

ZT1725 1/4" (6.4MM) Air Hydraulic Riveter W/ DIGITAL MODULE

TECHNICAL DATA	Traction Power	lbf(kgf)	: 3700(1700)
	Stroke Length	mm	: 25
	Net Weight	lbs(kgs)	: 5.6(2.5)
	Nosepieces Equipped	inch(mm)	: 3/16(4.8)1/4(6.4), Monobolt 3/16(4.8)1/4(6.4)
	Max. Capacity		: Max. 1/4"(6.4mm) structural rivets in all materials

P A R T S L I S T

Index	Part #	Description	Index	Part #	Description
1.	725101R	Hydraulic Section	51.	HC00407010	Set Screw (3)
2.	MS1823	Oil Seal (2)	52.	202402	Base
4.	214306	Nut	52A.	202404	Rubber Boot
5.	819305	Jaw Housing Coupler	53.	922701	Vacuum Valve
6.	OR1417	O-RING	54.	922702	Sleeve
7.	819308	Spring	55.	OR0811	O-RING (2)
8.	214302	Jaw Pusher	56.	PW0510	Washer
9.	819303	Jaw (2)	57.	612712	Swivel (2)
10.	819324	Jaw Hosing	58.	612713	Socket
11.	819106	Lock Nut	59.	922703	Vacuum Switch
12.	819105	Head	60.	HC00305020	Set Screw (2)
13.	725301	Hydraulic Plunger	61.	PW0306	Washer (3)
14.	OR2835	O-RING	62.	ST0310	Screw
14A.	MS2835	Oil Seal	62A.	HC00305006	Set Screw (4)
15.	BR2835	Back-Up Ring (2)	63.	107602	Valve Body
16.	202309	Return Spring	64.	107601	Bleeding Valve
17.	OR0812	O-RING (3)	65.	107201R	Trigger
18.	OR3034	O-RING	66.	202107RVE	Plastic Grip-Right
19.	725102	Rear Gland	67.	202107C	Battery Cap
20.	OR3542	O-RING	68.	202107LVE	Plastic Grip-Left
21.	HR00812508	Set Screw	68A.	HR002504506	Set Screw (2)
22.	258801	Hanger	69.	202E09	Dust Cover
23.	OR0306	O-RING (9)	70.	919904	Silencer
24.	612714	Washer (7)	71.	919903	Muffler Seat
25.	612717	Socket (4)	72.	919905	Silencer
25A.	612713A	Socket	73.	919901	Mandrel Collector
26.	612711	Cap (6)	74.	919906	Muffler Cap
27.	520106	Nut	75.	612901	Deflector
28A.	5201082	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.	2021081	Hydraulic Tube Connector-A	79.	314755	5mm Hex. Wrench
28E.	5201083	Washer	80.	922901	Oiler
29.	OR2025	O-RING	81A.	144905	17x19 Wrench (2)
30.	202401RA	Upper Cover	81B.	144906	19X21 Wrench
31.	NN005080	Nut (4)	82A.	202704A	2.5x4 PU Hose(Black)
32.	202403RZ	Air Cylinder Body	82B.	202704B	2.5x4 PU Hose(Orange)
33.	HC00508020	Set Screw (4)	82C.	202704C	2.5x4 PU Hose(Orange)
34.	TC00508010S	Set Screw	82D.	202704D	2.5x4 PU Hose(Black)
35.	258504	Magnet	82E.	258804	4mm Hose Loop (2)
36.	MS1621	Oil Seal (2)	83A.	202E01	Counter Sensor
40.	202501	Plunger Rod	83B.	202E02	Pressure Sensor
41.	202505	Bumper Ring	83C.	202E03	Digital Display
42A.	202504	Front Head Disc A	83D.	202E04	Lithium Battery
42B.	202503	Front Head Disc B	83E.	202E05	Signal Terminal
43.	920505	Packing Ring	83F.	202E06B	Power Cable - Display Terminal
44.	202502	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.	612706	Nose Piece 3/16" (4.8mm)
48.	OR0711	O-RING		612708	Nose Piece 1/4" (6.4mm)
48A.	OR0711A	O-RING		612746	Monobolt Nosepiece 3/16"(4.8mm)
49.	OR1014	O-RING		612748	Monobolt Nosepiece 1/4"(6.4mm)
50.	107409	Inlet Plug	89.	92L2	Air Inlet Assembly
50A.	922409	Socket Screw	90.	1725SK	Service Kit (opt.)

