



# Avdel



## Instruction Manual

Pass onto user to read and keep for reference



**Hydro-Pneumatic Power Tool**

# 0734 type

**07340 - 07344 - 07345  
07346 - 07347 - 07348 models**

AVDEL policy is one of continuous development. Specifications shown in this document may be subject to changes which may be introduced after publication. For the latest information always consult Avdel.

### SPECIFICATIONS FOR 0734 TYPE TOOL

AIR PRESSURE	■	Minimum - Maximum	■	<b>4.8 - 7 bar</b>	■	70 - 100 lbf/in <sup>2</sup>
FREE AIR VOLUME REQUIRED	■	@ 5.5 bar / 80 lbf/in <sup>2</sup>	■	<b>1.59 litres</b>	■	.056 ft <sup>3</sup>
STROKE	■	Minimum	■	<b>16 mm</b>	■	.625 in
PULL FORCE	■	@ 4.8 bar / 70 lbf/in <sup>2</sup>	■	<b>10.91 kN</b>	■	2450 lbf
CYCLE TIME	■	Approximately	■	<b>1.5 seconds</b>	■	
NOISE LEVEL	■		■	<b>73.4 dB(A)</b>	■	
WEIGHT	■	Without nose equipment	■	<b>1.66 kg</b>	■	3.65 lb
VIBRATION	■		■	<b>2.55 m/s<sup>2</sup></b>	■	

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# S A F E T Y

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

⚠ DO NOT USE OUTSIDE THE DESIGN INTENT.

⚠ DO NOT USE EQUIPMENT WITH THIS TOOL/MACHINE OTHER THAN THAT RECOMMENDED AND SUPPLIED BY AVDEL.

⚠ ANY MODIFICATION UNDERTAKEN BY THE CUSTOMER TO THE TOOL/MACHINE, NOSE ASSEMBLIES, ACCESSORIES OR ANY EQUIPMENT SUPPLIED BY AVDEL OR THEIR REPRESENTATIVES, SHALL BE THE CUSTOMER'S ENTIRE RESPONSIBILITY. AVDEL WILL BE PLEASED TO ADVISE UPON ANY PROPOSED MODIFICATION.

⚠ THE TOOL/MACHINE MUST BE MAINTAINED IN A SAFE WORKING CONDITION AT ALL TIMES AND EXAMINED AT REGULAR INTERVALS FOR DAMAGE AND FUNCTION BY TRAINED COMPETENT PERSONNEL. ANY DISMANTLING PROCEDURE SHALL BE UNDERTAKEN ONLY BY PERSONNEL TRAINED IN AVDEL PROCEDURES. DO NOT DISMANTLE THIS TOOL/MACHINE WITHOUT PRIOR REFERENCE TO THE MAINTENANCE INSTRUCTIONS. CONTACT AVDEL WITH YOUR TRAINING REQUIREMENTS.

⚠ THE TOOL/MACHINE SHALL AT ALL TIMES BE OPERATED IN ACCORDANCE WITH RELEVANT HEALTH AND SAFETY LEGISLATION. IN THE U.K. THE "HEALTH AND SAFETY AT WORK ETC. ACT 1974" APPLIES. ANY QUESTION REGARDING THE CORRECT OPERATION OF THE TOOL/MACHINE AND OPERATOR SAFETY SHOULD BE DIRECTED TO AVDEL.

⚠ THE PRECAUTIONS TO BE OBSERVED WHEN USING THIS TOOL/MACHINE MUST BE EXPLAINED BY THE CUSTOMER TO ALL OPERATORS.

⚠ ALWAYS DISCONNECT THE AIRLINE FROM THE TOOL/MACHINE INLET BEFORE ATTEMPTING TO ADJUST, FIT OR REMOVE A NOSE ASSEMBLY.

⚠ DO NOT OPERATE A TOOL/MACHINE THAT IS DIRECTED TOWARDS ANY PERSON(S).

⚠ ALWAYS ADOPT A FIRM FOOTING OR A STABLE POSITION BEFORE OPERATING THE TOOL/MACHINE.

⚠ ENSURE THAT VENT HOLES DO NOT BECOME BLOCKED OR COVERED AND THAT HOSES ARE ALWAYS IN GOOD CONDITION.

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In addition to the general safety rules opposite, the following specific safety points must also be observed:

- ⚠ THE OPERATING PRESSURE SHALL NOT EXCEED 7 BAR - 100 LBF/IN<sup>2</sup>.
- ⚠ DO NOT OPERATE THE TOOL WITHOUT FULL NOSE EQUIPMENT IN PLACE. 07345 AND 07346 TOOLS SHOULD NOT BE OPERATED IF THE GUARD IS DAMAGED IN ANY WAY.
- ⚠ CARE SHALL BE TAKEN TO ENSURE THAT SPENT STEMS ARE NOT ALLOWED TO CREATE A HAZARD.
- ⚠ 07340, 07344, 07347 AND 07348 TOOLS MUST BE FITTED WITH AN UNDAMAGED PINTAIL DEFLECTOR OR STEM CATCHER BEFORE OPERATING.
- ⚠ IF THE 0734 TOOL IS FITTED WITH A PINTAIL DEFLECTOR AND IS USED IN THE VERTICAL NOSE DOWNWARD POSITION, THE PINTAIL DEFLECTOR SHOULD BE ROTATED UNTIL THE APERTURE IS FACING AWAY FROM THE OPERATOR AND OTHER PERSON(S) WORKING IN THE VICINITY.
- ⚠ WHEN USING THE TOOL, THE WEARING OF SAFETY GLASSES IS REQUIRED BOTH BY THE OPERATOR AND OTHERS IN THE VICINITY TO PROTECT AGAINST RIVET EJECTION, SHOULD A FASTENER BE PLACED 'IN AIR'. WE RECOMMEND WEARING GLOVES IF THERE ARE SHARP EDGES OR CORNERS ON THE APPLICATION.
- ⚠ TAKE CARE TO AVOID ENTANGLEMENT OF LOOSE CLOTHES, TIES, LONG HAIR, CLEANING RAGS ETC... IN THE MOVING PARTS OF THE TOOL WHICH SHOULD BE KEPT DRY AND CLEAN FOR BEST POSSIBLE GRIP.
- ⚠ WHEN CARRYING THE TOOL FROM PLACE TO PLACE KEEP HANDS AWAY FROM THE TRIGGER/LEVER TO AVOID INADVERTENT START UP.
- ⚠ EXCESSIVE CONTACT WITH HYDRAULIC OIL SHOULD BE AVOIDED. TO MINIMIZE THE POSSIBILITY OF RASHES, CARE SHOULD BE TAKEN TO WASH THOROUGHLY.

# CONTENT OF USE

The hydro-pneumatic 0734 type tool is designed to place Avdel breakstem rivets at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

There are six different models of this type of tool. Select the one most suited to your application requirements or environment.

The 07340 fitted with a pintail deflector is the standard tool for which a stem catching option is available (see accessories page 11). It is also possible to order the base tool only (part number 07340-00200) which will not be fitted with a nose assembly.

The base tool part number for the 07344/07345/07346 models is also 07340-00200. The base tool part number for the 07347 is 07347-00200 and for the 07348 is 07348-00200. Differences between the base tools are shown on the general assembly drawings pages 22 to 27.

07340 TOOL SELECTION										
FASTENER			NOSE (see drawing opposite for A & B)						COMPLETE	
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°	
AVEX Snap head & 120° csk head except 07340-00019 large flange only.	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07490-00900	07340-00001	
		Al. Alloy	Extended	9.5	12.9	.375	.510	07490-01000	07340-00002	
		Al. Alloy	Head Forming	12.7	3.3	.500	.130	07490-04100	07340-00003	
	3 mm	5/32"	Steel	Standard	12.7	3.3	.500	.130	07490-01600	07340-00008
			Al. Alloy	Extended	12.7	3.3	.500	.130	07490-01400	07340-00006
			Al. Alloy	Standard	12.7	3.3	.500	.130	07490-01600	07340-00008
		3/16"	Al. Alloy	Extended	9.5	11.4	.375	.450	07490-01700	07340-00009
			Al. Alloy	Head Forming	12.7	3.3	.500	.130	07490-04200	07340-00010
			Steel	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015
	5/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07340-00016	
		Al. Alloy	Head Forming	12.7	4.1	.500	.160	07490-04300	07340-00017	
		Steel	Standard	12.7	3.3	.500	.130	07490-04900	07340-00018	
		Al. Alloy L/flange	Standard	19.0	4.1	.750	.162	07490-05000	07340-00019	
		Steel	Extended	9.5	11.8	.375	.465	07340-07300	07340-00036	
MONOBOLT	3/16"	Al. Alloy & Steel▲	Standard	12.7	4.1	.500	.160	07498-04500	07340-00031	
BULBEX	5/32"	Al. Alloy	Standard	12.7	3.3	.500	.130	07490-01600	07340-00008	
		Al. Alloy	Extended	9.5	11.4	.375	.450	07490-01700	07340-00009	
	3/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07340-00016	
AVSEAL	4mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07340-07600	07340-00064	
		Al. Alloy	Extended	12.7	6.7	.500	.264	07498-08400	07340-00074	
	5mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07640-02100	07340-00065	
		Al. Alloy	Extended	12.7	6.7	.500	.264	07640-03100	07340-00075	
	6mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07640-02200	07340-00066	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07640-03200	07340-00076	
	6.5mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07640-08300	07340-00062	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07498-09100	07340-00072	
	7mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07640-02200	07340-00067	
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07640-03400	07340-00077	
	TLR	3/16"	Al. Alloy	Standard	12.7	4.1	.500	.160	07498-01600	07340-00058
	AVINOX	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07490-01600	07340-00008
5/32"		Stainless Steel	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
AVEX Snap head & 120° csk head Forward stem release	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-04500	07340-00037	
		Steel	Standard	12.7	3.3	.500	.130	07381-04600	07340-00038	
	5/32"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-04600	07340-00038	
		Steel	Standard	12.7	3.3	.500	.130	07381-04700	07340-00039	
	3/16"	A. Alloy	Standard	12.7	3.3	.500	.130	07381-04700	07340-00039	
		Steel	Standard	12.7	3.3	.500	.130	07381-04800	07340-00040	
BULBEX Forward stem release	5/32"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-04600	07340-00038	
	3/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	07381-04700	07340-00039	
AVINOX Forward stem release	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07381-04600	07340-00038	
	5/32"	Stainless Steel	Standard	12.7	3.3	.500	.130	07381-04700	07340-00039	
T-LOK	4.3mm	Steel	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
		Steel	Extended	9.5	10.0	.375	.395	07241-07300	07340-00014	
	3/16"	Steel	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	
		Steel	Extended	9.5	10.0	.375	.395	07241-07300	07340-00014	
AVIBULB	1/8"	Steel	Standard	12.7	3.3	.500	.130	07490-01600	07340-00008	
	5/32"	Steel	Standard	12.7	3.3	.500	.130	07490-02300	07340-00015	

