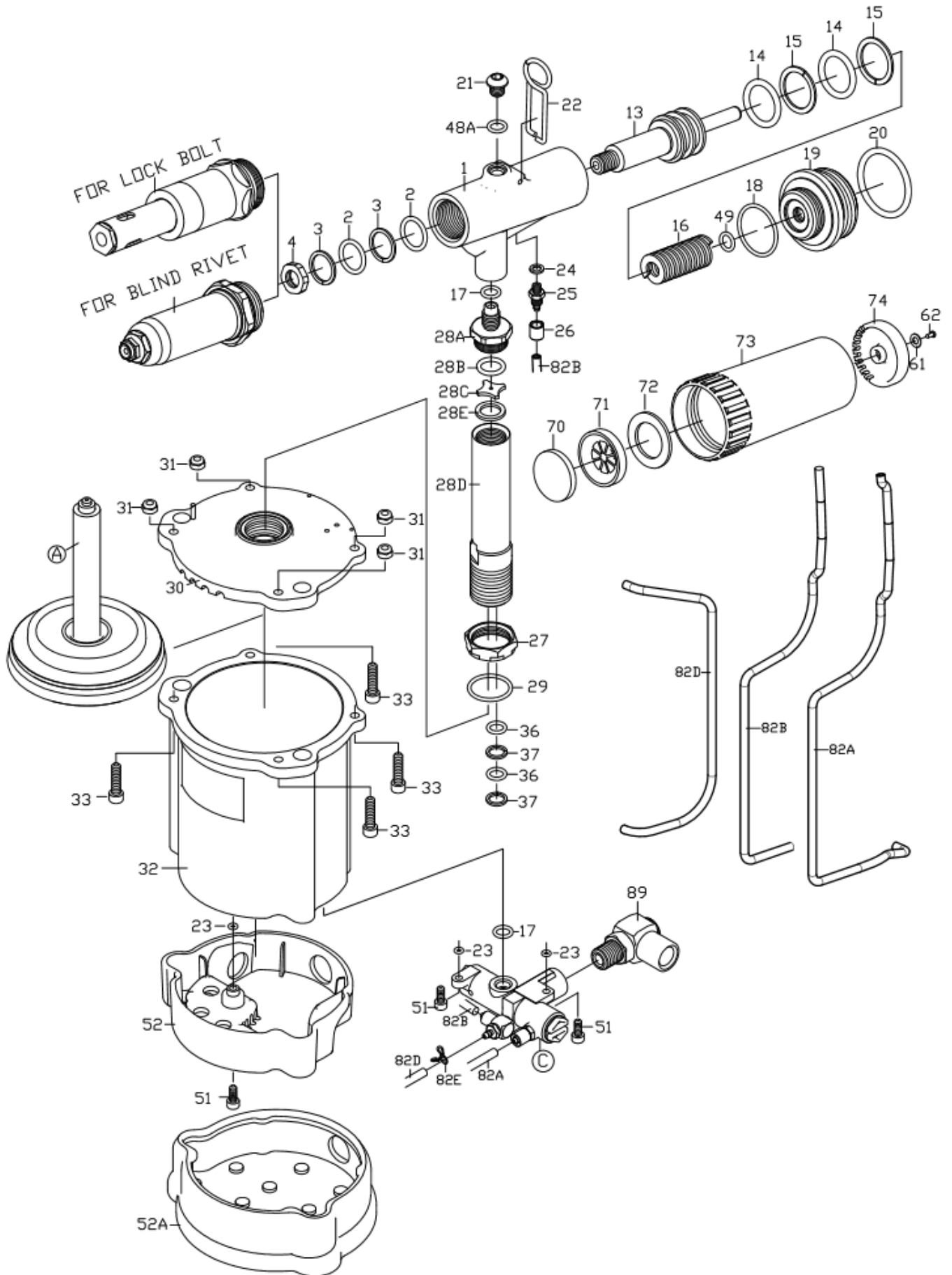
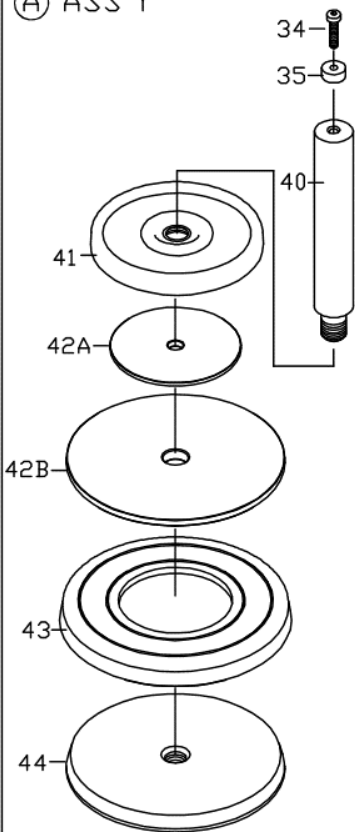


