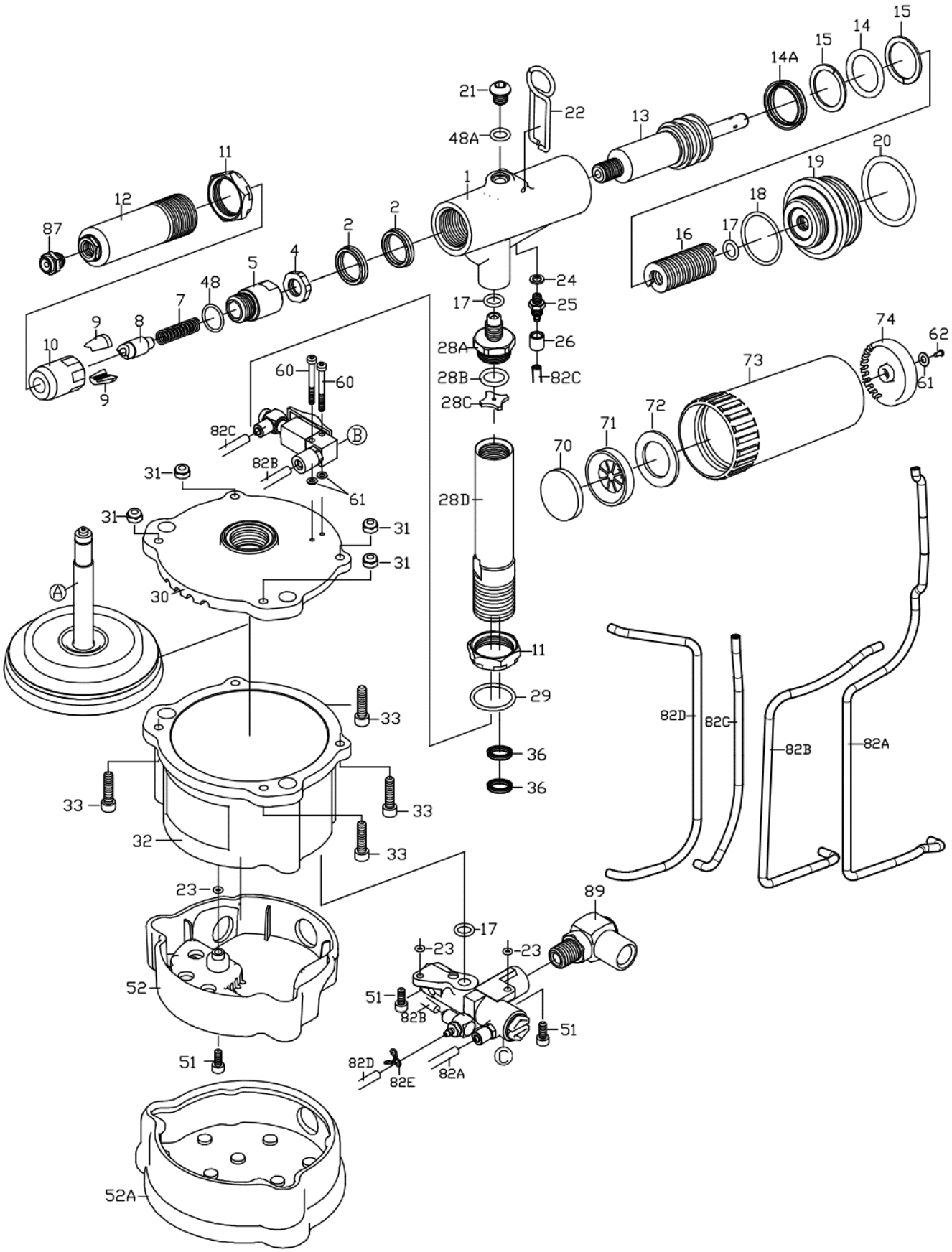
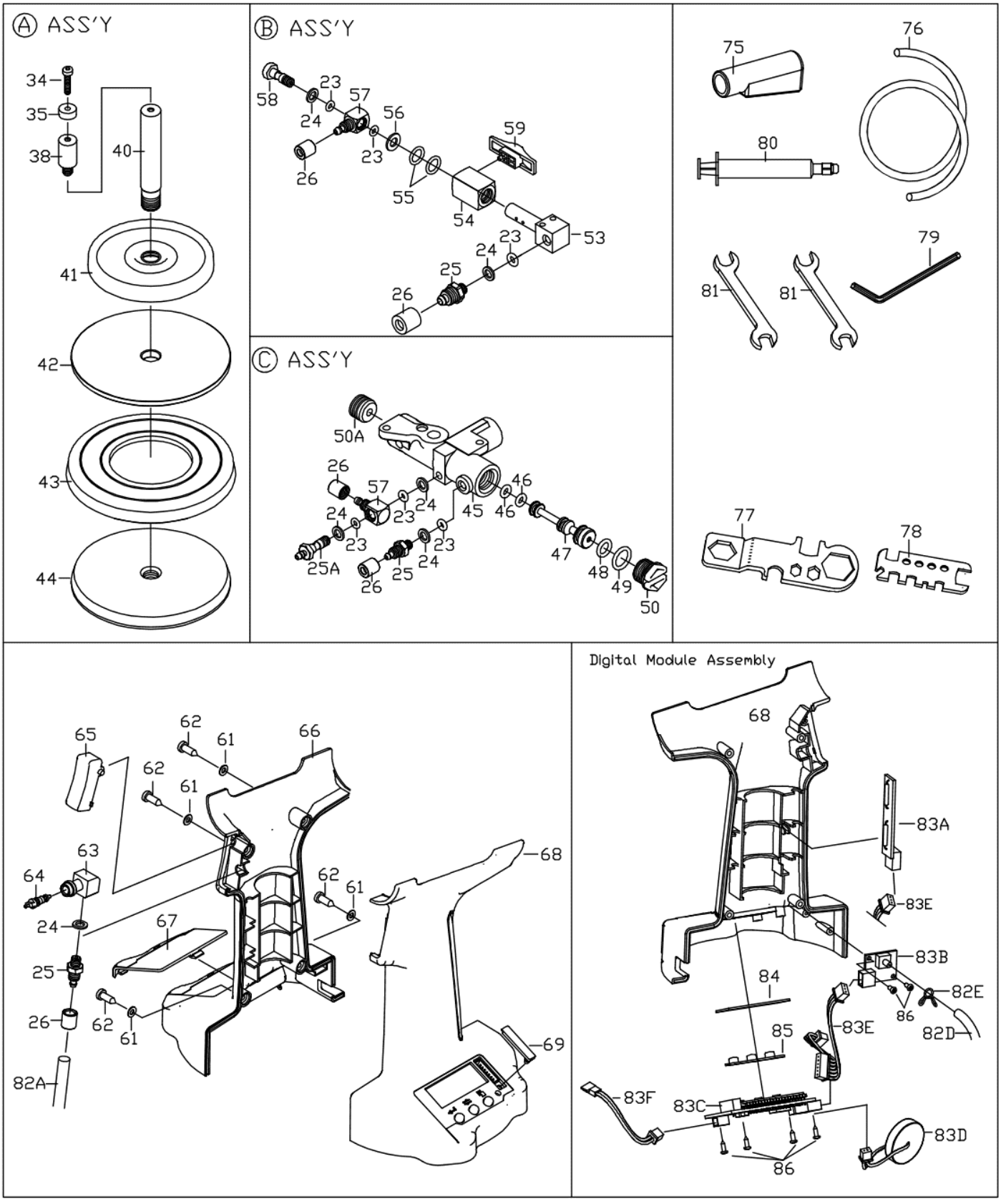
ZT0715D 3/16" (4.8MM) Air Hydraulic Riveter