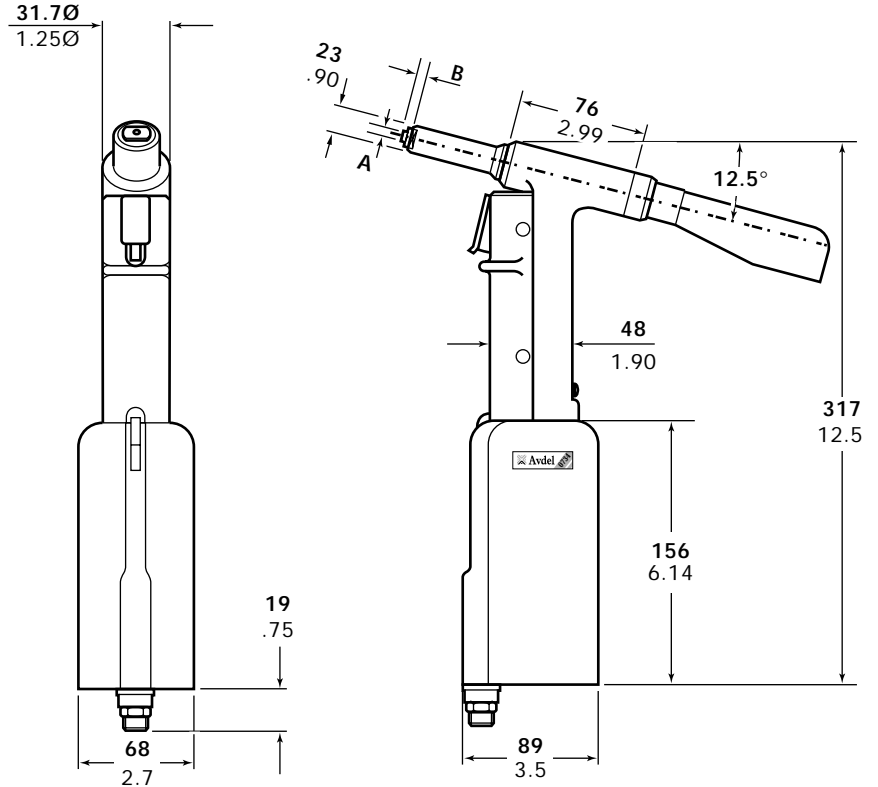
Minimum Pressure required      ■ 5.1 BAR / 75 lbf/in<sup>2</sup>      ▲ 5.4 BAR / 80 lbf/in<sup>2</sup>      ● 6.1 BAR / 90 lbf/in<sup>2</sup>

## 07340 & 07344 - FIXED NOSE ASSEMBLY

The 07340 and 07344 are fitted with fixed straight nose assemblies suitable where access is unrestricted.

Use the selection charts below and opposite to select a complete 07340 or 07344 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 12 and 13.

'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.  
Other dimensions are in inches.

### 07344 TOOL SELECTION

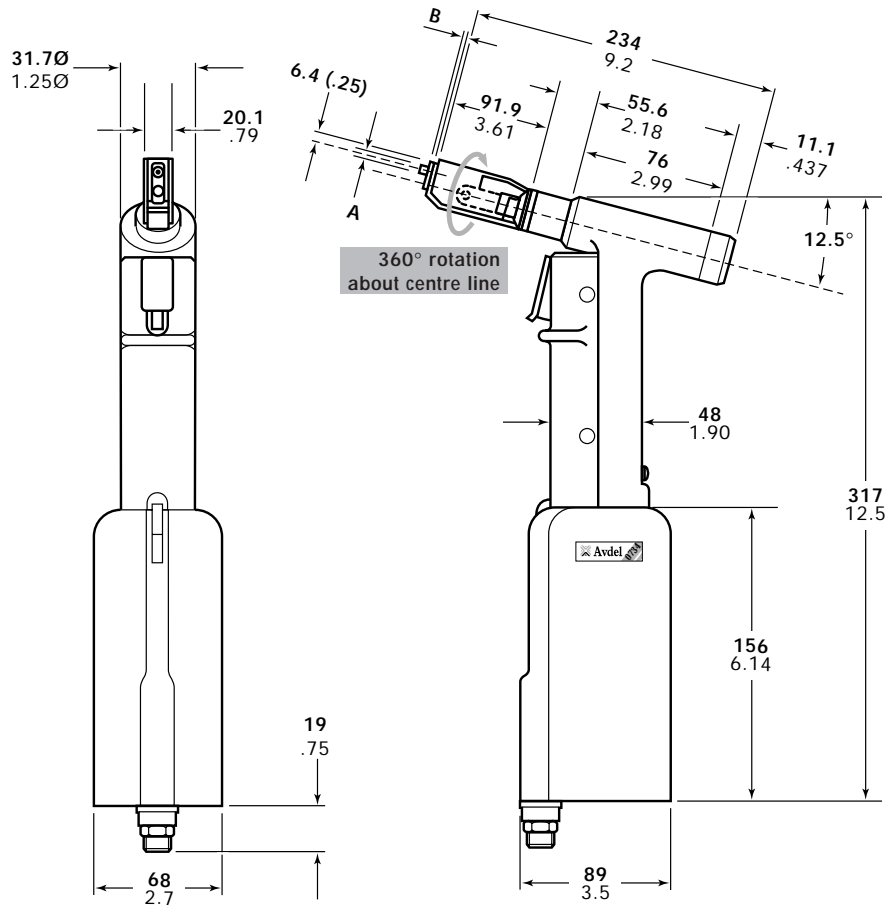
FASTENER		NOSE (see drawing above for A & B)						COMPLETE	
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A(mm)	B(mm)	A(in)	B(in)	NOSE ASSY PART N°	TOOL PART N°
<b>AVDEL</b> Snap head & 100° csk & 120° csk	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07344-02100	07344-00003
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02300	07344-00005
	5/32"	Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-02900	07344-00007
		Stainless Steel	Standard	12.7	2.5	.500	.100	07344-02400	07344-00010
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02600	07344-00012
	3/16"	Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-03000	07344-00013
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02700	07344-00019
Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-03100	07344-00020		
<b>MBC</b> Universal head & 100° csk	1/8"	Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02400	07344-00045
		Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07498-07000	07344-00054
	5/32"	Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06700	07344-00051
		Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02500	07344-00046
		Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06800	07344-00052
	3/16"	Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07344-03200	07344-00055
		Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06900	07344-00053
<b>LVC MBC</b> Universal head & 100° csk	1/8"	Stainless Steel	Standard	12.7	4.7	.500	.187	07344-04700	07344-00037
		Al. Alloy	Standard	12.7	4.7	.500	.187	07498-07600	07344-00033
	5/32"	Hybrid oversize	Standard	12.7	4.7	.500	.187	07498-07300	07344-00057
		Stainless Steel	Standard	12.7	4.7	.500	.187	07344-04700	07344-00037
		Al. Alloy	Standard	12.7	4.7	.500	.187	07344-05100	07344-00034
	3/16"	Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07344-05100	07344-00034
		Hybrid oversize	Standard	12.7	4.7	.500	.187	07344-05300	07344-00058
Al. Alloy	Extended	12.7	4.7	.500	.187	07498-07800	07344-00035		

## 07345 - STRAIGHT SWIVEL NOSE ASSEMBLY

The 07345 is fitted with a "straight" swivel type of nose assembly for use on applications with restricted access.

It will place all the fasteners listed in the selection table below. Use this table to select a complete 07345 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 15 and 16 .

'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.  
Other dimensions are in inches.

### 07345 TOOL SELECTION

FASTENER		NOSE (see drawing above for A & B)							COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
<b>AVEX</b> Snap head & 120° csk head	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03000	07345-00004
	5/32"	Steel	Standard	7.87	3.81	.310	.150	07345-03100	07345-00005
		Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03100	07345-00005
	3/16"	Steel	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006
<b>AVDEL</b> Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006
		Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006
		Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006
	5/32"	Al. Alloy	Standard	5.08	1.17	.200	.046	07345-03300	07345-00014
		Al. Alloy oversize	Standard	5.08	1.17	.200	.046	07494-03600	07345-00017
		Stainless Steel	Standard	5.08	3.81	.200	.150	07494-03000	07345-00024
		Al. Alloy	Standard	6.6	0.84	.260	.033	07345-03400	07345-00015
3/16"	Al. Alloy oversize	Standard	6.6	0.84	.260	.033	07494-03700	07345-00018	
	Al. Alloy	Standard	8.13	0.25	.320	.010	07345-03500	07345-00016	
3/32"	Al. Alloy oversize	Standard	8.13	0.25	.320	.010	07494-03800	07345-00019	
<b>MBC</b> Universal head & 100° csk	1/8"	Stainless Steel	Standard	5.08	1.27	.200	.050	07494-03400	07345-00023
		Al. Alloy	Standard	4.75	2.40	.187	.094	07345-04000	07345-00051
		Stainless Steel	Standard	4.75	2.40	.187	.094	07345-04000	07345-00051
	5/32"	Al. Alloy oversize	Standard	4.75	2.40	.187	.094	07345-04300	07345-00054
		Al. Alloy	Standard	6.35	2.40	.250	.094	07345-04100	07345-00052
		Stainless Steel	Standard	6.35	2.40	.250	.094	07345-04100	07345-00052
		Al. Alloy oversize	Standard	6.35	2.40	.250	.094	07345-04400	07345-00055
3/16"	Al. Alloy	Standard	7.92	2.40	.312	.094	07345-04200	07345-00053	
<b>BULBEX</b>	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03100	07345-00005
	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006
<b>AVSEAL</b>	4mm	Al. Alloy	Standard	6.35	1.95	.250	.077	07494-06000	07345-00064
		Al. Alloy	Extended	6.35	4.11	.250	.162	07494-06600	07345-00074
	5mm	Al. Alloy	Standard	7.62	2.00	.300	.079	07494-06100	07345-00065
		Al. Alloy	Extended	7.62	4.11	.300	.162	07494-06700	07345-00075
<b>AVINOX</b>	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03100	07345-00005
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07345-03200	07345-00006

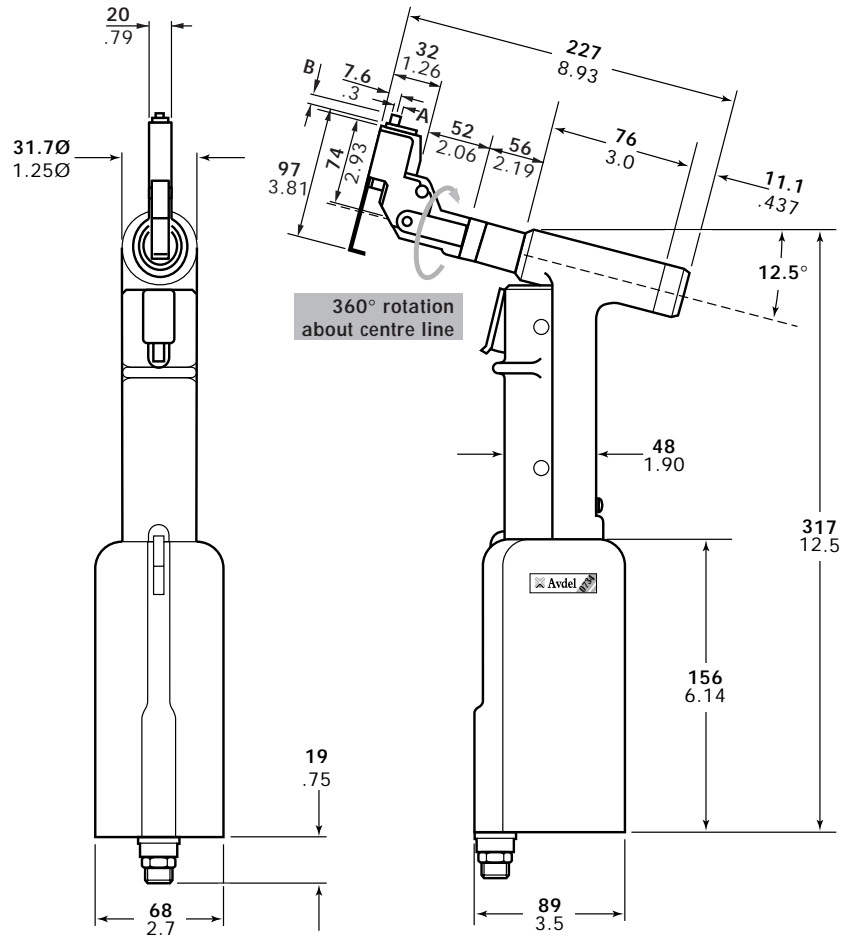


## 07346 - RIGHT ANGLE SWIVEL NOSE ASSEMBLY

The 07346 is fitted with a "right angle" swivel type of nose assembly for use on applications with no direct access to the fixing point.