ZT2318HD / ZT2318HDK

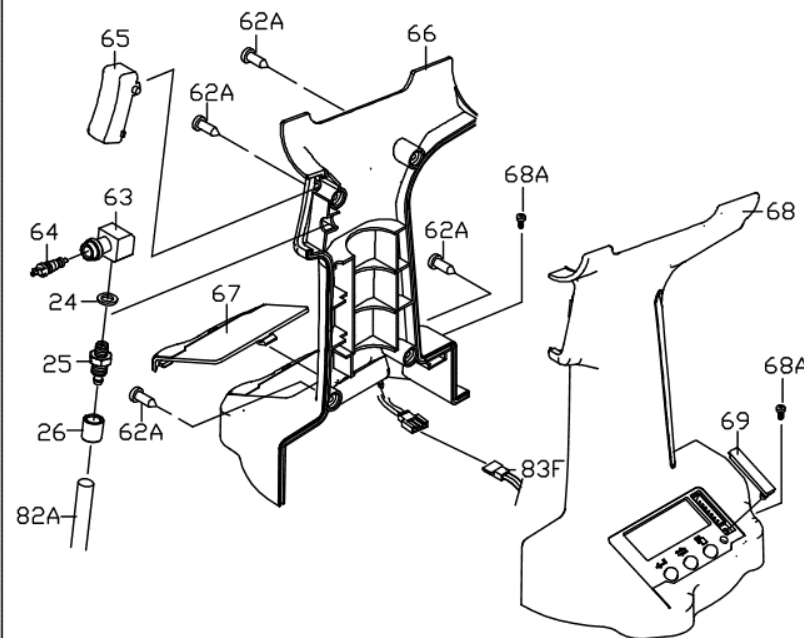
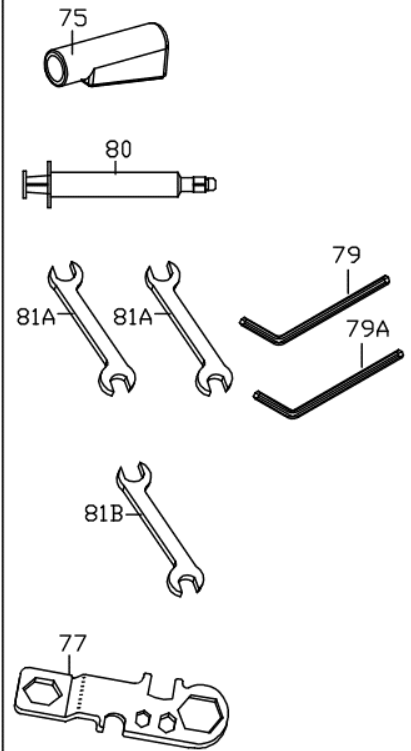
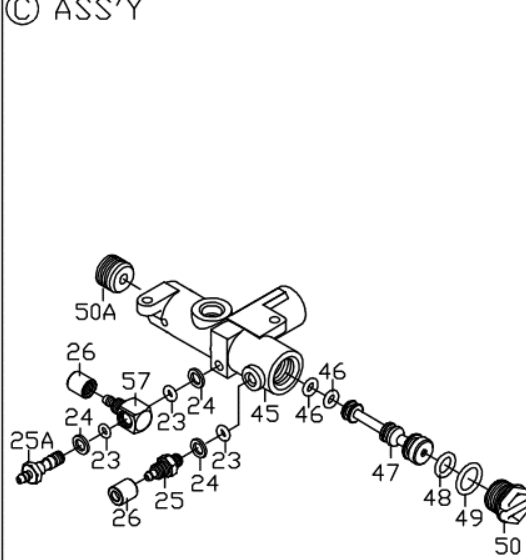
Air Hydraulic Lock Bolt Tool(W/Digital Module) /  
Air Hydraulic Lock Bolt Tool Kit(W/Digital Module)



