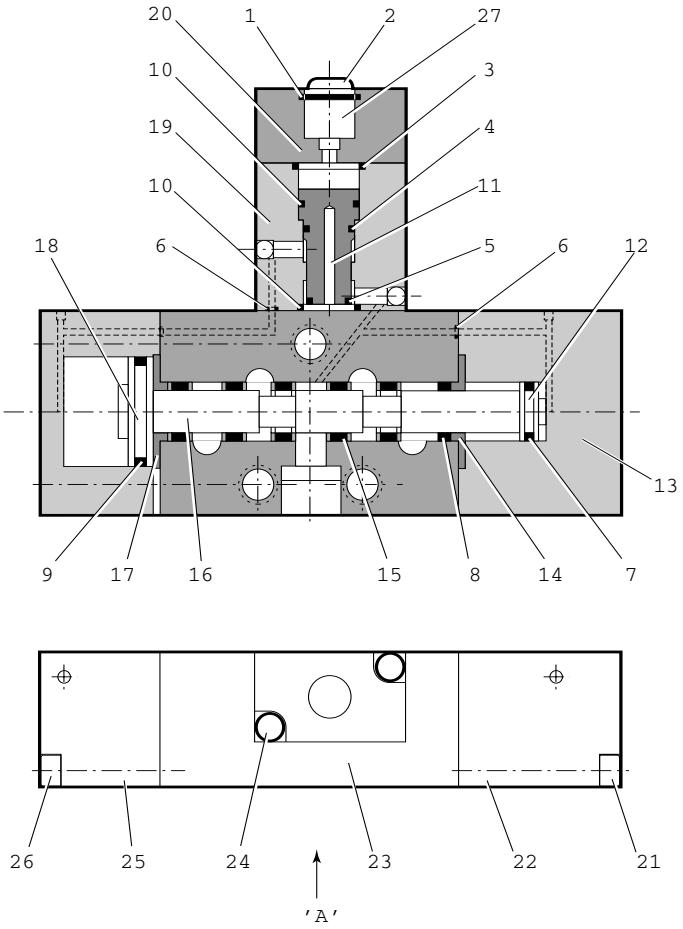
General Assembly of Intensifier 07005-01650

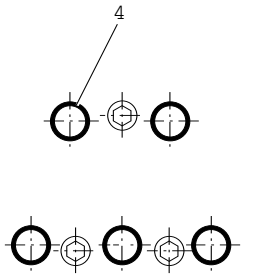


Parts List of Intensifier 07005-01650

07005-00529 INTENSIFIER PARTS LIST									
ITEM	PART Nº	DESCRIPTION	QTY	SPARES	ITEM	PART Nº	DESCRIPTION	QTY	SPARES
1	07267-08018	OIL RESERVOIR PLUG	1	-	19	07265-02414	TENSION RODS	4	-
2	07265-02405	OIL RESERVOIR CUP	1	-	20	07267-08026	WASHER	8	-
3	07265-02419	SEAL	4	-	21	07267-08013	NUT	8	-
4	07267-08020	SEAL	1	-	22	07267-08122	FILTER	1	-
5	07625-02407	FLANGE	1	-	23	07265-02409	PLUNGER ROD	1	-
6	07265-02435	WASHER	1	-	24	07267-08025	NIPPLE	1	-
7	07265-02417	PNEUMATIC CYLINDER	1	-	25	07267-08023	ELBOW	1	-
8	07265-02435	WASHER	1	-	26	07267-08029	PLUG	2	-
9	07267-08022	WASHER	4	-	27	07267-08030	WASHER	1	-
10	07265-02406	SCREW	4	-	28	07265-02403	SEAL	1	-
11	07265-02410	PISTON	1	-	29	07267-08128	WASHER	1	-
12	07267-08011	PISTON SEAL	1	-	30	07267-08101	PLUG	1	-
13	07267-08012	CYLINDER FLANGE SEAL	1	-	31	07265-02402	HEAD	1	-
14	07267-08020	SEAL	1	-	32	07267-08027	NUT	1	-
15	07267-08031	WASHER	1	-	33	07267-08024	CONNECTOR	1	-
16	07267-08015	LOCKING NUT	1	-	34	07267-08034	WASHER	1	-
17	07267-08016	REAR FLANGE	1	-	35	07267-08021	BLEED SCREW	1	-
18	07267-08032	PLUNGER ROD EXTENSION	1	-					

