

# STANLEY

Engineered Fastening

## Instruction Manual

- EN Hydro-Pneumatic Blind Rivet Tool
- DA Hydropneumatisk værktøj til blindnitter
- DE Hydropneumatisches Blindnietwerkzeug
- ES Remachadora hidroneumática para remaches ciegos
- FI Hydropneumaattinen sokkoniittityökalu
- FR Outil de rivetage hydro-pneumatique pour rivets aveugles
- IT Utensile oleopneumatico per il piazzamento di rivetti a strappo
- NL Hydro-Pneumatisch blindklink gereedschap
- NO Hydro-pneumatisk popnagleverktøy
- PL Pneumatyczno-hydrauliczna nitownica do nitonakrętek
- PT Ferramenta de rebites cegos hidro-pneumática
- SV Hydropneumatisk blindnitverktyg



ProSet® XT3 Blind Rivet Tool – 76003

ProSet® XT4 Blind Rivet Tool – 76004

## Hydro-Pneumatic Power Tool

POP®  Avdel®

Figure 1

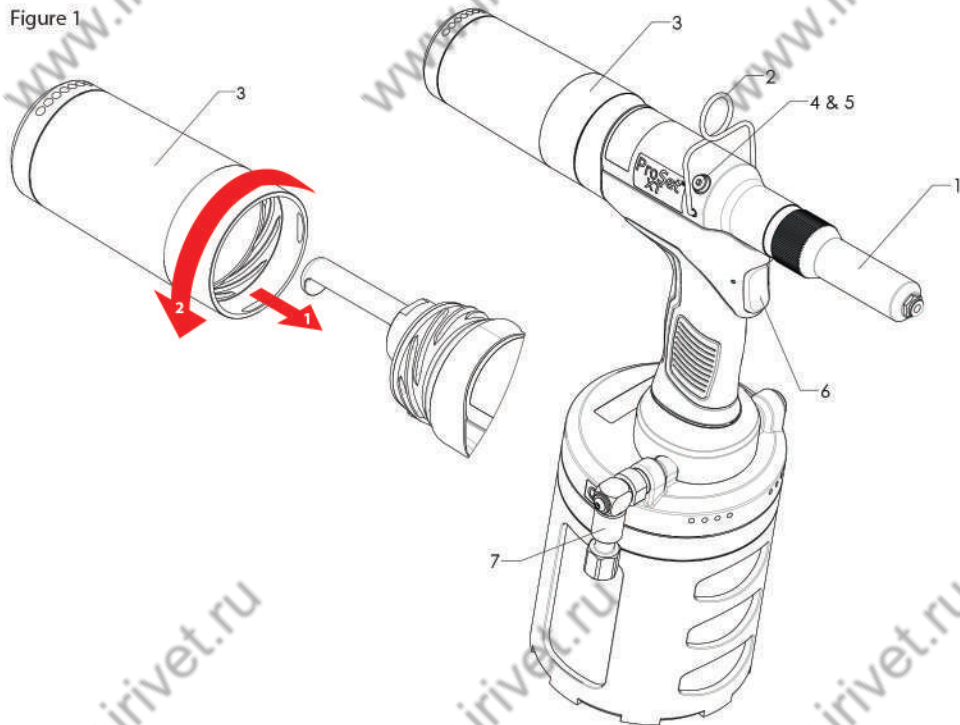


Figure 2

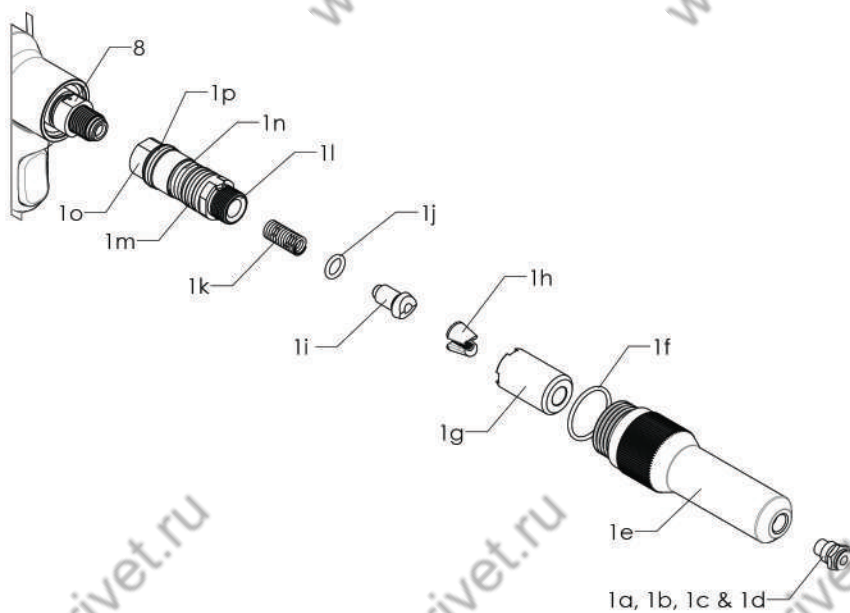


Figure 3

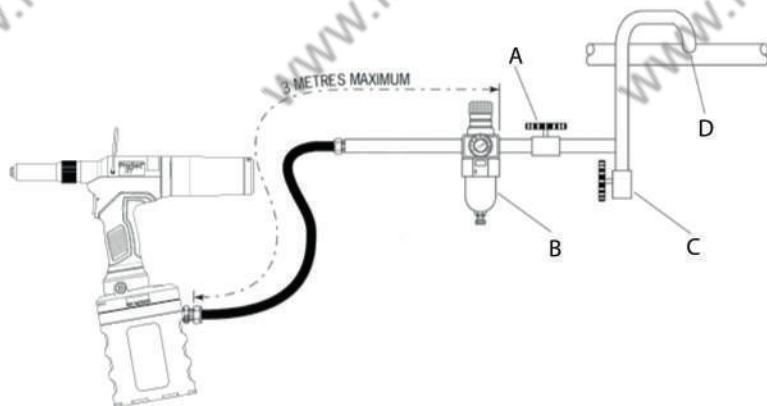


Figure 4

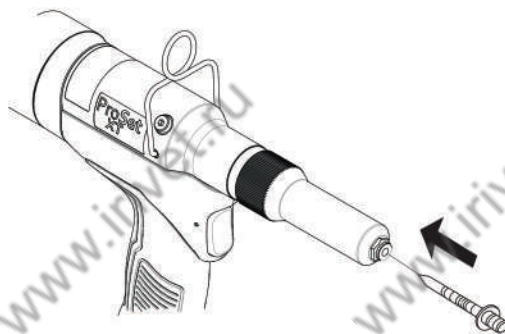


Figure 5

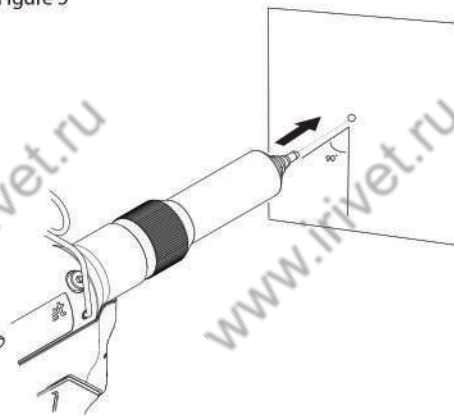
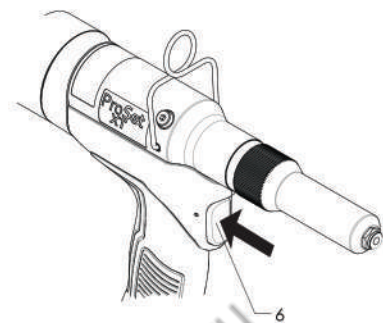


Figure 6



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This instruction manual must be read by any person installing or operating this tool with particular attention to the following safety rules.

## 1. SAFETY DEFINITIONS

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.