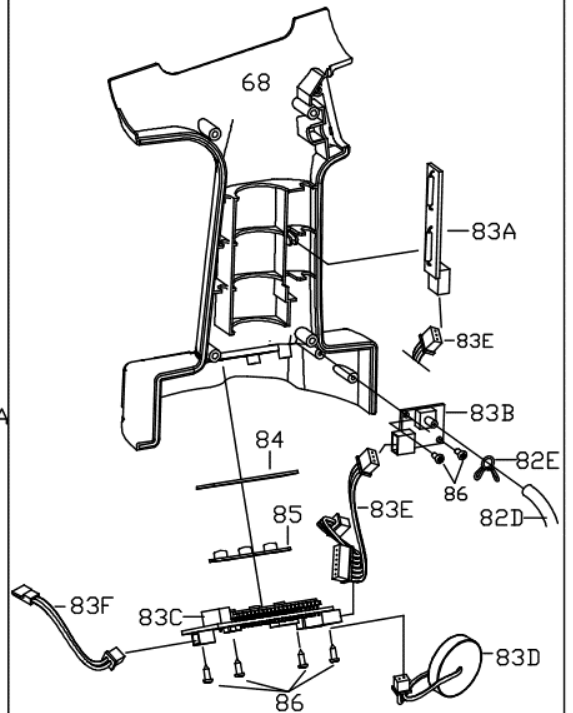
Ⓐ ASS'Y



Ⓒ 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																																									
		TYPE	202HB2 FOR 1/4" BOM ASS'Y																																								
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INDEX	PART#	DESCRIPTION	QT'Y																																								
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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)	<b>3/16" Fixed Grip Nose 1/4"Fixed Grip Nose 3/16"Multi Grip Nose 1/4"Multi Grip Nose</b>
		(ZT2318H with one size lock bolt nose assembly only ZT2318HK with all size nose assembly )
Max. Capacity		<b>1/4" Multi Grip Lock Bolts</b>