General Assembly of Valve 07005-00590





Parts List of Valve 07005-00590

07005-00590 VALVE PARTS LIST									
ITEM	PART Nº	DESCRIPTION	QTY	SPARES	ITEM	PART Nº	DESCRIPTION	QTY	SPARES
1	07005-00599	* 'O' RING	-	-	15	-	SPACER	5	-
2	07005-00598	* PLASTIC COLLET	-	-	16	-	SPOOL	1	-
3	07003-00204	* 'O' RING	1	-	17	-	WASHER	1	-
4	07003-00103	* 'O' RING	6	-	18	-	PISTON	1	-
5	07003-00042	* 'O' RING	1	-	19	-	BODY	1	-
6	07003-00121	* 'O' RING	4	-	20	-	TOP CAP	1	-
7	08005-00127	* 'O' RING	1	-	21	-	SCREW	2	-
8	07003-00105	* 'O' RING	6	-	22	-	END CAP	1	-
9	07003-00178	* 'O' RING	1	-	23	-	BODY	1	-
10	07003-00017	* 'O' RING	2	-	24	-	SCREW	2	-
11	-	PISTON	1	-	25	-	END CAP	1	-
12	-	PISTON	1	-	26	-	SCREW	2	-
13	07005-00590	VALVE ASSEMBLY	-	-	27	-	CARTRIDGE	1	-
14	-	WASHER	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 fasteners are not fully placed by one operation of the trigger.

Oil Details

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

Hyspin® VG 32 Oil Safety Data

First Aid

SKIN:

Wash thoroughly with soap and water as soon as possible. Casual contact requires no immediate attention. Short term contact requires no immediate attention.

INGESTION:

Seek medical attention immediately. DO NOT induce vomiting.

EYES:

Irrigate immediately with water for several minutes. Although NOT a primary irritant, minor irritation may occur following contact.

Fire

Flash point 232°C. Not classified as flammable.

Suitable extinguishing media: CO_2, dry powder, foam or water fog. DO NOT use water jets.

Environment

WASTE DISPOSAL: Through authorised contractor to a licensed site. May be incinerated. Used product may be sent for reclamation.

SPILLAGE: Prevent entry into drains, sewers and water courses. Soak up with absorbent material.

Handling

Wear eye protection, impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area.

Storage

No special precautions.

PROPERTIES	RESULT	
ISO oil type		HL
ISO viscosity grade		32
Kinematic viscosity		
	cS @ 40°C	32
	@ 100°C	5.3
Relative density	at 20°C	0.875
Viscosity Index		95
Pour point	°C	- 30
Open Flash point	°C	232
Neutralisation value mg KOH/g		1.5

PROPERTIES	RESULT	
Foaming tendency/stability		
	ml @ 24°C	Trace/Nil
	ml @ 93.5°C	20/Nil
	ml @ 24°C after test @ 93.5°C	Trace/Nil
Air release value minutes to		
	0.2% air content @ 50°C	4
Seal compatibility index		10
Water separation time		
	in minutes to 40-40-0 @54°C	15
	@83°C	15

Priming

Priming Procedure

I M P O R T A N T

CONNECT AIR SUPPLY (this causes the piston to bottom, allowing more priming oil into the tool).
DO NOT OPERATE THE TRIGGER WHILE THE BLEED SCREW IS REMOVED.
All operations should be carried out on a clean bench, with clean hands in a clean area.
Ensure that the priming pump is free from foreign matter
and that the oil is perfectly clean and free from air bubbles.
Care MUST be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

