



Repair Manual

AirPower4
Model Z-14026001
AirPower 5
Model Z-15026001
Hydraulic Threaded Insert
Tools



Repair manual (version 3 modified)

- *specified for riveting tools serie 4 (AirPower 4, EZM4000, E-412NA, ON-4, AS4, RK-55-SPS)*
- *specified for riveting tools serie 5 (AirPower 5, RK-59-SPS)*

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1. Abbreviations:

CA - compressed air

MP - special tool (assembly jig)

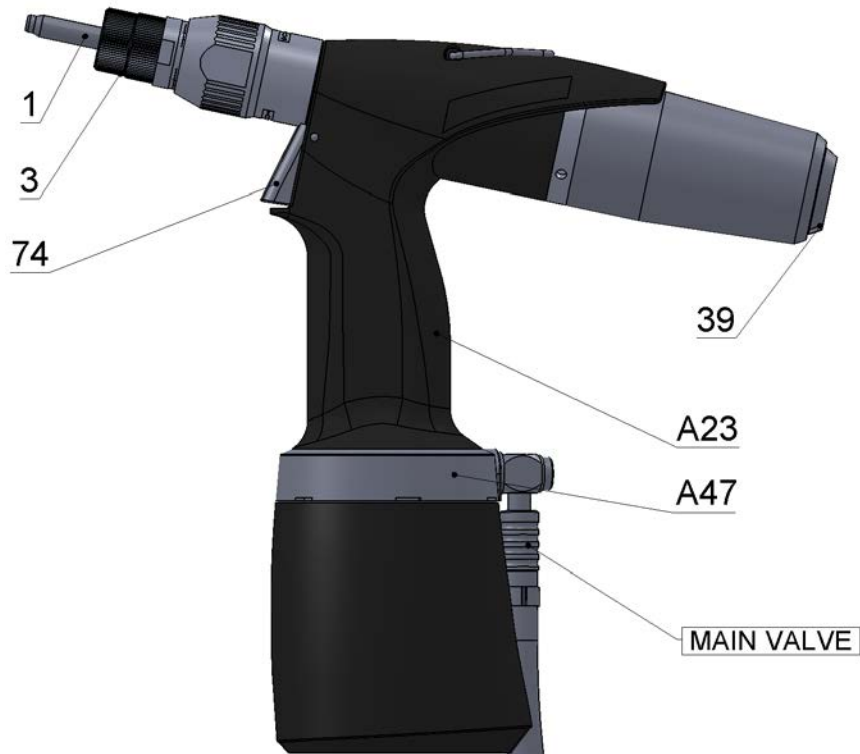
D - defect

BEM - basic engine monitoring

2. General instructions:

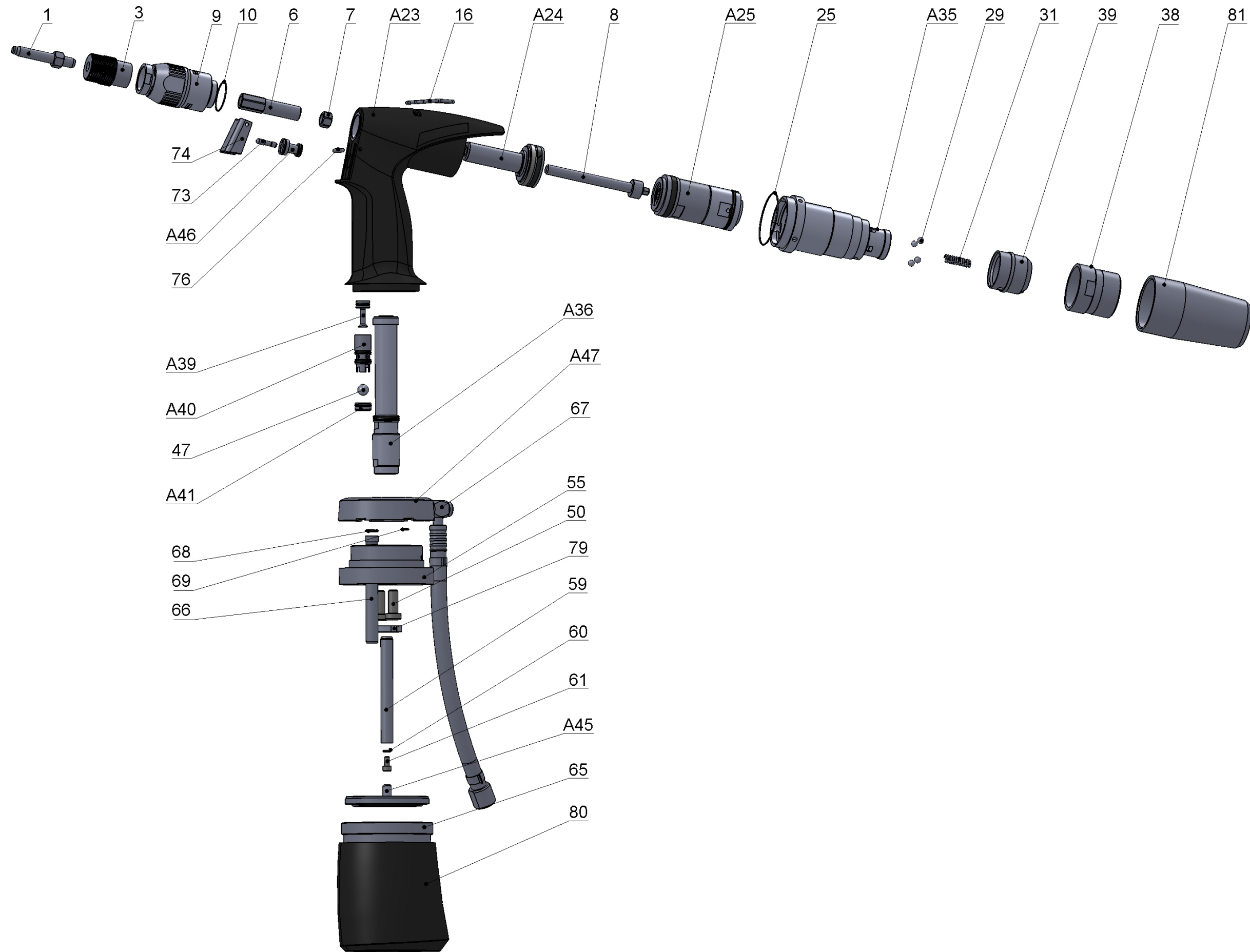
1. Riveting tool is always disconnected from the compressed air, unless otherwise stated
2. All threads are clockwise
3. Riveting tool is gripped in a stand (see chapter 10) while assembling and disassembling, unless otherwise stated
4. Before assembling, wash the disassembled parts in degreasing solution and insufflate with compressed air, wipe with a cloth
5. While assembling, lubricate the sealing (O-rings, pneumatic seals) and related opposite surfaces with oil MOGUL LV 2-3, unless stated otherwise

3. Proper function of riveting tool:

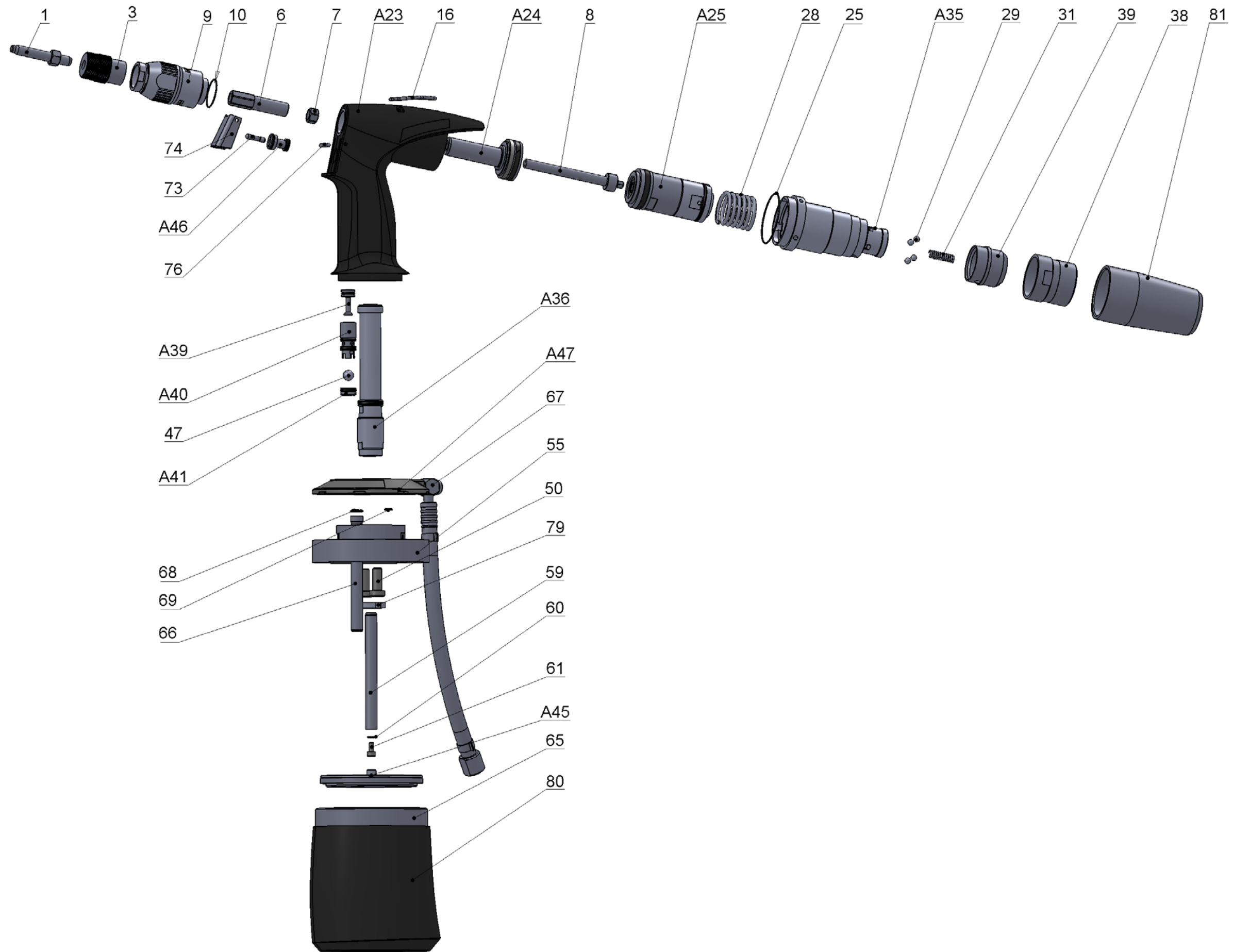


Operator activity	Tool function
Connect the riveting tool to CA, if the tool is equipped with main valve, turn it on. Pos. 74 is on the front extreme position, not pressed	CA does not leak, motor does not rotate
Put a rivet on pos. 1 and press towards the riveting tool, the rivet screws on	Motor turns right, outlet of CA through the outlets in pos. 39
The action is ready when the rivet is completely screwed on	Motor turns off, front of the rivet touches front of the pos. 3. CA does not leak
Press with hand pos. 39, the rivet screws out	Motor turns right, outlet CA through the outlets in pos. 39
Release pos. 39, screwing out stops	Pos. 39 gets back to the initial position, motor turns off, air does not leak
Turn with stroke adjustment according to arrow direction +/- . Further instructions are in the Operations manual	The scale moves, pos. 3 springs
Put a rivet on pos. 1 and press towards the riveting tool, the rivet screws on	Motor turns right, outlet of CA through the outlets in pos. 39, when the rivet is completely screwed on the motor turns off
Press pos. 74, the rivet is riveted in	If the extreme stroke is not set, the rivet and pos. 1 and pos. 3 move simultaneously, the length of the movement is cca 6.5mm, CA does not leak
Stop pressing pos. 74, the rivet completely screws out	CA outlets from the space pos. A47 and pos. 1 and pos. 3 get back, the motor turns, outlet of CA through the outlets in pos. 39, in the end motor stops itself, CA

