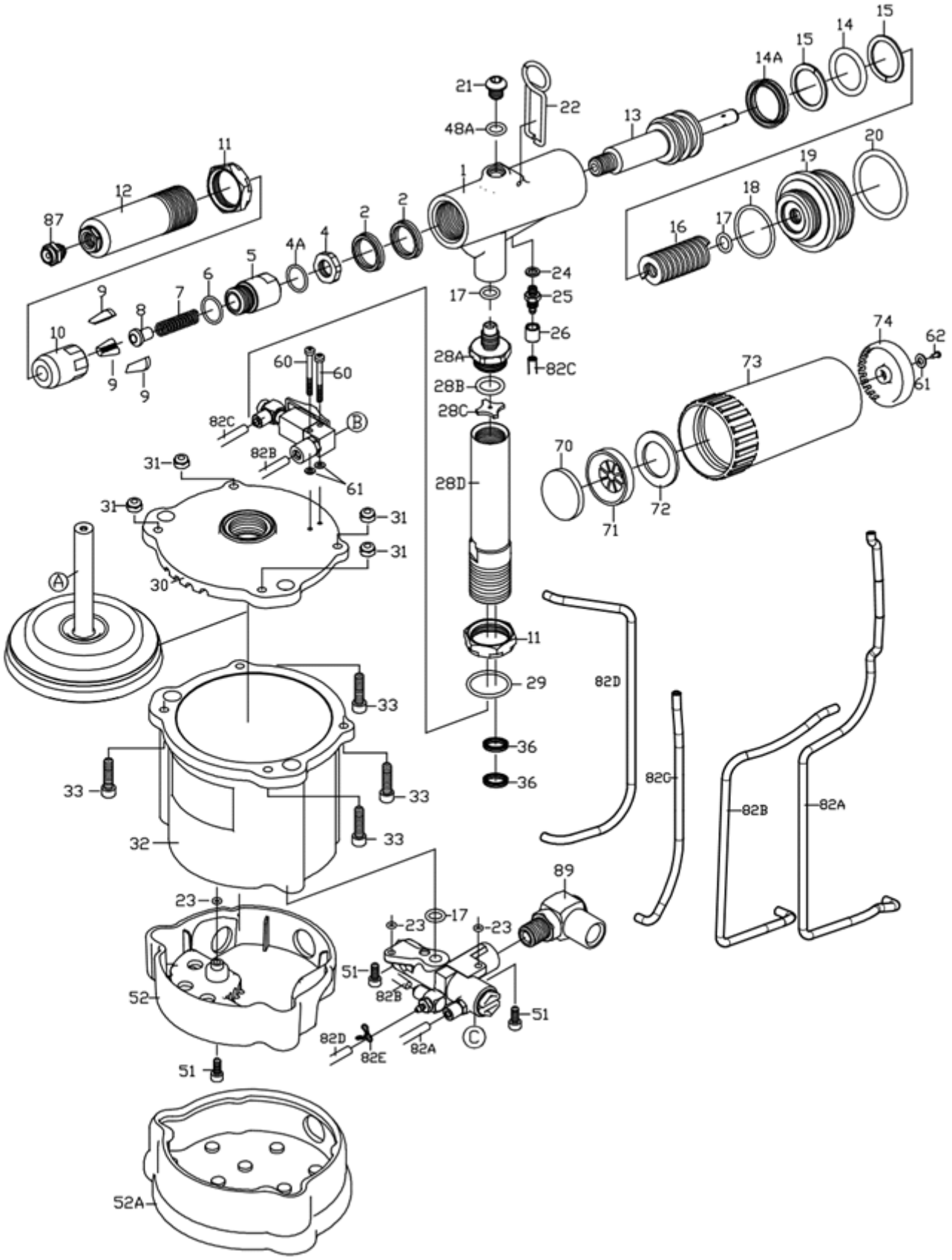
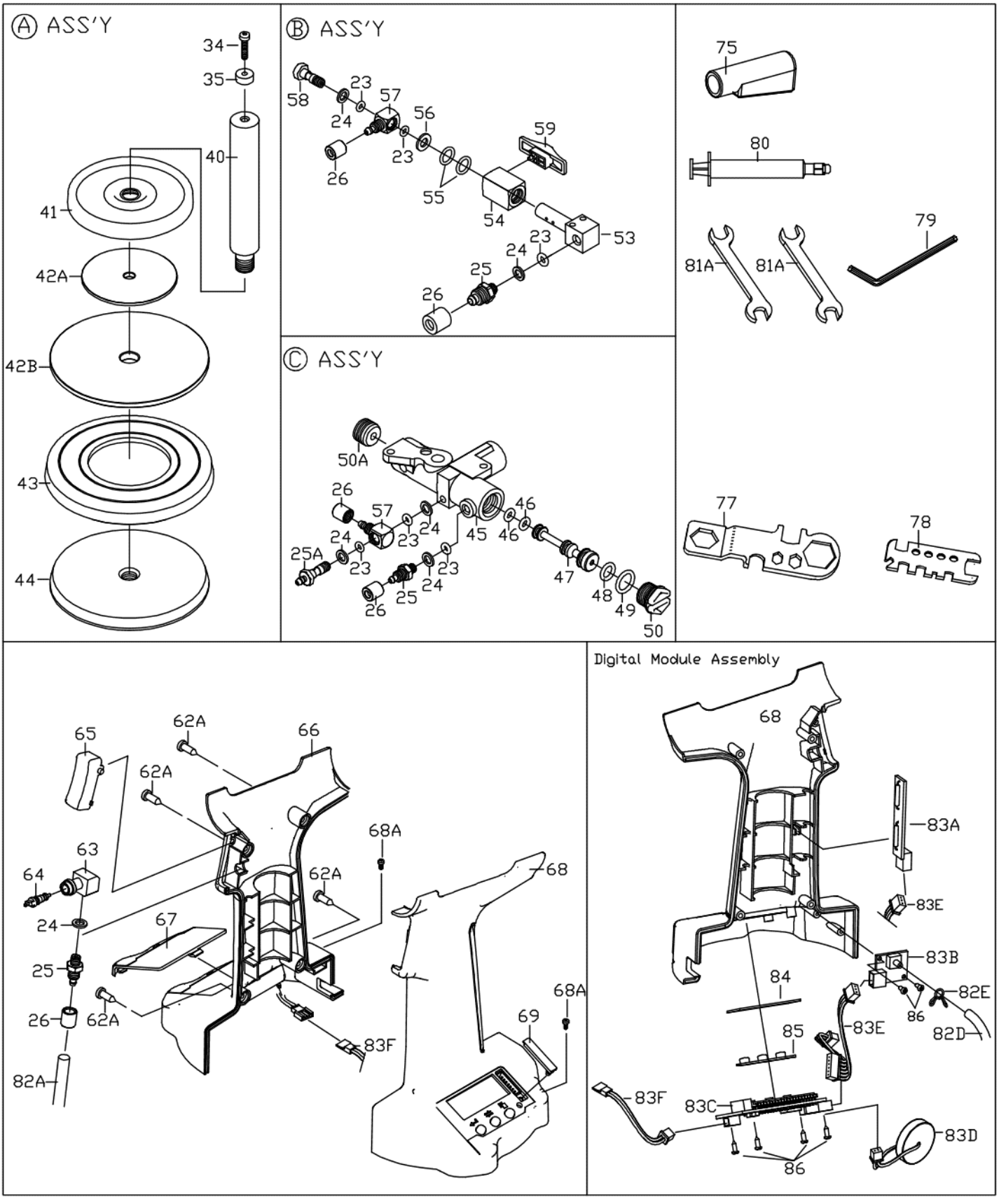
ZT2318D -8 5/16” (8mm) Air Hydraulic Riveter W/DIGITAL MODULE