- Prior to starting the priming procedure, obtain a suitable container to collect excess oil.
- Disconnect the air supply and undo the intensifier oil reservoir cap.
- Top up the reservoir with VG32 Castrol Hyspin® priming oil to a level of 20 mm (0.8") below top of the reservoir.
- Remove bleed screw **3** and associated washer **2** from placing tool handle.
- Connect the tool to the air supply.
- Place tool handle over the container with bleed hole orientated towards the container and operate the trigger.
- When oil is ejected from the bleed hole, release the trigger.
- Operate trigger again, replace bleed screw **3** and washer **2** BEFORE releasing trigger again.
- Repeat the trigger operating/releasing sequence, allowing a few seconds between cycles to allow priming oil to circulate.
- Continue until oil flowing from bleed hole is free of air bubbles, (ensure that the reservoir is not starved of oil, otherwise air will be drawn into the system introducing air bubbles in the oil stream).
- When air free oil is flowing, tighten the bleed screw with an Allen key and release the trigger.
- If necessary, top up the oil reservoir.

Item numbers in **bold** refer to the General Assembly drawing and Parts List on pages 16-17.

Fault Diagnosis

Symptom	Possible Cause	Remedy	Page Ref
Several pulls required to set rivet	Low air pressure	Increase air pressure	
	Lack of lubrication	Lubricate tool at air inlet point	5
	Worn or broken tail jaws	Fit new tail jaws	9
	Oil level in tool low or air in oil	Prime tool	18-19
Tool will not grip stem of fastener	Worn or dirty tail jaws	Clean or fit new jaws	9
	Tail jaw housing loose	Tighten against nylon locking ring	9
	Weak or broken spring in nose assembly	Fit new spring	9
	Incorrect component in nose assembly	Identify and replace	9
	Bent tail haw spreader assembly tube preventing it from moving forward into tail jaw housing	Replace tail jaw spreader assembly	9
Jaws will not release broken rivet stem	Dirty tail jaws or tail jaw housing	Clean and lubricate	12
	Tail jaw housing, nose tip or nose casing not properly seated	Tighten nose equipment Tighten nose assembly	9
	Weak or broken spring around tail jaw spreader assembly	Fit new spring	8-9
Spent rivet stem is jamming in tool	Incorrect tai jaw spreader fitted	Replace with correct part	4 (point 14)
	Bent or dirty tail jaw spreader assembly tube	Renew or clean as applicable	
	Collector bottle too full	Empty and ensure bottle never exceeds half full	5

Item numbers in **bold** refer to the general assembly drawing and parts list on pages 16-17.

Other symptoms or failures should be reported to your local Avdel authorised distributor or repair centre.

Notes

Notes

Declaration of Conformity

We, Avdel UK Limited, Watchmead Industrial Estate, Welwyn Garden City, Herts, AL7 1LY
declare under our sole responsibility that the product:

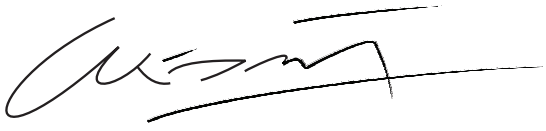
Model 07265

Serial No.

to which this declaration relates is in conformity with the following standards:

EN ISO 12100 - parts 1 & 2
BS EN ISO 8662 - part 6
BS EN ISO 3744
ISO EN 792 part 13 - 2000
BS EN ISO 11202
BS EN 982
BS EN 983

following the provisions of the Machine Directive 2006/42/EC



A. Seewraj - Product Engineering Manager - Automation Tools

Date of issue

CE **This box contains a power tool which is in conformity with Machines Directive 2006/42/EC. The 'Declaration of Conformity' is contained within.**

Since 1922 Since 1 936 2010

Our Technology, Your Success

AUSTRALIA
Infastech (Australia) Pty Ltd.
891 Wellington Road
Rowville
Victoria 3178
Tel: +61 3 9765 6400
Fax: +61 3 9765 6445
info@infastech.com.au

