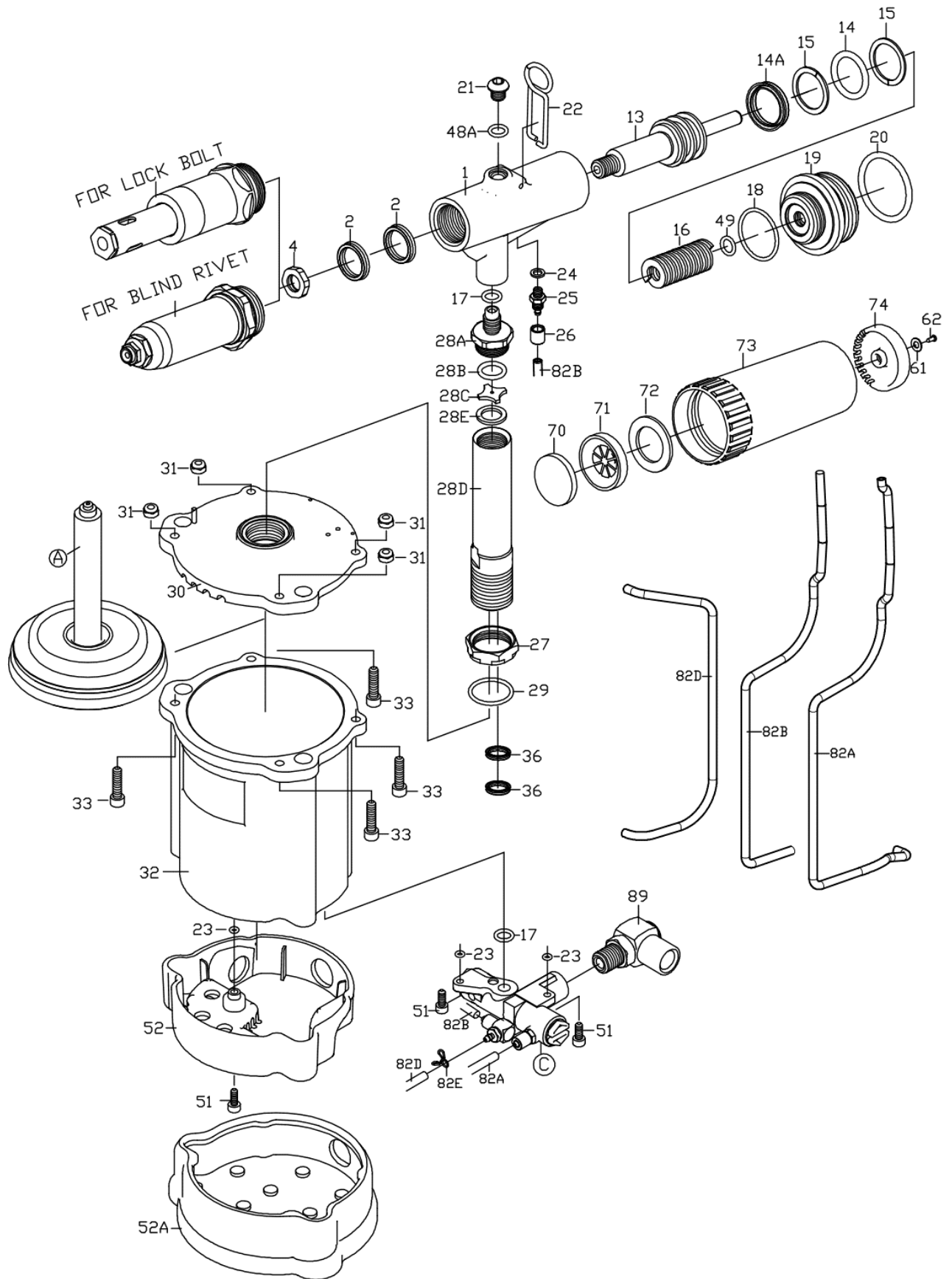
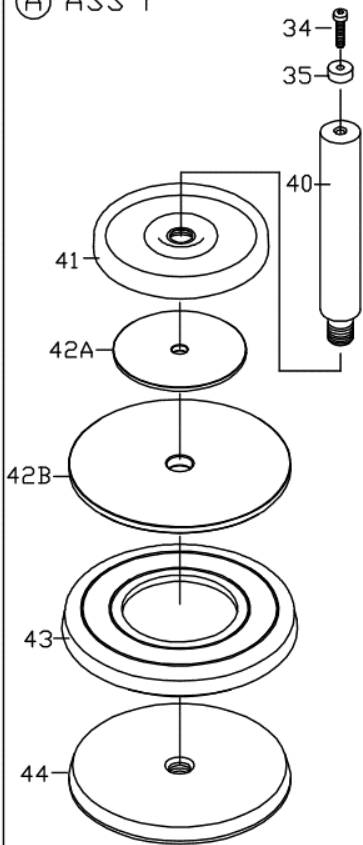