4. Assembly drawing of riveting tool – serie 4:



4. Assembly drawing of riveting tool – serie 5:



5. Informative list of spare parts of riveting tool – serie 4:

<i>Position</i>	<i>Article Nr.</i>	<i>Name of part</i>	<i>Pcs</i>
1	D-14001XX	Mandrels	1
3	S-14003XX	Anvils complete	1
6	D-1400400	Joint sleeve	1
7	D-1400500	Counternut	1
8	D-1401000	Joint shaft	1
9	S-1400600	Front nozzle complete	1
	0901 D-1400610	Front nozzle body	1
	0902 D-1400620	Front nozzle with scale	1
	0903 D-1400630	Front nozzle pin	2
	0904 D-1400640	Adjusting nut	1
	0905 D-1400650	Washer	1
	0906 N-1500000010005	Compression spring 2x27x40x4,5	1
	0907 D-1400670	Covering sleeve	1
	0908 D-1400680	Retained ring	1
	0909 D-1400690	Spring	1
	0910 N-3600000000005	Steel ball dia. 4,5	1
10	N-2103702400150	O - ring 24/1,5 Sh 70	1
A23	S-1407701	Hydraulic body	1
16	D-1100800	Hanger	1
A24	S-1400900	Hydraulic piston complete	1
	20 D-1406200	Guiding band	1
A25	S-1407000	Motor complete	1
	23 D-1406600	Pneumatic seal 35x28x4,5	1
	24 S-1405000	Motor	1
	27 N-2103703000200	O - ring 30/2 Sh 70	1
25	N-2103704200150	O - ring 42/1,5 Sh 70	1
A35	S-1404001	Rear screwing complete	1
	26 D-1404001	Rear screwing	1
	32 D-1404200	Sleeve	1
	33 D-1404300	Sleeve of permanent magnet	1
	35 S-1404400	Pin complete	1
	36 D-08411500	Spring	1
	37 D-1404500	Bush for pin	1
29	N-3600000000003	Steel ball 5	4
30	N-3704900208050	Permanent magnet 20x8x5	1
31	D-00220600	Spring D10	1
34	D-1404800	Cover of permanent magnet	1
38	D-1404600	Rear body	1
39	S-1404701	Push button complete	1
	3901 D-1404701	Push button	1
	3902 N-3700000100400	Filtr SB Fi 10x4 mm/E	2
A36	S-1407800	Insert PP complete	1
	40 N-2103901000200	O - ring 10/2 Sh 90	1
	41 S-1401800	Insert PP	1
	42 N-2104001800220	O - ring 18/2,2	1
A39	S-1101900	Valve piston complete	1
A40	S-1102000	Valve body complete	1
47	N-2406696500090	Plastic ball 9	1
A41	S-1102100	Valve bottom	1
50	N-1000798408200	Screw M8x20 DIN 7984	2
A47	S-110230X	Air supply ring complete	1
	52 N-2103706000200	O - ring 60/2 Sh 70	1
	53 N-2103706300200	O - ring 63/2 Sh 70	1
	54 D-110230X	Air supply ring	1
67	S-1103203	Aircoupling	1
	A43 S-1103213	Aircoupling body complete	1
	A44 S-1103221	Aircoupling rotary part complete	1
	6705 N-1402292500012	Retaining ring	1
55	D-1102403	Body bottom	1
59	D-1402700	Pneumatic piston	1
60	N-2103900400150	O - ring 4/1,5 Sh 90	1
61	N-1000091204080	Screw M4x8 DIN 912	1
A45	S-1402801	Pneumatic piston complete	1
	62 D-1402801	Pneumatic piston	1
	63 N-2300007140000	Pneumatic seal 14	1
	64 D-1106400	Pneumatic seal 70x60x4,5	1
65	D-1103001	Pneumatic cvlinder	1
66	S-1403100	Tube	1
68	N-2103700700200	O - ring 7/2 Sh 70	1
69	N-2103700400150	O - ring 4/1,5 Sh 70	1
A46	S-1103300	Trigger body complete	1
73	D-1103400	Trigger piston	1
74	D-110350X	Trigger	1
76	D-1103800	Pin	1
79	D-1103600	Nut of body	1
80	D-1103700	Soft sleeve	1
81	D-1406800	Plastic cover	1

5. Informative list of spare parts of riveting tool – serie 5:

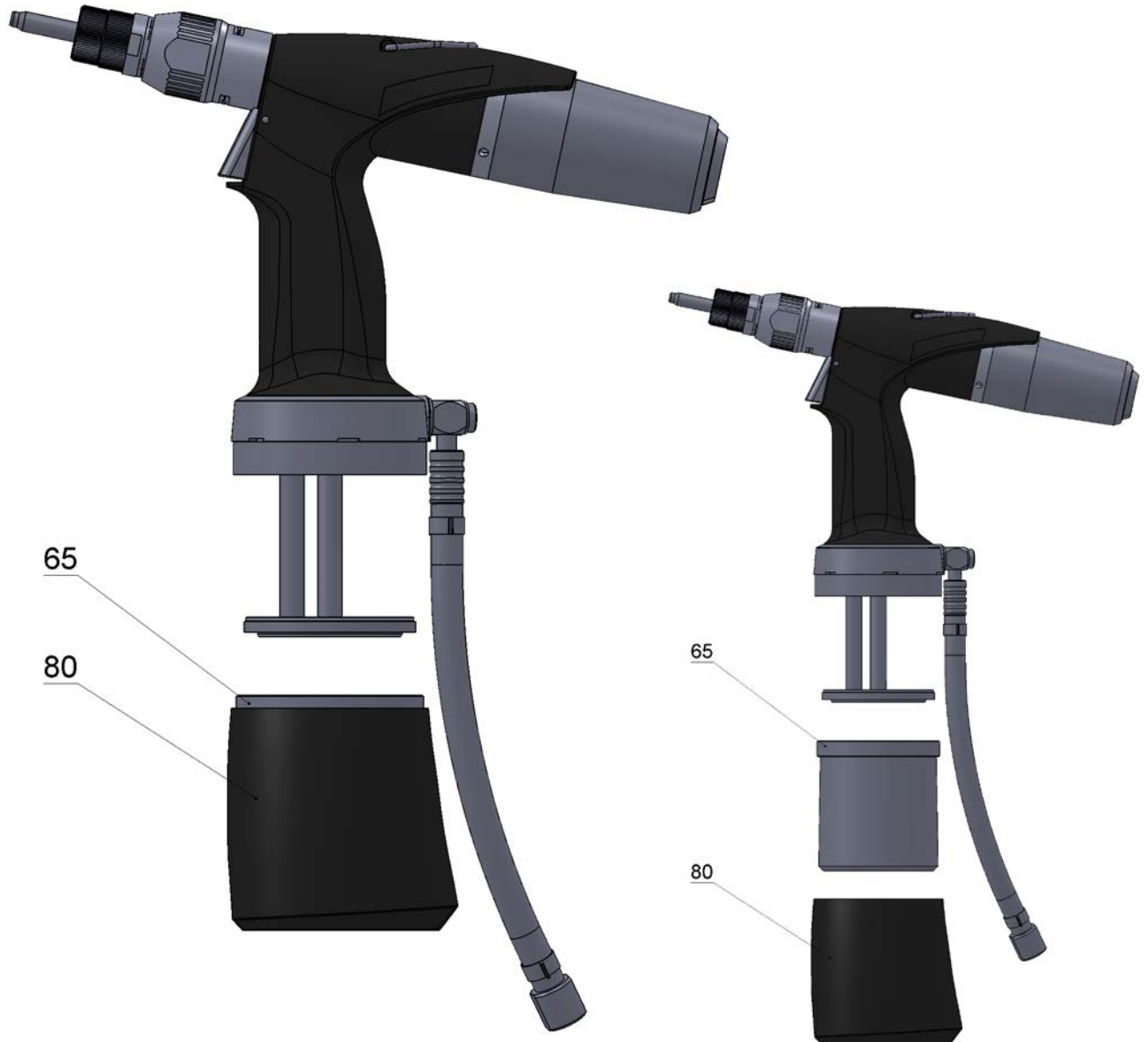
<i>Position</i>	<i>Article Nr.</i>	<i>Name of part</i>	<i>Pcs</i>
1	D-14001XX (D-15001XX)	Mandrels	1
3	S-14003XX	Anvils complete	1
6	D-1500400	Joint sleeve	1
7	D-1500500	Counternut	1
8	D-1501000	Joint shaft	1
9	S-1500600	Front nozzle complete	1
	0901 D-1400610	Front nozzle body	1
	0902 D-1500620	Front nozzle with scale	1
	0903 D-1400630	Front nozzle pin	2
	0904 D-1400640	Adjusting nut	1
	0905 D-1400650	Washer	1
	0906 N-1500000010005	Compression spring 2x27x40x4,5	1
	0907 D-1400670	Covering sleeve	1
	0908 D-1400680	Retained ring	1
	0909 D-1400690	Spring	1
	0910 N-3600000000005	Steel ball dia. 4,5	1
10	N-2103702400150	O – ring 24/1,5 Sh 70	1
A23	S-1507700	Hydraulic body	1
16	D-1100800	Hanger	1
A24	S-1500900	Hydraulic piston complete	1
	20 D-1406200	Guiding band	1
A25	S-1407000	Motor complete	1
	23 D-1406600	Pneumatic seal 35x28x4,5	1
	24 S-1405000	Motor	1
	27 N-2103703000200	O - ring 30/2 Sh 70	1
25	N-2103704200150	O - ring 42/1,5 Sh 70	1
A35	S-1504000	Rear screwing complete	1
	26 D-1504000	Rear screwing	1
	32 D-1404200	Sleeve	1
	33 D-1404300	Sleeve of permanent magnet	1
	35 S-1504400	Pin complete	1
	36 D-08411500	Spring	1
	37 D-1404500	Bush for pin	1
28	D-08651500	Spring	1
29	N-3600000000003	Steel ball 5	4
30	N-3704900208050	Permanent magnet 20x8x5	1
31	D-00220600	Spring D10	1
34	D-1404800	Cover of permanent magnet	1
38	D-1504600	Rear cover	1
39	S-1504700	Push button complete	1
	3901 D-1504700	Push button	1
	3902 N-3700000100400	Filtr SB Fi 10x4 mm/E	2
A36	S-1507800	Insert PP complete	1
	40 N-2703701487100	Bonded seal USIT 8,7x14x1	1
	41 S-1501800	Insert PP	1
	42 N-2104001800220	O - ring 18/2,2	1
A39	S-1101900	Valve piston complete	1
A40	S-1102000	Valve body complete	1
47	N-2406696500090	Plastic ball 9	1
A41	S-1102100	Valve bottom	1
50	N-1000798408200	Screw M8x20 DIN 7984	2
A47	S-120230X	Air supply ring complete	1
	52 N-2103706000200	O - ring 60/2 Sh 70	1
	53 N-2103706300200	O - ring 63/2 Sh 70	1
	54 D-120230X	Air supply ring	1
67	S-1203203	Aircoupling	1
	A43 S-1203213	Aircoupling body complete	1
	A44 S-1103221	Aircoupling rotary part complete	1
	6705 N-1402292500012	Retaining ring	1
55	D-1202400	Body bottom	1
59	D-1502700	Pneumatic piston	1
60	N-2103900400150	O - ring 4/1,5 Sh 90	1
61	N-1000091204080	Screw M4x8 DIN 912	1
A45	S-1502800	Pneumatic piston complete	1
	62 D-1502800	Pneumatic piston	1
	63 N-2300007140000	Pneumatic seal 14	1
	64 D-1206400	Pneumatic seal 90x80x4,5	1
65	D-1203000	Pneumatic cylinder	1
66	S-1203100	Tube	1
68	N-2103700700200	O - ring 7/2 Sh 70	1
69	N-2103700400150	O - ring 4/1,5 Sh 70	1
A46	S-1103300	Trigger body complete	1
73	D-1103400	Trigger piston	1
74	D-110350X	Trigger	1
76	D-1103800	Pin	1
79	D-1103600	Nut of body	1
80	D-1203700	Soft sleeve	1
81	D-1406800	Plastic cover	1

6. Instructions for assembling and disassembling – steps 1-19:

Step 1

Disassembly:

Put MP14 on pos. 80, loosen and screw out pos. 65 and pos. 80.



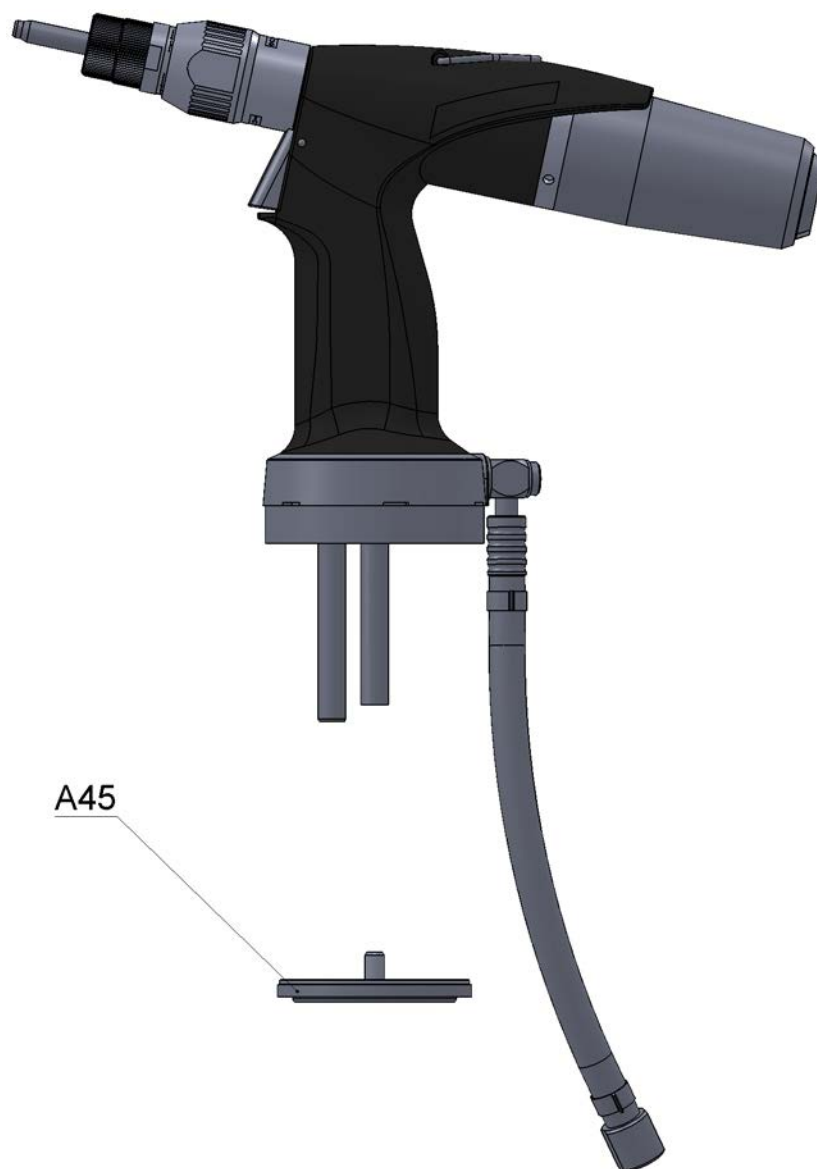
Assembly:

Screw on pos. 65 with pos. 80, put on MP14, tighten and put coloured warranty plug. In case of using new parts pos. 65 and pos. 80 the process is different, at first screw on pos. 65, put MP14 on, tighten and put coloured warranty plug. Then apply glue PATTEX EXPRESS FIX PL600 on pos. 65, put on pos. 80 by circular motion and position it according to the picture.