### 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.	OR1217	O-RING (2)	62A	HC00305006	Set Screw (4)	87A	819709SUS	Nose Piece 5/16"(8mm)
3.	BR1217	Back-Up Ring (2)	63.	107602	Valve Body			<b>FOR BLIND RIVET</b>
4.	202306	Nut	64.	107601	Bleeding Valve			<b>4.8mm,6.4mm</b>
5A	202315	Connector	65.	107201R	Trigger		<b>2318RS</b>	<b>(3/16",1/4") (OPT.)</b>
12A.	202115	Head(for Lock Bolt)	66	202107R	Plastic Grip-Right			Jaw Housing Coupler
12B.	202113	Lock Nut (for Lock Bolt)	67	202107C	Battery Cap	5	202325	(for Blind Rivet)
12C.	OR2630	O-RING	68.	202107LE	Plastic Grip-Left	6.	OR1417	O-RING (for Blind Rivet)
13.	231301	Hydraulic Plunger	68A.	HR002504506	Set Screw (2)	7.	819308	Spring (for Blind Rivet)
14.	OR2835	O-RING (2)	69.	202E09	Cover	8.	214302	Jaw Pusher (for Blind Rivet)
15.	BR2835	Back-Up Ring (2)	70.	919904	Silencer	9.	819303	Jaw (2) (for Blind Rivet)
16.	202309	Return Spring	71.	919903	Muffler Seat	10.	819324	Jaw Hosing (for Blind Rivet)
17.	OR0812	O-RING (2)	72	919905	Silencer	11.	819106	Lock Nut (for Blind Rivet)
18.	OR3034	O-RING	73.	919901	Mandrel Collector	12.	819105	Head (for Blind Rivet)
19.	202102	Rear Gland	74.	919906	Muffler Cap	87.	612706	Nose Piece 3/16" (4.8mm)
20.	OR3542	O-RING	75.	612901	Deflector			(for Blind Rivet)
21.	HR00812508	Set Screw	79.	314755	5mm Hex. Wrench			Nose Piece 1/4" (6.4mm)
22.	258801	Hanger	79A	314966	6mm Hex. Wrench			(for Blind Rivet)
23.	OR0306	O-RING (5)	80.	922901	Oiler			Nose Piece 1/4" (for Blind Rivet)
24.	612714	Washer (4)	82A	202704A	2.5x4 PU Hose			<b>FOR BLIND RIVET</b>
25.	612717	Socket (3)	82B	231704B	2.5x4 PU Hose			<b>3.2mm,4.0mm</b>
26.	612711	Cap (3)	82D	202704D	2.5x4 PU Hose			<b>(1/8",5/32") (OPT.)</b>
27.	520106	Nut	82E	258804	4mm Hose Loop (2)			Jaw Housing Coupler
28A.	5201082	Hydraulic Tube	83A	202E01	Counter Sensor			(for Blind Rivet)
		Connector-B	83B	202E02	Pressure Sensor			Nose Piece 1/4" (6.4mm)
28B	OR1417	O-RING	83C	202E03	Digital Display			(for Blind Rivet)
28C	8211012	Hydraulic Tube	83D	202E04	Lithium Battery			Nose Piece 1/4" (6.4mm)
		Washer	83E	202E05	Signal Terminal			(for Blind Rivet)
