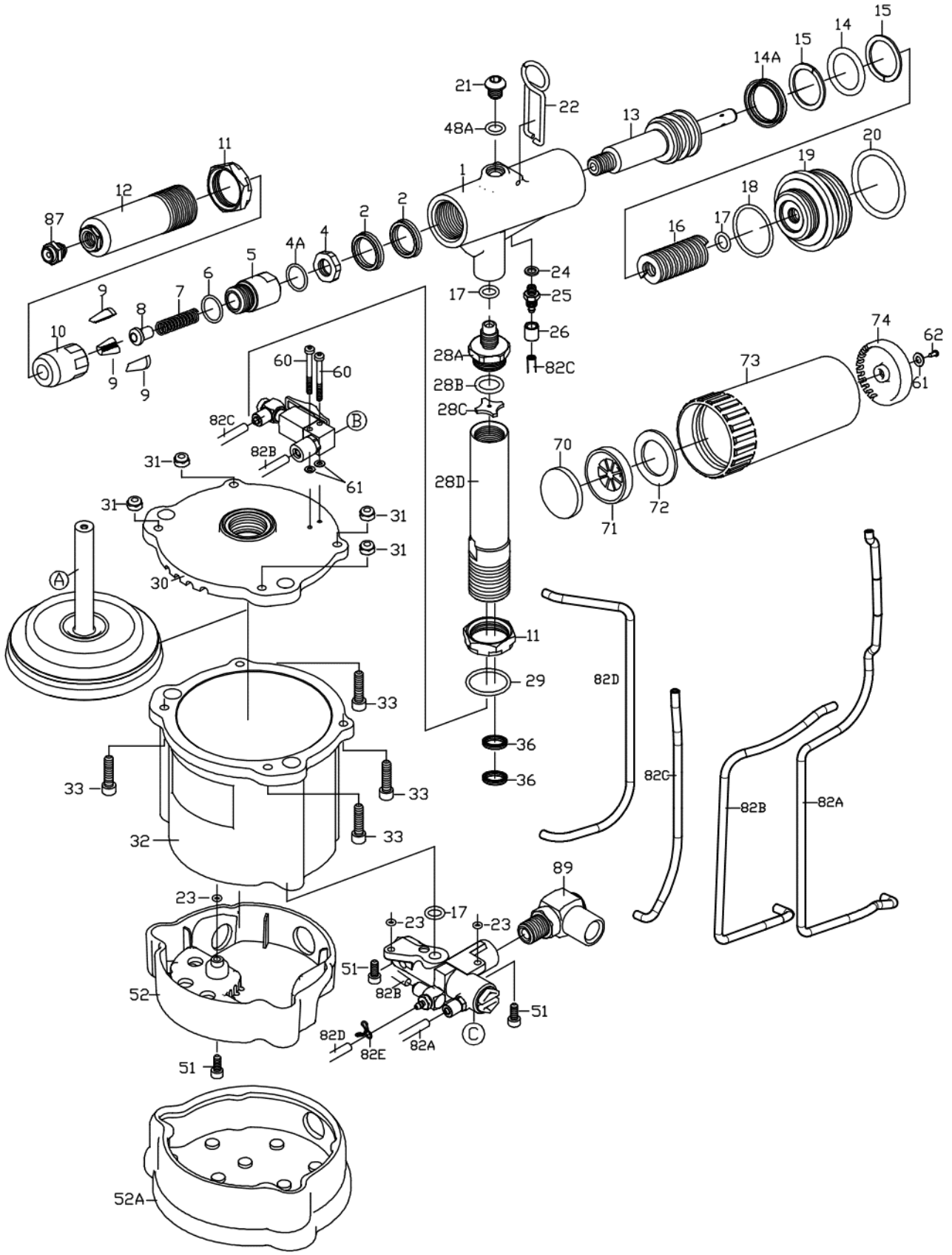
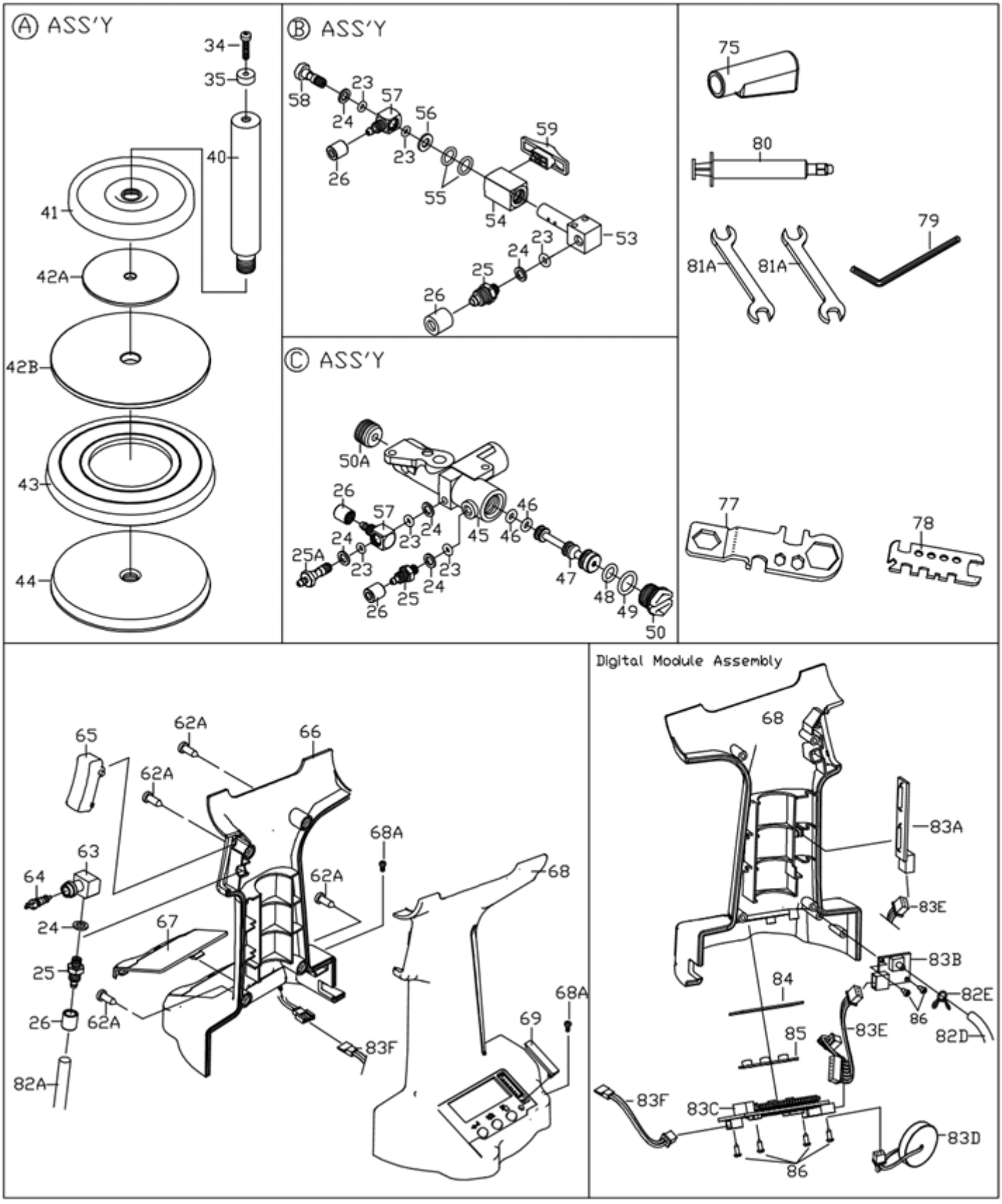
ZT2021D-8 5/16" (8mm)Air Hydraulic Riveter W/DIGITAL MODULE