Step 2

Disassembly:

Release pos. A45.



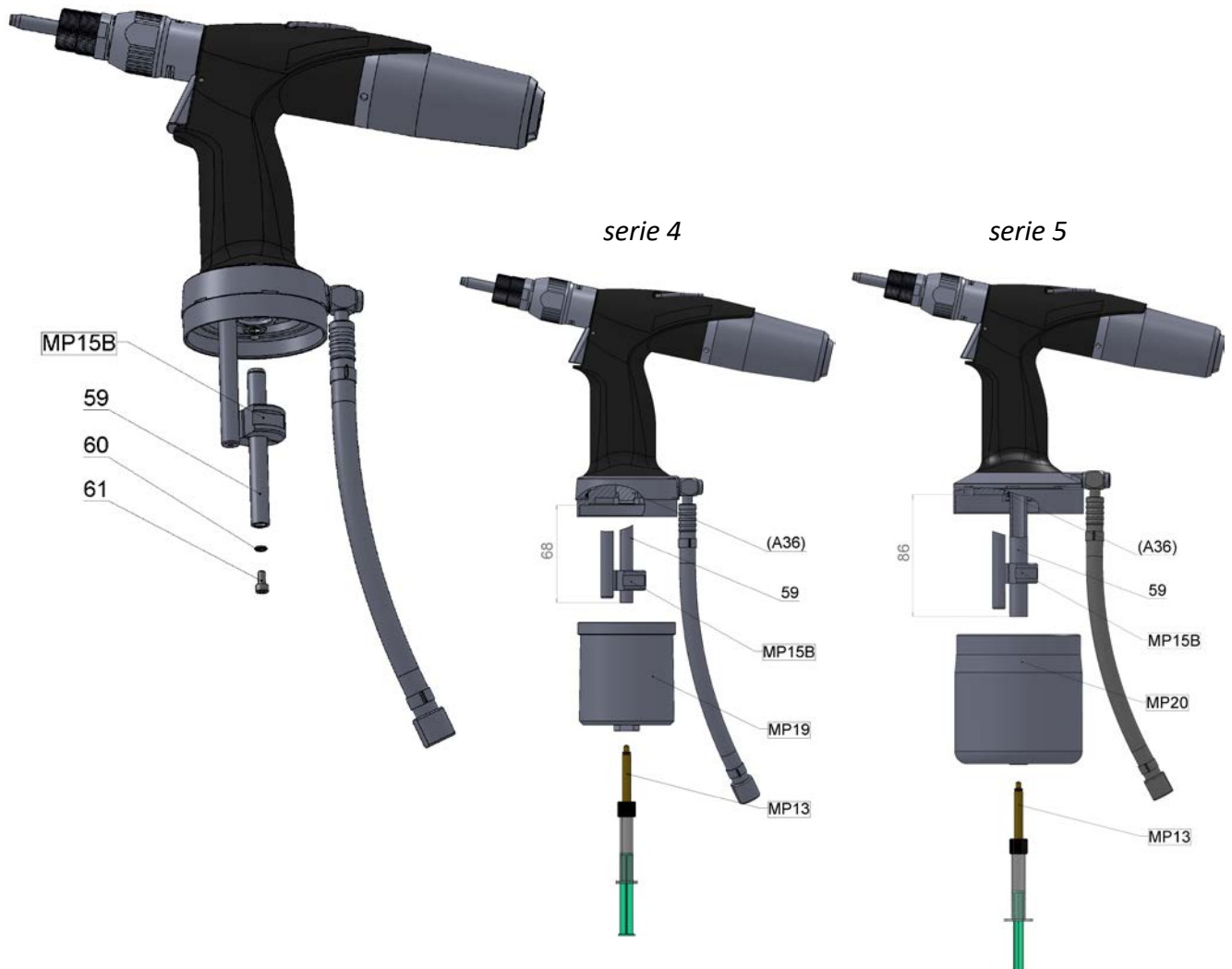
Assembly:

Put on pos. A45.

Step 3

Disassembly:

Put MP15B on pos. 59, then press MP15B with pliers, screw out pos. 61 with imbus key nr. 3 and take out pos. 60 and pos. 59. Then pour out the hydraulic oil from the riveting tool to the suitable container.



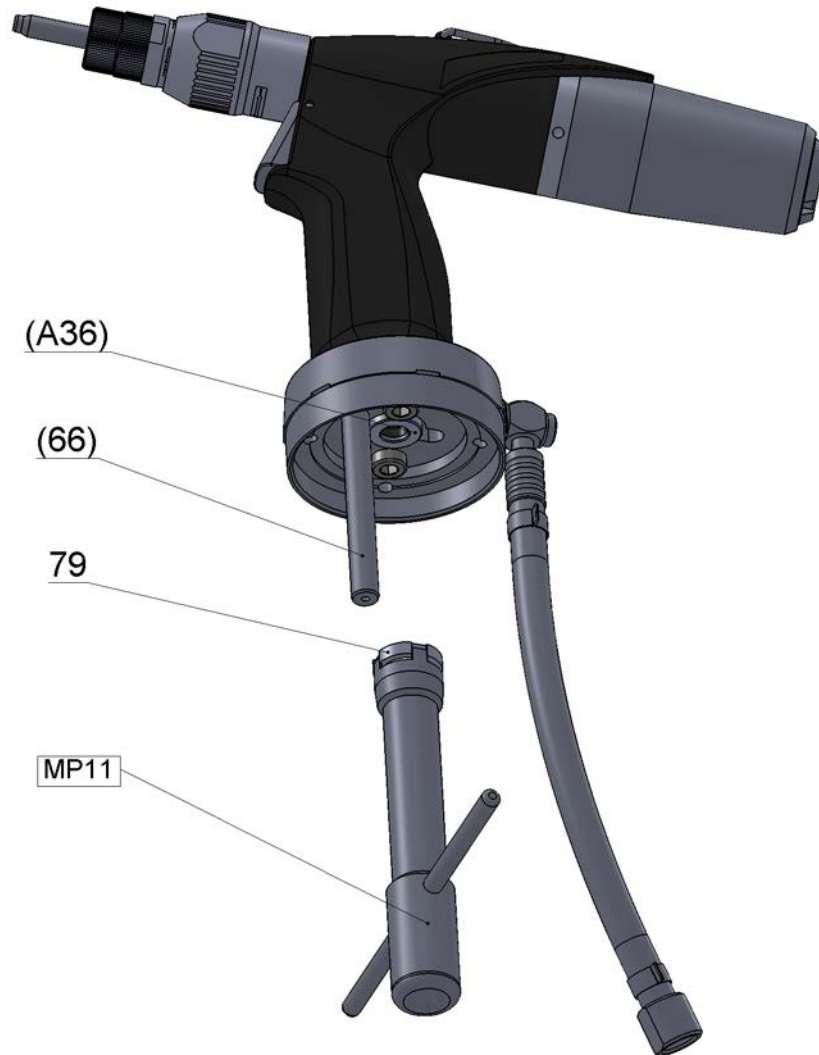
Assembly:

Pour hydraulic oil KERNITE IGM ISO 32 in to pos. A36, oil level up to 2. sealing in pos. A36. Lubricate the external surface of the pos. 59 with silicon paste LUKOSAN, put pos. 59 in pos A36 according to the picture ((serie 4 aprox. 68 mm, serie 5 aprox. 86 mm), screw on MP19 (MP20) tightly to the stop position, screw on MP13 (filled with hydraulic oil) to the pos. 59. Then repeatedly press and release the piston MP13 until air bubbles stop leaking from the hydraulic system to MP13. MP13 must be always filled with hydraulic oil, if not fill it. After filling the hydraulic system of the riveting tool with hydraulic oil, screw out MP13 and MP19 (MP20). Put pos. 60 on pos. 61 and screw it on to pos. 59 with imbus key nr. 3. Put MP15B on pos. 59, then press MP15B with pliers and retighten pos. 61 with imbus key nr. 3. Take off MP15B.

Step 4

Disassembly:

Put MP11 to the locks pos. 79, divert pos. 66 from MP11 (because the surface of pos. 66 might be damaged) and screw out pos. 79.



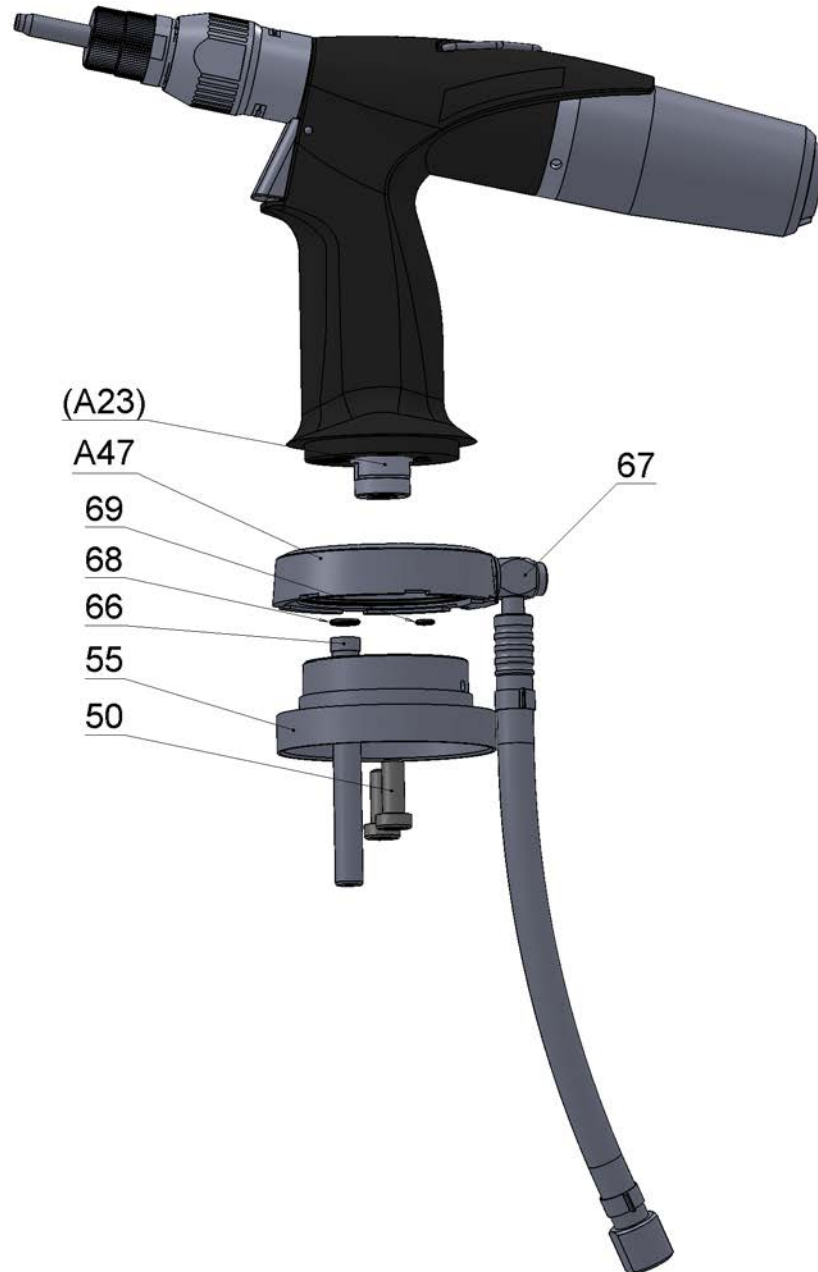
Assembly:

Screw pos. 79 on thread pos. A36, put MP11 on locks pos. 79, divert pos. 66 from MP 11 (because the surface of pos. 66 might be damaged). Retighten pos. 79.

Step 5

Disassembly:

Screw out pos. 50 (2x) with imbus key nr. 5, put out pos. 55 with pos. 66, 68, 69 and pos. A47 with pos. 67. Put pos. 66 with pos. 68 out., take pos. 69 out with MP32, be careful and do not damage recess in pos. 55. Put pos. 55 out of pos. A47.



