

Repair manual (version 1)

- *specified for riveting tools serie 865 (MS 865, XGrip N09QI)*

Obsah:

1. Abbreviations
2. General instructions
3. Proper function of riveting tool
4. Assembly drawing of riveting tool
5. Informative list of spare parts of riveting tool
6. Instructions for assembling and disassembling – steps 1-11

1. Abbreviations:

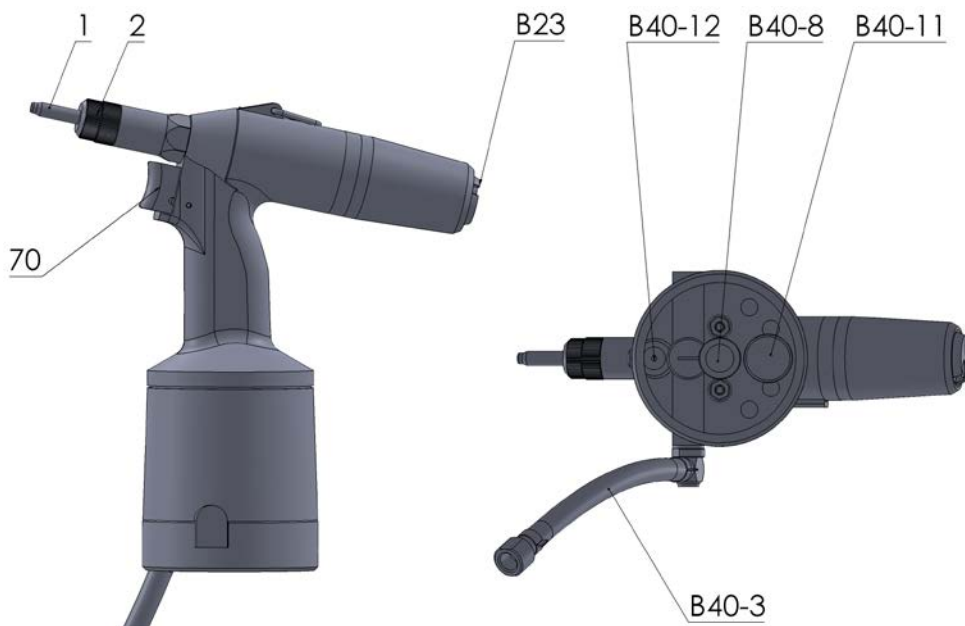
CA - compressed air

MP - special tool (assembly jig)

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 8) 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 without hairs
5. While assembling, lubricate the sealing (O-rings, pneumatic seals) and related opposite surfaces with grease EP 2 (KP2K-30 according to DIN 51502), unless stated otherwise

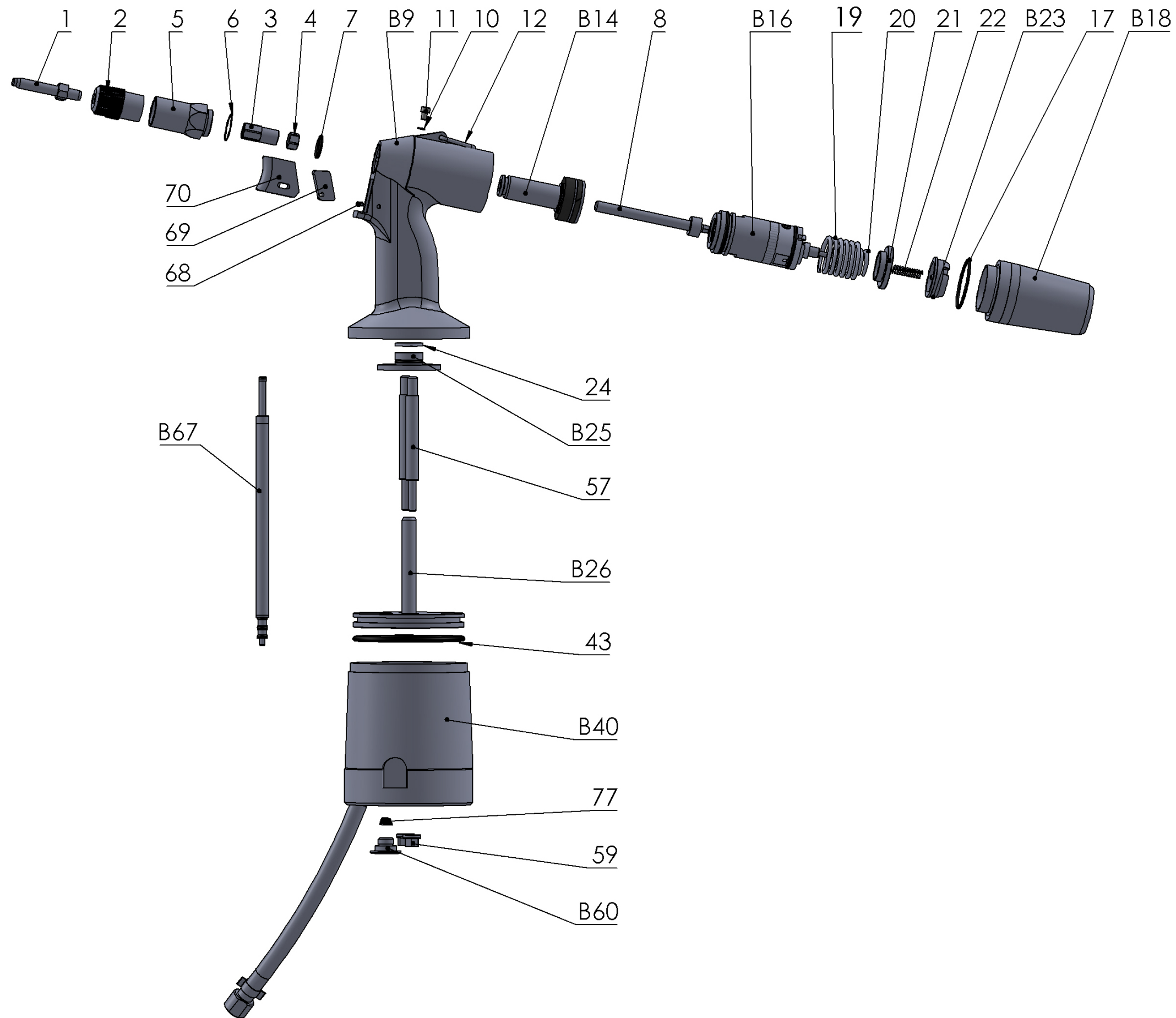
3. Proper function of riveting tool:



Operator activity	Tool function
Connect the riveting tool to CA, if the tool is equipped with main valve, turn it on. Pos. 70 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. 23
The action is ready when the rivet is completely screwed on	Motor turns off, front of the rivet touches front of the pos. 2. CA does not leak
Press with hand pos. 23, the rivet screws out	Motor turns left, outlet of CA through the outlets in pos. 23
Release pos. 23, screwing out stops	Pos. 23 gets back to the initial position, motor turns off, air does not leak
Turn with stroke force adjustment according to arrow direction +/- . Further instructions are in the Operations manual	The indicator of the manometer moves
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. 23, when the rivet is completely screwed on the motor turns off
Press pos. 70, the rivet is riveted in	The rivet is deformed, the movement ends when the set stroke force is reached
Stop pressing pos. 70, the rivet completely screws out	CA outlets from the space pos. B40, pos. 1 gets back, the motor turns, outlet of CA through the outlets in pos. 23, in the end motor stops itself, CA does not leak