28D	2311081	Hydraulic Tube	83F	202E06B	Power Cable - Display Terminal		<b>2318RS-4</b>	<b>FOR BLIND RIVET</b>
		Connector-A	84.	202E07	Display			<b>3.2mm,4.0mm</b>
28E	5201083	Washer	85	202E08	Button			<b>(1/8",5/32") (OPT.)</b>
29.	OR2025	O-RING	86.	ST0206	Screw (6)	5.	202325	Jaw Housing Coupler
30.	202401RA	Upper Cover	89.	92L2	Air Inlet Assembly			(for Blind Rivet)
31.	NN005080	Nut (4)	90.	<b>202HC1A</b>	For 3/16" Fixed Grip ass'y	6.	OR1417	O-RING (for Blind Rivet)
32.	202403RZ	Air Cylinder Body			(for Lock Bolt)	7B.	612308	Spring (for Blind Rivet)
33.	HC00508020	Set Screw (4)			For 3/16" Multi Grip ass'y	8B.	214312	Jaw Pusher (for Blind Rivet)
34.	TC00508010S	Set Screw		202HM1	(for Lock Bolt)	9B.	612303	Jaw (2) (for Blind Rivet)
36.	OR1520	O-RING (2)			FOR 1/4" Blind Bolt ASS'Y	10B.	612324A	Jaw Hosing (for Blind Rivet)
37.	BR1520	Back-Up Ring (2)		202HB2	For 1/4" Fixed Grip ass'y	11.	819106	Lock Nut (for Blind Rivet)
40.	231501	Plunger Rod			(for Lock Bolt)	12.	819105	Head (for Blind Rivet)
41.	202505	Bumper Ring		231HC2	For 1/4" Multi Grip ass'y	87.	612704	Nose Piece 1/8" (3.2mm)
42A.	202504	Front Head Disc A			(for Lock Bolt)			(for Blind Rivet)
42B	202503	Front Head Disc B			FOR 1/4" Fixed Grip ass'y			Nose Piece 5/32" (4.0mm)
43.	920505	Packing Ring			(for Lock Bolt)			(for Blind Rivet)
44.	202502	Lower Plate		202HM2	For 1/4" Multi Grip ass'y			(for Blind Rivet)
45.	919211	Valve Case			(for Lock Bolt)			Multi-Wrench (A)(OPT)
46.	OR0408AS	O-RING (2)			Service Kit (opt.) (No.02.03.14.15.36. 37.46. 48.48A.49) <b>FOR BLIND RIVET</b>			Multi-Wrench (B) (OPT)
47.	919202	Valve Stem	<b>91</b>	<b>2318HDK</b>	<b>8mm(5/16") (OPT.)</b>			17x19 Wrench (2)
48.	OR0711	O-RING						19X21 Wrench
48A.	OR0711A	O-RING						
49.	OR1014	O-RING (2)		<b>2318RS-8</b>				
50.	107409	Inlet Plug						
50A	922409	Plug	5B	202305	Connector			
51.	HC00407010	Set Screw (3)	6	OR1417	O-RING	77	612904	
52.	202402	Base	7A	202308	Spring			
52A	202404	Rubber Boot	8A	202302	Jaw Pusher	78	918905	
61.	PW0306	Washer	9A.	202303	Jaw(3)			
			10A.	202304	Jaw Hosing	81A.	144905	
			11.	819106	Lock Nut (for Blind Rivet)	81B.	144906	