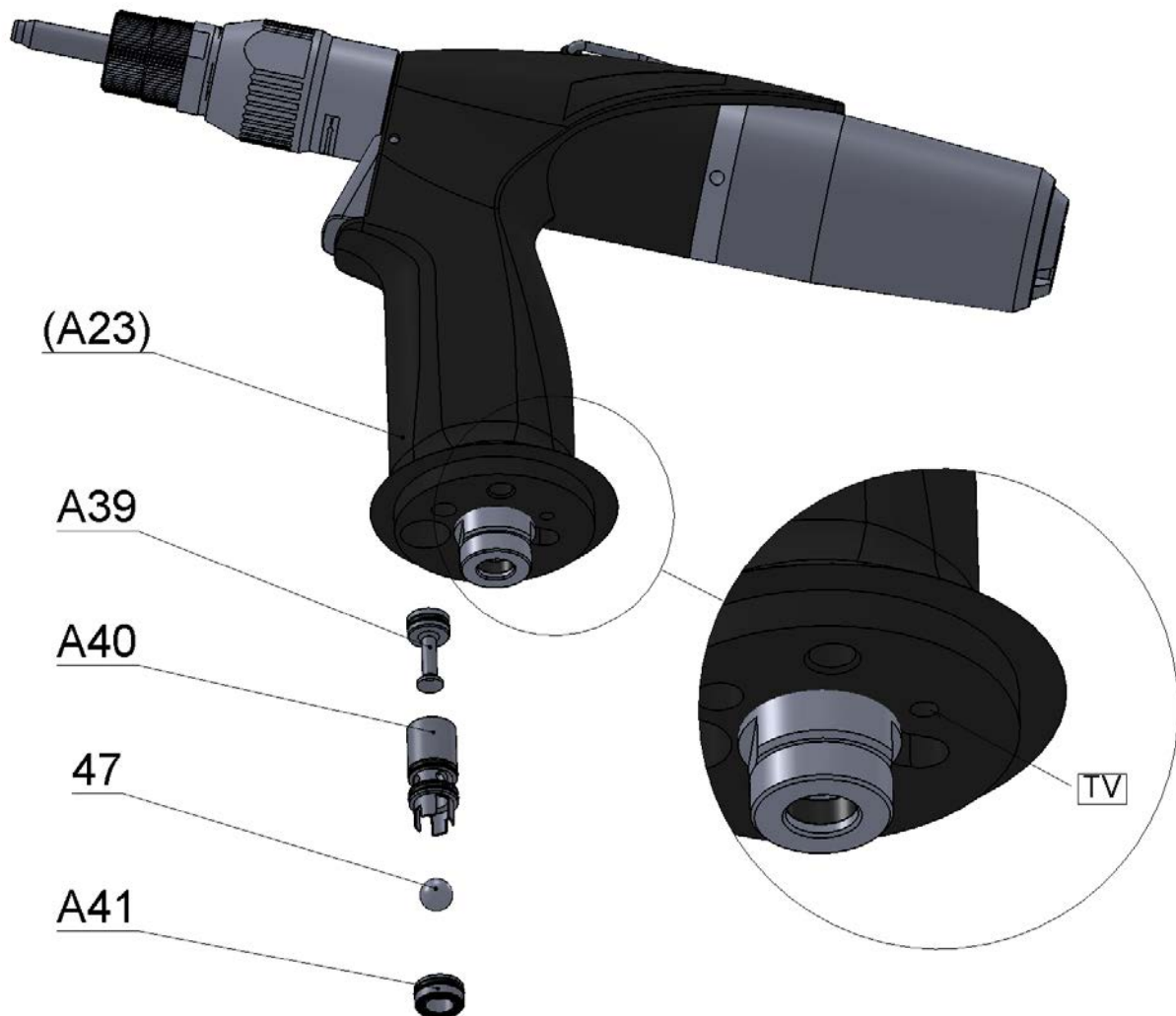
Assembly:

Put pos. 55 on pos. A47, insert pos. 66 to pos. 55. Lubricate recess in pos. 55 and insert in pos. 68 and pos. 69 and check the proper placing of pos. 68 and 69. Put pos. A47 with pos. 67, 68, 69 and pos. 55 on pos. A23, screw on pos. 50 (2x) and tighten with imbus key nr. 5.

Step 6

Disassembly:

Put the blow gun on the outlet (see the detail) and release a small amount of CA, pos. A39, A40 and A41 blow out off the pos. A23, it is necessary to catch them (e.g. to the cloth).



Assembly:

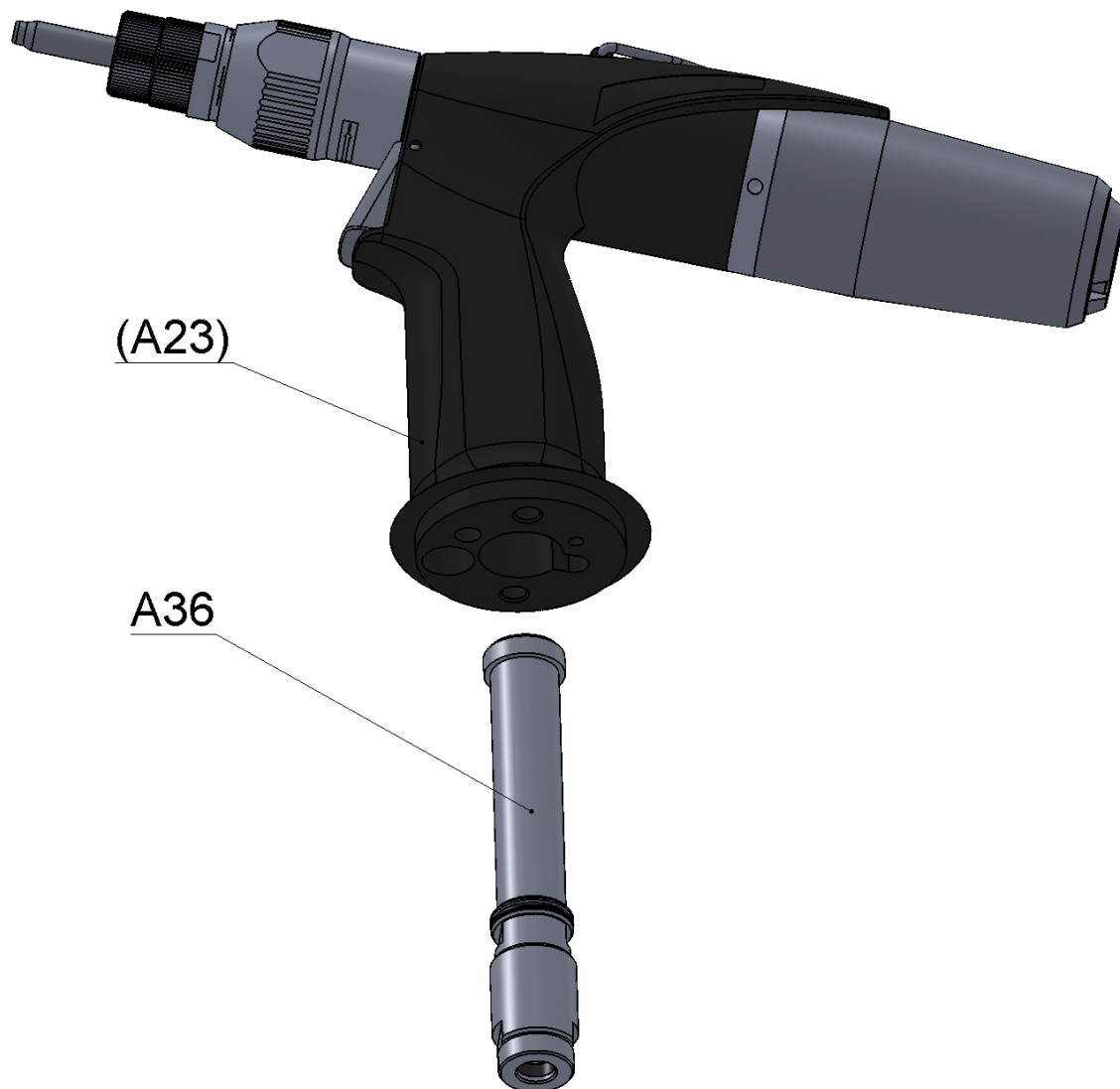
Insert pos. A39 into pos. A40 and insert this complet into pos. A23. Insert pos. 47 into pos. A40, put on pos. A41 and press to the stop to pos. A23.

! Do not lubricate pos. 47 !

Step 7

Disassembly:

Loosen pos. A36 with MP33 key, screw out and put out from pos. A23.



Assembly.

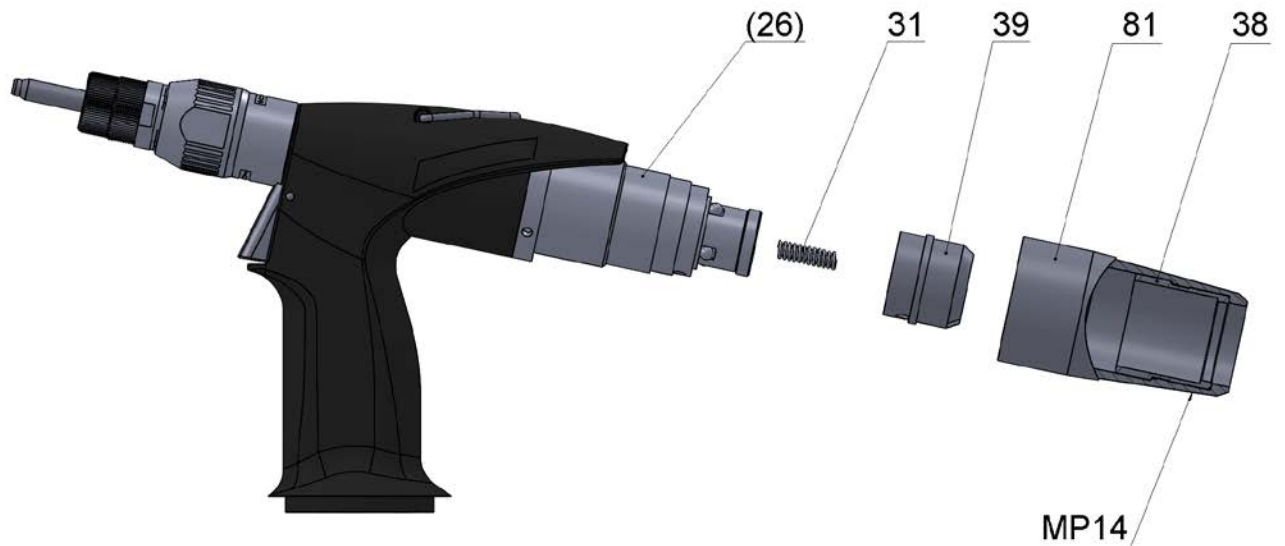
Check the sealing of pos. 40 (see Step 22). Put pos. A36 on pos. A23, screw on and tighten with MP33 key.

! Check the proper position of the sealing!

Step 8

Disassembly:

Put MP14 on pos. 81 in marked area (ending), loosen and screw out pos. 81 with pos. 38, put out pos. 39 and take out pos. 31 from pos. 26.



Assembly:

Put pos. 31 on pin pos. 39, put pos. 39 to pos. 81, screw this complete on pos. 26 and tighten with MP14.

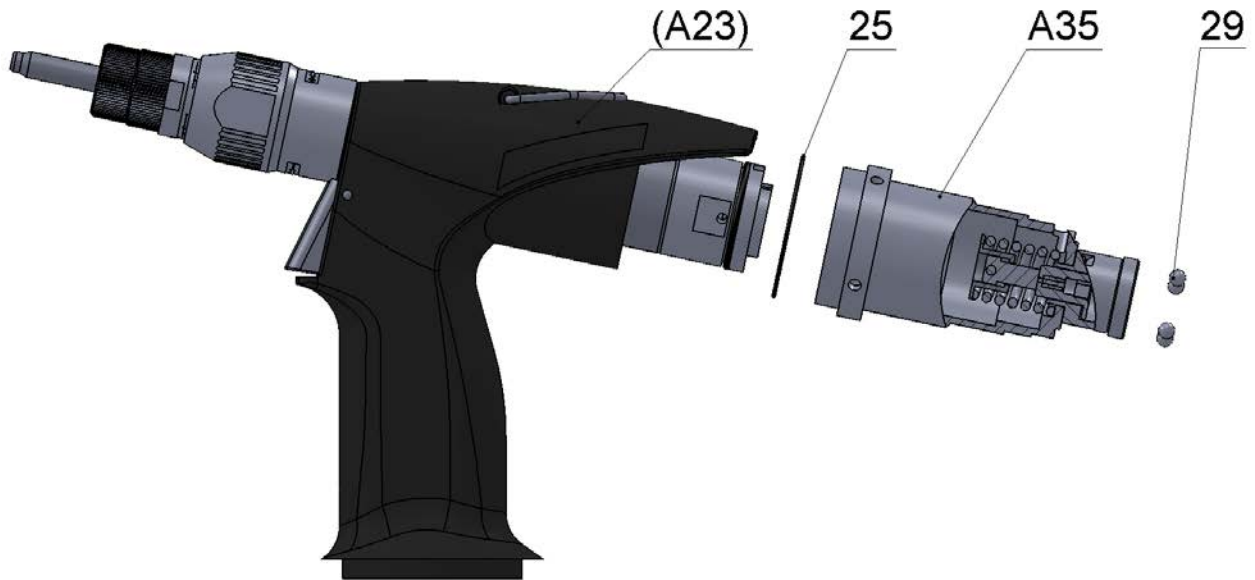
! Be careful about proper mounting of pos. 31 to pos. 39 !