It will place all the fasteners listed in the selection table below. Use this table to select a complete 07346 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 15 and 16 .

'A' and 'B' dimensions will help you assess the accessibility of your application.



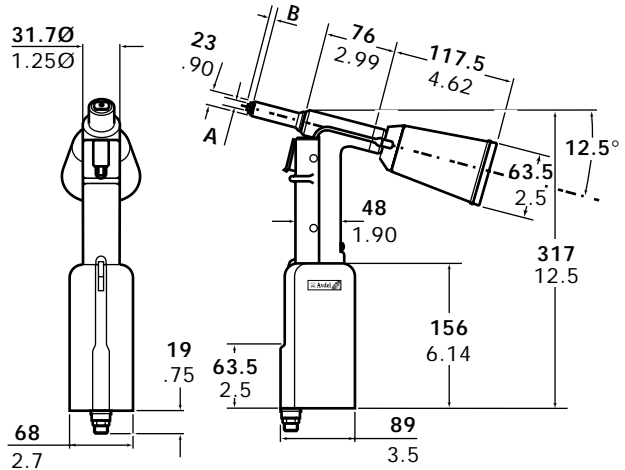
Dimensions shown in bold are millimetres.  
Other dimensions are in inches.

07346 TOOL SELECTION									
FASTENER			NOSE (see drawing above for A & B)						COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
<b>AVEX</b> Snap head & 120° csk head	1/8"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03000	07346-00004
		Steel	Standard	7.87	3.81	.310	.150	07346-03100	07346-00005
	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03100	07346-00005
		Steel	Standard	7.87	3.81	.310	.150	07346-03200	07346-00006
<b>AVDEL</b> Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	5.08	1.17	.200	.046	07346-03300	07346-00014
		Al. Alloy oversize	Standard	5.08	1.17	.200	.046	07495-03600	07346-00017
		Stainless Steel	Standard	5.08	3.81	.200	.150	07495-03000	07346-00024
	5/32"	Al. Alloy	Standard	6.6	0.84	.260	.033	07346-03400	07346-00015
		Al. Alloy oversize	Standard	6.6	0.84	.260	.033	07495-03700	07346-00018
		Al. Alloy	Standard	8.13	0.25	.320	.010	07346-03500	07346-00016
3/16"	Al. Alloy oversize	Standard	8.13	0.25	.320	.010	07495-03800	07346-00019	
	Stainless Steel	Standard	5.08	1.27	.200	.050	07495-03400	07346-00023	
	<b>MBC</b> Universal head & 100° csk	1/8"	Al. Alloy & Stainless Steel	Standard	4.75	2.40	.187	.094	07346-04000
Al. Alloy oversize			Standard	4.75	2.40	.187	.094	07346-04000	07346-00051
5/32"		Al. Alloy & Stainless Steel	Standard	4.75	2.40	.187	.094	07346-04300	07346-00054
		Al. Alloy oversize	Standard	6.35	2.40	.250	.094	07346-04100	07346-00052
		Al. Alloy & Stainless Steel	Standard	6.35	2.40	.250	.094	07346-04100	07346-00052
		Al. Alloy oversize	Standard	6.35	2.40	.250	.094	07346-04400	07346-00055
3/16"	Al. Alloy	Standard	7.92	2.40	.312	.094	07346-04200	07346-00053	
	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03100	07346-00005	
<b>BULBEX</b>	5/32"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07346-00006
	3/16"	Al. Alloy	Standard	7.87	3.81	.310	.150	07346-03200	07346-00006
<b>AVSEAL</b>	4mm	Al. Alloy	Standard	6.35	1.95	.250	.077	07495-04000	07346-00064
		Al. Alloy	Extended	6.35	4.11	.250	.162	07495-04700	07346-00074
	5mm	Al. Alloy	Standard	7.62	2.00	.300	.079	07494-04100	07346-00065
		Al. Alloy	Extended	7.62	4.11	.300	.162	07495-04800	07346-00075
<b>AVINOX</b>	1/8"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03100	07346-00005
	5/32"	Stainless Steel	Standard	7.87	3.81	.310	.150	07346-03200	07346-00006

## 07347 - VACUUM EXTRACTION

The 07347 has an in-built, vacuum stem extractor for use where gravity feed would be unsuitable. The tool is fitted with a fixed, straight nose assembly.

Use the selection chart below to select a complete 07347 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 12 to 14. 'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.  
Other dimensions are in inches.

### 07347 TOOL SELECTION

FASTENER		NOSE (see drawing above for A & B)							COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk head except 07347-00019 large flange only	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03000	07348-00001
		Al. Alloy	Extended	9.50	12.9	.375	.510	07490-01000	07347-00002
	3mm	Al. Alloy	Head Forming	12.7	3.3	.500	.130	07347-03400	07347-00003
		Steel	Standard	12.7	3.3	.500	.130	07347-03200	07347-00008
		Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03100	07347-00006
		Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03200	07347-00008
		Al. Alloy	Extended	9.5	11.4	.375	.450	07490-01700	07347-00009
		Al. Alloy	Head Forming	12.7	3.3	.500	.130	07347-03500	07347-00010
	3/16"	Steel	Standard	12.7	3.3	.500	.130	07347-03300	07347-00015
		Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03300	07347-00015
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07347-00016
		Al. Alloy	Head Forming	12.7	4.11	.500	.160	07347-03600	07347-00017
		Steel	Standard	12.7	3.3	.500	.130	07381-04800	07347-00018
		Al. Alloy L.Flange	Standard	19.00	4.11	.750	.160	07490-05000	07347-00019
MONOBOLT	3/16"	Al. Alloy & Steel	Standard	12.7	4.11	.500	.160	07498-04500	07347-00031
BULBEX	5/32"	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03200	07347-00008
		Al. Alloy	Extended	9.5	11.4	.375	.456	07490-01700	07347-00009
	3/16"	Al. Alloy	Standard	12.7	3.3	.500	.130	07347-03300	07347-00015
		Al. Alloy	Extended	9.5	10.0	.375	.395	07490-02400	07347-00016
AVSEAL	4mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07340-07600	07347-00064
		Al. Alloy	Extended	12.7	6.7	.500	.264	07498-08400	07347-00074
	5mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07640-02100	07347-00065
		Al. Alloy	Extended	12.7	6.7	.500	.264	07640-03100	07347-00075
	6mm	Al. Alloy	Standard	12.7	5.3	.500	.208	07640-02200	07347-00066
		Al. Alloy	Extended	12.7	7.2	.500	.283	07640-03200	07347-00076
	6.5mm	Al. Alloy	Standard	12.7	5.3	.500	.208	07340-08300	07347-00062
		Al. Alloy	Extended	12.7	7.2	.500	.283	07498-09100	07347-00072
7mm	Al. Alloy	Standard	12.7	5.3	.500	.208	07640-02400	07347-00067	
Al. Alloy	Extended	12.7	7.2	.500	.283	07640-03400	07347-00077		
TLR	3/16"	Al. Alloy	Standard	12.7	4.1	.500	.160	07498-01600	07347-00058
T-LOK Snap head	4.3mm	-	Standard	12.7	3.3	.500	.130	07241-07400	07347-00013
		-	Extended	9.5	10.0	.375	.395	07241-07300	07347-00014
	3/16"	-	Standard	12.7	3.3	.500	.130	07241-07400	07347-00013
		-	Extended	9.5	10.0	.375	.395	07241-07300	07347-00014
AVINOX	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07347-03200	07347-00008
	5/32"	Stainless Steel	Standard	12.7	3.3	.500	.130	07347-03300	07347-00015
AVDEL Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02300	07347-00024
		Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-02900	07347-00026
	5/32"	Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02600	07347-00030
		Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-03000	07347-00029
	3/16"	Stainless Steel	Standard	12.7	2.5	.500	.100	07344-02400	07347-00028
		Al. Alloy	Standard	12.7	2.5	.500	.100	07344-02700	07347-00034
Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07344-03100	07347-00035		
MBC Universal head & 100° csk	1/8"	Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06700	07347-00051
		Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07498-07000	07347-00054
		Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02400	07347-00045
	5/32"	Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06800	07347-00052
		Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07344-03200	07347-00055
	3/16"	Stainless Steel	Standard	12.7	4.7	.500	.187	07498-02500	07347-00046
		Al. Alloy	Standard	12.7	4.7	.500	.187	07498-06900	07347-00053
AVIBULB Low profile	1/8"	Steel	Standard	12.7	3.3	.500	.130	07347-03200	07347-00008
	5/32"	Steel	Standard	12.7	3.3	.500	.130	07347-03300	07347-00015

Minimum Pressure required

■ 5.1 BAR / 75 lbf/in<sup>2</sup>

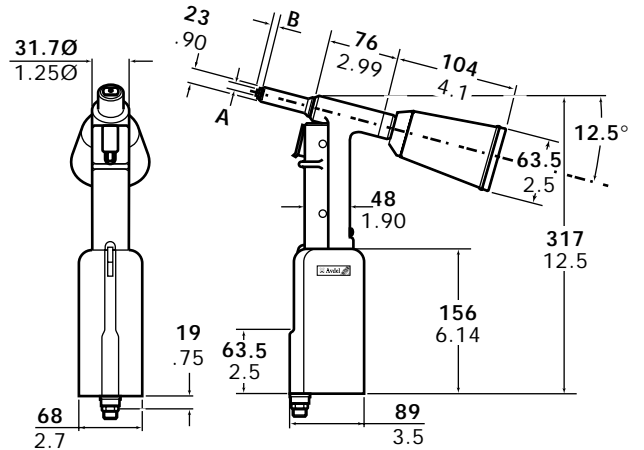
▲ 5.4 BAR / 80 lbf/in<sup>2</sup>

● 6.1 BAR / 90 lbf/in<sup>2</sup>

## 07348 - FORCED AIR EVACUATION

The 07348 has an in-built, forced air stem evacuation system for use where gravity feed would be unsuitable. The tool is fitted with a fixed straight nose assembly.

Use the selection chart below to select a complete 07348 tool which will include the correct nose assembly for a selected fastener. For details of Nose Assemblies see pages 12 to 14. 'A' and 'B' dimensions will help you assess the accessibility of your application.



Dimensions shown in bold are millimetres.  
Other dimensions are in inches.