4. Assembly drawing of riveting tool:



5. Informative list of spare parts of riveting tool:

Pozice	Číslo dílu	Název dílu	Ks
3	D-08650400	Joint sleeve	1
4	D-1400500	Contra-nut	1
5	D-08650600	Front nozzle	1
6	N-2103701600125	O - ring 16/1,25 Sh 70	1
7	N-2103701430240	O - ring 14,3/2,4 Sh 70	1
8	D-1401000	Šroub tažný	1
9	S-08651900	Hydraulic body complete	1
	0901 D-08651900	Hydraulic body	1
	0902 N-2104001800220	O - ring 18/2,2 VITON	1
	0903 N-2040000000180	Stepseal 18	1
	0904 D-08651200	Guiding band 18	1
10	N-2103900400150	O - ring 4/1,5 Sh 90	1
11	N-1000091204060	Screw M4x6 imbus DIN 912 Zn	1
12	D-06401300	Hanger	1
14	S-08650900	Hydraulic piston complete	1
	1401 D-08650900	Hydraulic piston	1
	1402 N-2300007342283	Lip seal 34x22x8,3 (red color)	1
	1403 D-1406200	Guiding band 35	1
16	S-08655000	Motor complete	1
17	N-2103703600200	O - ring 36/2 Sh 70	1
18	S-08652700	Rear screwing complete	1
	1801 D-08652700	Rear screwing	1
	1802 D-08652800	Cover	1
19	D-08651500	Compression spring	1
20	D-08411500	Compression spring	1
21	D-08655600	Push button piston	1
22	D-08700001	Compression spring	1
23	S-08655500	Push button complete	1
	1801 D-08655500	Push button	1
	1802 N-370000100400	Filtr SB Fi 10x4 mm/E	2
24	D-08653300	Washer PP	1
25	S-08653200	Cover plate complete	1
	2501 D-08653200	Cover plate	1
	2502 N-2040000000110	Stepseal 11	1
	2503 N-2103701310262	O - ring 13,1/2,62 Sh 70	1
	2504 D-08653400	Guiding band 11	1
	2505 N-2104001800220	O - ring 18/2,2 VITON	1
26	S-08653000	Pneumatic plunger complete	1
	2601 D-08653000	Pneumatic plunger	1
	2602 D-06404200	Adjusting ring	3
	2603 N-2103701000200	O - ring 10/2 Sh 70	3
40	S-08650700	Pneumatic cylinder complete	1
	4001 D-08650700	Pneumatic cylinder	1
	4002 D-08654302	Bottom ring – red color	1
	4003 S-08654201	Aircoupling	1
	4004 D-08653800	Pressure regulation body	1
	4005 N-2103701717178	O - ring 17,17/1,78 Sh 70	2
	4006 D-08600601	Piston of stroke valve	1
	4007 N-2103701000220	O - ring 10/2,2 Sh 70	1
	4008 N-2104000700200	O - ring 7/2 VITON	1
	4009 D-08600604	Spring	1
	4010 D-08653900	Pressure regulation key	1
	4011 N-8400000086504	Sticker of regulation key	1
	4012 D-08600800	Screw joint of pressure gauge	1
	4013 N-2103700975178	O - ring 9,75/1,78 Sh 70	1
	4014 N-9140000000001	Pressure gauge	1
	4015 N-8400000086506	Sticker of regulation scale	1
	4016 N-2103700700120	O - ring 7/1,2 Sh 70	1
	4017 S-08653700	Outlet regulation	1
43	N-2103708214353	O - ring 82,14/3,53 Sh 70	1
57	D-07403700	Connecting screw	2
59	N-1102143100008	Collar nut M6 DIN 6331 - Zn	2
60	S-08654300	Nut cap complete	1
67	S-07405100	Valve pin complete	1
68	N-1300000703200	Dowel pin 3 x 20 DIN 7	1
69	D-07415400	Excentric trigger	1
70	D-07415503	Trigger	1
77	D-07404600	Compression spring	1
80	D-06400002	Serial number CE label	1
85	N-8400000086501	Sticker of type XGrip N09QI	1
86	N-8400000086502	Sticker of producer	1

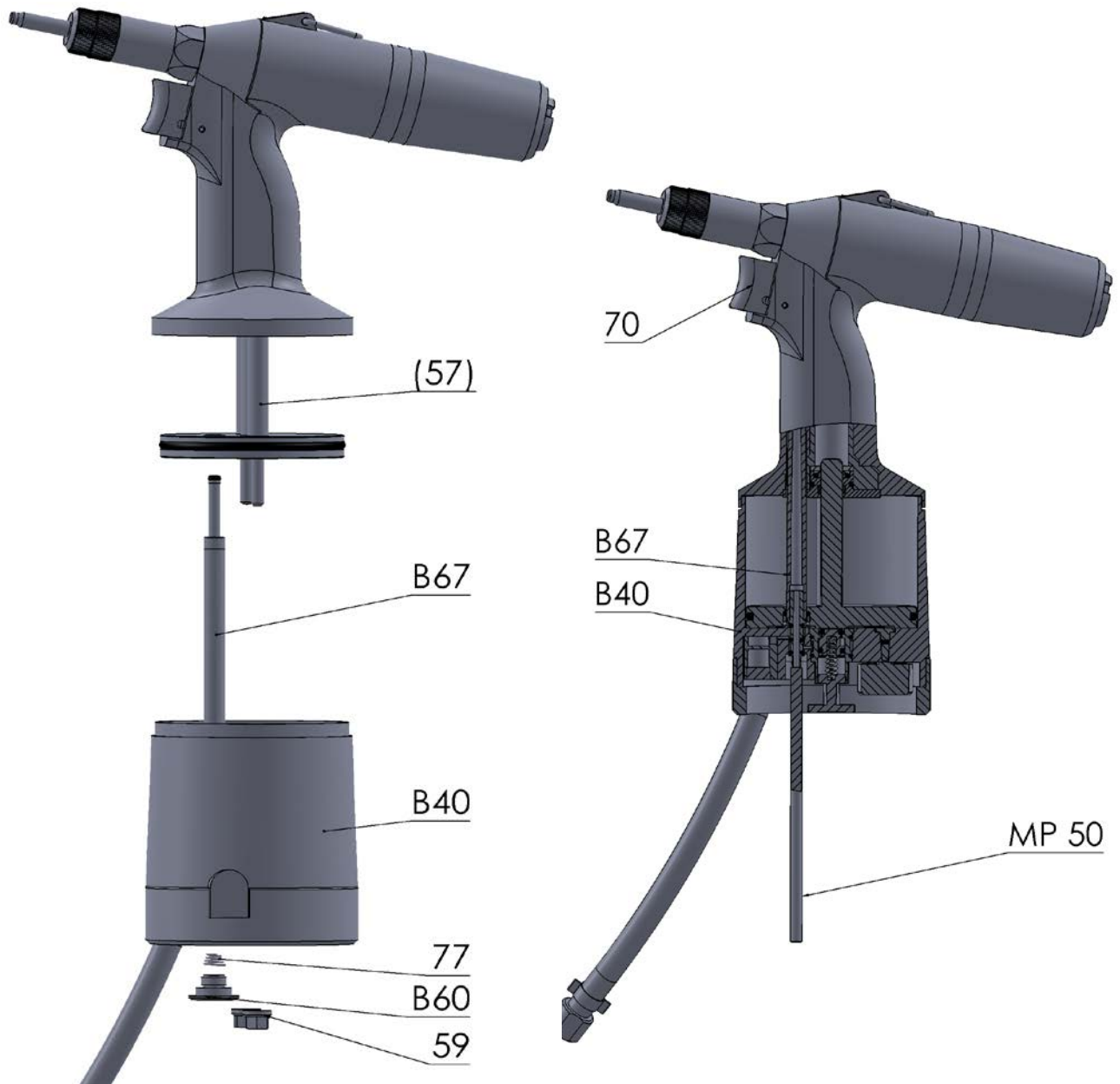
6. Instructions for assembling and disassembling – steps 1-11:

Step 1

Disassembly:

Loosen and screw out pos. 59 (2x) with using tommy bar 10, loosen and screw out pos. B60 with using screwdriver and put pos. 77 out.

Put pos. B40 with pos. B67 out off pos. 57 (2x), put pos. B67 out off pos. B40.

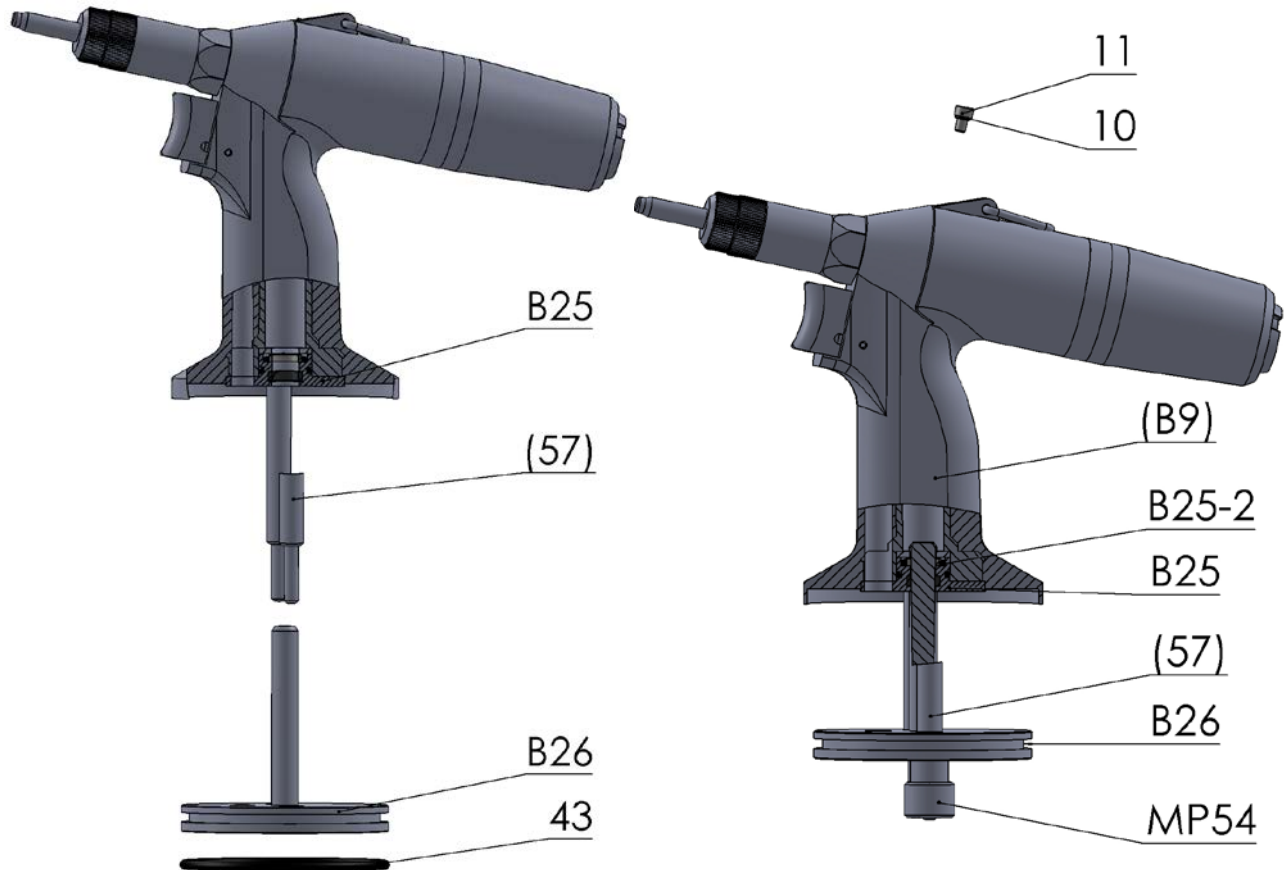


Assembly:

Put pos. B67 into pos. B40 and this complete put on pos. 57 (2x), screw on pos. 59 (2x) and tighten. Attach the MP50 to the bottom of the B67, press pos. 70, pos. B67 moves „down“, release pos. 70 and push to MP50. Pos. B67 must slide slightly. Put pos. 77 to recessing on the lower part pos. B67, screw pos. B60 into pos. B40. Pos. 59 (2x) secure with paint.