Ⓐ ASS'Y
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Digital Module Assembly
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ZT2318D -8 5/16" (8mm) Air Hydraulic Riveter W/DIGITAL MODULE

TECHNICAL DATA

Traction Power	lbf(kgf)	:	5000(2300)
Stroke Length	mm	:	18
Net Weight	lbs(kgs)	:	5.6(2.5)
Nosepieces Equipped	inch(mm)	:	5/16(7.8)
Max. Capacity		:	Max. 5/16"(7.8mm) structural rivets in all materials

PARTS LIST

Index	Part #	Description
1.	202101R	Hydraulic Section
*2.	MS1217	Oil Seal (2)
4.	202306	Nut
4A.	WW1317	Wave Washer
5.	202305	Jaw Housing Coupler (for Blind Rivet)
6.	OR1417	O-RING
7.	202308-B	Spring
8.	202302	Jaw Pusher
9.	202303	Jaw (3)
10.	202304	Jaw Hosing
11.	819106	Lock Nut
12.	819105	Head(for Blind Rivet)
13.	202311	Hydraulic Plunger
*14.	OR2835	O-RING
*14A.	MS2835	Oil Seal
*15.	BR2835	Back-Up Ring (2)
16.	202309	Return Spring
17.	OR0812	O-RING (2)
18.	OR3034	O-RING
19.	202102	Rear Gland
20.	OR3542	O-RING
21.	HR00812508	Set Screw
22.	258801	Hanger
23.	OR0306	O-RING (9)
24.	612714	Washer (7)
25.	612717	Socket (4)
25A.	612713A	Socket
26.	612711	Cap (6)
27.	520106	Nut
28A.	5201082	Hydraulic Tube Connector-B
28B	OR1417	O-RING
28C	8211012	Hydraulic Tube Washer
28D	2311081	Hydraulic Tube Connector-A
28E	5201083	Washer
29.	OR2025	O-RING
30.	202401RA	Upper Cover
31.	NN005080B	Nut (4)
32.	202403RZ	Air Cylinder Body
33.	HC00508020	Set Screw (4)
34.	TC00508010S	Set Screw
35.	258504	Magnet
*36.	MS1520	Oil Seal (2)
40.	231501	Back-Up Ring (2)
41.	202505	Plunger Rod
42A.	202504	Bumper Ring
42B	202503	Front Head Disc A
43.	920505	Front Head Disc B
44.	202502	Packing Ring
45.	919211	Lower Plate
*46.	OR0408AS	Valve Case
47.	919202A	O-RING (2)
*48.	OR0711	Valve Stem
*48A.	OR0711A	O-RING
*49.	OR1014	O-RING
50.	107409	O-RING (2)
50A.	922409	Inlet Plug Socket Screw