07348 TOOL SELECTION									
FASTENER			NOSE (see drawing above for A & B)						COMPLETE
NAME & HEAD	Ø	MATERIAL/DETAIL	NOSE TIP TYPE	A (mm)	B (mm)	A (in)	B (in)	NOSE ASSY PART N°	TOOL PART N°
AVEX Snap head & 120° csk head except 07348-00019 large flange only	1/8"	Al. Alloy	Standard	12.7	3.3	.500	.130	07348-00800	07348-00001
		Al. Alloy	Hd. Forming	12.7	3.3	.375	.130	07348-04100	07348-00003
	5/32"	Steel	Standard	12.7	3.3	.500	.130	07348-06800	07348-00008
		Al. Alloy	Standard	12.7	3.3	.500	.130	07348-06800	07348-00008
		Al. Alloy	Hd. Forming	12.7	3.3	.500	.130	07348-04200	07348-00010
		Steel	Standard	12.7	3.3	.500	.130	07348-02300	07348-00015
		Al. Alloy	Standard	12.7	3.3	.500	.130	07348-01400	07348-00006
		Al. Alloy	Standard	12.7	3.3	.500	.130	07348-02300	07348-00015
		Al. Alloy	Hd. Forming	12.7	4.1	.500	.160	07348-04300	07348-00017
		Steel	Standard	12.7	3.3	.500	.130	07348-04900	07348-00018
Al. Alloy L/flange	Standard	19.00	4.1	.750	.160	07348-05000	07348-00019		
MONOBOLT	3/16"	Al. Alloy & Steel ▲	Standard	12.7	4.1	.500	.160	07348-04500	07348-00008
BULBEX	5/32"	-	Standard	12.7	3.3	.500	.130	07348-06800	07348-00015
	3/16"	-	Standard	12.7	3.3	.500	.130	07348-02300	07348-00008
AVSEAL	4mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07348-06600	07348-00064
		Al. Alloy	Extended	12.7	6.7	.500	.264	07348-06700	07348-00074
	5mm	Al. Alloy	Standard	12.7	4.5	.500	.177	07348-02100	07348-00065
		Al. Alloy	Extended	12.7	6.7	.500	.177	07348-03100	07348-00075
	6mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07348-02200	07348-00066
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07348-03200	07348-00076
		Al. Alloy ●	Standard	12.7	5.3	.500	.208	07348-08300	07348-00062
		Al. Alloy ●	Extended	12.7	7.2	.500	.283	07348-09100	07348-00072
	7mm	Al. Alloy ●	Standard	12.7	5.3	.500	.208	07348-02600	07348-00067
		Al. Alloy ●	Extended	12.7	7.2	.500	.208	07348-03400	07348-00077
TLR	3/16"	Al. Alloy	Standard	12.7	4.1	.500	.160	07348-02500	07348-00058
AVINOX	1/8"	Stainless Steel	Standard	12.7	3.3	.500	.130	07348-06800	07348-00008
	5/32"	Stainless Steel	Standard	12.7	3.3	.500	.130	07348-02300	07348-00015
AVDEL Snap head & 100° csk & 120° csk	1/8"	Al. Alloy	Standard	12.7	2.5	.500	.100	07348-05100	07348-00024
		Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07348-05400	07348-00026
	5/32"	Stainless Steel	Standard	12.7	3.4	.500	.132	07348-04800	07348-00025
		Al. Alloy	Standard	12.7	2.5	.500	.100	07348-05200	07348-00030
	3/16"	Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07348-05500	07348-00029
		Stainless Steel	Standard	12.7	2.5	.500	.100	07348-05700	07348-00028
		Al. Alloy	Standard	12.7	2.5	.500	.100	07348-05300	07348-00034
		Al. Alloy oversize	Standard	12.7	2.5	.500	.100	07348-05600	07348-00035
MBC Universal head & 100° csk	1/8"	Al. Alloy	Standard	12.7	4.7	.500	.187	07348-05800	07348-00051
		Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07348-06100	07348-00054
	5/32"	Stainless Steel	Standard	12.7	4.7	.500	.187	07348-06300	07348-00045
		Al. Alloy	Standard	12.7	4.7	.500	.187	07348-05900	07348-00052
		Al. Alloy oversize	Standard	12.7	4.7	.500	.187	07348-06200	07348-00055
		Stainless Steel	Standard	12.7	4.7	.500	.187	07348-06400	07348-00046
3/16"	Al. Alloy	Standard	12.7	4.7	.500	.187	07348-06000	07348-00053	
AVDEL SR Raised Head & 120° csk	1/8"	Al. Alloy	Standard	61	3.3	2.4	.130	07490-00900	07498-00001
		Copper	Standard	61	3.3	2.4	.130	07490-00900	07498-00001
	5/32"	Copper Nickel Al.	Standard	61	3.3	2.4	.130	07490-00900	07498-00001
		Al. Alloy	Standard	61	3.3	2.4	.130	07490-01600	07498-00008
	3/16"	Copper	Standard	61	3.3	2.4	.130	07490-01600	07498-00008
		Copper Nickel Al.	Standard	61	3.3	2.4	.130	07490-01600	07498-00008
		Al. Alloy	Standard	61	3.3	2.4	.130	07498-03900	07498-00004
		Copper	Standard	61	3.3	2.4	.130	07498-03900	07498-00004
		Copper Nickel Al.	Standard	61	3.3	2.4	.130	07498-03900	07498-00004
		Al. Alloy	Standard	61	3.3	2.4	.130	07490-04900	07498-00026
1/4"	Al. Alloy	Standard	61	3.3	2.4	.130	07490-04900	07498-00026	
	Al. Alloy	Standard	61	3.3	2.4	.130	07490-04900	07498-00026	
AVIBULB Low profile	1/8"	Steel	Standard	12.7	3.3	.500	.130	07348-01600	07348-00009
	5/32"	Steel	Standard	12.7	3.3	.500	.130	07348-02300	07348-00015

Minimum Pressure required

■ 5.1 BAR / 75 lbf/in<sup>2</sup>

▲ 5.4 BAR / 80 lbf/in<sup>2</sup>

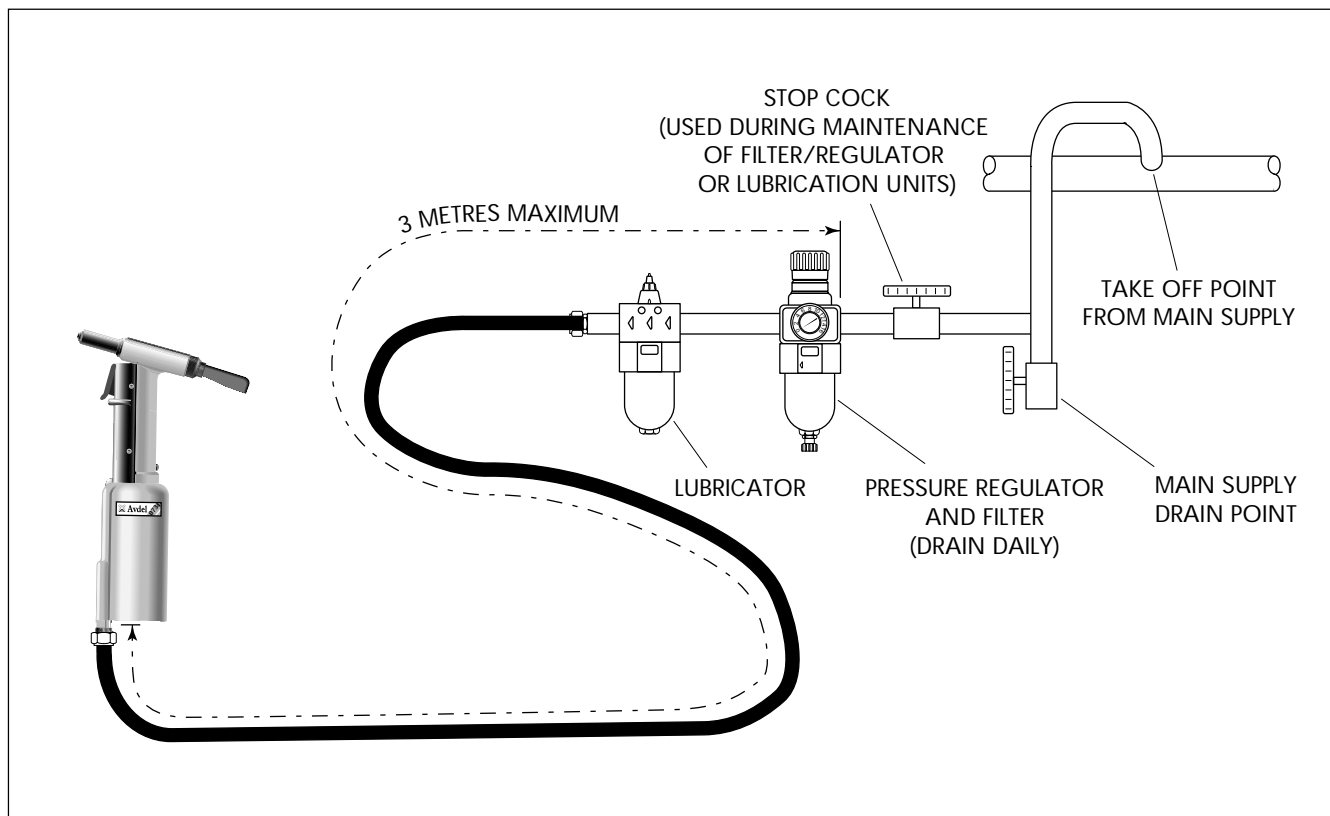
● 6.1 BAR / 90 lbf/in<sup>2</sup>

## AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.5 bar. We recommend the use of pressure regulators and automatic oiling/filtering systems on the main air supply. These should be fitted within 3 metres of the tool (see diagram below) to ensure maximum tool life and minimum tool maintenance.

Air supply hoses should 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 should be oil resistant, have an abrasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged. All air hoses MUST have a minimum bore diameter of 6.4 millimetres or  $\frac{1}{4}$  inch.

Read servicing daily details page 17.



## OPERATING PROCEDURE

### OPTION 1

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener body squarely into the prepared hole of the application.
- Apply the tool to the protruding rivet stem.
- Fully depress the trigger. The tool cycle will ensure the rivet is placed.

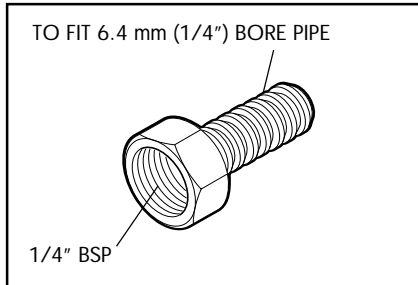
### OPTION 2

- Ensure that the correct nose equipment is fitted.
- Connect the tool to the air supply.
- Insert the fastener stem into the nose of the tool.
- Insert the tool with the fastener squarely into the prepared hole of the application.
- Fully depress the trigger. The tool cycle will ensure the rivet is placed.