Step 2**Disassembly:**

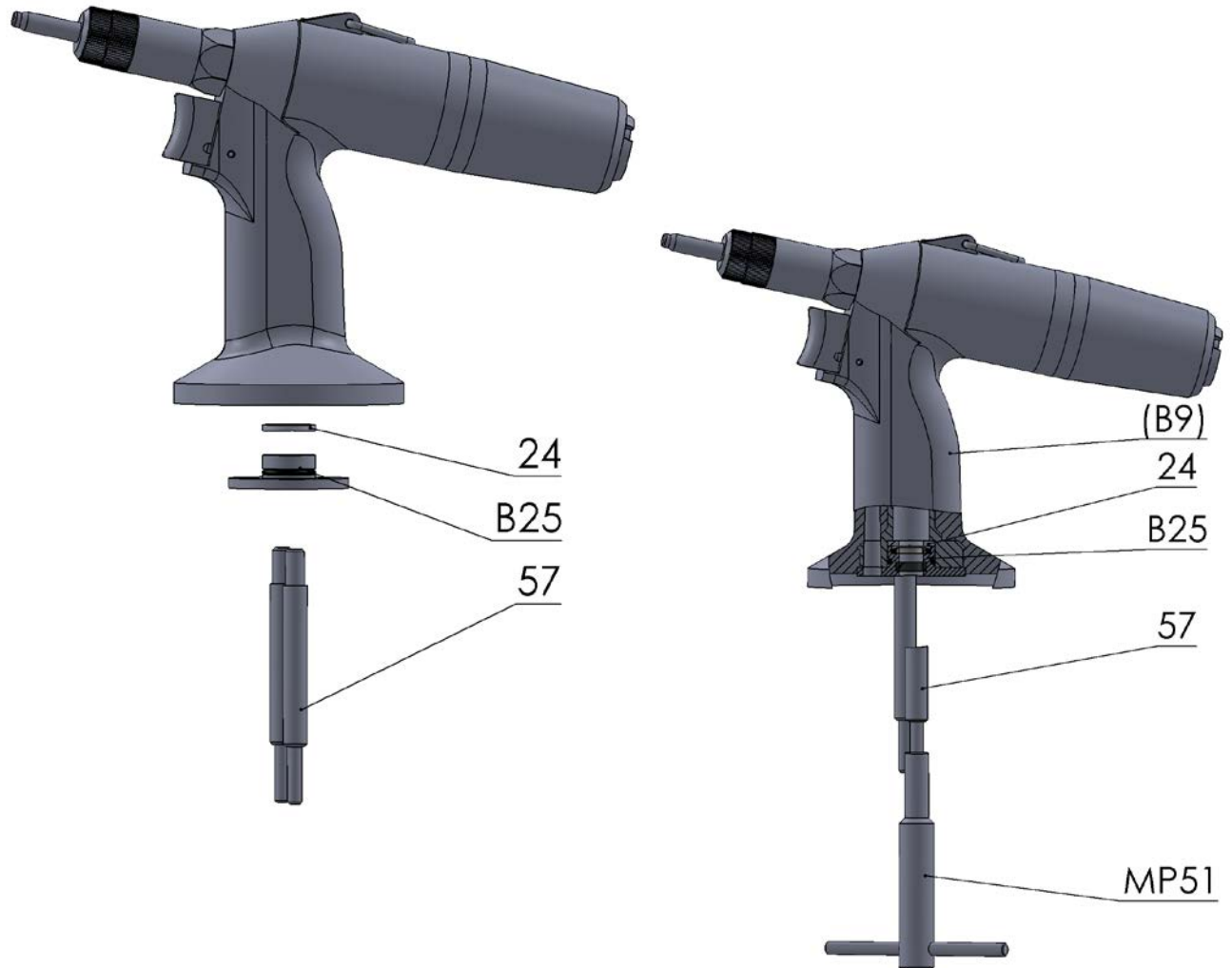
Put pos. B26 with pos. 43 out of pos. B25 and pos. 57 (2x), put pos. 43 out of pos. B26. Then pour out the hydraulic oil from the riveting tool to the suitable container.

**Assembly:**

Pour hydraulic oil into pos. B9 (we recommended hydraulic oil HYSPIH AWHM 32 CASTROL or hydraulic oils grade HLP ISO VG 32), oil level up to 2. sealing (pos. B25-2) into pos. B25. Put pos. B26 on pos. 57 (2x) and into pos. B25. Then press and release pos. B26 toward pos. B9 cca 30 mm and wait until air bubbles stop leaking from the hydraulic system. After filling oil into hydraulic system of riveting tool (oil level up to 2. sealing (pos. B25-2) into pos. B25) press and release pos. B26 toward pos. B9, release pos. B26 and wait until air bubbles stop leaking from the hydraulic system (repeat this Step if necessary). Filling oil into hydraulic system of riveting tool. External surface pos. B26 lubricate with silicon paste LUKOSAN, put pos. B26 on and screw MP54 on pos. 57 to the stop position. Screw pos. 11 (ev. pos. 11 with pos. 10) out of pos. B9 with using socket-screw key no.3. Surplus oil leaks from pos. B9, screw pos. 11 with pos. 10 back to pos. B9 and tighten with using socket-screw key no.3. Take off MP54.

Step 3**Disassembly:**

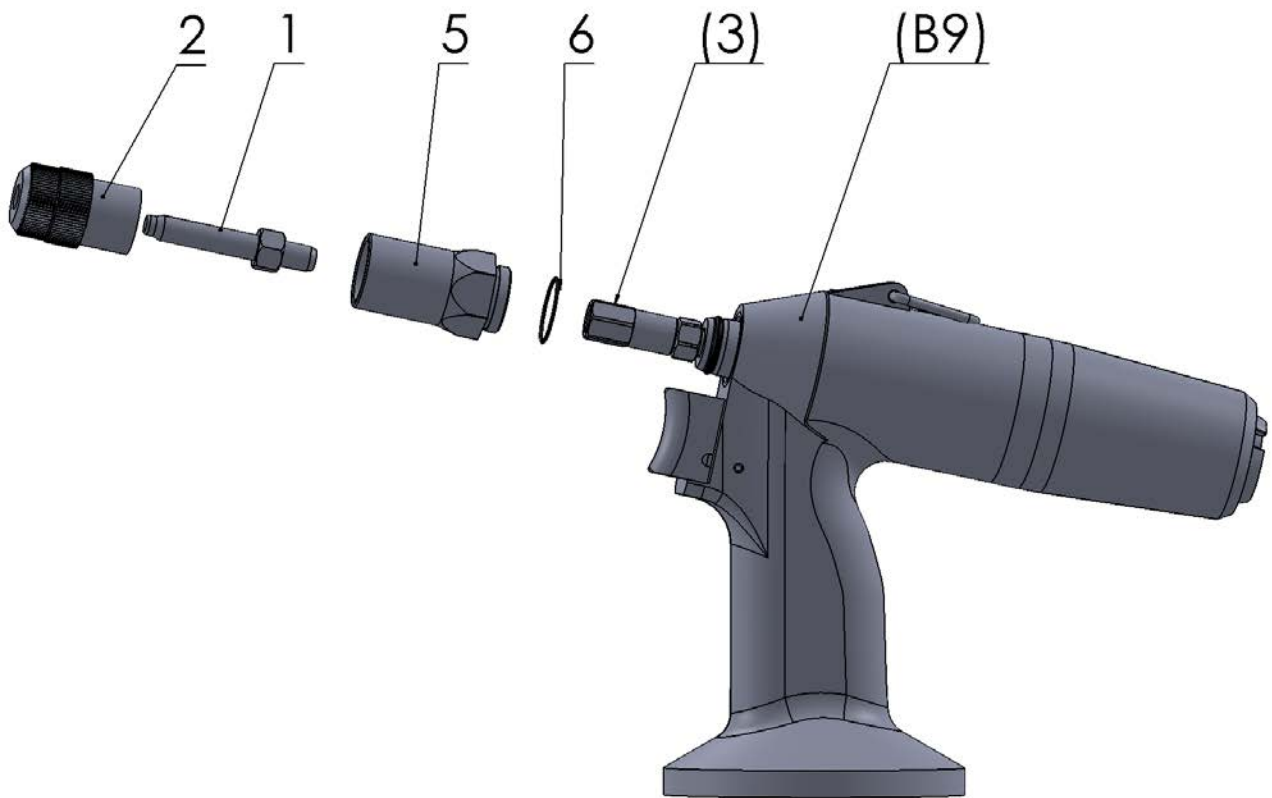
Loosen and screw out pos. 57 (2x) with using nut and contranut on thread M6. Remove nut and contranut and screw pos. 57 (2x) to pos. B25 (thread M6). Pull both pos. 57 and pos. B25, put pos. 24 out.