**DANGER:** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING:** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION:** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**CAUTION:** Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

***Improper operation or maintenance of this product could result in serious injury and property damage. Read and understand all warnings and operating instructions before using this equipment. When using power tools, basic safety precautions must always be followed to reduce the risk of personal injury.***

## SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

### **WARNING:**

- DO NOT use outside the design intent of Placing STANLEY Engineered Fastening Blind Rivets.
- Use only parts, fasteners, and accessories recommended by the manufacturer.
- DO NOT modify the tool in any way. Any modification to the tool is undertaken by the customer and will be the customer's entire responsibility and void any applicable warranties.
- Prior to use, check for misalignment or binding of moving parts, breakage of parts, and any other condition that affects the tool's operation. If damaged, have the tool serviced before using. Remove any adjusting key or wrench before use.
- The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained personnel. Any dismantling procedure will be undertaken only by trained personnel. Do not dismantle this tool without prior reference to the maintenance instructions.
- The operating supply air must not exceed 7 bar (100 PSI).
- Operators and others in work area must wear approved safety glasses with side shields. Always wear safety glasses and ear protection during operation.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- DO NOT operate a tool that is directed towards any person(s).
- DO NOT operate tool with the nose casing removed.
- Adopt a firm footing or a stable position before operating the tool.
- Prior to use, inspect airlines for damage, all connections must be secure. Do not drop heavy objects on Hoses. A sharp impact may cause internal damage and lead to premature hose failure.
- DO NOT lift the placing tool by the hose. Always use the placing tool handle.
- Vent holes must not become blocked or covered.
- Disconnect the air hose from the tool before performing any maintenance, attempting to adjust, fit or remove a nose assembly.
- Keep tool handles dry, clean, and free from oil and grease.
- When carrying the tool from place to place keep hands away from the trigger to avoid inadvertent activation.
- Never leave operating tool unattended. Disconnect air hose when tool is not in use.
- Adequate clearance is required for the tool operator's hands before proceeding.
- DO NOT abuse the tool by dropping or using it as a hammer.
- Keep dirt and foreign matter out of the hydraulic system of the tool as this will cause the tool to malfunction.
- Care should be taken to ensure that spent mandrels do not create a hazard.
- The mandrel collector must be emptied when approximately half full.
- DO NOT use the tool without mandrel collector installed.
- DO NOT let air exhaust opening on the mandrel collector face in the direction of the operator or other persons.
- Contact with hydraulic fluid should be avoided. To minimise the possibility of rashes, care should be taken to wash thoroughly if contact occurs.
- Material Safety Data Sheets for all hydraulic oils and lubricants is available on request from your tool supplier.

**STANLEY Engineered Fastening policy is one of continuous product development and improvement and we reserve the right to change the specification of any product without prior notice.**

## 2. SPECIFICATIONS

The ProSet® XT3 & XT4 are hydro-pneumatic tools designed to place Stanley Engineered Fastening blind rivets at high speed

The tools feature a vacuum system for rivet retention and trouble free collection of the spent mandrels regardless of tool orientation.

When coupled to the relevant nose equipment the ProSet®XT3 & XT4 can be used to place blind rivets in the range of Ø4.0mm to Ø6.4mm. Refer to the table on page 8 for a list of all rivets that can be placed.

The safety warnings on pages 5 & 6 must be followed at all times.

### 2.1. TOOL SPECIFICATIONS

	XT3		XT4	
<b>Pull-Force:</b> @5.5 bar	17.0 kN	3822 lbf	23.0 kN	5193 lbf
<b>Air Supply Pressure:</b> Min. to Max.	5.0 - 7.0 bar	72.5 - 101.5 lbf/in <sup>2</sup>	5.0 - 7.0 bar	72.5 -101.5 lbf/in <sup>2</sup>
<b>Oil Pressure:</b> Pull @ 5.5 bar	290 bar	4206 lbf/in <sup>2</sup>	395 bar	5729 lbf/in <sup>2</sup>
<b>Stroke:</b> Minimum Piston Stroke	26.0 mm	1.02 in.	18.0 mm	0.71 in.
<b>Weight:</b> Incl. nose equipment	2.14 kg	4.71 lb	2.16 kg	4.76 lb
<b>Weight:</b> without nose equipment	2.0 kg	4.41 lb	2.0 kg	4.41 lb
<b>Free Air Volume:</b> @ 5.5 bar	6.3 ltr	384.4 in <sup>3</sup>	6.3 ltr	384.4 in <sup>3</sup>
<b>Cycle Time:</b> Approximate	0.9 seconds	0.9 seconds	1.0 seconds	1.0 seconds
<b>Noise Level:</b> Uncertainty noise: k = 3db(A)	<78.4 dB(A)	<78.4 dB(A)	<77.9 dB(A)	<77.9 dB(A)
<b>Vibration Level:</b> Uncertainty vibration: k = 0.1 m/s <sup>2</sup>	<2.5 m/s <sup>2</sup>	<8.2 ft/s <sup>2</sup>	<2.5 m/s <sup>2</sup>	<8.2 ft/s <sup>2</sup>