## Maintenance Schedule

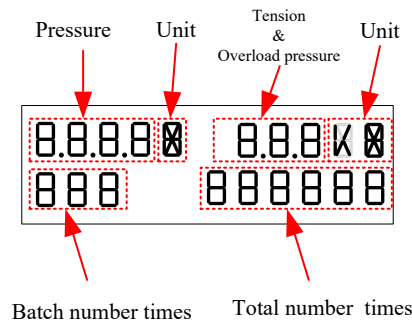
Frequency	Action
Daily after work or every <b>5,000 cycles</b>	Lubricate tool through <b>air inlet</b> . Clean inside of <b>Head</b>
Jaws will not grip rivet stem or <b>Every 20,000 cycles</b>	Replace new Jaws
When oil leakage occurs or every <b>50,000 cycles</b>	Replace <b>O-Rings</b> and <b>Back-Up-Rings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

## Troubleshooting

Symptom	Diagnosis	Remedy
Rivet cannot be set by a single pull	<ol style="list-style-type: none"> <li>Low working air pressure</li> <li>Tool requires re-priming</li> <li>Worn <b>Jaws</b> or dirt in <b>Jaws</b></li> <li>Broken <b>Jaws</b></li> </ol>	<ol style="list-style-type: none"> <li>Check air pressure at the tool.</li> <li>Priming the tool correctly according to the instruction</li> <li>Replace the <b>Jaws</b></li> </ol>
The tool can't do suction	The <b>Suction Switch</b> didn't open	Turn on the <b>Suction Switch</b> .
Jaws will not grip rivet mandrel	<ol style="list-style-type: none"> <li>Worn <b>Jaws</b> or build up of dirt on <b>Jaws</b></li> <li><b>Jaw Housing</b> loose</li> <li>Weakened <b>Jaw Pusher Spring</b></li> </ol>	<ol style="list-style-type: none"> <li>Clean before replace new <b>Jaws</b></li> <li>Tighten <b>Jaw Housing, Jaw Housing Coupler</b> and <b>Nut</b></li> <li>Replace new <b>Jaw Pusher Spring</b></li> </ol>
Broken rivet mandrel can't be released by <b>Jaws</b>	<ol style="list-style-type: none"> <li>Dirty <b>Jaws</b> and <b>Jaw Housing</b></li> <li>Weakened <b>Jaw Pusher Spring</b></li> <li>Hydraulic oil over primed.</li> </ol>	<ol style="list-style-type: none"> <li>Clean and re-lubricate</li> <li>Replace <b>Jaw Pusher Spring</b></li> <li>Remove <b>Plug Screw</b> and <b>O-Ring</b>, let it spill till stop by itself</li> </ol>
Broken rivet mandrel jammed inside the <b>Head</b>	<ol style="list-style-type: none"> <li>Damaged <b>Jaws</b></li> <li>Damaged or dirty <b>Jaw Pusher</b></li> </ol>	<ol style="list-style-type: none"> <li>Replace <b>Jaws</b></li> <li>Replace or clean <b>Jaw Pusher</b></li> </ol>
The suction force is not strong enough to suck broken mandrel	<ol style="list-style-type: none"> <li>Low air pressure</li> <li>Air leakage inside <b>Suction Switch</b></li> </ol>	<ol style="list-style-type: none"> <li>Check and regulate proper air pressure</li> <li>Check if exhaust air is stuck at rear end of <b>Collector</b></li> <li>Check and replace <b>O-Rings</b></li> </ol>
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 <sup>2</sup> .	Adjust the inlet pressure to the pressure below 7.5kg/cm <sup>2</sup> .
Digital monitor show "Er2".	<ol style="list-style-type: none"> <li>Oil leaking causes insufficient hydraulic oil</li> <li>Improper assembly of the tool</li> </ol>	<ol style="list-style-type: none"> <li>Check the cause of leakage and replace seals if necessary</li> <li>Re-prime hydraulic oil.</li> </ol>


# 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.

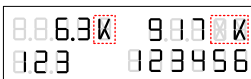


b. Push  button. Pressure and **pulling force** display begins to flash.

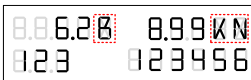
c. Push  button. Enter **Unit** choose mode, Air Pressure and **pulling force** unit display begins to flash.



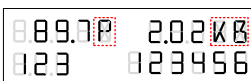
d. Push  button. Change unit.



Push  button again. Change unit.



Push  button again. Change unit.





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

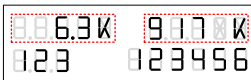
Table 1 below is **Unit** selection of **Air Pressure** and **Pulling Force**.


Table 1. Unit displays

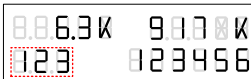
	Air Pressure unit	display	Pulling Force unit	display
<b>ISO</b>	Kg/Cm <sup>2</sup>	K	KgF	K
<b>ISO</b>	MPa	M	NF	N
<b>Newton</b>	Bar	B	NF	N
<b>ISS</b>	Psi	P	LbF	B


## 5. Setting batch number

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




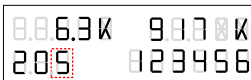
- b. Push  **button**. The batch number display begins to flash.




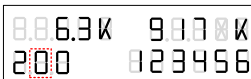
- c. Push  **button**. Enter batch number times function. The first number display begins to flash.




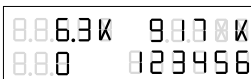
- d. Push  **button**. Change number 0~9.



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



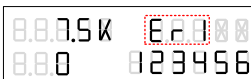
- f. Push  **button**. Finish batch number setting. The monitor is stop flashing. Batch number display will show "0".



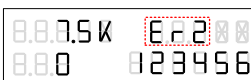
- g. Push  **button** twice, the batch number display will show "0"

## 6. Error message :

- a. If working air pressure is over 7.5 kg/ cm<sup>2</sup>(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".