Ⓐ ASS'Y
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Ⓑ ASS'Y
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Ⓒ ASS'Y
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Digital Module Assembly
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62A
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68A
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62A
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83F
82A
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83E
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82D
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83C
83D
86

ZT2021D-8 5/16" (8mm)Air Hydraulic Riveter W/DIGITAL MODULE

TECHNICAL DATA

Traction Power	lbf(kgf)	:	4400(2000)
Stroke Length	mm	:	21
Net Weight	lbs(kgs)	:	5.6(2.5)
Nosepieces Equipped	inch(mm)	:	5/16(7.8)
Max. Capacity		:	Max. 5/16"(7.8mm) blind rivets in steel/steel

PARTS LIST

Index	Part #	Description	Index	Part #	Description
1.	202101R	Hydraulic Section	51.	HC00407010	Set Screw (3)
*2.	MS1217	O-RING (2)	52.	202402	Base
4.	202306	Nut	52A.	202404	Rubber Boot
4A.	WW1317	Wave Washer	53.	922701	Vacuum Valve
5.	202305	Jaw Housing Coupler	54.	922702	Sleeve
6.	OR1417	O-RING	55.	OR0811	O-RING (2)
7.	202308-B	Spring	56.	PW0510	Washer
8.	202302	Jaw Pusher	57.	612712	Swivel (2)
*9.	202303	Jaw (3)	58.	612713	Socket
10.	202304	Jaw Hosing	59.	922703	Vacuum Switch
11.	819106	Lock Nut	60.	HC00305020	Set Screw (2)
12.	819105	Head	61.	PW0306	Washer (4)
13.	202311	Hydraulic Plunger	62.	ST0310	Screw
*14.	OR2835	O-RING	62A.	HC00305006	Set Screw (4)
*14A.	MS2835	Oil Seal	63.	107602	Valve Body
*15.	BR2835	Back-Up Ring (2)	64.	107601	Bleeding Valve
16.	202309	Return Spring	65.	107201R	Trigger
17.	OR0812	O-RING (2)	66	202107RVE	Plastic Grip-Right
18.	OR3034	O-RING	67.	202107C	Battery Cap
19.	202102	Rear Gland	68.	202107LVE	Plastic Grip-Left
20.	OR3542	O-RING	68A.	HR002504506	Set Screw (2)
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
27.	520106	Nut	77.	612904	Multi-Wrench (A)
28A.	5201082	Hydraulic Tube Connector-B	78.	918905	Multi-Wrench (B)
28B	OR1417	O-RING	79.	314755	5mm Hex. Wrench
28C	8211012	Hydraulic Tube Washer	80.	922901	Oiler
28D	2021081	Hydraulic Tube Connector-A	81A.	144905	17x19 Wrench (2)
28E	5201083	Washer	82A	202704A	2.5x4 PU Hose(Black)
29.	OR2025	O-RING	82B	202704B	2.5x4 PU Hose(Orange)
30.	202401R	Upper Cover	82C	202704C	2.5x4 PU Hose(Orange)
31.	NN005080	Nut (4)	82D	202704D	2.5x4 PU Hose(Black)
32.	202403RZ	Air Cylinder Body	82E	258804	4mmHose Loop (2)
33.	HC00508020	Set Screw (4)	83A	202E01	Counter Sensor
34.	TC00508010S	Set Screw	83B	202E02	Pressure Sensor
35.	258504	Magnet	83C	202E03	Digital Display
*36.	MS1621	Oil Seal (2)	83D	202E04	Lithium Battery
40.	202501	Plunger Rod	83E	202E05	Signal Terminal
41.	202505	Bumper Ring	83F	202E06B	Power Cable - Display Terminal
42A.	202504	Front Head Disc A	84	202E07	Display
42B	202503	Front Head Disc B	85	202E08	Button
43.	920505	Packing Ring	86.	ST0206	Screw (6)
44.	202502	Lower Plate	87.	819709SUS	Nose Piece 5/16" (8mm)
45.	919211	Valve Case	89.	92L2	Air Inlet Assembly
*46.	OR0408AS	O-RING (2)	90	2021SK	Service Kit (opt.)
47.	919202A	Valve Stem			(No.02.09.14.14.A15.36.46.
*48.	OR0711	O-RING			48.48A.49)
*48A.	OR0711A	O-RING			
*49.	OR1014	O-RING (2)			
50.	107409	Inlet Plug			
50A	922409	Socket Screw			

Maintenance Schedule

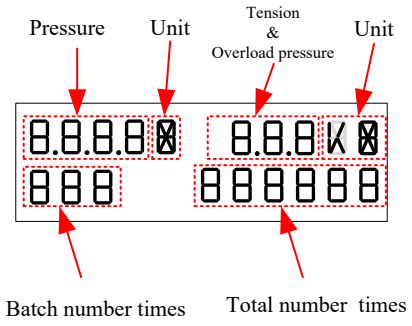
Frequency	Action
Daily after work or every **5,000 cycles**	Lubricate tool through **air inlet**. Clean inside of **Head**
Jaws will not grip rivet stem or **Every 20,000 cycles**	Replace new Jaws
When oil leakage occurs or every **50,000 cycles**	Replace **O-Rings** and **Back-Up-Rings** in **Hydraulic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

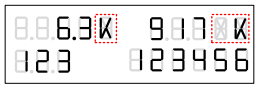
Turn off：No actuating the tool within 30 seconds, the monitor will be shut down automatically

4. Unit Selection

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

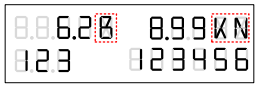
b. Push ⇆ button. Pressure and **pulling force** display begins to flash.

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.

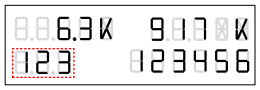
Table 1 below is **Unit** selection of **Air Pressure** and **Pulling Force**.

Table 1. Unit displays

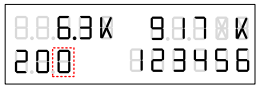
	Air Pressure unit	display	Pulling Force unit	display
ISO	Kg/Cm^2	K	KgF	K
ISO	MPa	M	NF	N
Newton	Bar	B	NF	N
ISS	Psi	P	LbF	B

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

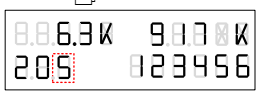
   b. Push ⇆ **button.** The batch number display begins to flash.



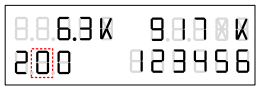
   c. Push ↵ button. Enter batch number times function. The first number display begins to flash.



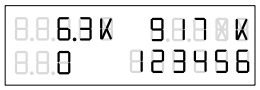
   d. Push 🗍 button. Change number 0~9.



   e. Push ⇆ button. Change numbers'.

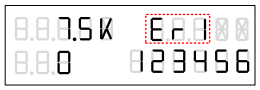


   f. Push ↵ button. Finish batch number setting. The monitor is stop flashing. Batch number display will show "0".

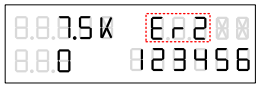


   g. Push ↵ button twice, the batch number display will show "0"

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".