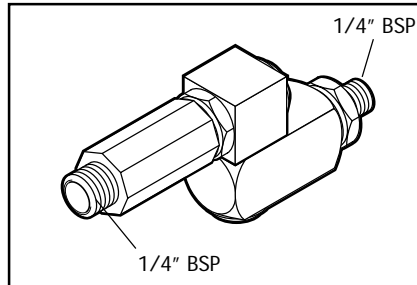
## ACCESSORIES

Three different accessories are available to make the connection to your air supply:

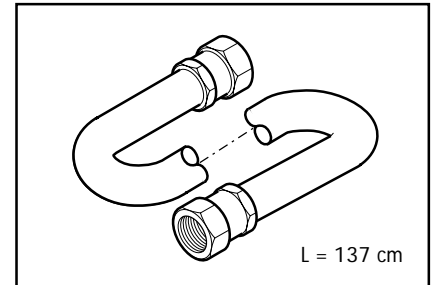
**Hose Connector**  
part n° 07005-00276



**Swivel Connector assembly**  
part n° 07640-01400



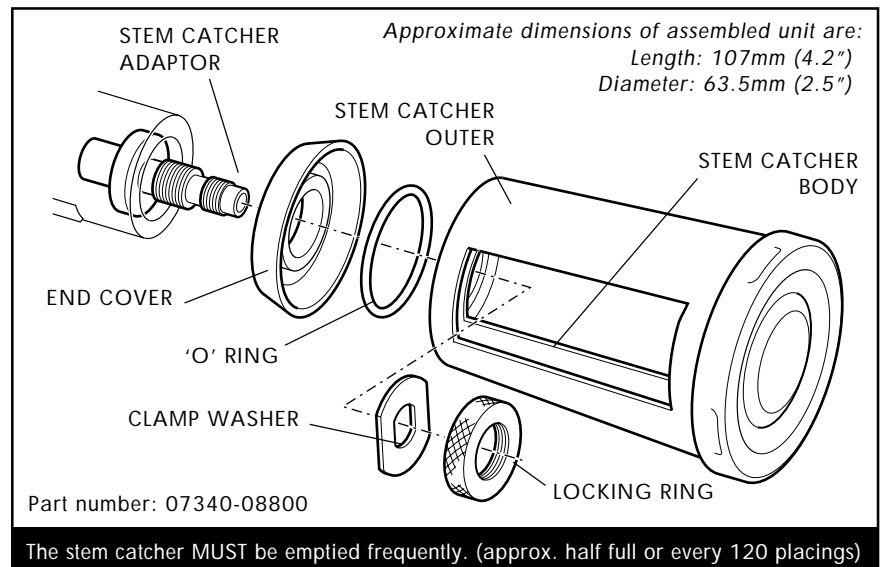
**Hose Assembly**  
part n° 07008-000324



You may want to consider one more accessory to improve efficiency. FOR USE ON 07340 & 07344 TOOLS ONLY.

### STEM CATCHER UNIT

- To replace the pin tail deflector with the stem catcher unit, unscrew the end cap and remove together with pintail deflector (items 56 and 55 of page 22).
- Assemble all items in the order shown on the diagram opposite.
- Offer the assembly to the new stem catcher adaptor.
- Start tightening the locking ring onto stem catcher adaptor.
- Rotate the stem catcher body until the opening is in the desired position.
- Fully tighten the locking ring.



The stem catcher MUST be emptied frequently. (approx. half full or every 120 placings)

# NOSE ASSEMBLIES

There are three types of nose assemblies used with the 0734 type of tooling, these combine with three types of base tools to make up the six models: 07340, 07344, 07345, 07346, 07347 and 07348. If you have purchased a complete tool, it will already be fitted with the correct nose assembly for your fastener.

It is essential that the correct nose assembly is fitted prior to operating the tool. By knowing your original complete tool part number or the details of the fastener to be placed, you will be able to order a new complete nose assembly using the selection table pages 4, 5, 6, 7, 8 and 9 according to the tool model you are using.

## 07340 / 4 / 7 / 8 MODELS

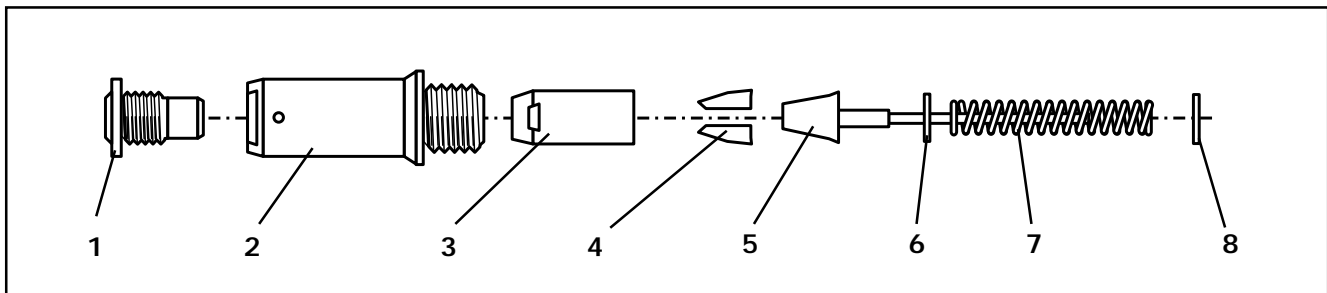
While these models all use fixed nose assemblies, there will be minor variations on some components. Check part numbers on respective component table.

### FITTING INSTRUCTIONS

#### IMPORTANT

The air supply must be disconnected when fitting or removing nose assemblies unless specifically instructed otherwise.

- Lightly coat the jaws with Moly lithium grease.
- Drop jaws 4 into jaw housing 3.
- Insert jaw spreader 5 into jaw housing 3 (locating in the 'V' shape formed by the jaws).
- Locate buffer 6 on jaw spreader 5.
- Locate spring 7 onto jaw spreader 5.
- Fit locking ring 8 onto the jaw spreader housing assembly of the tool.
- Holding tool pointing down, screw on the assembled jaw housing onto the jaw spreader housing assembly and tighten with spanner.
- Screw nose tip 1 into nose casing 2.
- Place nose casing 2 over jaw housing 3, tightening with spanner.



### SERVICING INSTRUCTIONS

Nose assemblies should be serviced at weekly intervals.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting Instructions'.
- Any worn or damaged part should be replaced by a new part.
- Particularly check wear on jaws.
- Ensure jaw spreader assembly tube 5, where fitted, is not distorted.
- Check spring 7 is not distorted.
- Assemble according to fitting instructions.

## 07340/4/7/8 NOSE ASSEMBLY COMPONENTS

Each nose assembly represents a unique combination of components which can be ordered individually. Component numbers refer to the illustration on the opposite page. We recommend some stock as items will need regular replacement. Read the Nose Assemblies servicing instructions opposite carefully.

07340								
NOSE ASSY	1	2	3	4	5	6	7	8
07241-07300	07241-07101	07340-02804	07340-00304	07340-00213	07240-01501	07340-01503	07340-01502	07340-00327
07340-07300	07340-07301	07340-02804	07340-00304	07340-07502	07340-07503	07340-01503	07340-01502	07340-00327
07340-07600	07340-07601	07340-00306	07340-00304	07340-00213	07344-01400	07340-01304	07340-01303	07340-00327
07381-04600	07381-04601	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07381-04700	07381-04701	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-00900	07340-06000	07340-00306	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303	07340-00327
07490-01000	07340-02805	07340-02804	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303	07340-00327
07490-01400	07340-06300	07340-00306	07340-00304	07340-00222	07340-02000	07340-01304	07340-01303	07340-00327
07490-01600	07340-06400	07340-00306	07340-00304	07340-00213	07340-05700	07340-01304	07340-01303	07340-00327
07490-01700	07340-02806	07340-02804	07340-00304	07340-00213	07344-05700	07340-01304	07340-01303	07340-00327
07490-02300	07340-06200	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-02400	07340-02807	07340-02804	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-04100	07340-06400	07340-00306	07340-00304	07340-00213	07340-01300	07340-01304	07340-01303	07340-00327
07490-04200	07340-06500	07340-00306	07340-00304	07340-00213	07344-01300	07340-01304	07340-01303	07340-00327
07490-04300	07340-06600	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07490-04900	07340-04400	07340-00306	07340-00304	07340-07502	07340-07503	07340-01503	07340-01502	07340-00327
07490-05000	07340-04800	07340-00306	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07498-08400	07498-08401	07340-00306	07340-00304	07340-00213	07340-03702	07498-01304	07340-01303	07340-00327
07498-09100	07498-09101	07340-00306	07340-00304	07490-04602	07498-03002	07498-03003	07100-04003	07340-00327
07640-02100	07340-07701	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301	07340-00327
07640-02200	07340-07801	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327
07640-02400	07340-07901	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327
07640-03100	07498-08501	07340-00306	07340-00304	07100-08203	07241-03702	07241-02001	07498-04301	07340-00327
07640-03200	07498-08601	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327
07640-03400	07498-08701	07340-00306	07340-00304	07340-07502	07241-03702	07241-02001	07498-04301	07340-00327
07640-08300	07340-08301	07340-00306	07340-00304	07340-04602	07498-03002	07498-03003	07100-04003	07340-00327

07344								
NOSE ASSY	1	2	3	4	5	6	7	8
07344-02100	07344-02101	07344-02001	07340-00304	07340-00213	07344-01400	07340-01304	07340-01303	07340-00327
07344-02300	07140-02104	07344-02001	07340-00304	07340-00229	07344-01400	07340-01304	07340-01303	07340-00327
07344-02400	07344-02401	07344-02001	07340-00304	07340-00213	07340-01501	07340-01503	07340-01502	07340-00327
07344-02600	07140-02105	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-02700	07140-02106	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-02900	07344-02901	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-03000	07344-03001	07344-02001	07340-00304	07340-00229	07344-02002	07340-01503	07340-01502	07340-00327
07344-03100	07344-03101	07344-02001	07340-00304	07498-04401	07344-02002	07340-01503	07340-01502	07340-00327
07344-03200	07344-07101	07344-02001	07340-00304	07340-00229	07344-02002	-	07498-06801	07340-00327
07344-04700	07344-04701	07498-02601	07498-04503	07498-04501	07498-04800	07498-03003	07100-04003	07340-00327
07344-05100	07344-04701	07498-02601	07340-00304	07340-00229	07498-03002	-	07100-04003	07340-00327
07344-05300	07344-04701	07498-02601	07498-04503	07498-04501	07498-04502	-	07100-04003	07340-00327
07498-02400	07340-06701	07344-02001	07340-00304	07498-04401	07340-01300	07340-01304	07340-01303	07340-00327
07498-02500	07340-06801	07344-02001	07498-04503	07498-04501	07498-04800	07498-03003	07100-04003	07340-00327
07498-06700	07340-06701	07344-02001	07340-00304	07340-00229	07340-01400	07340-01304	07340-01303	07340-00327
07498-06800	07340-06801	07344-02001	07340-00304	07340-00229	07344-02002	-	07498-06801	07340-00327
07498-06900	07340-06901	07344-02001	07340-00304	07340-00229	07340-02002	-	07498-06801	07340-00327
07498-07000	07340-07001	07344-02001	07340-00304	07340-00229	07344-02002	-	07498-06801	07340-00327