CANADA
Avdel Canada Limited
1030 Lorimar Drive
Mississauga
Ontario L5S 1R8
Tel: +1 905 364 0664
Fax: +1 905 364 0678
infoAvdel-Canada@infastech.com

CHINA
Infastech (China) Ltd.
RM 1708, 17/F., Nanyang Plaza,
57 Hung To Rd., Kwun Tong
Hong Kong
Tel: +852 2950 0631
Fax: +852 2950 0022
infochina@infastech.com

FRANCE
Avdel France S.A.S.
33 bis, rue des Ardennes
BP4
75921 Paris Cedex 19
Tel: +33 (0) 1 4040 8000
Fax: +33 (0) 1 4208 2450
AvdelFrance@infastech.com

GERMANY
Avdel Deutschland GmbH
Klusriede 24
30851 Langenhagen
Tel: +49 (0) 511 7288 0
Fax: +49 (0) 511 7288 133
AvdelDeutschland@infastech.com

INDIA
Infastech Fastening Technologies India Private Limited
Plot No OZ-14, Hi Tech SEZ,
SIPCOT Industrial Growth Center,
Oragadam, Sriperumbudur Taluk,
Kanchipuram District,
602105 Tamilnadu
Tel: +91 44 4711 8001
Fax: +91 44 4711 8009
info-in@infastech.com

ITALY
Avdel Italia S.r.l.
Viale Lombardia 51/53
20047 Brugherio (MI)
Tel: +39 039 289911
Fax: +39 039 2873079
vendite@infastech.com

JAPAN
Infastech Kabushiki Kaisha
Center Minami SKY,
3-1 Chigasaki-Chuo, Tsuzuki-ku,
Yokohama-city,
Kanagawa Prefecture
Japan 224-0032
Tel: +81 45 947 1200
Fax: +81 45 947 1205
info@infastech.co.jp

MALAYSIA
Infastech (Malaysia) Sdn Bhd
Lot 63, Persiaran Bunga Tanjung 1,
Senawang Industrial Park
70400 Seremban
Negeri Sembilan
Tel: +606 676 7168
Fax: +606 676 7101
info-my@infastech.com

SINGAPORE
Infastech (Singapore) Pte Ltd.
31 Kaki Bukit Road 3
#05-03/06 Techlink
Singapore, 417818
Tel: +65 6372 5653
Fax: +65 6744 5643
info-sg@infastech.com

SOUTH KOREA
Infastech (Korea) Ltd.
212-4, Suyang-Ri,
Silchon-Eup, Kwangju-City,
Kyunggi-Do, Korea, 464-874
Tel: +82 31 798 6340
Fax: +82 31 798 6342
info@infastech.co.kr

SPAIN
Avdel Spain S.A.
C/ Puerto de la Morcuera, 14
Poligono Industrial Prado Overa
Ctra. de Toledo, km 7,8
28919 Leganés (Madrid)
Tel: +34 91 3416767
Fax: +34 91 3416740
ventas@infastech.com

TAIWAN
Infastech/Tri-Star Limited
No 269-7, Baodong Rd,
Guanmiao Township,
71841 Tainan County,
Taiwan, R.O.C
Tel: +886 6 596 5798 (ext 201)
Fax: +886 6 596 5758
info-tw@infastech.com

UNITED KINGDOM
Avdel UK Limited
Pacific House
2 Swiftfields
Watchmead Industrial Estate
Welwyn Garden City
Hertfordshire AL7 1LY
Tel: +44 (0) 1707 292000
Fax: +44 (0) 1707 292199
enquiries@infastech.com

USA
Avdel USA LLC
614 NC Highway 200 South
Stanfield, North Carolina 28163
Tel: +1 704 888 7100
Fax: +1 704 888 0258
infoAvdel-USA@infastech.com

Manual No.	Issue	Change Note No.	Date
07900-00662	A	04/065	06/04
	B	07/044	02/07
	B2	07-103	03/07
	B3	11-061	03/11

www.avdel-global.com
www.infastech.com