## 2.2 PLACING SPECIFICATIONS

Rivet Type	Rivet Diameter mm [inches]										
	4 [5/32]	4,3	4,8 [3/16]	6	6,4 [1/4]	7	8	9	10	11	12
Open End	●*		●**		●						
Closed End	●*		●**		●						
HR	●*		●		●						
HS					● (3)						
Multi-Grip	●*		●**		●						
TL	●*		●								
T-Rivet (Emhart)	●*		●		●						
Self-Pluggger	●*		●		●						
Ultra Grip (UG) (NPR)					Ⓢ (3)						
CD					● (3)						
Avex®	● (2)		● (2)		● (2)						
Stavex®	● (2)		● (2)		● (1)(3)						
Avinox®/ Avibulb®	● (2)		● (2)	● (2)							
Avinox®XT / Avibulb®XT					● (1)(3)						
LSR/Bulbex®	● (2)		● (2)								
T-Lok®		● (2)	● (2)								
Avdel® SR	● (2)		● (2)		● (2)						
Hemlok®					● (1)(3)						
Interlock®			Ⓢ (2)		Ⓢ (1)(3)						
Maxlok®			● (3)		④ (3)						
Monobolt®			Ⓢ (1)(2)		Ⓢ (1)(3)						
Avtainer®									④ (1)(3)		
Avseal® (STD)				● (1)(3)		● (1)(3)	● (1)(3)	● (1)(3)	④ (1)(3)		
Avseal® (Low Press)							● (1)(3)	● (1)(3)	● (1)(3)	④ (1)(3)	④ (1)(3)
Q Rivet	● (2)		● (2)		● (2)						
T Rivet (Avdel)			● (1)(2)		● (1)(2)						
Avdelmate®			● (2)		● (2)						
Klamp-Tite® BAPK			Ⓢ (2)		Ⓢ (2)						
Klamp-Tite® BAPKTR			Ⓢ (1)(2)		Ⓢ (1)(2)						
Avdelok®			● (3)		④ (3)						

\* Use PRG540-46 jaws and FAN276-064 jaw pusher assembly

\*\* Use PRG540-46 jaws.

● Is applicable for both XT3 and XT4 tool

Ⓢ Is only applicable for XT3 tool

④ Is only applicable for XT4 tool

(1) Non-standard nose piece required

(2) Alternative type nose equipment available

(3) Non-standard nose equipment required.

For a full list of compatible nose equipment for each rivet type, together with assembly and maintenance instructions, please refer to the ProSet® nose equipment manual 07900-09414

### 2.3 THE PACKAGE CONTENTS

- 1 ProSet® XT3 or XT4 blind rivet tool.
- 1 set Standard Nose Equipment & Nosepieces for 3.2mm [1/8"], 4.0mm [5/32"], 4.8mm [3/16"] and 6.4mm [1/4"] rivets.
- 1 Printed Instruction Manual – region dependent.

### 2.4 MAIN COMPONENTS LIST

Refer to figure 1 & 2 and the table below.

Item	Part Number	Description	Qty
1	76003-15000	Standard nose equipment	1
2	76003-02022	Suspension hook	1
3	76003-05200	Mandrel collector	1
4	07001-00405	Oil plug	1
5	07003-00194	Seal	1
6	76003-02008	Trigger	1
7	76003-03700	On/Off valve	1
8	71210-02103	Locknut	1

### 2.5 STANDARD NOSE EQUIPMENT

Refer to figure 2 and the table below.