Step 9

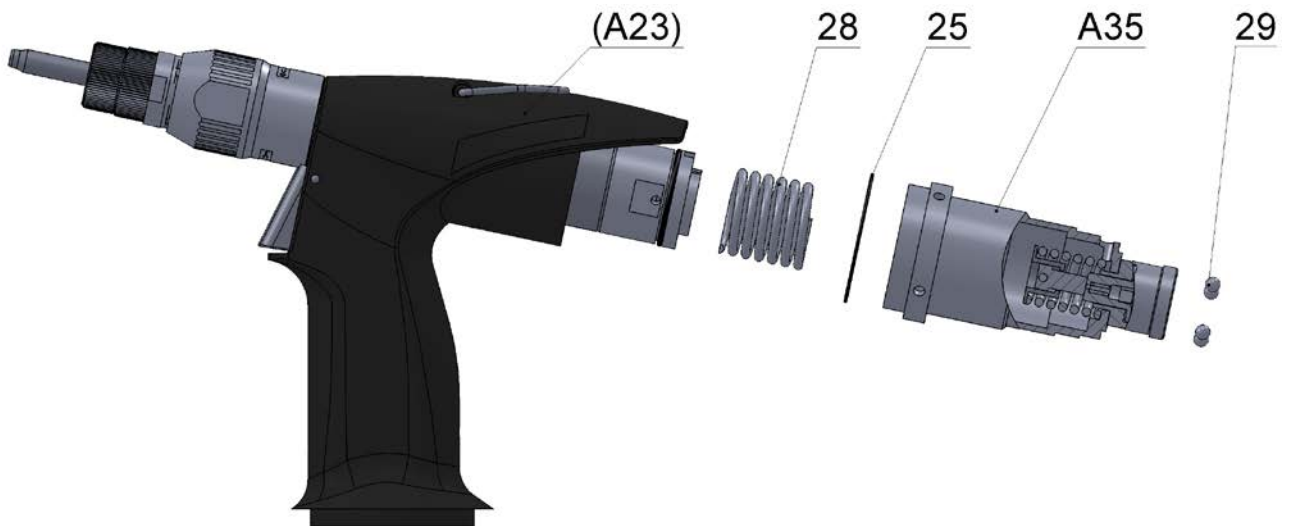
Disassembly:

Take out pos. 29 (4x) with the help of MP32. Screw out pos. A35 with pos. 25 from pos. A23 with hook spanner 30-32 (MP28). Take out pos. 25 and pos. 28 (serie 5 only)

serie 4



serie 5



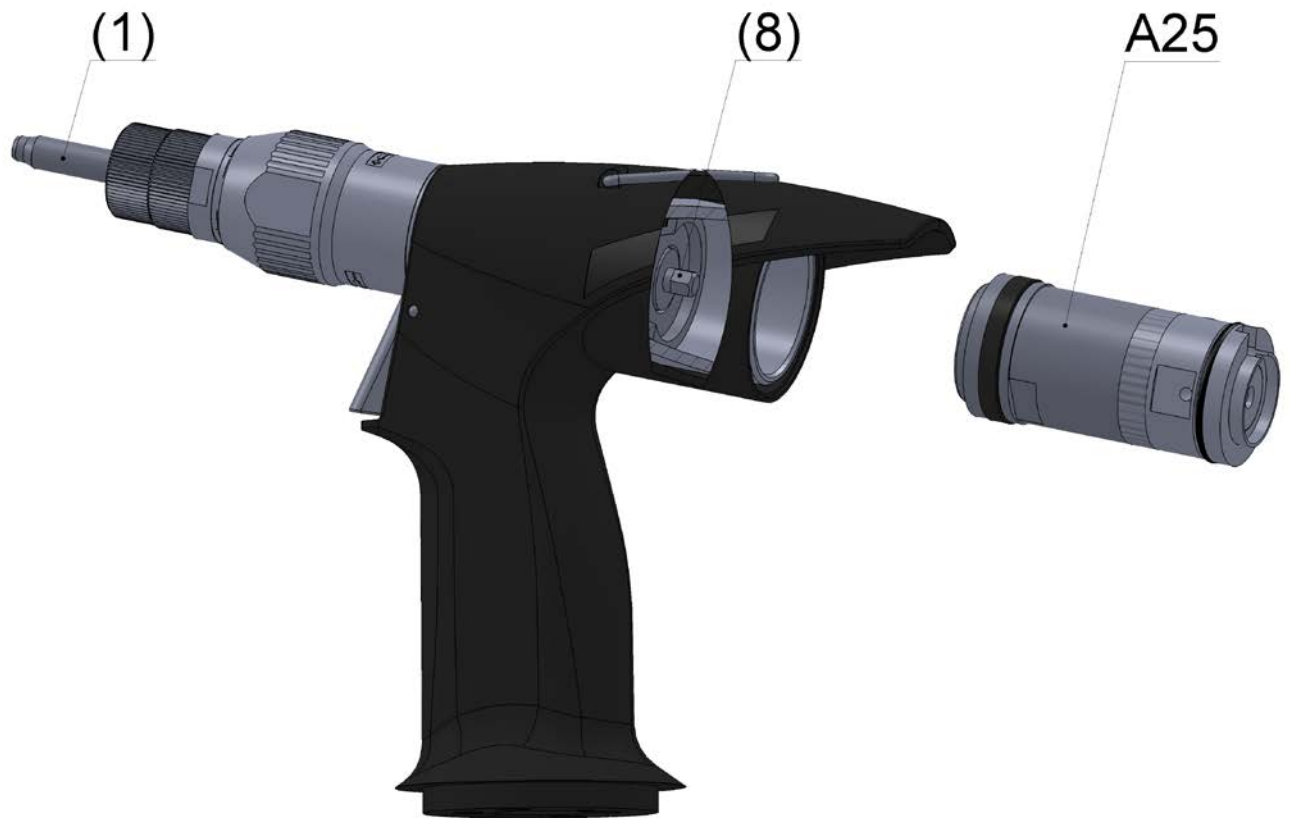
Assembly:

Put pos. 25 to pos. A35, insert pos. 28 (serie 5 only), and screw this complete into pos. A23. Then tighten pos. A35 with hook spanner 30-32 (MP28). Lubricate outlets in pos. A35 with vaseline and press pos. 29 (4x) into outlets.

Step 10

Disassembly:

Put out pos. A25



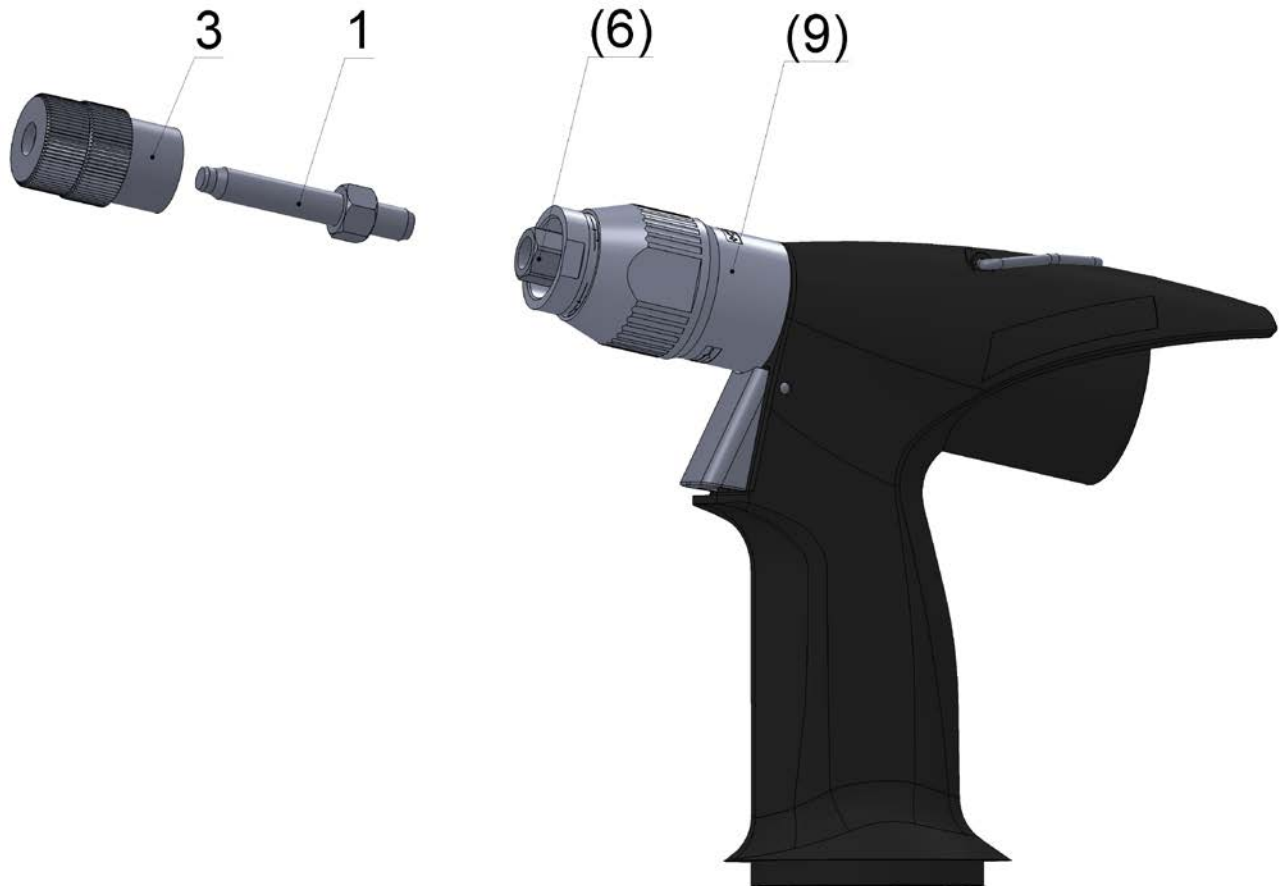
Assembly:

Put on pos. A25 and move around a slight amount so that hexagon pos. A25 and pos. 8 match, then move pos. A25 to the stop. Turn pos. 1 to check if the installation was successful, rotation in pos. A25 must be obvious and audible.

Step 11

Disassembly:

Screw out pos. 3 and pos. 1



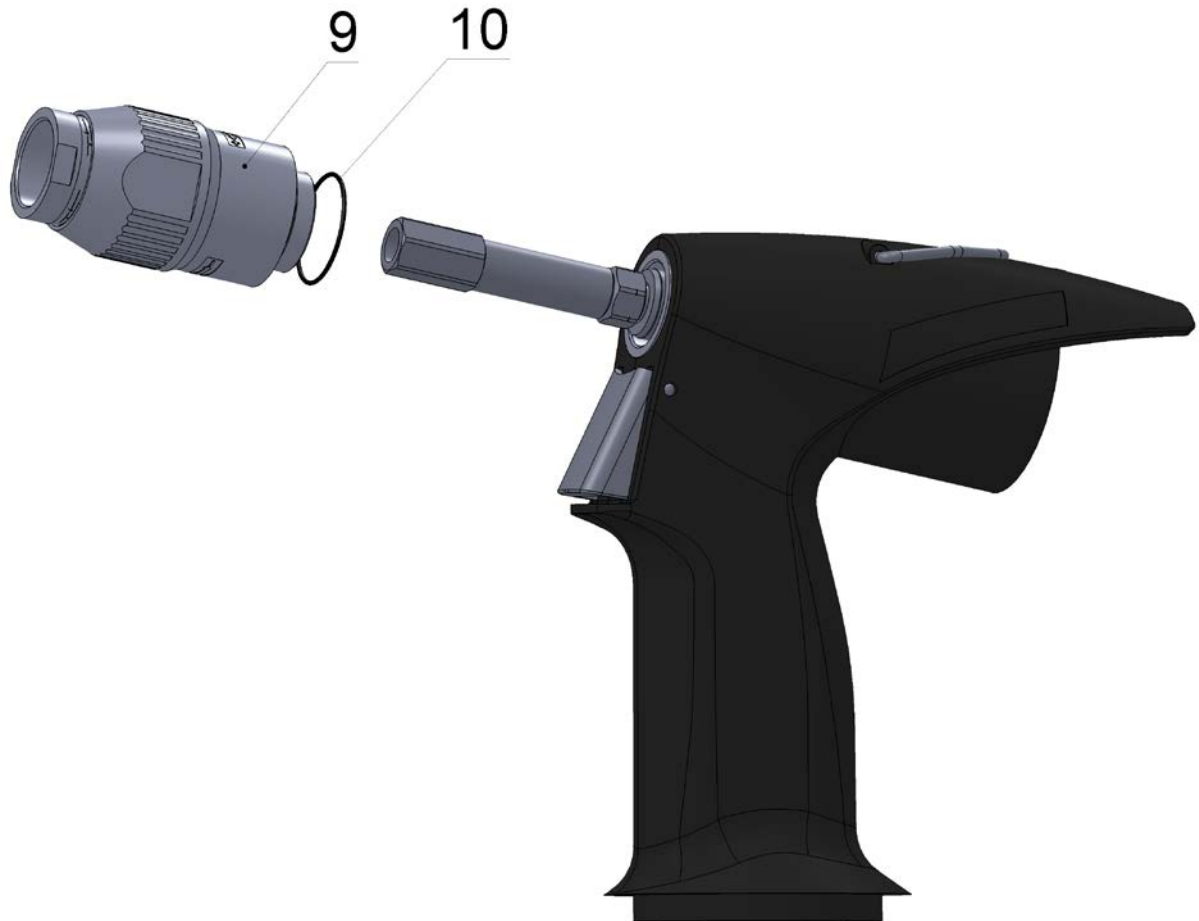
Assembly:

Screw pos. 1 on pos. 6 to the stop and move back a slight amount, so that hexagon pos. 1 and pos. 6 match. Put pos. 3 on pos. 1 and pos. 6, so that hexagon socket pos. 3 match with hexagon pos. 1 and pos. 6, screw on to pos. 9. Tighten the backnut in pos. 3 to the front of pos. 9.

Step 12

Disassembly:

Screw out pos. 9 with wrench 24 and put out pos. 10 with MP32.