**Assembly:**

Put pos. 24 into pos. B9 groove to each other, put pos. B25 and screw pos. 57 (2x) on and tighten with using MP51.

Step 4**Disassembly:**

Screw pos. 2 and pos. 1 out. Screw pos. 5 out of pos. B9 with using wrench 24 and put pos. 6 out with using MP32.

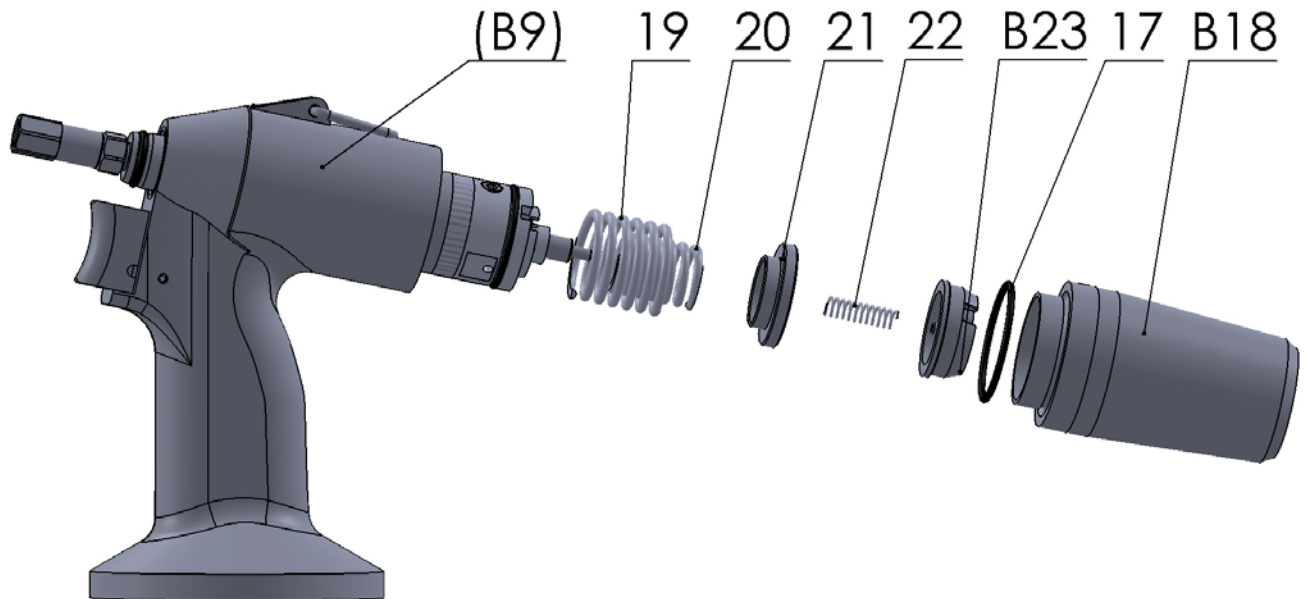
**Assembly:**

Put pos. 6 on pos. 5, screw pos. 5 to pos. B9 and tighten with using wrench 24. Screw pos. 1 on pos. 6 to the stop and move back a slight amount, so that hexagon pos. 1 and pos. 3 match. Put pos. 2 on pos. 1 and pos. 3, so that hexagon socket pos. 2 match with hexagon pos. 1 and pos. 3, screw on to pos. 5. Tighten the backnut in pos. 2 to the front of pos. 5.

Step 5

Disassembly:

Screw pos. B18 out of pos. B9 with using adjustable hook spanner 35-50. Be carefull, pos. B18 is under spring pressure pos. 19 and pos. 20. Gradually slide pos. 19, pos.20, pos. 21, pos. 22, pos. 23 out and put pos. 17 out with using MP32.

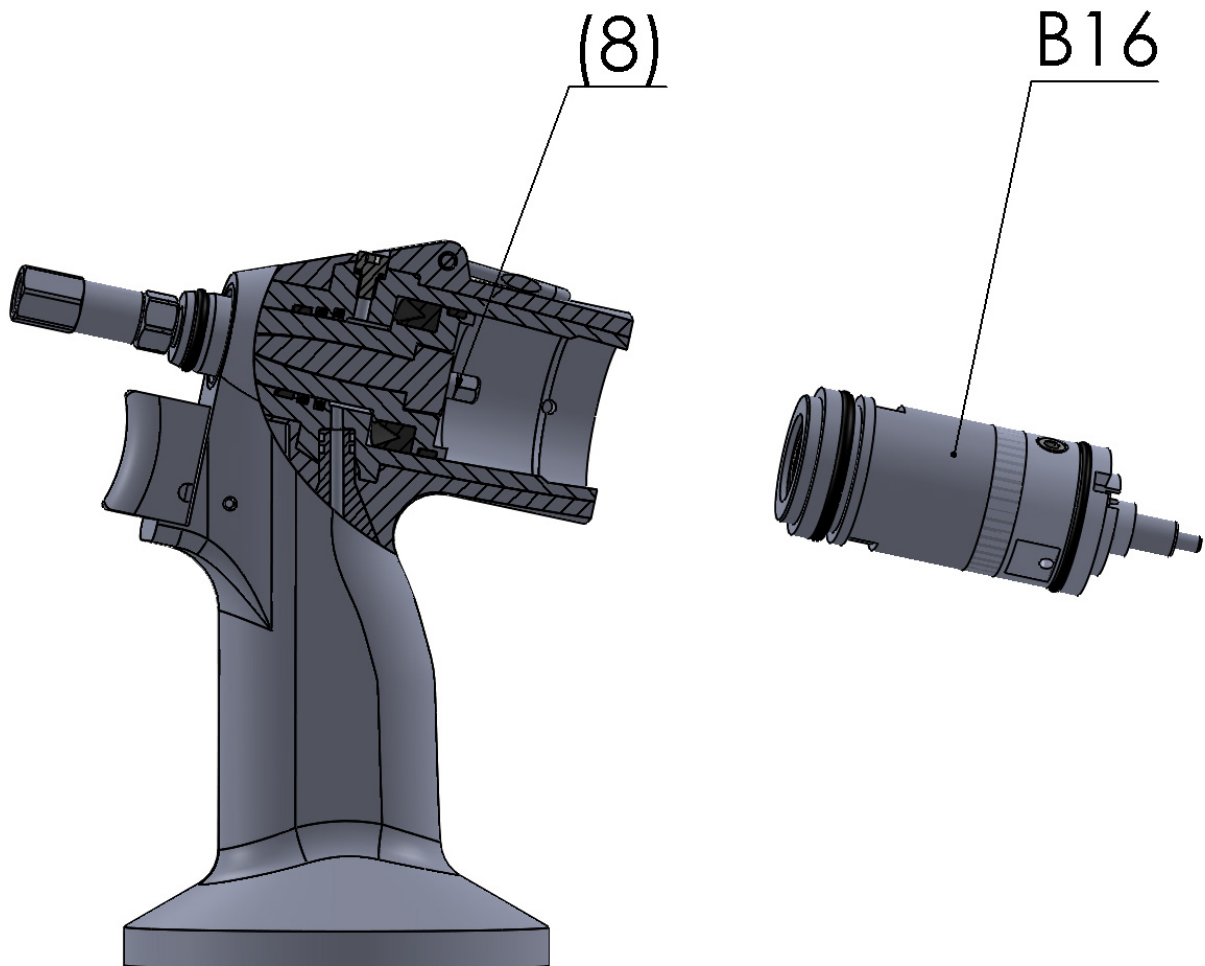


Assembly:

Put pos. 17 onto pos. B18, gradually put pos. B23, pos. 22, pos. 21, pos. 20 and pos. 19 into pos. B18. Screw this complete into pos. B9 and tighten with using adjustable hook spanner 35-50. During assembly it is necessary to overcome the force of the springs pos. 19 and pos. 20!