Item	Part Number	Description	Qty
1a	PRN414	Nose Piece - 3.2mm [1/8"]	1
1b	PRN514	Nose Piece - 4.0 mm [5/32"]	1
1c	PRN614	Nose Piece - 4.8 mm [3/16"] (Fitted)	1
1d	PRN811	Nose Piece - 6.4 mm [1/4"]	1
1e	76003-15001	Nose casing	1
1f	07003-00067	O ring	1
1g	DPN276-001	Jaw guide	1
1h	PRG540-44	Jaws	1 Set
1i	DPN276-006	Jaw pusher	1
1j	DPN900-060	O ring	1
1k	DPN901-019	Jaw pusher spring	1
1l	76003-15002	Pulling head	1
1m	76003-15004	Jaw guide lock	1
1n	DPN901-020	Spring	1
1o	76003-15003	Pulling head adapter	1
1p	07003-00277	O ring	1

For additional nose equipment please refer to the ProSet® Nose Equipment Manual 07900-09414 or visit [www.stanleyengineeredfastening.com/resource-center/document-library](http://www.stanleyengineeredfastening.com/resource-center/document-library)

For a full list of tool accessories, please refer to the ProSet Accessories Manual 07900-09415.



### 3. TOOL SET UP

**IMPORTANT - READ THE SAFETY WARNINGS ON PAGE 5 & 6 CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE ASSEMBLY.**

#### 3.1 NOSE EQUIPMENT (Ref. fig. 2)

Item numbers in bold refer to the components in figures 1 & 2 and the tables on page 9.

The complete tool will be supplied pre-assembled with the Nose Piece for 4.8mm [3/16"] rivets.

Three additional Nose Pieces for 3.2mm [1/8"], 4.0mm [5/32"] and 6.4mm [1/4"] rivets are supplied separately.

#### Mounting the nose piece

- The air supply must be disconnected.
- Select the correct nose piece for the rivet to be installed.
- Remove the nose casing (**1e**), including nose piece (**1a,b,c, or d**), and O ring (**1f**)
- Remove the nose piece (**1a,b,c or d**) from the nose casing (**1e**)
- Select the relevant size nose piece and assemble in reverse order.

#### Removing complete nose equipment.

- The air supply must be disconnected.
- Remove the nose casing (**1e**), including the nose piece (**1a,b,c or d**), and O ring (**1f**) from the tool.
- Pull back the jaw guide lock (**1m**) against the spring (**1n**) and then remove the jaw guide (**1g**).
- Remove the jaws (**1h**) from the jaw guide (**1g**).
- Remove jaw pusher (**1i**), O ring (**1j**), and Jaw pusher spring (**1k**), from the pulling head (**1l**).
- Remove the pulling head assembly (**1q**) from the tool piston using spanners

#### Mounting the complete nose equipment

- The air supply must be disconnected
- Any worn or damaged part should be replaced.
- Clean and check wear on jaws (**1h**).
- Ensure that the jaw pusher (**1i**) or the jaw pusher spring (**k**) are not distorted.
- Lightly coat jaws (**1h**) with moly lithium grease.
- Drop Jaws (**1h**) into the jaw guide (**1g**).
- Insert jaw pusher (**1i**) and O ring (**1j**) into the pulling head (**1l**).
- Pull back the jaw guide lock (**1m**) and screw the jaw guide (**1g**) fully on to the pulling head (**1l**).
- Release the jaw guide lock (**1m**) and then partially unscrew the jaw guide (**1g**) until the jaw guide lock (**1m**) tooth clicks into the next slot on the jaw guide (**1g**).
- Place nose casing (**1e**) over the jaw guide (**1g**) and tighten fully onto the tool.

Nose assemblies should be serviced at weekly intervals. You should hold some stock of all internal components of the nose assembly and nose tips as they will need regular replacement.

#### 3.2 AIR SUPPLY (Ref. fig. 3)

Components

- Stop cock (used during maintenance of filter/regular or lubricated units)
  - Pressure regulator and filter (daily drain)
  - Main supply drain point
  - Take off point from main supply
- All tools are operated with compressed air at a minimum pressure of 5.0 bar.
  - Pressure regulators and automatic oiling/filtering systems to be used on the main air supply within 3 metres of the tool (see fig. 3).
  - Air supply hoses will have a minimum working effective pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest.

- Air hoses must be oil resistant, have an abrasion resistant exterior and be armoured where operating conditions may result in hoses being damaged.
- All air hoses MUST have a minimum bore diameter of 6.4 millimetres.
- Check for air leaks. If damaged, hoses and couplings must be replaced by new items.
- If there is no filter on the pressure regulator, bleed the airline to clear it of accumulated dirt or water before connecting air hose to the tool.