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Digital Module Assembly
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83A
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82E
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82D
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83C
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ZT0715D 3/16" (4.8MM) Air Hydraulic Riveter

TECHNICAL DATA

Traction Power	lbf(kgf)	:	1500 (700)
Stroke Length	mm	:	15
Net Weight	lbs(kgs)	:	3.8(1.7)
Nosepieces Equipped	inch(mm)	:	5/32(4.0)
Blind Rivet Nut Setting Capacity		:	Max. 3/16"(4.8mm)blind rivets in alum./steel

PARTS LIST

Index	Part #	Description	Index	Part #	Description
1.	520101R	Hydraulic Section	50A.	922409	Socket Screw
*2.	MS2025	Oil seal (2)	51.	HC00407010	Set Screw (3)
4.	214306	Nut	52.	922402	Base
5.	214305	Jaw Housing Coupler	52A.	922404	Rubber Boot
6.	OR1417	O-RING	53.	922701	Vacuum Valve
7.	214308	Spring	54.	922702	Sleeve
8.	214302	Jaw Pusher	55.	OR0811	O-RING (2)
*9.	612303	Jaw (2)	56.	PW0510	Washer
10.	612324A	Jaw Hosing	57.	612712	Swivel (2)
11.	918106	Lock Nut (2)	58.	612713	Socket
12.	612105	Head	59.	922703	Vacuum Switch
13.	520301	Hydraulic Plunger	60.	HC00305020	Set Screw (2)
*14.	OR2229	O-RING	61.	PW0306	Washer (7)
*14A.	MS2229	Oil seal	62.	ST0310	Screw (5)
*15.	BR2229	Back-Up Ring (2)	63.	107602	Valve Body
16.	922309	Return Spring	64.	107601	Bleeding Valve
17.	OR0812	O-RING (3)	65.	107201R	Trigger
18.	OR2832	O-RING	66.	922107RVE	Plastic Grip-Right
19.	922102	Rear Gland	67.	922107C	Battery Cap
20.	OR3542	O-RING	68.	922107LVE	Plastic Grip-Left
21.	HR00812508	Set Screw	69.	202E09	Dust Cover
22.	258801	Hanger	70.	919904	Silencer
23.	OR0306	O-RING (9)	71.	919903	Muffler Seat
24.	612714	Washer (7)	72.	919905	Silencer
25.	612717	Socket (4)	73.	919901	Mandrel Collector
25A.	612713A	Socket	74.	919906	Muffler Cap
26.	612711	Cap (6)	75.	612901	Deflector
28A.	9221082	Hydraulic Tube Connector-B	76.	612902	PU Tube (OPT.)
28B.	OR1417	O-RING	77.	612904	Multi-Wrench (A)
28C.	8211012	Hydraulic Tube Washer	78.	918905	Multi-Wrench (B)
28D.	9221081	Hydraulic Tube Connector-A	79.	314755	5mm Hex. Wrench
29.	OR2025	O-RING	80.	922901	Oiler
30.	922401R	Upper Cover	81.	144905	17x19 Wrench(2)
31.	NN005080B	Nut (4)	82A.	520704A	2.5x4 PU Hose(Black)
32.	520403R	Air Cylinder Body	82B.	520704B	2.5x4 PU Hose(Orange)
33.	HC00508020	Set Screw (4)	82C.	922704C	2.5x4 PU Hose(Orange)
34.	TC00508010S	Set Screw	82D.	520704D	2.5x4 PU Hose(Black)
35.	258504	Magnet	82E.	258804	4mm Hose Loop (2)
*36.	MS1419	Oil seal (2)	83A.	202E01	Counter Sensor
38.	5205112	Magnet Seat	83B.	202E02	Pressure Sensor
40.	715501	Plunger Rod	83C.	202E03	Digital Display
41.	202505	Bumper Ring	83D.	202E04	Lithium Battery
42.	107503	Front Head Disc	83E.	202E05	Signal Terminal
43.	819502	Packing Ring	83F.	202E06B	Power Cable - Display Terminal
44.	107502	Lower Plate	84.	202E07	Display
45.	919211	Valve Case	85.	202E08R	Button
*46.	OR0408AS	O-RING (2)	86.	ST0206	Screw (6)
47.	919202A	Valve Stem	87.	612703	Nose Piece 3/32" (2.4mm)
*48	OR0711	O-RING		612704	Nose Piece 1/8" (3.2mm)
*48A	OR0711A	O-RING		612705	Nose Piece 5/32" (4.0mm)
*49.	OR1014	O-RING		612706	Nose Piece 3/16" (4.8mm)
50.	107409	Inlet Plug	89.	92L2	Air Inlet AssemblyService Kit
			90	0715SK	(opt.) (No.02.09.14.14A.15.36.46. 48.48A.49)

Maintenance Schedule

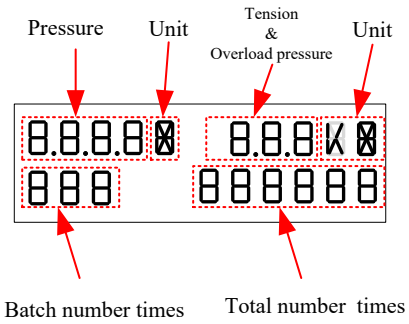
Frequency	Action
Daily after work or every **5,000 cycles**	Lubricate tool through **air inlet**. Clean inside of **Head**
Jaws will not grip rivet stem or **Every 20,000 cycles**	Replace new Jaws
When oil leakage occurs or every **50,000 cycles**	Replace **O-Ring**s and **Back-Up-Ring**s in **Hydraulic Section** and **Hydraulic Tube**.
every **100,000 cycles**	Replace **Packing Ring** in **Air Cylinder**