## 07345 & 07346 MODELS

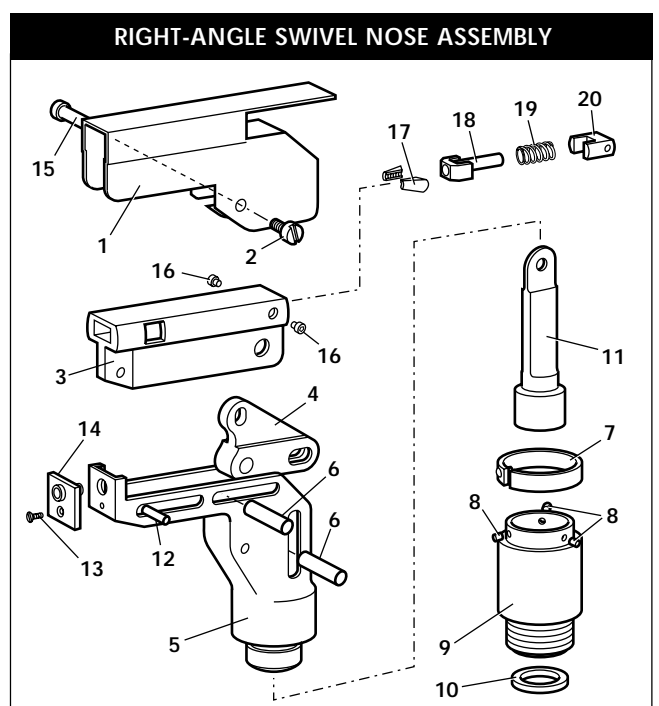
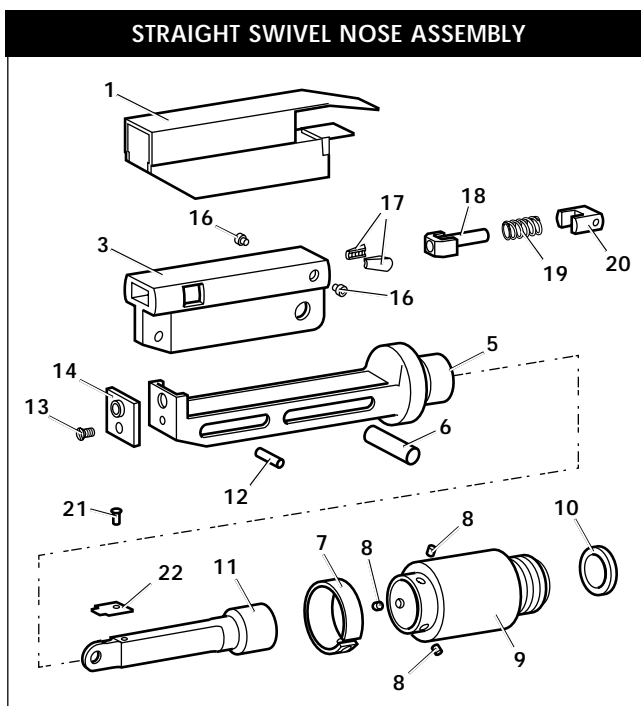
As described on pages 6 and 7 the fitting of a straight swivel nose assembly to a 07340-00200 base tool will create a 07345 tool model and the fitting of a right-angle swivel nose assembly to the same base tool will create a 07346 tool model. Because there are few differences between the two nose assemblies, the fitting and servicing procedures are almost identical.

### FITTING INSTRUCTIONS

The following procedure will allow you to fit either of the swivel nose assemblies (as illustrated below) to the tool. If you order a complete nose assembly rather than individual components, you will only need to start at stage ■.

All moving parts should be lubricated. Unless stated otherwise use Moly lithium grease (details page 17). When on grey tint, instructions refer only to the right-angle nose assembly fitted to 07346 models.

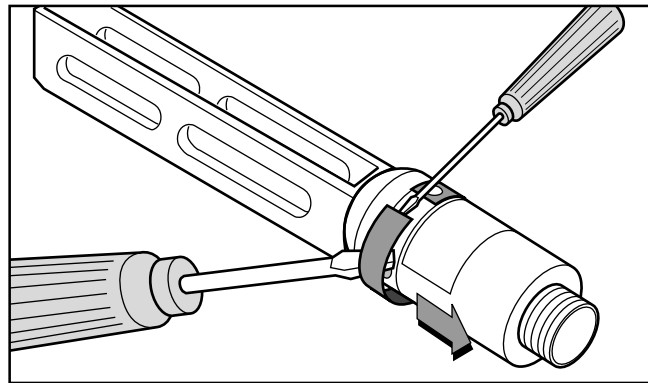
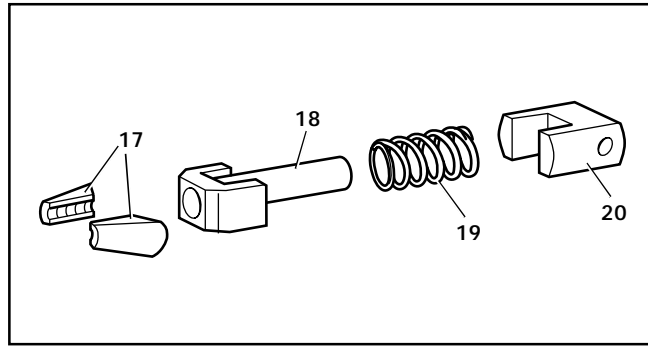
- Fit locking ring 10, detailed below, over jaw spreader housing of tool (item 47 page 22).
- Coat screw 13 with thread locking adhesive and use to secure nose tip 14 onto body 5.
- Lightly lubricate items 17,18,19,20 and insert into jaw carrier 3 as shown. Secure with screws 16.
- Position lever 4 into body 5 and hold in place with pin 15 through the hole of body 5 (not a slot).
- Lubricate the sides of the jaw carrier assembly and insert into body 5.
- Lubricate rollers 8 and ENSURE that they will freely rotate in the holes of adaptor 9. If necessary ream the holes.
- Position spring clip 7 over adaptor 9 past the holes for the rollers and rotate until the locating peg is aligned with the corresponding hole in adaptor 9 (smallest hole).
- Fit adaptor 9 over the end of body 5 and drop rollers 8 into place. Push spring clip 7 over rollers 8.
- Insert spindle 11 through adaptor 9 into jaw carrier 3 until the hole lines up with slot in body 5. Temporarily hold in place with pin 6.
- Insert pin 12 through the front slot of body 5 into jaw carrier 3.
- Hold the assembly vertical to prevent all pins dropping and slide the jaw carrier assembly back and forth a few times to ensure free movement.
- Push pin(s) 6 out and let spindle 11 drop out. Screw spindle 11 onto the jaw spreader housing of the tool, leaving the small screw fixing hole uppermost for straight swivel nose assemblies. Tighten gently with a tommy bar.
- Screw the assembly over spindle 11 onto the tool handle. Replace pin(s) 6.
- On straight swivel nose assemblies attach platform 22 onto the top of the spindle with screw 21. Deburr the back end of platform 22 so that it cannot catch on guard 1.
- Snap guard 1 over the assembly, carefully sliding cut-out around the head of screw 15 and secure with screw 2.



## SERVICING INSTRUCTIONS

Nose assemblies should be serviced at weekly intervals.  
Item numbers refer to both illustrations on page 15.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting instructions'.
- If guard 1 is at all damaged it must be replaced by a new one.
- Any worn or damaged parts should be replaced.
- Pay particular attention to jaw carrier items in the upper illustration on the right as follows:
  - Check wear on jaws 17.
  - Check that jaw spreader tube 18 is not distorted.
  - Check that spring 19 is neither broken or distorted.
  - Check that spring guide 20 is not damaged.
- Check that spring clip 7 is not distorted. When removing spring clip 7, use two screwdrivers as shown in the lower illustration opposite.
- Check for excessive wear on slots of body 5.
- Assemble according to fitting instructions.



## 07345 & 07346 NOSE ASSEMBLY COMPONENTS

Nose tips and jaws will vary for each nose assembly while other components remain the same as shown in the tables below. Jaws are always in pairs.

CONSTANT COMPONENTS				VARYING COMPONENTS					
	ITEM	07345	07346	NOSE ASSY	NOSE TIP(14)	JAWS(17)	NOSE ASSY	NOSE TIP(14)	JAWS(17)
1	GUARD	07494-05000	07495-03003	07345-03000	07345-03600	07340-00213	07346-04300	07165-00801	07340-00229
2	BLADE SCREW	-	07210-02015	07345-03100	07345-03700	07340-00213	07346-04400	07165-00802	07498-04401
3	JAW CARRIER	07494-03026	07494-03026	07345-03200	07345-03800	07490-04602	07494-03000	07494-03011	07340-00213
4	LEVER	-	07495-03004	07345-03300	07345-03301	07340-00229	07494-03400	07494-03401	07340-00222
5	BODY	07494-03015	07495-03002	07345-03400	07345-03401	07340-00229	07494-03600	07494-03601	07340-00229
6	PIVOT PIN	07343-02207	07343-02207	07345-03500	07345-03501	07498-04401	07494-03700	07494-03701	07340-00229
7	SPRING CLIP	07495-03900	07495-03900	07345-04000	07165-00701	07340-00229	07494-03800	07494-03801	07498-04401
8	ROLLER	07007-00039	07007-00039	07345-04100	07165-00702	07340-00229	07494-06000	07494-06001	07340-00213
9	ADAPTOR	07345-03001	07345-03001	07345-04200	07165-00703	07498-04401	07494-06100	07494-06101	07340-00213
10	LOCKING RING	07345-03003	07345-03003	07345-04300	07165-00801	07340-00229	07494-06600	07494-06601	07340-00213
11	SPINDLE	07345-03002	07345-03002	07345-04400	07165-00802	07498-04401	07494-06700	07494-06701	07340-00213
12	DOWEL PIN	07007-00038	07007-00038	07346-03000	07345-03600	07340-00213	07495-03000	07494-03011	07340-00213
13	SCREW	07342-02207	07342-02207	07346-03100	07345-03700	07340-00213	07495-03400	07494-03401	07340-00222
15	PIVOT PIN	-	07495-03005	07346-03200	07345-03800	07490-04602	07495-03600	07494-03601	07340-00229
16	SCREW	07494-03028	07494-03028	07346-03300	07345-03301	07340-00229	07495-03700	07494-03701	07340-00229
18	JAW SPREADER	07166-01100	07166-01100	07346-03400	07345-03401	07340-00229	07495-03800	07494-03801	07498-04401
19	SPRING	07166-01102	07166-01102	07346-03500	07345-03501	07498-04401	07495-04000	07494-06001	07340-00213
20	SPRING GUIDE	07494-03027	07494-03027	07346-04000	07165-00701	07340-00229	07495-04100	07494-06101	07340-00213
21	CSK. SCREW	07001-00368	-	07346-04100	07165-00702	07340-00229	07495-04700	07494-06601	07340-00213
22	PLATFORM	07345-00401	-	07346-04200	07165-00703	07498-04401	07495-04800	07494-06701	07340-00213

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

## IMPORTANT

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.  
The operator should not be involved in maintenance or repair of the tool unless properly trained.

## DAILY

- Daily, before use or when first putting the tool into service, pour a few drops of clean, light lubricating oil into the air inlet of the tool if no lubricator is fitted on air supply. If the tool is in continuous use, the air hose should be disconnected from the main air supply and the tool lubricated every two to three hours.
- Check for air leaks. If damaged, hoses and couplings should be replaced by new items.
- If there is no filter on the pressure regulator, bleed the air line 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 is correct.
- Check the stroke of the tool meets the minimum specification (inside front page). It is the difference in the measurement between the front face of the jaw spreader housing assembly and the front face off the handle top bore **before pressing the trigger and when it is fully depressed.**

## WEEKLY

- Dismantle and clean the nose assembly with special attention to the jaws. Lubricate with Moly Lithium grease before assembling.
- Check for oil leaks and air leaks in the air supply hose and fittings.

Grease can be ordered as a single item, the part number is shown in the service kit page 18.