### 3.3 PRINCIPLE OF OPERATION

**CAUTION - CORRECT SUPPLY PRESSURE IS IMPORTANT FOR PROPER FUNCTION OF THE INSTALLATION TOOL. PERSONAL INJURY OR DAMAGE TO EQUIPMENT MAY OCCUR WITHOUT CORRECT PRESSURES. THE SUPPLY PRESSURE MUST NOT EXCEED THAT LISTED IN THE PLACING TOOL SPECIFICATION**

Item numbers in bold refer to the components in figures 1 & 2 and the tables on page 9.

When the pneumatic hose is connected to the placing tool, the pull and return cycles of the tool are controlled by depressing and releasing the trigger (**6**) located in the handle.

- Air supply is disconnected.
- Connect the appropriate nose equipment as described on page 8 & 10.
- Connect the pneumatic hose to the air on/off valve (**7**).
- Connect the pneumatic hose mains air supply.
- Switch on the mains supply to the tool by sliding the air on/off valve (**7**) to the up position.
- Air is now be supplied to the tool and the vacuum system is in operation.
- Pull and release the trigger (**6**) a few times to the full stroke of the tool to check operation. Observe action of tool. Check for fluid and/or air leaks.

## 4. OPERATION PROCEDURE

### 4.1 TOOL OPERATION (Ref. fig. 1, 4, 5, 6)

#### Installing a blind rivet

- Ensure that the mandrel collector (**3**) is fitted.
- Insert rivet mandrel into the nose piece (**1a,b,c or d**). The vacuum system will retain the rivet in the nose piece.
- Position the tool.
- Ensure nose equipment is at right angle (90°) to the work piece.
- Pull and hold trigger (**6**) until the rivet is fully set in the application.
- When the rivet has been set completely, release the trigger (**6**). The tool will return to its initial position automatically. The mandrel is automatically dropped into the mandrel collector (**3**) by the vacuum system.
- Mandrel collector must be emptied before it is half full.

**CAUTION –DO NOT FORCE THE INSERTION OF A RIVET MANDREL OR RIVET BODY. THIS WILL CAUSE DAMAGE TO THE TOOL AND/OR APPLICATION.**

### 4.2 EMPTYING THE MANDREL COLLECTOR (Ref. fig. 1)

#### CAUTION - DO NOT USE THE TOOL WHEN THE MANDREL COLLECTOR IS REMOVED

- The tool is fitted with a quick connect/release mandrel collector (**3**).
- A 60° rotation removes or replaces the mandrel collector.
- Removing the mandrel collector (**3**) from the tool automatically turns OFF the vacuum rivet retention and mandrel extraction system.
- Refitting the mandrel collector turns the vacuum system ON.

## 5. SERVICING THE TOOL

### 5.1 MAINTENANCE FREQUENCY

Regular servicing must be carried out by trained personnel and a comprehensive inspection performed annually or every 500,000 cycles, whichever is sooner.



DISCONNECT AIR SUPPLY



**CAUTION** - Never use solvents or other harsh chemicals for cleaning the non-metallic parts of the tool. These chemicals may weaken the materials used in these parts.

### 5.2 NOSE EQUIPMENT

Nose assemblies need to be serviced at weekly intervals or every 5,000 cycles. Hold some stock of all internal components of the nose assembly and nose pieces, they need regular replacement.

- Disconnect the air supply
- Remove the complete nose assembly using the procedure described in section 3.1.
- Inspect all components. Any worn or damaged parts must be replaced by a new part.
- Particularly check wear on the Jaws (**1h**).
- Clean all parts and apply moly lithium Grease (07992-00020) to jaws (**1h**) and taper bore of jaw guide (**1g**).
- Assemble according to fitting instructions in section 3.1.

### 5.3 DAILY SERVICING

- Before use, check the tool, hose and couplings for air leaks and oil leaks. If damaged, remove the tool from service and replace affected items with new parts.
- If there is no filter on the pressure regulator, bleed the airline to clear it of accumulated dirt or water before connecting the air hose to the tool. If there is a filter, drain it.
- Check that the nose equipment (**1**) is correct for the rivet to be placed and that it is fitted properly.
- Check that the stroke of the tool meets the minimum specification (ref. 2.1).
- The mandrel collector (**3**) must fitted to the tool.
- Check that the air chamber is fully tightened onto the tool body.