ZT2318HD / ZT2318HDK

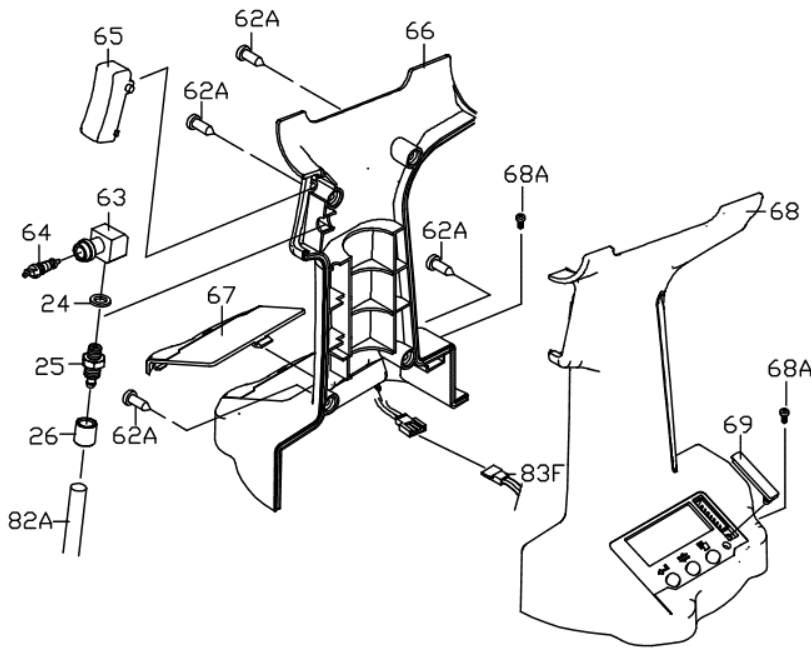
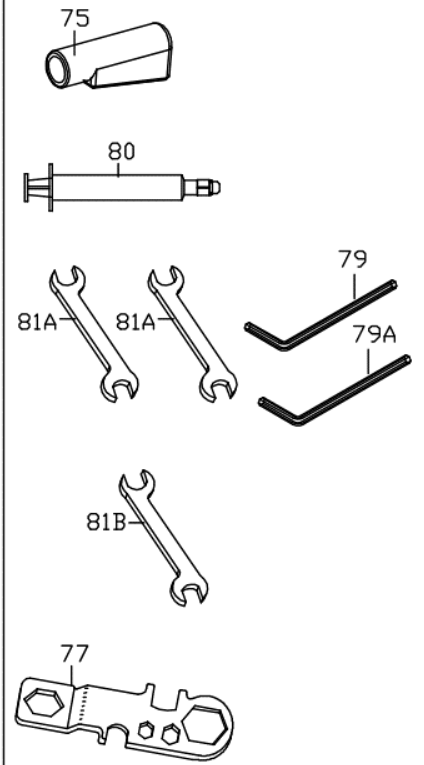
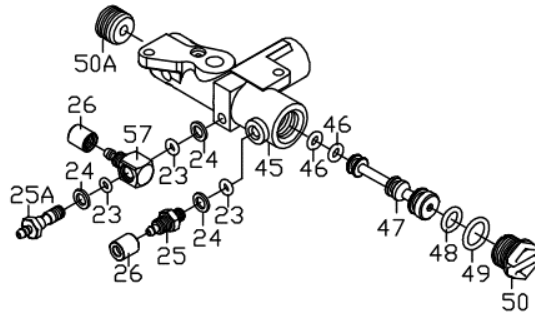
Air Hydraulic Lock Bolt Tool(W/Digital Module) / Air Hydraulic Lock Bolt Tool Kit(W/Digital Module)