M O L Y L I T H I U M G R E A S E E P 3 7 5 3 S A F E T Y D A T A	
<p><b>FIRST AID</b> SKIN: As the grease is completely water resistant it is best removed with an approved emulsifying skin cleaner.</p> <p>INGESTION: Make the individual drink 30ml Milk of Magnesia, preferably in a cup of milk.</p> <p>EYES: Irritant but not harmful. Irrigate with water and seek medical attention.</p> <p><b>ENVIRONMENT</b> Scrape up for burning or disposal on approved site.</p>	<p><b>FIRE</b> FLASH POINT: Above 220°C. Not classified as flammable. Suitable extinguishing media: CO<sub>2</sub>, Halon or water spray if applied by an experienced operator.</p> <p><b>HANDLING</b> Use barrier cream or oil resistant gloves</p> <p><b>STORAGE</b> Away from heat and oxidising agent.</p>

For all servicing we recommend the use of the service kit below (part number 07900-03400) supplied in its own plastic case. The kit for the 07348 has a different part number 07900-03480 because it contains a different spring compression tool part number 07900-00170.

SERVICE KIT		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00001	SPRING COMPRESSION TOOL	1
07900-00002	SPANNER ASSEMBLY FOR HEAD PISTON	1
07900-00004	CIRCLIP PLIERS	1
07900-00005	PLUG	1
07900-00006	'O' RING ASSEMBLING TOOL	1
07900-00008	7/16" x 1/2" A/F SPANNER	1
07900-00009	3/32" A/F SPANNER	1
07900-00010	PIN PUNCH	1
07900-00012	9/16" x 5/8" A/F SPANNER	1
07900-00013	1/8" ALLEN KEY	1
07900-00015	5/8" x 11/16" A/F SPANNER	1
07900-00018	PISTON EXTRACTOR	1
07900-00427	SLIDING OFFSET HANDLE	1

SERVICE KIT (Continued)		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00087	SOCKET ASSEMBLY (ADAPTOR)	1
07900-00092	3/4" x 7/8" A/F SPANNER	1
07992-00020	80g TIN MOLY LITHIUM GREASE EP 3753	1
07900-00151	'T' HANDLE. EXTENSION	1
07900-00192	PRIMING PUMP ASSEMBLY	1
07900-00078	5/32" A/F ALLEN KEY	1
07900-00203	TORQUE WRENCH	1
07900-00401	ADAPTOR	1
07340-00306	NOSE CASING	1
07900-00421	13/16" A/F RING SPANNER	1
07900-00422	3/4" A/F RING SPANNER	1
07900-00638	PRIMING SPACER	1

## MAINTENANCE

Every 500000 cycles the tool should be completely dismantled and new components should be used where worn, damaged or recommended. All 'O' rings and seals should be renewed and lubricated with Moly Lithium grease EP 3753 before assembling.

### IMPORTANT

Safety Instructions appear on pages 2 & 3.

The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.  
The operator should not be involved in maintenance or repair of the tool unless properly trained.

The airline must be disconnected before any servicing or dismantling is attempted unless specifically instructed otherwise.

It is recommended that any dismantling operation be carried out in clean conditions.

Item **numbers in bold** refer to the general assembly and parts list pages 22 and 23 for the 07340-00200, 24 and 25 for the 07347-00200, and 26 and 27 for the 07348-00200.

Before proceeding with dismantling, empty the oil from the tool. Remove handle plug **2** and bonded seal **1** and drain the oil into a suitable container.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, pages 12 to 16.

For total tool servicing we advise that you proceed with dismantling of sub-assemblies in the order shown below. The procedure is similar for all tools once the nose assembly has been removed. Where there is a difference the model is indicated.

### HYDRAULIC PISTON

- **07340/07344/07345/07346 MODELS (07340-00200 BASE TOOL)** - Unscrew end cap **56** and remove together with pin tail deflector **55**. If stem catcher is fitted, rotate stem catcher to expose locking ring and clamp washer. Use a tommy bar to undo locking ring, grasping rear end of stem catcher body whilst applying pressure.
- **07347 MODEL (07347-00200 BASE TOOL)** - Unscrew locknut **63** and remove stem catcher assembly comprising : stem catcher outer **64**; stem catcher end cap **54**; stem catcher body **53** and clamp washer **56**.
- **07348 MODEL (07348-00200 BASE TOOL)** - Unscrew locking ring **64** and remove stem catcher comprising of: stem catcher outer **61**; stem catcher end cap **62**; stem catcher body **63** and clamp washer **60**.
- Grip spring compression tool\* in a vice and compress spring **8**, applying the clamp screw ball end to stem catcher adaptor **54** on the **07340-00200** base tool or **66** on the **07348-00200**, or spring housing assembly **55** on the **07347-00200** base tool.
- Remove internal circlip **10** using the circlip pliers\*.
- Unscrew clamp and remove stem catcher adaptor **54** on the **07340-00200** or **66** on the **07348-00200** base tools, or spring housing assembly **55** on the **07347-00200** base tool - then remove the spring **8**.
- Using spanner assembly for head piston\* and spanner\* unscrew jaw spreader housing assembly **47**, then withdraw piston **9**.
- Inspect the piston diameters and the cylinder bore for wear and damage.
- Assemble in reverse order to dismantling.
- Use 'O' ring assembly tool\* and plug\* when renewing 'O' rings.
- If jaw spreader housing assembly **47** is removed from piston **9**, a new jaw spreader housing assembly **MUST** be fitted into the piston and tightened with a torque of 20lb.ft./9.1 kg.m. to the dimension shown on the appropriate 'General Assembly' drawing for the tool in question.

\* refers to items included in the Avdel service kit. For complete list see page 18.

## AIR PISTON ASSEMBLY

- With tool the connected to air supply, depress trigger and disconnect the air supply.
- Remove internal circlip **26** and screw piston extractor\* into plug **27**.
- Pull out plug **27** and disengage piston extractor\*.
- Engage piston extractor\* with piston rod **19** and pull out piston assembly **18**.
- Unscrew piston rod nut **24** and remove: piston washer **23**; air piston cup **22**; buffer washer **21** and buffer **20**.
  
- Assemble in reverse order to dismantling.

## AIR VALVE

- **07340/07344/07345/07346 MODELS (07340-00200 BASE TOOL)** - Using spanner\* unscrew adaptor **57**. Remove: valve spring **58**; valve **40**; spring **59**; valve plunger **29** and valve operating rod **42**.
- **07347 MODEL (07347 BASE TOOL)** - Using spanner\* unscrew connector bolt **70**.  
Remove: valve spring **73**; valve **40**; spring **72**; valve plunger **29** and valve operating rod **42**.
- **07348 MODEL (07348 BASE TOOL)** - Using spanner\* unscrew adaptor **48**.  
Remove ; valve spring **53**, valve **40**, spring **54**, valve plunger **29** and valve operating rod **42**.
  
- Assemble in reverse order to dismantling, paying particular attention to the sealing face of valve **40** and seal diameter of valve plunger **29** for marks and scratching.

## ADAPTOR ASSEMBLY

- Grip tool lightly in a vice fitted with soft jaws.
- Remove piston assembly **18** as described earlier.
- Using socket assembly (adaptor)\*, 'T' handle extension, unscrew adaptor assembly **12** and facing washer **16**.
- Remove 'O' rings **13** & **38** and back-up rings **14** & **33**.
  
- Assemble in reverse order to dismantling, ensuring 'O' rings **13** & **38** and back-up rings **14** & **33** are replaced in correct positions.

## TRIGGER TIE REPLACEMENT

- Using the pin punch\* drift out grooved pin **36**.
- Remove four socket button head screws **34** and pull off trigger guard **52**.
- Unbend trigger tie loop at trigger cam lever **32** and disengage.
- Clean and inspect all components, renewing worn or damaged items.
  
- Assemble in reverse order to dismantling.
  
- Introduce free end of trigger mounting and insert angled end of trigger tie into trigger cam lever **32**.
- Bend trigger tie over cam lever **32**, making sure that it pivots freely.
- Position trigger guard **59** on handle **46**, insert four socket button head screws **34** and tighten.
- Line up trigger assembly **35** with trigger guard **52** and insert new grooved pin **36**.
- Check free movement of trigger assembly.

### IMPORTANT

Check the tool against daily and weekly servicing.

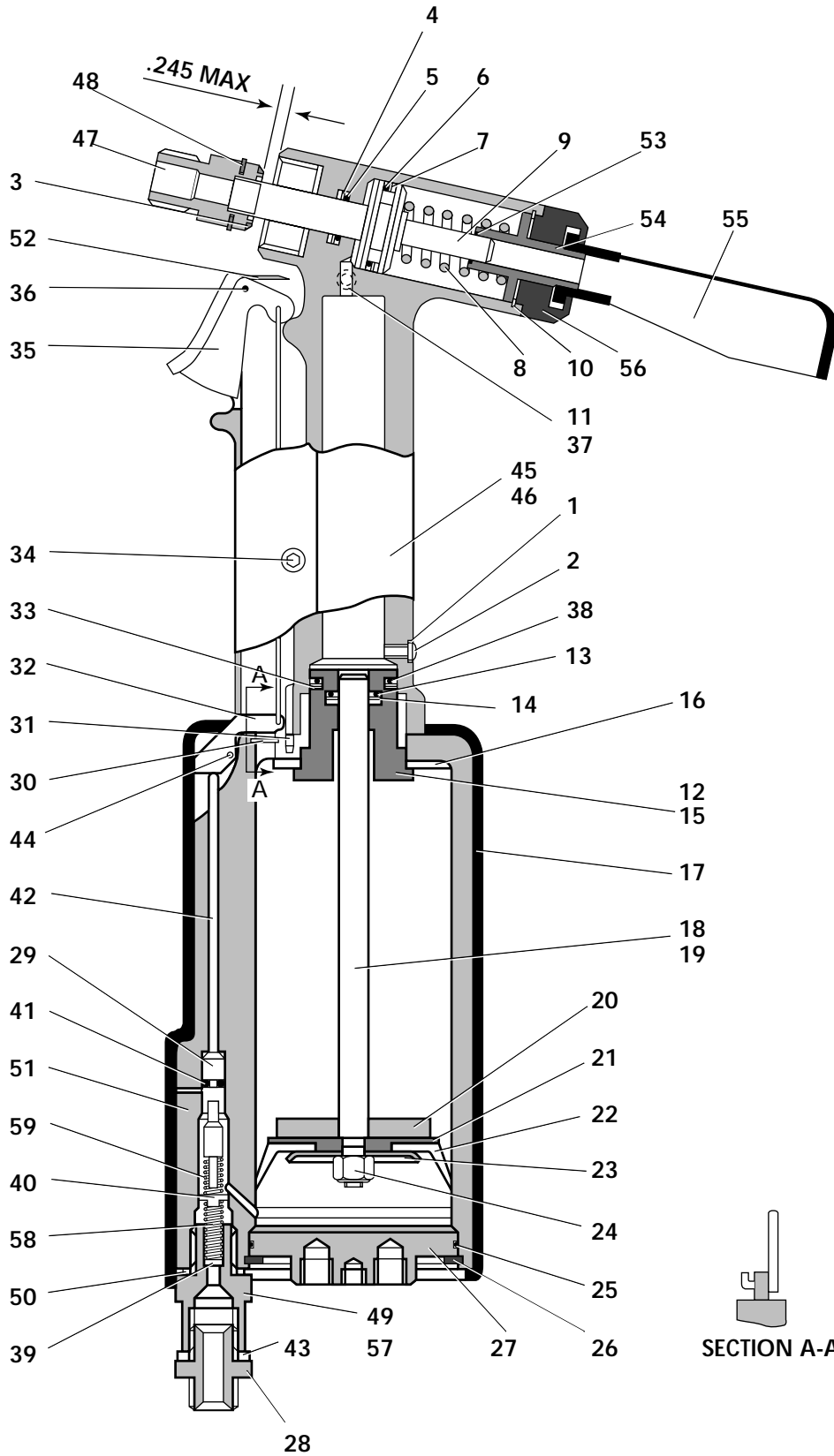
Priming is ALWAYS necessary after the tool has been dismantled and prior to operating (refer to page 28).