Step 6**Disassembly:**

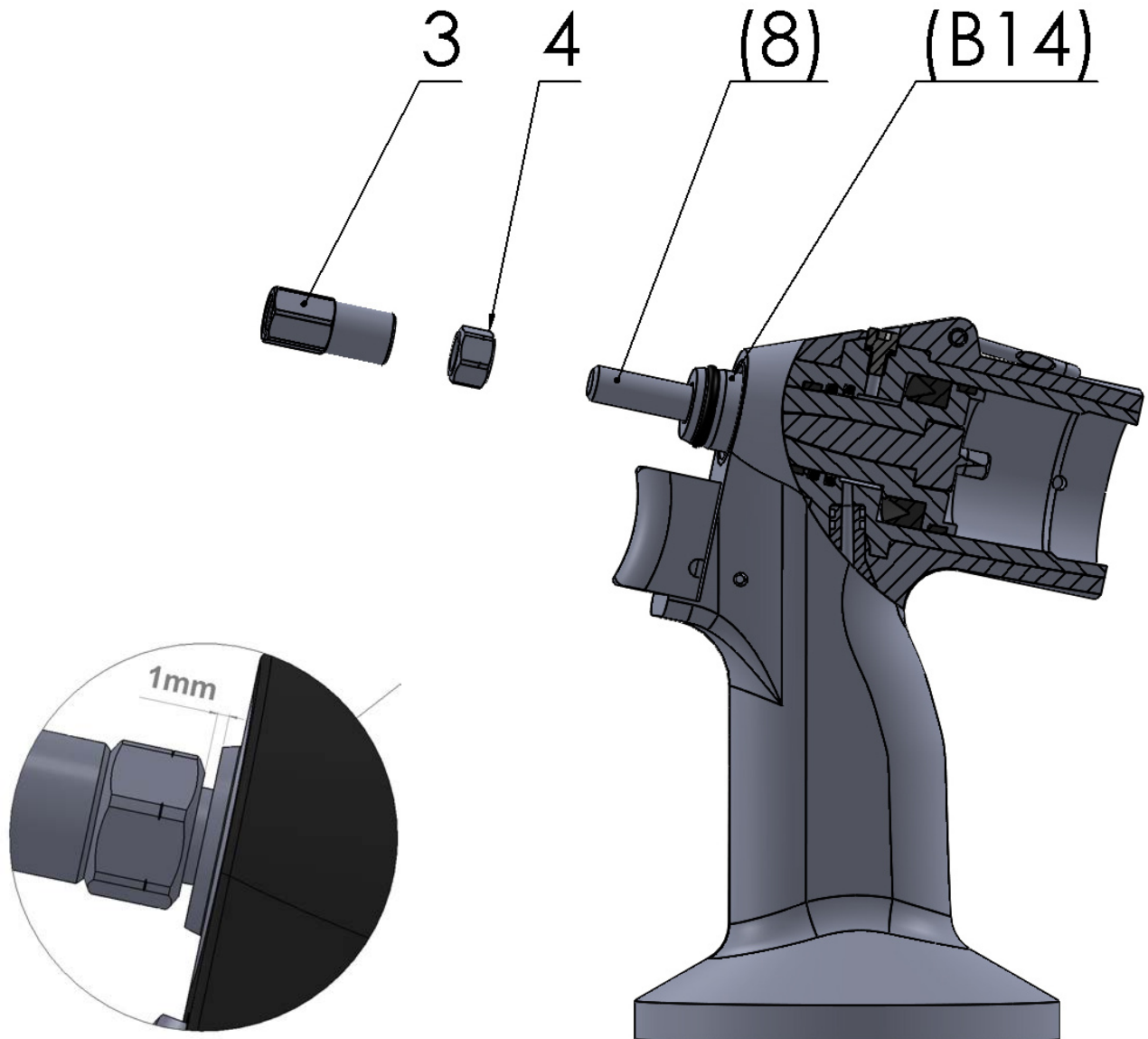
Put out pos. B16.

**Assembly:**

Put on pos. B16 and move around a slight amount so that hexagon pos. B16 and pos. 8 match, then move pos. B16 to the stop. Turn pos. 3 to check if the installation was successful, rotation in pos. B16 must be obvious and audible.

Step 7**Disassembly:**

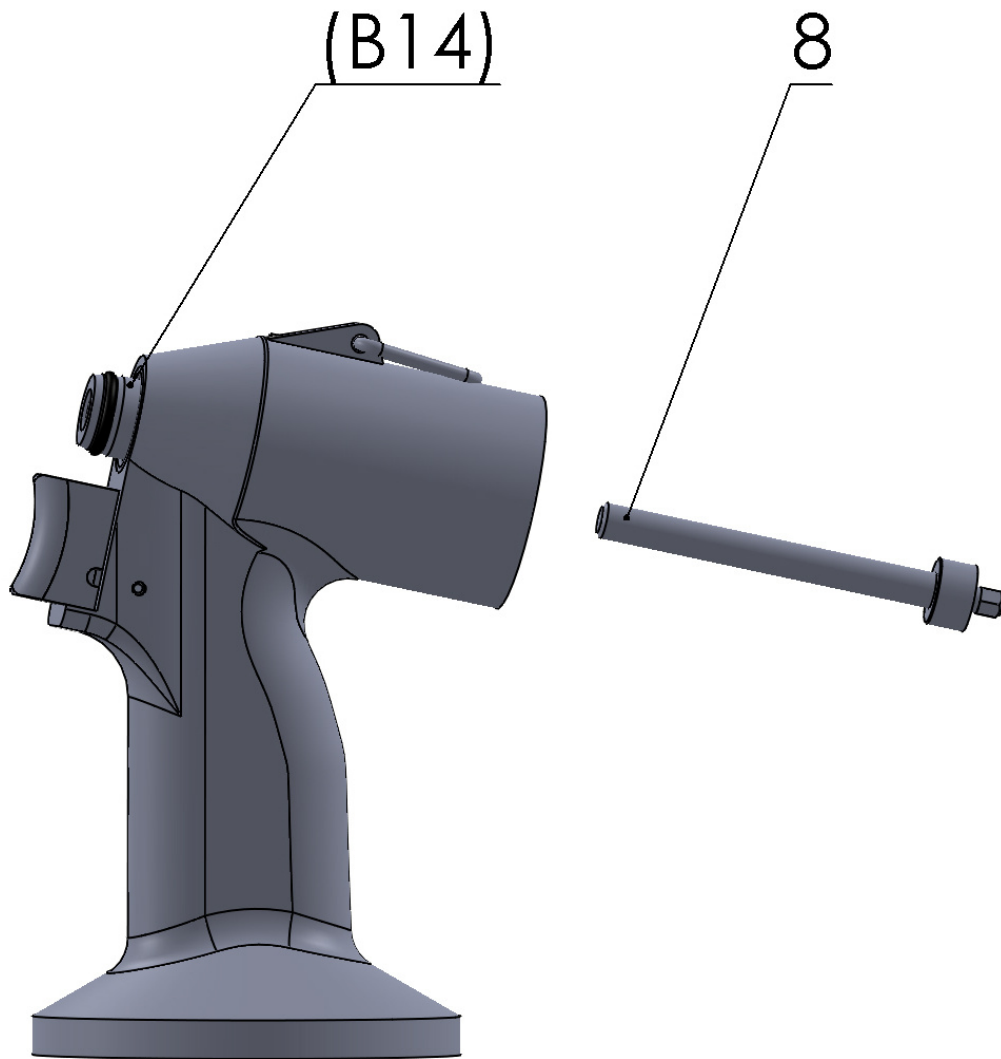
Put wrenches 12 (2x) on pos. 3 and pos. 4, loosen and screw out pos. 3, put hex key on pos. 8 from the inside and screw out pos. 4.