Troubleshooting

Symptom	Diagnosis	Remedy
Rivet cannot be set by a single pull	1. Low working air pressure 2. Tool requires re-priming 3. Worn **Jaws** or dirt in **Jaws** 4. Broken **Jaws**	1. Check air pressure at the tool. 2. Priming the tool correctly according to the instruction 3. Replace the **Jaws**
The tool can't do suction	The **Suction Switch** didn't open	Turn on the **Suction Switch**.
Jaws will not grip rivet mandrel	1. Worn **Jaws** or build up of dirt on **Jaws** 2. **Jaw Housing** loose 3. Weakened **Jaw Pusher Spring**	1. Clean before replace new **Jaws** 2. Tighten **Jaw Housing**, **Jaw Housing Coupler** and **Nut** 3. Replace new **Jaw Pusher Spring**
Broken **rivet mandrel** can't be released by **Jaws**	1. Dirty **Jaws** and **Jaw Housing** **2.** Weakened **Jaw Pusher Spring** 3. Hydraulic oil over primed.	1. Clean and re-lubricate **2.** Replace **Jaw Pusher Spring** 3. Remove **Plug Screw** and **O-Ring**, let it spill till stop by itself
Broken **rivet mandrel** jammed inside the **Head**	1. Damaged **Jaws** 2. Damaged or dirty **Jaw Pusher**	1. Replace **Jaws** 2. Replace or clean **Jaw Pusher**
The suction force is not strong enough to suck broken mandrel	1. Low air pressure **2.** Air leakage inside **Suction Switch**	1. Check and regulate proper air pressure 2. Check if exhaust air is stuck at rear end of **Collector** 3. Check and replace **O-Ring**s
Digital monitor no display or show "Low"	Low battery power.	Replace new battery
Digital monitor show "Er1".	Inlet pressure is higher than 7.5kg/cm^2.	Adjust the inlet pressure to the pressure below 7.5kg/cm^2.
Digital monitor show "Er2".	1. Oil leaking causes insufficient hydraulic oil 2. Improper assembly of the tool	1. Check the cause of leakage and replace seals if necessary 2. Re-prime hydraulic oil.

Digital Module Operation

1. Digital monitor



2. Button explanation

There are three button on the plastic grip-left.

⧉：**Module button**. The button is used to choose unit or 0~9 number.

⇆：**Shift button**. The button is used to select the mode.

↵：**Enter button**. The button is used to confirm setting.

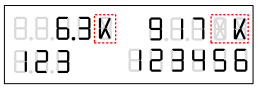
3. Turn on & turn off the monitor

Turn on：Push⧉ button or the tool is working.

Turn off：No actuating the tool within 30 seconds, the monitor will be shut down automatically

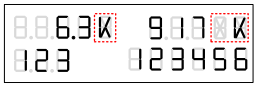
4. Unit Selection

a. Push↵ button 3 seconds. Enter mould function, the monitor begins to flash.



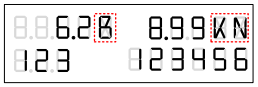
b. Push ⇆ button. Pressure and **pulling force** display begins to flash.

c. Push ⇆ button. Enter **Unit** choose mode, Air Pressure and **pulling force** unit display begins to flash.



d. Push ⧉ button. Change unit.

Push ⧉button again. Change unit.



Push ⧉ button again. Change unit.

e. Push ↵ button. Finish **Unit** setting. The monitor stop flashing.

Table 1 below is **Unit** selection of **Air Pressure** and **Pulling Force**.

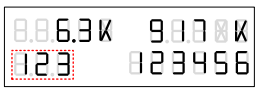
Table 1. Unit displays

	Air Pressure unit	display	Pulling Force unit	display
ISO	Kg/Cm^2	K	KgF	K
ISO	MPa	M	NF	N
Newton	Bar	B	NF	N
ISS	Psi	P	LbF	B

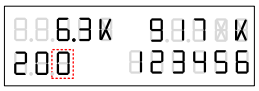
5. Setting batch number

a. Push ↵ **button** 3 seconds. Enter module function, the monitor begins to flash.

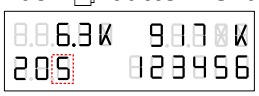
b. Push ⇆ **button.** The batch number display begins to flash.



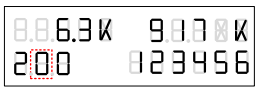
c. Push ↵ button. Enter batch number times function. The first number display begins to flash.



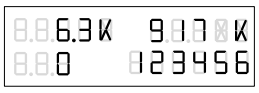
d. Push ⿻ button. Change number 0~9.



e. Push ⇆ button. Change numbers'.



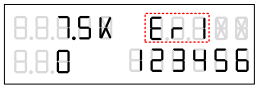
f. Push ↵ button. Finish batch number setting. The monitor is stop flashing. Batch number display will show "0".



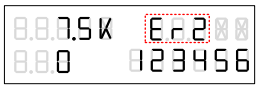
g. Push ↵ button twice, the batch number display will show "0"

6. **Error massage**：

a. If working air pressure is over 7.5 kg/ cm^2(107psi), the monitor will display "Er1".



b. Insufficient hydraulic oil inside Hydraulic Section, the monitor will display "Er2".



c. If battery is low power, the monitor will display "Low".