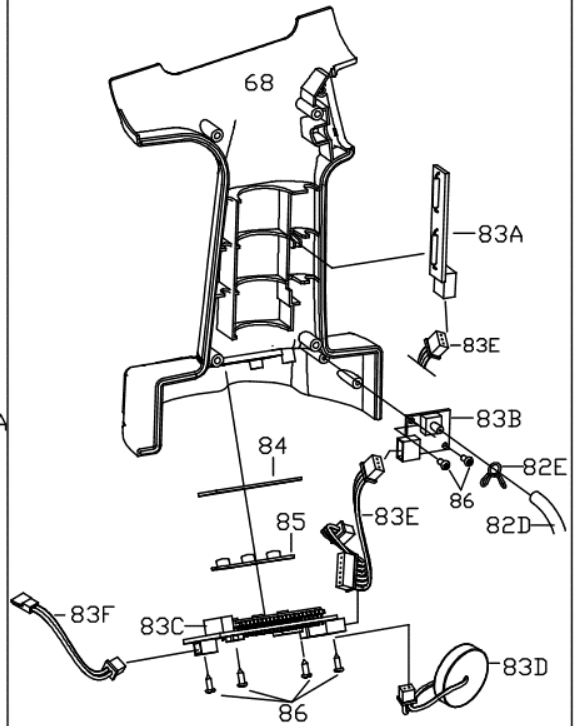
Ⓐ ASS'Y



Ⓒ ASS'Y



Digital Module Assembly



2318RS	FOR RIVET 4.8mm,6.4mm(3/16",1/4")	2318RS-8	FOR RIVET 8mm(5/16")																																								
2318RS-4	FOR RIVET 3.2mm,4.0mm(1/8",5/32")	FOR #90 ASS'Y																																									
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FOR LOCK BOLT																																											
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ZT2318HD / ZT2318HDK

Air Hydraulic Lock Bolt Tool(W/Digital Module) / Air Hydraulic Lock Bolt Tool Kit(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)	3/16" Fixed Grip Nose 1/4"Fixed Grip Nose 3/16"Multi Grip Nose 1/4"Multi Grip Nose
		(ZT2318H with one size lock bolt nose assembly only ZT2318HK with all size nose assembly)
Max. Capacity		1/4" Multi Grip Lock Bolts