**Assembly:**

Screw pos. 4 on pos. 8 (recess in direction to pos. B14) so that the length between pos. 4 and pos. B14 is 1 mm (see the detail). Put several drops of glue LOCTITE 243 on thread of pos. 8, screw on pos. 3, put wrenches 12 (2x) on pos. 3 and pos. 4 and properly tighten towards pos. 4.

Step 8**Disassembly:**

Put pos. 8. out of pos. B14.

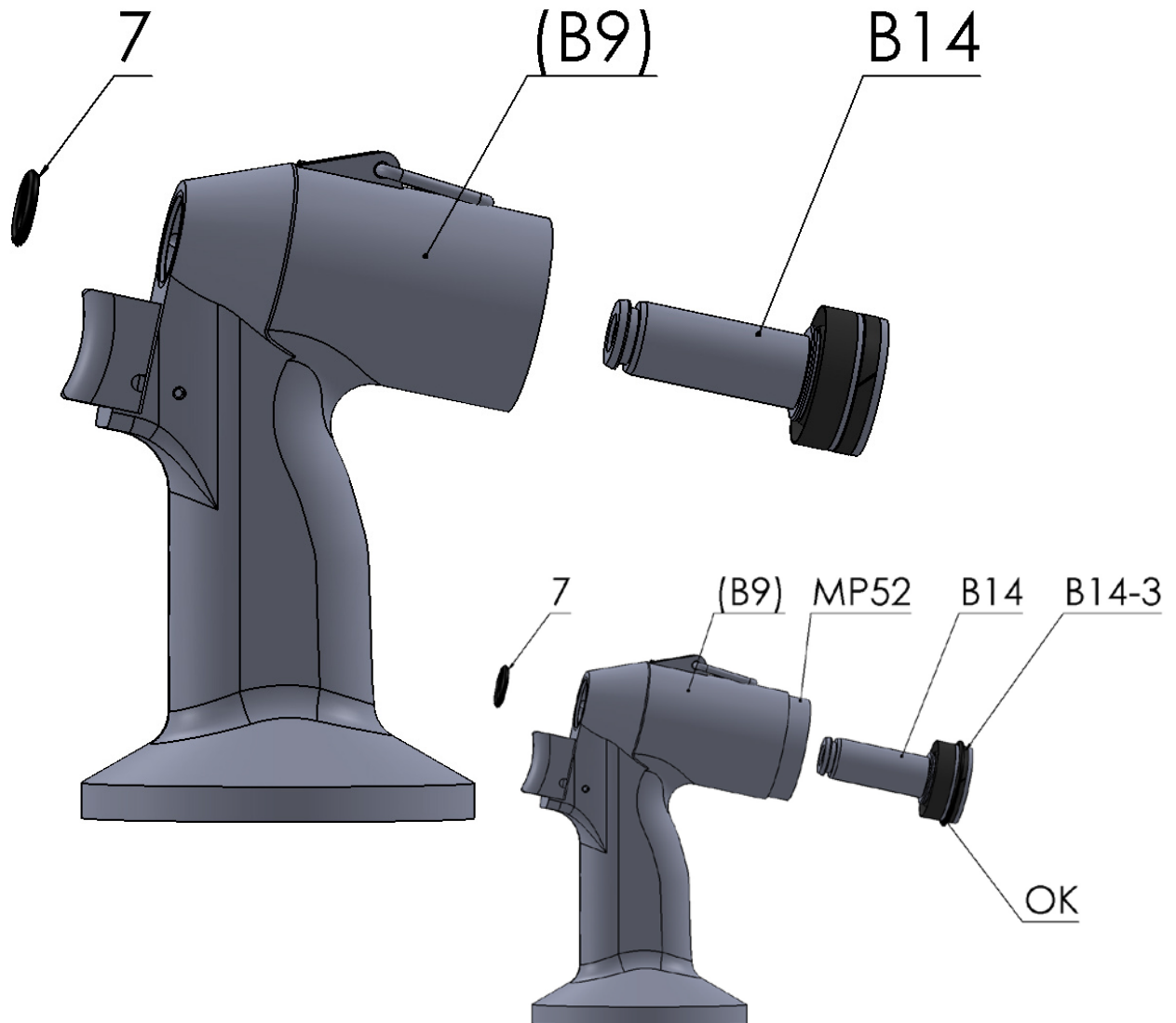
**Assembly:**

Put pos. 8 into pos. B14.

Step 9**Disassembly:**

Put pos. 7 out of pos. B14 with using MP32. Put pos. B14 out of pos. B9.

! Be careful and do not damage the sealing in pos. B9!