### 5.4 WEEKLY SERVICING

- Check the tool, hose and couplings for air leaks and oil leaks. If damaged, remove the tool from service and replace affected items with new parts.

For full servicing, troubleshooting and maintenance instructions please refer to the Service Manual Nr. 07900-09410 for the XT3 and 07900-09411 for the XT4.

For Safety Data relating to the grease and oil used in this tool please refer to the Service Manual Nr. 07900-09410 for the XT3 and 07900-09411 for the XT4.

## 6. EC-DECLARATION OF CONFORMITY

### Original

We, **Avdel UK Limited; Stanley House, Works Road, Letchworth Garden City, Hertfordshire, SG6 1JY UNITED KINGDOM**, declare under our sole responsibility that the product:

**Description**

ProSet® XT3 and ProSet® XT4 Hydro-Pneumatic tools for Blind Rivets

**Brand/Model**

POP-Avdel® / 76003 and POP-Avdel® / 76004

**Serial No.**

to which this declaration relates is in conformity with the following standard:

ISO 12100:2010	EN ISO 3744:2010
EN ISO 11202:2010	EN ISO 11148-1:2011
EN ISO 4413:2010	BS EN 28662-1:1993
EN ISO 4414:2010	EN ISO 20643:2008+A1:2012
EN ISO 28927-5:2009/A1:2015	

Technical documentation is compiled in accordance with Annex 1, section 1.7.4.1, in accordance with the following Directive:

**2006/42/EC The Machinery Directive**

UK Statutory Instruments 2008 No 1597 - The Supply of Machinery (Safety) Regulations refers.

**A. K. Seewraj**
**Technology Manager – EU Blind Fastening**

Avdel UK Limited; Stanley House, Works Road, Letchworth Garden City,  
Hertfordshire, SG6 1JY UNITED KINGDOM

**Signature**
**Place of issue**
**Letchworth Garden City**
**Date of issue**
**01.03.2017**


This machinery is in conformity with Machinery Directive 2006/42/EC.

## **7. PROTECT YOUR INVESTMENT!**

### **7.1 POP®AVDEL® BLIND RIVET TOOL WARRANTY**

STANLEY Engineered Fastening warrants that all power tools have been carefully manufactured and that they will be free from defect in material and workmanship under normal use and service for a period of one (1) year.

This warranty applies to the first time purchaser of the tool for original use only.

#### **Exclusions:**

##### **Normal wear and tear.**

Periodic maintenance, repair and replacement parts due to normal wear and tear are excluded from coverage.

##### **Abuse & Misuse.**

Defect or damage that results from improper operation, storage, misuse or abuse, accident or neglect, such as physical damage are excluded from coverage.

##### **Unauthorized Service or Modification.**

Defects or damages resulting from service, testing adjustment, installation, maintenance, alteration or modification in any way by anyone other than STANLEY Engineered Fastening, or its authorized service centres, are excluded from coverage.

All other warranties, whether expressed or implied, including any warranties of merchantability or fitness for purpose are hereby excluded.

Should this tool fail to meet the warranty, promptly return the tool to our factory authorized service centre location nearest you. For a list of POP®Avdel® Authorized Service Centres in the US or Canada, contact us at our toll free number (877)364 2781.

Outside the US and Canada, visit our website [www.StanleyEngineeredFastening.com](http://www.StanleyEngineeredFastening.com) to find your nearest STANLEY Engineered Fastening location.

STANLEY Engineered Fastening will then replace, free of charge, any part or parts found by us to be defective due to faulty material or workmanship, and return the tool prepaid. This represents our sole obligation under this warranty.

In no event shall STANLEY Engineered Fastening be liable for any consequential or special damages arising out of the purchase or use of this tool.

### **7.2 REGISTER YOUR BLIND RIVET TOOL ONLINE.**

To register your warranty online, visit us at

<http://www.stanleyengineeredfastening.com/popavdel-powertools/warranty-card>.

Thank you for choosing a STANLEY Engineered Fastening's POP®Avdel® Brand tool.



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