PARTS LIST

Index	Part #	Description	Index	Part #	Description	Index	Part #	Description		
1.	202101	Hydraulic Section	62.	ST0310	Screw	12.	819105	Head (for Blind Rivet)		
2.	MS1217	Oil Seal (2)	62A	HC00305006	Set Screw (4)	87A	819709SUS	Nose Piece 5/16"(8mm)		
4.	202306	Nut	63.	107602	Valve Body			FOR BLIND RIVET 4.8mm,6.4mm (3/16",1/4") (OPT.)		
5A.	202315	Connector	64.	107601	Bleeding Valve					
12A.	202115	Head(for Lock Bolt)	65.	107201R	Trigger		2318RS			
12B.	202113	Lock Nut (for Lock Bolt)	66	202107R	Plastic Grip-Right					
			67	202107C	Battery Cap					
12C.	OR2630	O-RING	68.	202107LE	Plastic Grip-Left	5	202325	Jaw Housing Coupler (for Blind Rivet)		
13.	231301	Hydraulic Plunger	68A.	HR002504506	Set Screw (2)					
14.	OR2835	O-RING	69.	202E09	Cover	6.	OR1417	O-RING (for Blind Rivet)		
14A.	MS2835	Oil Seal	70.	919904	Silencer					
15.	BR2835	Back-Up Ring (2)	71.	919903	Muffler Seat	7.	819308	Spring (for Blind Rivet)		
16.	202309	Return Spring	72	919905	Silencer					
17.	OR0812	O-RING (2)	73.	919901	Mandrel Collector	8.	214302	Jaw Pusher (for Blind Rivet)		
18.	OR3034	O-RING	74.	919906	Muffler Cap					
19.	202102	Rear Gland	75.	612901	Deflector	9.	819303	Jaw (2) (for Blind Rivet)		
20.	OR3542	O-RING	79.	314755	5mm Hex. Wrench					
21.	HR00812508	Set Screw	79A	314966	6mm Hex. Wrench	10.	819324	Jaw Hosing (for Blind Rivet)		
22.	258801	Hanger	80.	922901	Oiler					
23.	OR0306	O-RING (5)	82A	202704A	2.5x4 PU Hose	11.	819106	Lock Nut (for Blind Rivet)		
24.	612714	Washer (4)	82B	231704B	2.5x4 PU Hose					
25.	612717	Socket (3)	82D	202704D	2.5x4 PU Hose	12.	819105	Head (for Blind Rivet)		
26.	612711	Cap (3)	82E	258804	4mm Hose Loop (2)					
27.	520106	Nut	83A	202E01	Counter Sensor	87.	612706	Nose Piece 3/16" (4.8mm)		
28A.	5201082	Hydraulic Tube Connector-B	83B	202E02	Pressure Sensor					
			83C	202E03	Digital Display					
28B	OR1417	O-RING	83D	202E04	Lithium Battery		612708	Nose Piece 1/4" (6.4mm)		
28C	8211012	Hydraulic Tube Washer	83E	202E05	Signal Terminal					
			83F	202E06B	Power Cable - Display Terminal		2318RS-4	FOR BLIND RIVET 3.2mm,4.0mm (1/8",5/32") (OPT.)		
28D	2311081	Hydraulic Tube Connector-A	84.	202E07	Display					
			85	202E08	Button					
28E	5201083	Washer	86.	ST0206	Screw (6)	5.	202325	Jaw Housing Coupler (for Blind Rivet)		
29.	OR2025	O-RING	89.	92L2	Air Inlet Assembly					
30.	202401RA	Upper Cover	90.	202HC1A	For 3/16" Fixed Grip ass'y	6.	OR1417	O-RING (for Blind Rivet)		
31.	NN005080	Nut (4)			(for Lock Bolt)	7B.	612308	Spring (for Blind Rivet)		
32.	202403RZ	Air Cylinder Body		202HM1	For 3/16" Multi Grip ass'y	8B.	214312	Jaw Pusher (for Blind Rivet)		
33.	HC00508020	Set Screw (4)			(for Lock Bolt)	9B.	612303	Jaw (2) (for Blind Rivet)		
34.	TC00508010S	Set Screw		202HB2	FOR 1/4" Blind Bolt ASS'Y	10B.	612324A	Jaw Hosing (for Blind Rivet)		
36.	MS1520	O-RING (2)		231HC2	For 1/4" Fixed Grip ass'y	10B.	612324A	Jaw Hosing (for Blind Rivet)		
40.	231501	Plunger Rod			(for Lock Bolt)	11.	819106	Lock Nut (for Blind Rivet)		
41.	202505	Bumper Ring			For 1/4" Multi Grip ass'y	12.	819105	Head (for Blind Rivet)		
42A.	202504	Front Head Disc A		202HM2	(for Lock Bolt)					
42B	202503	Front Head Disc B			Service Kit (opt.) (No.02.03.14.15.36. 37.46. 48.48A.49)	87.	612704	Nose Piece 1/8" (3.2mm)		
43.	920505	Packing Ring			FOR BLIND RIVET 8mm(5/16") (OPT.)		612705	Nose Piece 5/32" (4.0mm)		
44.	202502	Lower Plate			Connector					
45.	919211	Valve Case		5B	202305					
46.	OR0408AS	O-RING (2)		6	OR1417		77	612904	Multi-Wrench (A)(OPT)	
47.	919202	Valve Stem		7A	202308					
48.	OR0711	O-RING	91		202302					
48A.	OR0711A	O-RING			9A.	202303		78	918905	Multi-Wrench (B) (OPT)
49.	OR1014	O-RING (2)			10A.	202304		81A.	144905	17x19 Wrench (2)
50.	107409	Inlet Plug			11.	819106		81B.	144906	19X21 Wrench
50A	922409	Plug								
51.	HC00407010	Set Screw (3)								
52.	202402	Base								
52A	202404	Rubber Boot								
61.	PW0306	Washer								

Maintenance Schedule

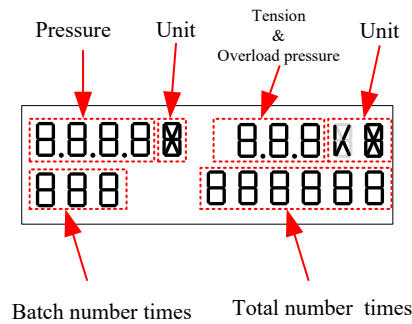
Frequency	Action
Daily after work or every 5,000 cycles	Lubricate tool through air inlet . Clean inside of Head
Jaws will not grip rivet stem or Every 20,000 cycles	Replace new Jaws
When oil leakage occurs or every 50,000 cycles	Replace O-Rings and Back-Up-Rings in Hydraulic Section and Hydraulic Tube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

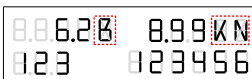
c. Push  button. Enter **Unit** choose mode, Air Pressure and **pulling force** unit display begins to flash.



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".



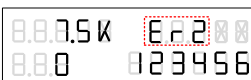
- g. Push  **button** twice, the batch number display will show "0"

6. Error message :

- a. If working air pressure is over 7.5 kg/ cm²(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".