Index	Part #	Description
51.	HC00407010	Set Screw (3)
52.	202402	Base
52A.	202404	Rubber Boot
53.	922701	Vacuum Valve
54.	922702	Sleeve
55.	OR0811	O-RING (2)
56.	PW0510	Washer
57.	612712	Swivel (2)
58.	612713	Socket
59.	922703	Vacuum Switch
60.	HC00305020	Set Screw (2)
61.	PW0306	Washer (3)
62.	ST0310	Screw
62A.	HC00305006	Set Screw (4)
63.	107602	Valve Body
64.	107601	Bleeding Valve
65.	107201R	Trigger
66	202107RVE	Plastic Grip-Right
67.	202107C	Battery Cap
68.	202107LVE	Plastic Grip-Left
68A	HR002504506	Set Screw (2)
69	202E09	Dust Cover
70.	919904	Silencer
71.	919903	Muffler Seat
72.	919905	Silencer
73.	919901	Mandrel Collector
74.	919906	Muffler Cap
75.	612901	Deflector
77.	612904	Multi-Wrench (A)
78.	918905	Multi-Wrench (B)
79.	314755	5mm Hex. Wrench
80.	922901	Oiler
81A.	144905	17x19 Wrench (2)
82A	202704A	2.5x4 PU Hose(Black)
82B	202704B	2.5x4 PU Hose(Orange)
82C	202704C	2.5x4 PU Hose(Orange)
82D	202704D	2.5x4 PU Hose(Black)
82E	258804	4mm Hose Loop (2)
83A	202E01	Counter Sensor
83B	202E02	Pressure Sensor
83C	202E03	Digital Display
83D	202E04	Lithium Battery
83E	202E05	Signal Terminal
83F	202E06B	Power Cable - Display Terminal
84	202E07	Display
85	202E08R	Button
86	ST0206	Screw (6)
87	819709SUS	Nose Piece 5/16" (8mm)
89.	92L2	Air Inlet Assembly
90	2318SK	Service Kit (opt.) **(No.02.09.14.14A.15.36.46.48.48A.49)**

Maintenance Schedule

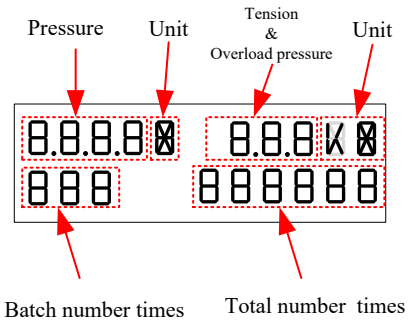
Frequency	Action
Daily after work or every **5,000 cycles**	Lubricate tool through **air inlet**. Clean inside of **Head**
Jaws will not grip rivet stem or **Every 20,000 cycles**	Replace new Jaws
When oil leakage occurs or every **50,000 cycles**	Replace **O-Ring**s and **Back-Up-Ring**s in **Hydraulic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

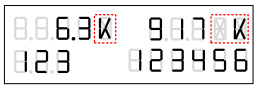
3. Turn on & turn off the monitor

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

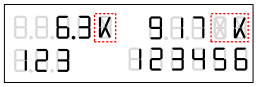
4. Unit Selection

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



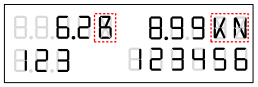
b. Push ⇆ button. Pressure and **pulling force** display begins to flash.

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**.

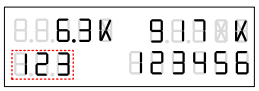
Table 1. Unit displays

	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

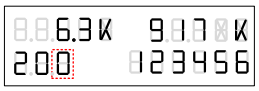
5. Setting batch number

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

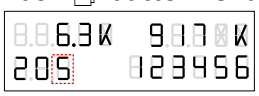
b. Push ⇆ **button.** The batch number display begins to flash.



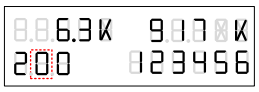
c. Push ↵ button. Enter batch number times function. The first number display begins to flash.



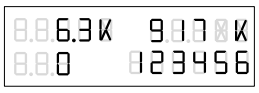
d. Push ⿻ button. Change number 0~9.



e. Push ⇆ button. Change numbers'.



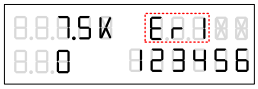
f. Push ↵ button. Finish batch number setting. The monitor is stop flashing. Batch number display will show "0".



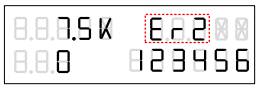
g. Push ↵ button twice, the batch number display will show "0"

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".