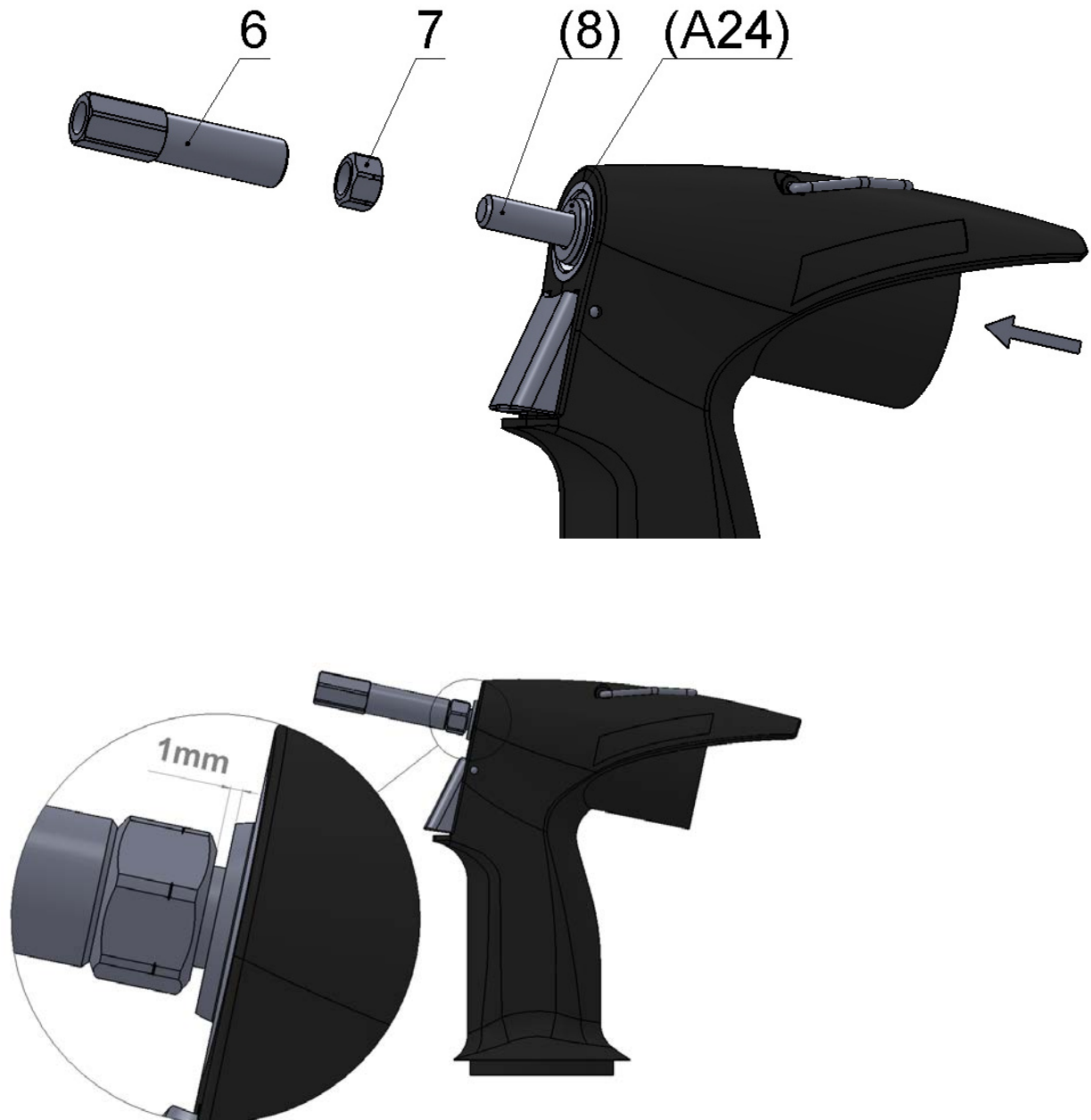
Assembly:

Put pos. 10 on pos. 9, screw on pos. 9 and tighten with wrench 24.

Step 13

Disassembly:

Put wrenches 12 (2x) on pos. 6 and pos. 7, loosen and screw out pos. 6, put hex key on pos. 8 and from the side of the dart screw out pos. 7.



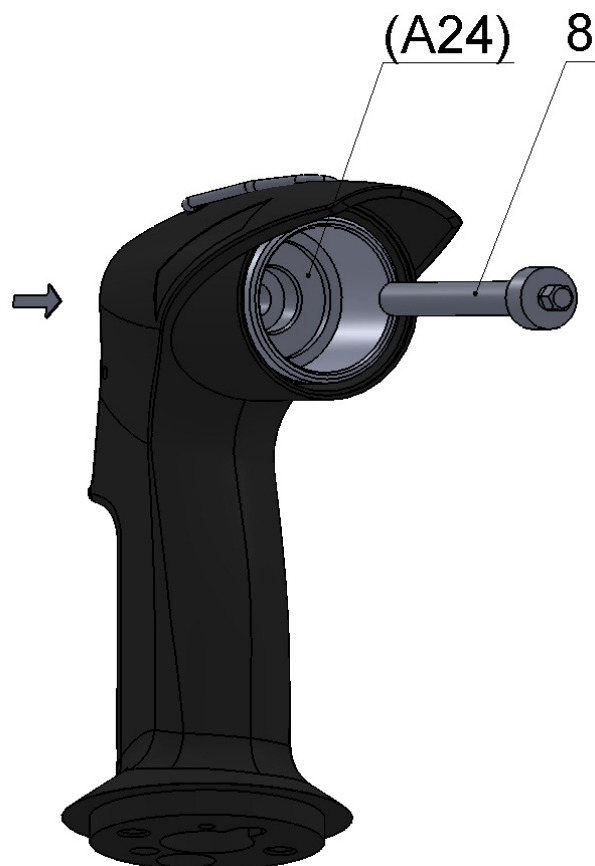
Assembly:

Screw pos. 7 on pos. 8 (recess in direction to pos. A24) so that the length between pos. 7 and pos. A24 is 1 mm (see the detail). Put several drops of glue LOCTITE 243 on thread pos. 8, screw on pos. 6, screw wrenches 12 (2x) on pos. 6 and pos. 7 and tighten towards pos. 7.

Step 14

Disassembly:

Put pos. 8 out of pos. A24 in the direction of the dart.



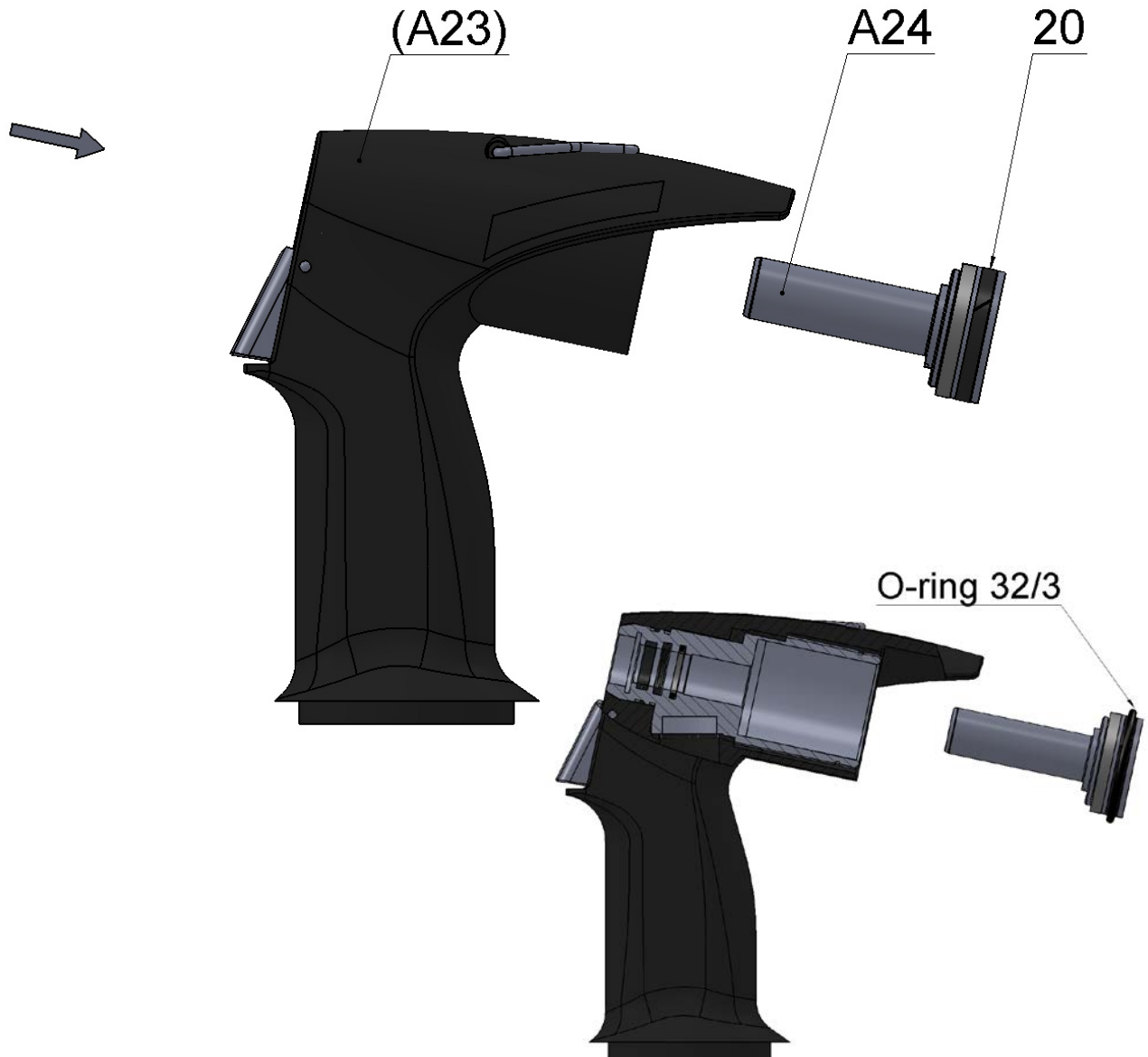
Assembly:

Put pos 8 on to pos. A24.

Step 15

Disassembly:

Put pos. A24 out of pos. A23 in the direction of the dart.
! Be careful and do not damage the sealing in pos. A23!



Assembly:

Lubricate external surface of pos. A24, inner surface of pos. A23 and related sealing of pos. A24 and pos. 23 with silicon paste LUKOSAN, secure pos. 20 in the pos. A24 with O ring 32/3 (see the picture), then insert pos. A24 to the pos. A23 to the stop, pos. A24 must slide in pos. A23.
! O ring 32/3 will loosen while inserting pos. A24 to pos. A23, it is not a part of the riveting tool!

Step 16

Disassembly:

Place a pin cca 2,8 mm in diametre to the pos. 76 and knock out with a hammer from pos. A23, put out pos. 74.



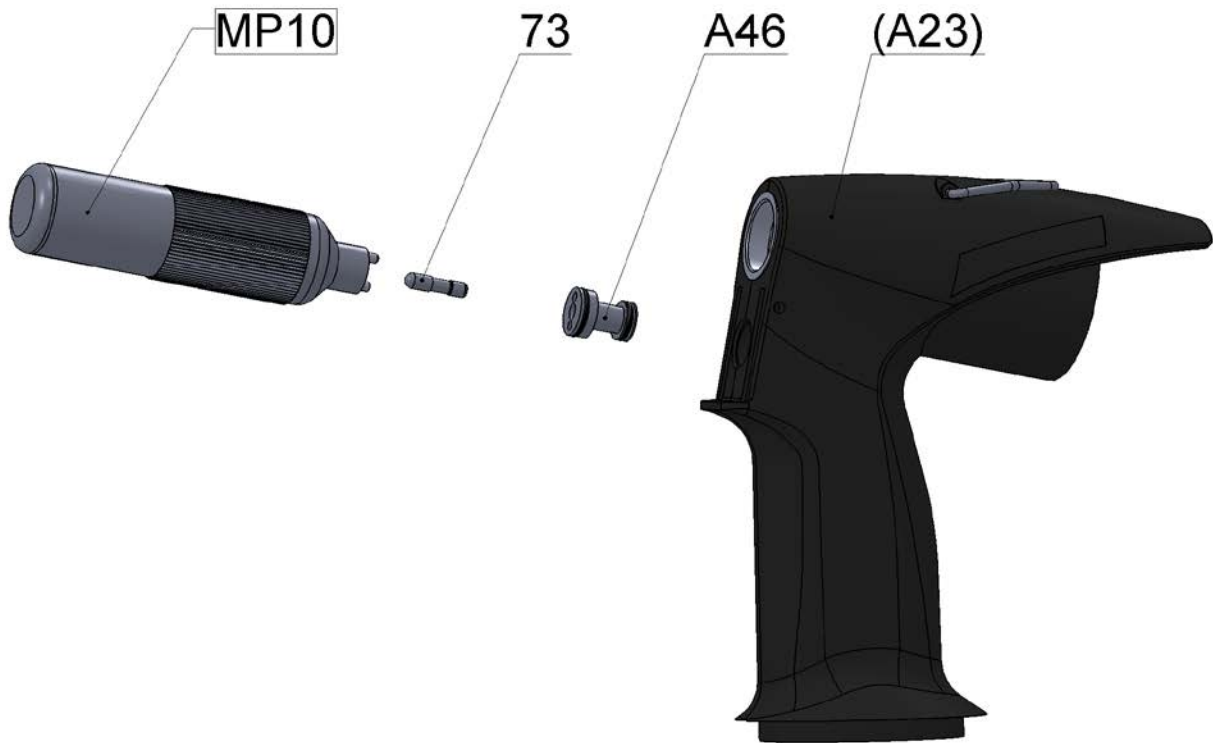
Assembly:

Put on pos. 74, put on pos. 76 and beat in with hammer and a pin cca 2,8 mm in diametre so that the pos. 76 is placed symmetrically in pos. A23. Put coloured warranty plug on pos. 76.

Step 17

Disassembly:

Put MP10 to the locks of pos. A46 and screw out together with pos. 73, take pos. 73 out of pos. A46.



Assembly:

Screw pos. A46 on pos. 23 with the help of MP10, so that the front sides of both positions were neck and neck, then insert pos. 73 to pos. A46.

Step 18

Disassembly:

Take pos. 16 out of pos. A23.