Maintenance Schedule

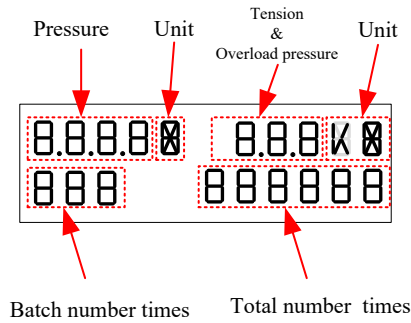
Frequency	Action
Daily after work or every 5,000 cycles	Lubricate tool through air inlet . Clean inside of Head
Jaws will not grip rivet stem or every 20,000 cycles	Replace new Jaws
When oil leakage occurs or every 50,000 cycles	Replace O-Rings and Back-Up-Rings in Hydraulic Section and Hydraulic Tube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

Troubleshooting

Symptom	Diagnosis	Remedy
Rivet cannot be set by a single pull	<ol style="list-style-type: none"> Low working air pressure Tool requires re-priming Worn Jaws or dirt in Jaws Broken Jaws 	<ol style="list-style-type: none"> Check air pressure at the tool. Priming the tool correctly according to the instruction 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	<ol style="list-style-type: none"> Worn Jaws or build up of dirt on Jaws Jaw Housing loose Weakened Jaw Pusher Spring 	<ol style="list-style-type: none"> Clean before replace new Jaws Tighten Jaw Housing, Jaw Housing Coupler and Nut Replace new Jaw Pusher Spring
Broken rivet mandrel can't be released by Jaws	<ol style="list-style-type: none"> Dirty Jaws and Jaw Housing Weakened Jaw Pusher Spring Hydraulic oil over primed. 	<ol style="list-style-type: none"> Clean and re-lubricate Replace Jaw Pusher Spring Remove Plug Screw and O-Ring, let it spill till stop by itself
Broken rivet mandrel jammed inside the Head	<ol style="list-style-type: none"> Damaged Jaws Damaged or dirty Jaw Pusher 	<ol style="list-style-type: none"> Replace Jaws Replace or clean Jaw Pusher
The suction force is not strong enough to suck broken mandrel	<ol style="list-style-type: none"> Low air pressure Air leakage inside Suction Switch 	<ol style="list-style-type: none"> Check and regulate proper air pressure Check if exhaust air is stuck at rear end of Collector Check and replace O-Rings
Digital monitor no display or show "Low"	Low battery power.	Replace new battery
Digital monitor show "Er1".	Inlet pressure is higher than 7.5kg/cm² .	Adjust the inlet pressure to the pressure below 7.5kg/cm² .
Digital monitor show "Er2".	<ol style="list-style-type: none"> Oil leaking causes insufficient hydraulic oil Improper assembly of the tool 	<ol style="list-style-type: none"> Check the cause of leakage and replace seals if necessary 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.

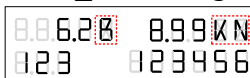
c. Push  button. Enter **Unit** choose mode, Air Pressure and **pulling force** unit display begins to flash.




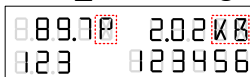
d. Push  button. Change unit.



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.



8.8 6.3k 9.9 7.0k
0.23 023456

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



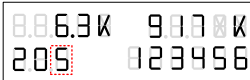
8.8 6.3k 9.9 7.0k
1.23 023456

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



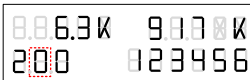
8.8 6.3k 9.9 7.0k
20.0 023456

- d. Push **📄** button. Change number 0~9.



8.8 6.3k 9.9 7.0k
20.5 023456

- e. Push **↔** button. Change numbers'.



8.8 6.3k 9.9 7.0k
20.0 023456

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

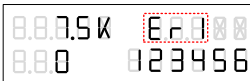


8.8 6.3k 9.9 7.0k
8.8 0 023456

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

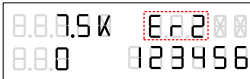
6. Error message :

- a. If working air pressure is over 7.5 kg/ cm²(107psi), the monitor will display "Er1".



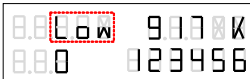
8.8 7.5k 9.9 7.0k
8.8 0 023456

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



8.8 7.5k 9.9 7.0k
8.8 0 023456

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



8.8 0.0k 9.9 7.0k
8.8 0 023456