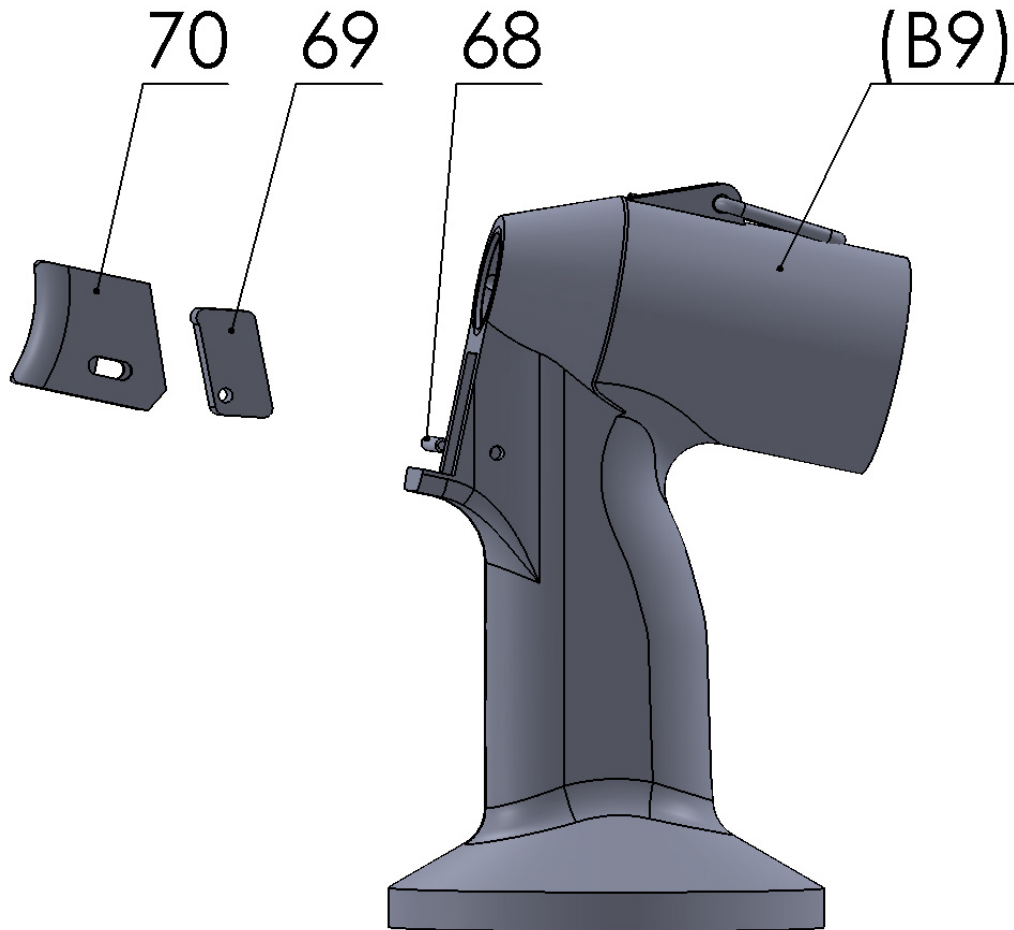
**Assembly:**

Screw MP52 into pos. B9. Lubricate external surface of pos. B14, inner surface of pos. B9 and related sealing of pos. B14 and pos. B9 with silicon paste LUKOSAN, secure pos. B14-3 in the pos. B14 with O ring 32/3 (see the picture, marked OK), than insert pos. B14 to the pos. B9 to the stop, pos. B14 must slide in pos. B9. Screw MP52 out of pos. B9. Put pos. 7 on pos. B14.

! O ring 32/3 will loosen while inserting pos. B14 to pos. B9, it is not a part of the riveting tool!

Step 10**Disassembly:**

Place a pin cca 2,8 mm in diametre to the pos. 68 and knock out with a hammer from pos. B9, put out pos. 70 and pos. 69.

**Assembly:**

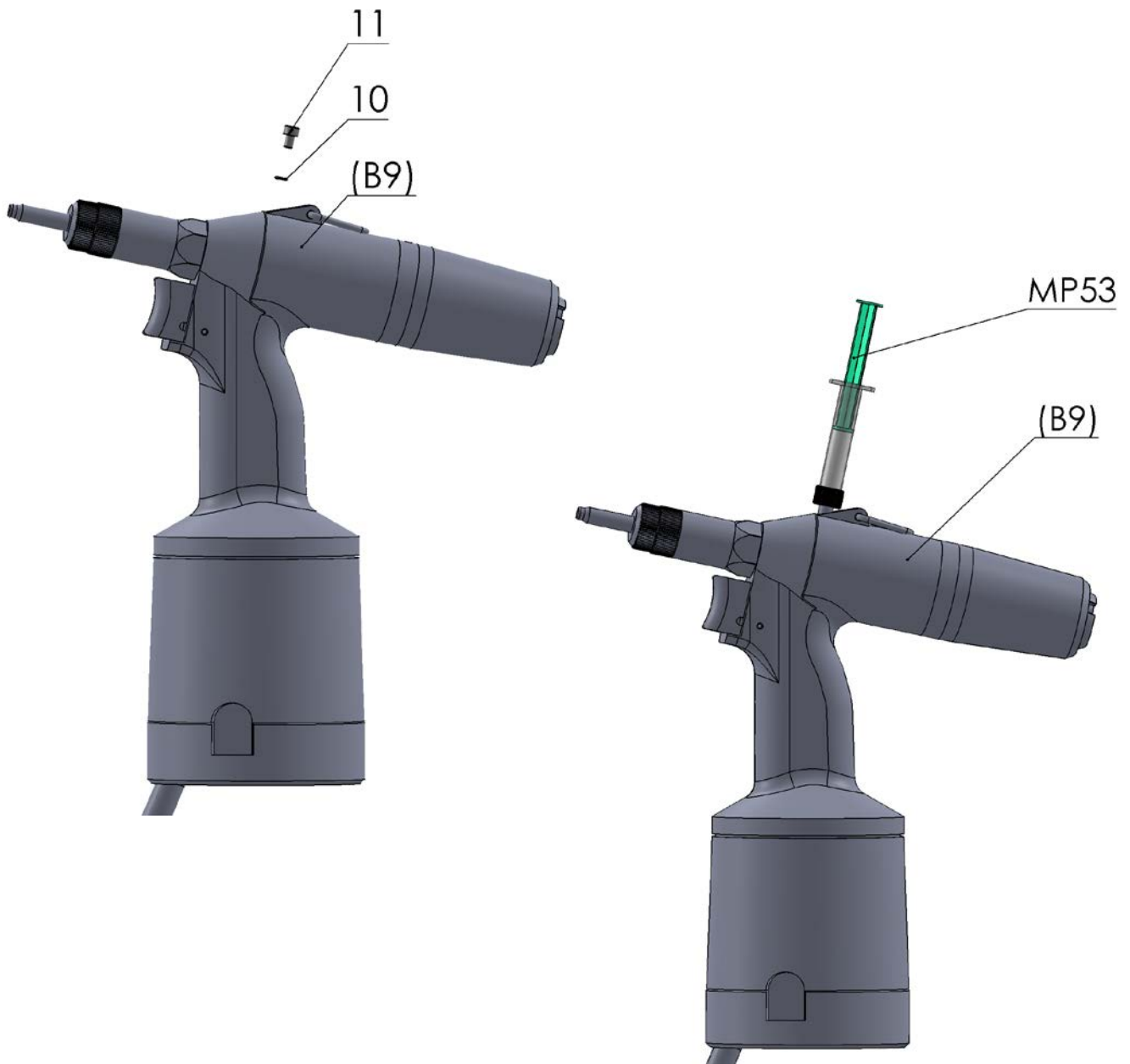
Put pos. 69 to pos. 70 and this complete put into pos. B9, put on pos. 68 and beat in with hammer and a pin cca 2,8 mm in diametre so that the pos. 68 is placed symmetrically in pos. B9 and secure both ends of pos. 68 with paint .

Step 11

Oil filling after assembling the tool:

Connect the tool to the source of CA! Press and release the trigger several times.

Disconnect the tool from the source of CA! Unscrew pos. 11 with socket-screw key no.3. Fill hydraulic oil (from the supplied bottle with hydraulic oil) into MP53, take extra care to avoid air sucking, air must not be present in the hydraulic oil. Screw the MP53 tool into pos. B9 and inject the hydraulic oil into the tool. When the moving part of MP53 tool is released, the redundant oil is returned back to the MP53 tool. Unscrew MP53, screw pos. 11 with pos. 10 back to pos. B9 and tighten with using socket-screw key no.3.



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