Assembly:

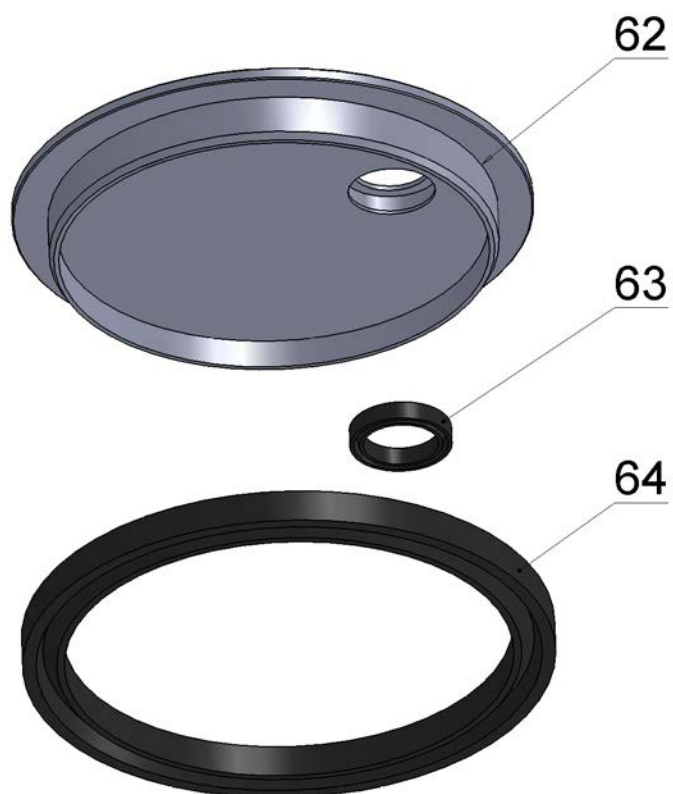
Put pos. 16 on pos. A23.

6. Instructions for assembling and disassembling of chosen sub-assemblies – steps 20-25

Step 20 – pos. A45

Disassembly:

Put pos. 64 out of pos. 62, take pos. 63 out of pos. 62 with MP32, be careful and do not damage recess in pos. 62.



Assembly:

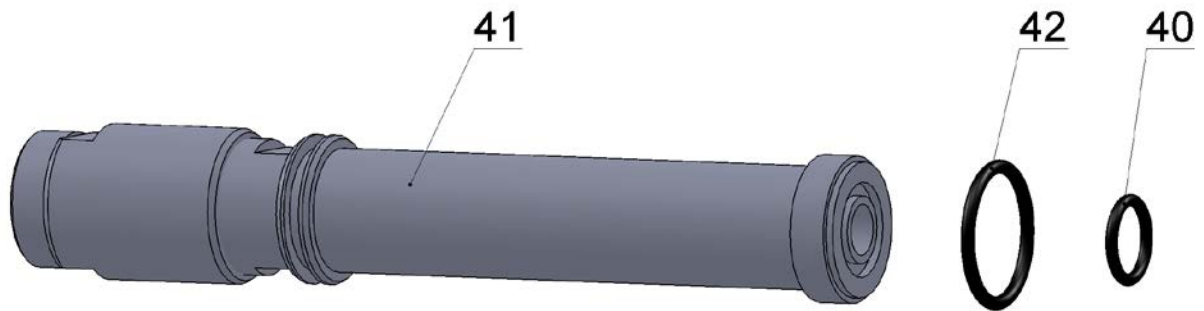
Insert pos. 63 to pos. 62 so that the pos. 63 does not twist off. Put pos. 64 to pos. 62.

Step 21 – pos. A36

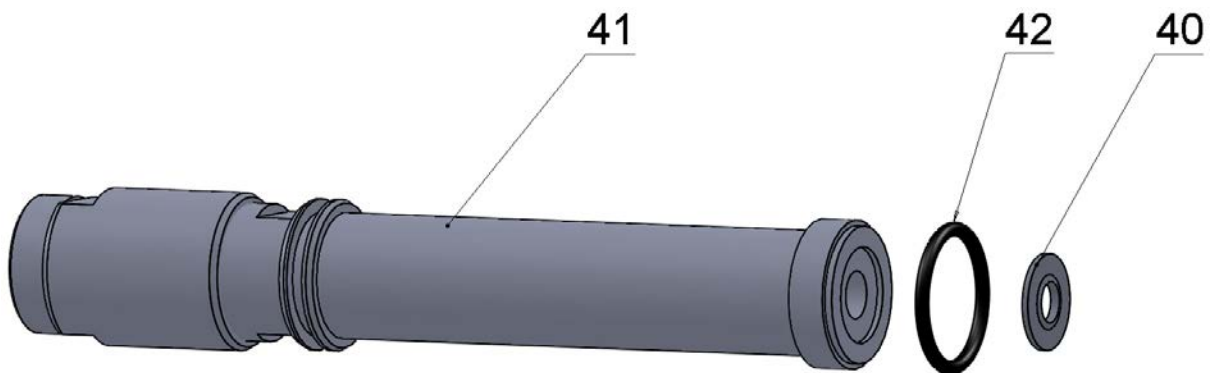
Disassembly:

Put pos. 42 and pos. 40 out of pos. 41 with the help of MP32, while putting out be careful and do not damage recess in pos. 41.

serie 4



serie 5



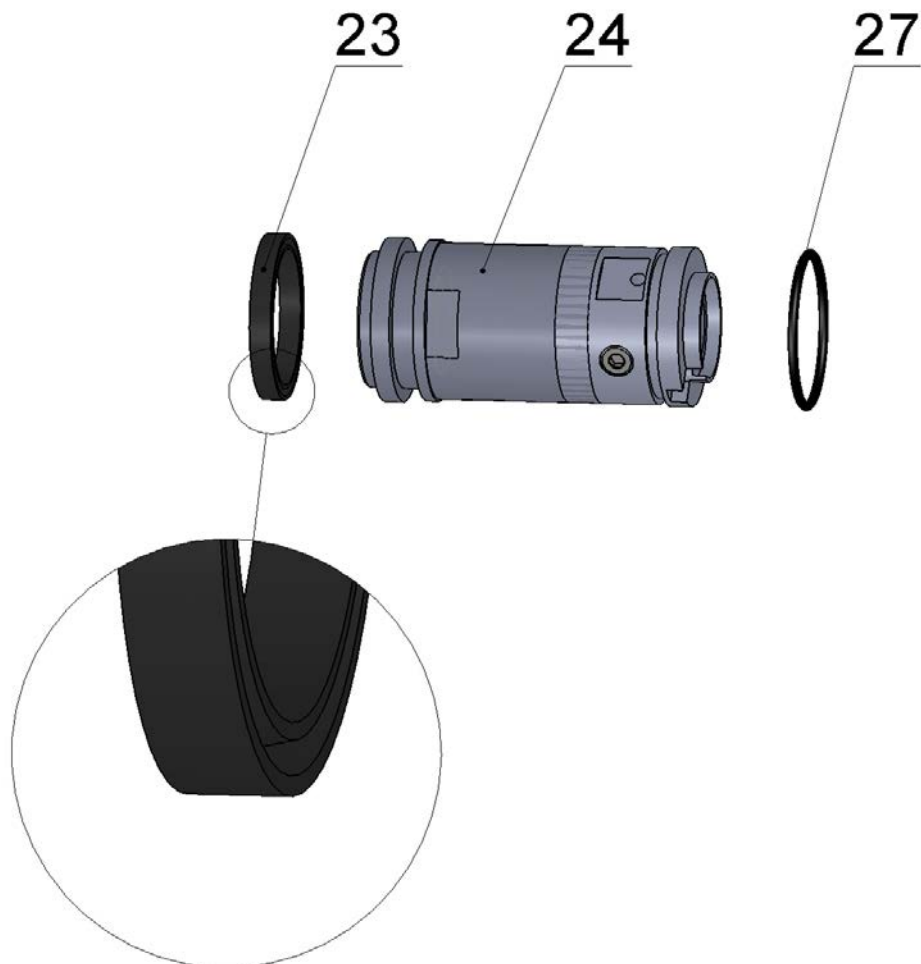
Assembly:

Put pos. 42 on pos. 41, be careful while putting it on and do not damage pos. 42 with a thread on pos. 41. Lubricate the recess in pos. 41 and put it on pos. 40.

Step 22 – pos. A25

Disassembly:

Put pos. 27 and pos. 23 out of pos. 24 with the help of MP32, while putting out be careful and do not damage recesses in pos. 24.



Assembly:

Put pos. 27 on pos. 24. Put pos. 23 into the recess pos. 24.

! Is necessary to keep the orientation pos. 23 into the recess pos. 24 according to detail !

Step 23 – pos. A47 a pos. 67

Disassembly:

Put pos. 52 and pos. 53 out of pos. 54 with MP32. Be careful and do not damage recesses in pos. 54. Put a imbus key nr. 5 into the hex. in pos. A43 and screw the complete out of pos. 54. Disassembly pos. 6705, put pos. A44 out of pos. 43



Assembly:

Put pos. A44 on pos. A43 and secure pos. 6705. Screw pos. A43 into pos. 54 and tighten with imbus key nr. 5. Insert pos. 52 and pos. 53 to recesses pos. 54.

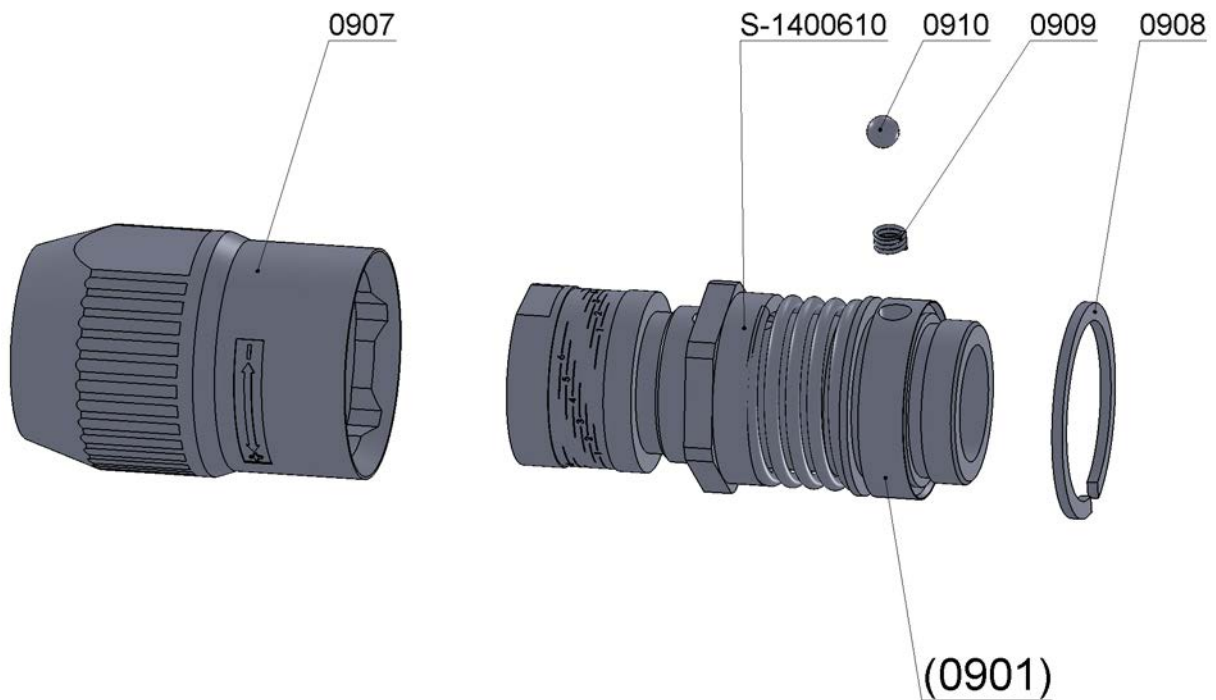
Step 24 – pos. 9

Disassembly:

Grip the set (pos. 9) into a vice and mechanically take off (break up) pos. 0907.

! Attention, wearing protective eyewear during this operation is strongly recommended!

Be careful not to damage other parts and also not to lose pos. 0910, which may be „blown out“ by interaction with pos. 0909.



Assembly:

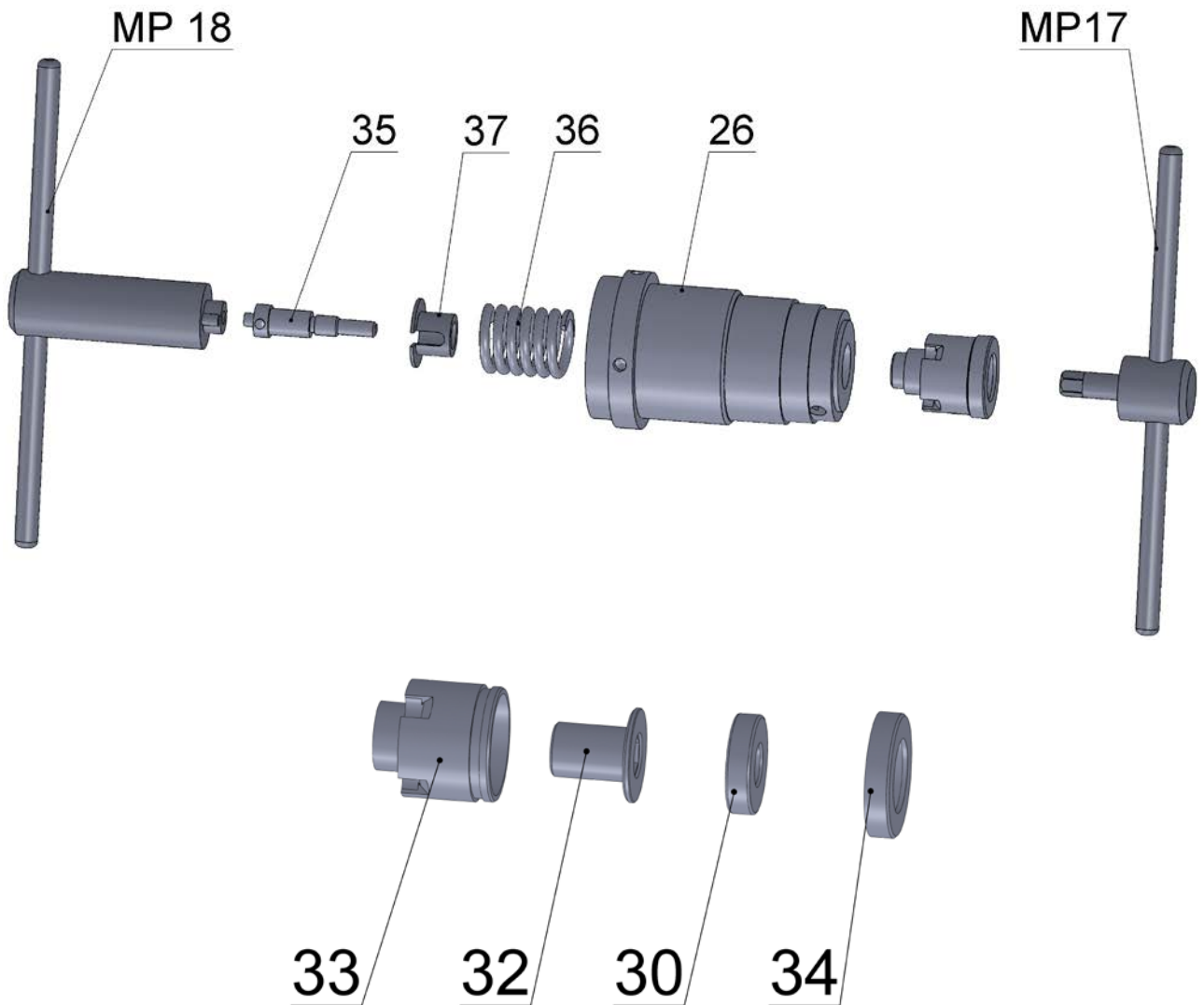
Put pos. 0908 to recess in pos. 0901, put pos. 0907, press pos. 0908 and slide it to the edge of pos. 0907. Put pos. 0909 into pos. 0901, put pos. 0910, press pos. 0909 and fix it with a finger. Than put pos. 0907 to the block and secure it with pos. 0908.

Step 25 – pos. A35

Disassembly:

Put wrench MP17 into hexagon socket pos. 32, put wrench MP18 into recess pos. 37, loosen and screw out pos. 35. Put out pos. 37, pos. 36 and pos. 26. Take pos. 34 out of pos. 33 with help MP 31. Take pos. 30 and pos. 32 out of pos. 33.

! Beware of bounce of pos. 28 from spring pos. 36 !



Assembly :

Put pos. 32 and pos. 30 into pos. 33. Press pos. 34 onto pos. 33. Put out pos. 37, pos. 36 and pos. 26 on pos. 35. Put several drops of glue LOCTITE 243 on thread pos. 35, put wrench MP18 into recess pos. 37, put wrench MP17 into hexagon socket pos. 32 and screw pos. 35 into pos. 32.

! Caution, this operation require certain force to push the spring pos. 36 !

8. List of defects of riveting tool:

D1	tears threads in the rivet nuts
D2	does not wind up or winds up slowly
D3	keeps winding up
D4	keeps winding out
D5	does not wind out or winds out slowly (while riveting)
D6	does not wind out with button
D7	does not rivet
D8	oil leaks
D9	CA distribution
D10	does not return
D11	CA leaks in pos. 74 (pos. 74 is not pressed)
D12	CA leaks in pos. 74 (pos.74 pressed)
D13	CA leaks in pos. A47 and 67 (pos. 74 is not pressed)
D14	CA leaks in pos. A47 and 67, 65 (pos. 74 is pressed)
D15	CA leaks between pos. A23 and 26jroztocil
D16	CA leaks through outlets in pos. 39

9. Description of defects and their remedies:

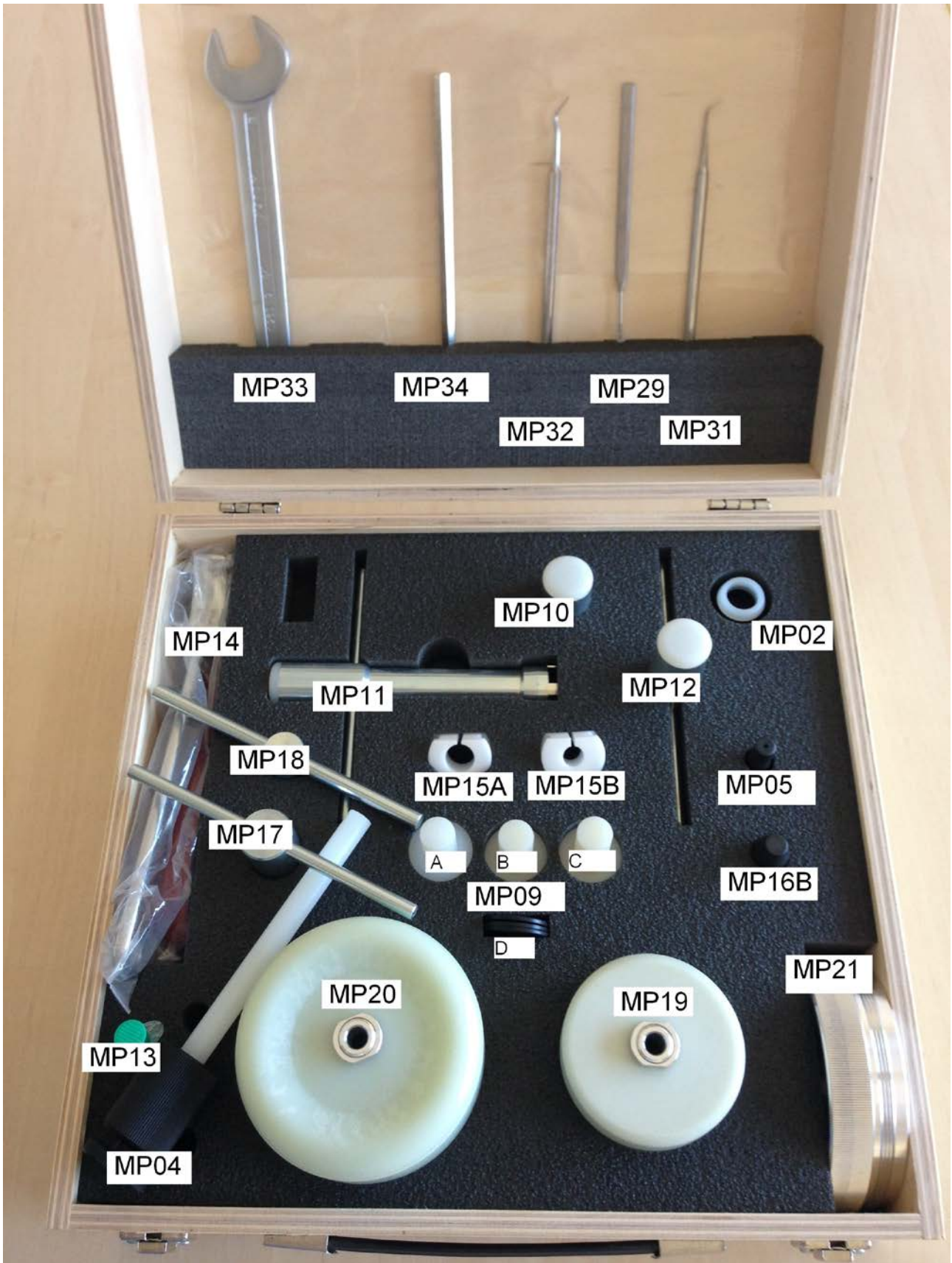
Defect	Operation	Step	Change of pos.
BEM	turn pos. 1, there must be rotation in pos. A25		
	check if pos. 1 slides freely cca 1mm		
	NO		
	disassembly pos. 3,1,9	11,12	
	check deformation of hexagon pos. 1,6,3 - must slight freely		1,3,6
	check tightening of pos. 6,7 and clearance 1 mm	13	
	check "cracking" of pos. 1,6,8		1,6,8
	disassembly to pos. 8	8,9,10,14	
	check hexagon socket in pos. A25		A25
	check pos. 8 - hexagon and if the front is not damaged		8
	- pos. A24 slides freely	15	8,A24
D1	check thread on pos. 1		
	disassembly pos. 3,1	11	1
	check stroke adjustment, pos. 3 springs in pos. 9		
	disassembly pos. 9	12	9
D2 ,3	see BEM		
D5	BEM is OK		
	disassembly pos. 8,39,31	8	
	check tightening of pos. A35	9	

	disassembly pos. A35	9	A35
D6	BEM is OK		
	disassembly pos.38,39,31	8	
	check tightening of pos. A35	9	
	check pos. 29,39,A35		29,39,A35
D4	BEM is OK		
	disassembly and check pos.38,39,31	8	31,39
	disassembly and check pos. A35,29	9	A35,29
	disassembly pos. 28,26,36,35,37	9,25	
	check pos. 35,36,37		35,36,37
	NO		
	further see D10		
D11	disassembly pos. 74	16	
	check pos. 74 and position of ajustement pos. A46 and A23	17	74
	disassembly pos. A46, 73	17	
	check quality of external surface of pos. 73 and sealing of pos. A46		73,A46
D12	everything as in D11		
D13	CA leaks in pos. 67 Yes: disassembly pos. 67	23	67
	NO		
	disassembly pos. 65+80,A45,79,50,55,A47+67	1,2,4,5	A47
	NO		
	disassembly pos. A39,A40,A41,47	6	
	check sealing of pos. A39,A40,A41		
	check surface of pos. 47 and seating pos. A41		A39,A40,A41,47
	NO		
	disassembly pos. 59, A36	3,7,21	A36,(42)
D14	disassembly pos. 65+80,A45	1,2	
	check inner surface pos. 65		65,80
	check sealing pos. A45	20	A45,(63,64)
	check external surface pos. 66	23	66
	NO		
	disassembly pos. 79,50,55,A47+67	4,5	
	disassembly pos. A39,A40,A41,47	6	
	check sealing of pos. A40		
	check surface of pos. 47 and seating of pos. A40		A40,47
D15	disassembly to pos. 26	8,9	25,26
	NO		
	disassembly all		A23
D16	BEM is OK		
	disassembly and check pos. 38,39,31	8	31,39

	disassembly pos. A35,29	9	
	disassembly pos. 28,26,36,35,37	9,25	
	check pos. 35 (fron),26 (inner surface)		35,26
	NO		
	disassembly pos. A25	10	
	disassembly pos. 27	22	27
	NO		A25
D7	disassembly pos. 3,1,9	11,12	
	check "cracking" pos. 1,6,8		1
	if pos. 6 damaged, disassembly	13	6
	if pos. 8 damaged, disassembly	8,9,10,14,13	8
	NO		
	press and release pos. 74		
	NO outlet from pos. A47		
	further see D9		
	YES outlet from pos. A47		
	further see D8		
D8	disassembly pos. 65+80,A45,61,60	1,2,3	
	fill in hydraulic oil	3	
	if necessary disassembly all		
	check functional surfaces and sealing of pos. A23,A24,A36,59		A23,A24,A36,59
D9	accomplish steps - see D11, D12, D13, D14		
D10	press and release pos. 74		
	NO outlet from pos. A47		
	further see CH9		
	YES outlet from pos. A47		
	disassembly to pos. 36	8,9,25	
	check pos. 36		36
	NO		
	disassembly all		
	check functional surfaces and sealing of pos. A23,A24,A36,59,65,A45		A23,A24,A36,59,65,A45

10. Service set:

Order Nr. of service set is S-1002002.



Service stand for assembling and disassembling of riveting tool is not piece of service set.
Order Nr. of service stand is S-1005000.



11. List of special tools in the service set:

<i>S-1002002 Service set for AP tool (version 2016)</i>				
<i>Marked</i>	<i>Article Nr.</i>	<i>Pcs/set</i>	<i>Name of special tool</i>	<i>Specified for riveting tool</i>
MP02	S-1002020	1	Threader MP02	SERIE 1, SERIE 2, SERIE 3
MP04	D-1003040	1	Adjustable stop MP04ABC	SERIE 1, SERIE 2, SERIE 3
MP05	D-1002050	1	Threader MP05	SERIE 1, SERIE 2, SERIE 4
MP09A	D-1003090	1	Stop MP09A	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP09B	D-1003091	1	Stop MP09B	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP09C	D-1003092	1	Stop MP09C	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP09D	D-1003095	3	Stop washer MP09D	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP10	S-1002100	1	Wrench MP10	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP11	S-1002110	1	Wrench MP11	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP12	S-1002120	1	Wrench MP12	SERIE 1, SERIE 2, SERIE 3
MP13	S-1002130	1	Oil filling tool MP13	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP14	N-5200900002140	1	Belt wrench 23/600	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP15A	D-1002150	1	Sleeve MP15A	SERIE 1, SERIE 2, SERIE 3
MP15B	D-1002151	1	Sleeve MP15B	SERIE 4
MP16B	D-1002161	1	Threader MP16B	SERIE 1, SERIE 2, SERIE 3
MP17	S-1002170	1	Wrench MP17	SERIE 4
MP18	S-1002180	1	Wrench MP18	SERIE 4
MP19	S-1002190	1	Oil filling tool MP19	SERIE 1, SERIE 4
MP20	S-1003200	1	Oil filling tool MP20	SERIE 2, SERIE 3
MP21	D-1003205	1	Oil filling reduction MP21	SERIE 3
MP28	N-4900000003032	1	Hook spanner 30/32	SERIE 4
MP29	N-5200900002330	1	Dissecting needle	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP31	N-5200900002310	1	Twin ball- burnisher	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP32	N-5200900002320	1	Twin float	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP33	N-4900000000002	1	Nut wrench 19 spec.	SERIE 1, SERIE 2, SERIE 3, SERIE 4
MP34	N-4100000000007	1	Imbus key 7 ISO 2936	SERIE 3

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