\* refers to items included in the Avdel service kit. For complete list see page 18.



GENERAL ASSEMBLY OF BASE TOOL AND RESPECTIVE PARTS LIST ON THE FOLLOWING PAGES.

**GENERAL ASSEMBLY OF BASE TOOL 07340-00200  
(07340/07344/07345/07346 MODELS)**





**07340-00200 PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07003-00099	1/4 BONDED SEAL	1	2	31	07007-00016	LOCATING PIN	1	-
2	07001-00394	HANDLE PLUG	1	2	32	07340-00208	TRIGGER CAM LEVER	1	-
3	07340-00329	NYLON BUFFER	1	-	33	07340-00217	BACK UP RING	2	2
4	07003-00034	BACK UP RING	1	1	34	07001-00393	SOCKET BUTTON HEAD SCREW 3/8 LG	4	4
5	07003-00036	'O' RING	1	1	35	07340-04900	TRIGGER ASSEMBLY	1	-
6	07003-00015	'O' RING	1	1	36	07007-00439	GROOVED PIN	1	1
7	07003-00035	BACK UP RING	1	1	37	07001-00114	10-24 X 1/4 SKT BUT HD SCREW	1	2
8	07340-00324	SPRING	1	1	38	07003-00032	ADAPTOR 'O' RING	1	1
9	07344-00301	PISTON	1	-	39	07330-01302	FILTER	1	1
10	07004-00019	CIRCLIP	1	1	40	07340-00413	VALVE	1	-
11	07003-00033	2BA BONDED SEAL	1	1	41	07003-00040	'O' RING	1	2
12	07340-00700	ADAPTOR ASSEMBLY	1	-	42	07340-00416	VALVE OPERATING ROD	1	1
13	07003-00036	'O' RING	1	1	43	07005-00015	1/4 B.S.P. WASHER	1	-
14	07003-00034	BACK UP RING	1	1	44	07007-00014	CAM LEVER PIN	1	1
15	07340-00701	ADAPTOR	1	1	45	07340-00300	HANDLE ASSEMBLY	1	-
16	07340-00204	FACING WASHER	1	-	46	07340-00302	HANDLE MACHINED	1	-
17	07340-00415	CYLINDER COVER	1	-	47	07344-00400	JAW SPREADER HOUSING. ASSY.	1	-
18	07340-00500	PISTON ASSEMBLY	1	-	48	07340-00330	WIPER WASHER	1	1
19	07340-00505	PISTON ROD	1	-	49	07340-00400	CYLINDER ASSEMBLY	1	-
20	07340-00506	BUFFER	1	-	50	07003-00065	1/4 B.S.P.F. WASHER	1	1
21	07340-00510	BUFFER WASHER	1	-	51	07340-00407	CYLINDER MACHINED	1	-
22	07003-00038	AIRPISTON CUP	1	-	52	07340-04600	TRIGGER GUARD	1	-
23	07340-00502	PISTON WASHER	1	-	53	07003-00029	DIRT EXCLUDER	1	1
24	07002-00011	PISTON ROD NUT	1	1	54	07340-00334	STEM CATCHER ADAPTOR	1	-
25	07003-00031	PLUG 'O' RING	1	1	55	07340-00342	PINTAIL DEFLECTOR	1	2
26	07340-00230	INTERNAL CIRCLIP	1	1	56	07340-00332	END CAP	1	-
27	07391-00201	PLUG	1	-	57	07340-00412	1/4 B.S.P.F. FEMALE ADAPTOR	1	-
28	07005-00041	DOUBLE MALE CONNECTOR	1	-	58	07340-00401	VALVE SPRING	1	-
29	07340-00417	VALVE PLUNGER	1	-	59	07340-00403	SPRING	1	1
30	07340-00414	FILTER	1	1					



**07347-00200 PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07003-00099	1/4 BONDED SEAL	1	2	38	07003-00032	ADAPTOR 'O' RING	1	1
2	07001-00394	HANDLE PLUG	1	2	39	07330-01302	FILTER	1	1
3	07340-00329	NYLON BUFFER	1	-	40	07340-00413	VALVE	1	-
4	07003-00034	BACK UP RING	1	1	41	07003-00040	'O' RING	1	2
5	07003-00036	'O' RING	1	1	42	07340-00416	VALVE OPERATING ROD	1	1
6	07003-00015	'O' RING	1	1	43	07005-00015	1/4 B.S.P. WASHER	2	-
7	07003-00035	BACK UP RING	1	1	44	07007-00014	CAM LEVER PIN	1	1
8	07340-00324	SPRING	1	1	45	07347-00300	HANDLE ASSEMBLY	1	-
9	07344-00301	PISTON	1	-	46	07340-00302	HANDLE - MACHINED	1	-
10	07004-00019	CIRCLIP	1	1	47	07344-00400	JAW SPREADER HOUSING ASSY	1	-
11	07003-00033	2BA BONDED SEAL	1	1	48	07340-00330	WIPER WASHER	1	1
12	07340-00700	ADAPTOR ASSEMBLY	1	-	49	07347-00400	CYLINDER ASSEMBLY	1	-
13	07003-00036	'O' RING	1	-	50	07005-00015	1/4 B.S.P. WASHER	2	2
14	07003-00034	BACK UP RING	1	1	51	07340-00407	CYLINDER MACHINED	1	-
15	07340-00701	ADAPTOR	1	1	52	07340-04600	TRIGGER GUARD	1	-
16	07340-00204	FACING WASHER	1	-	53	07640-00241	STEM CATCHER BODY	1	-
17	07340-00415	CYLINDER COVER	1	-	54	07340-00335	STEM CATCHER END CAP	1	-
18	07340-00500	PISTON ASSEMBLY	1	-	55	07347-00500	SPRING HOUSING ASSEMBLY	1	-
19	07340-00505	PISTON ROD	1	-	56	07340-00336	CLAMP WASHER	1	-
20	07340-00506	BUFFER	1	-	57	07003-00205	'O' RING	1	-
21	07340-00510	BUFFER WASHER	1	-	58	07003-00067	'O' RING	1	1
22	07003-00038	AIR PISTON CUP	1	-	59	07347-00404	ADJUSTING SCREW RETAINER	1	-
23	07340-00502	PISTON WASHER	1	-	60	07001-00005	HAMMER DRIVE SCREW	1	-
24	07002-00011	PISTON ROD NUT	1	1	61	07347-00302	PISTON SLEEVE	1	-
25	07003-00031	PLUG 'O' RING	1	1	62	07347-00201	CARRIER	1	-
26	07340-00230	INTERNAL CIRCLIP	1	1	63	07002-00097	1/2 - 20 UNF LOCKNUT	1	-
27	07391-00201	PLUG	1	-	64	07640-00239	STEM CATCHER OUTER	1	-
28	07005-00041	DOUBLE MALE CONNECTOR	1	1	65	N. D.	TUBING 3mm 1/2 MAKE FROM 07005-0045	36cm	
29	07340-00417	VALVE PLUNGER	1	-	66	07005-00456	SERRATED NIPPLE	1	1
30	07340-00414	FILTER	1	1	67	07347-00403	CONNECTOR MACHINED	1	-
31	07007-00016	LOCATING PIN	1	-	68	07003-00022	'O' RING	1	1
32	07340-00208	TRIGGER CAM LEVER	1	-	69	07347-00202	VACUUM ADJUSTING SCREW	1	1
33	07340-00217	BACK UP RING	2	2	70	07347-00402	CONNECTOR BOLT	1	-
34	07001-00393	SOCKET BUTTON HEAD SCREW 3/8 LG	4	4	71	07347-00401	FILTER (.465 DIAMETER )	1	1
35	07340-04900	TRIGGER ASSEMBLY	1	-	72	07347-00403	SPRING	1	1
36	07007-00439	GROOVED PIN	1	1	73	07340-00401	VALVE SPRING	1	-
37	07001-00114	10-24 X 1/4 SKT BUT HD SCREW	1	2					



**07348-00200 PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07003-00099	1/4 BONDED SEAL	1	2	36	07007-00439	GROOVED PIN	1	1
2	07001-00394	HANDLE PLUG	1	2	37	07001-00114	10-24 X 1/4 SKT BUT HD SCREW	1	2
3	07340-00329	NYLON BUFFER	1	-	38	07003-00032	ADAPTOR 'O' RING	1	1
4	07003-00034	BACK UP RING	1	1	39	07330-01302	FILTER	1	1
5	07003-00036	'O' RING	1	1	40	07340-00413	VALVE	1	-
6	07003-00015	'O' RING	1	1	41	07003-00040	'O' RING	1	2
7	07003-00035	BACK UP RING	1	-	42	07340-00416	VALVE OPERATING ROD	1	1
8	07340-00324	SPRING	1	1	43	07005-00015	1/4 B.S.P. WASHER	1	-
9	07344-00301	PISTON	1	-	44	07007-00014	CAM LEVER PIN	1	1
10	07004-00019	CIRCLIP	1	1	45	07348-00300	HANDLE ASSEMBLY	1	-
11	07003-00033	2BA BONDED SEAL	1	1	46	07348-00301	HANDLE - MACHINED	1	-
12	07340-00700	ADAPTOR ASSEMBLY	1	-	47	07348-00500	JAW SPREADER HOUSING ASSY.	1	-
13	07003-00036	'O' RING	1	1	48	07340-00412	FEMALE ADAPTOR	1	-
14	07003-00034	BACK UP RING	1	1	49	07348-00400	CYLINDER ASSEMBLY	1	-
15	07340-00701	ADAPTOR	1	1	50	07003-00065	1/4 B.S.P.F. WASHER	1	-
16	07340-00204	FACING WASHER	1	-	51	07348-00403	CYLINDER - MACHINED	1	-
17	07340-00415	CYLINDER COVER	1	-	52	07340-00201	TRIGGER GUARD	1	-
18	07340-00500	PISTON ASSEMBLY	1	-	53	07340-00401	VALVE SPRING	1	-
19	07340-00505	PISTON ROD	1	-	54	07340-00403	SPRING	1	-
20	07340-00506	BUFFER	1	-	55	07005-00456	BARBED FITTING AND SEAL	1	-
21	07340-00510	BUFFER WASHER	1	-	56	07005-00591	3mm I.D. BLACK PLASTIC TUBING	23cms	-
22	07003-00038	AIR PISTON CUP	1	-	57	07003-00033	2BA BONDED SEAL	2	-
23	07340-00502	PISTON WASHER	1	-	58	07348-00302	BARBED FITTING	1	-
24	07002-00011	PISTON ROD NUT	1	1	59	07640-00240	END COVER	1	-
25	07003-00031	PLUG 'O' RING	1	1	60	07340-00336	CLAMP WASHER	1	-
26	07340-00230	INTERNAL CIRCLIP	1	1	61	07640-00239	STEM CATCHER OUTER	1	-
27	07391-00201	PLUG	1	-	62	07340-00335	STEM CATCHER END CAP	1	-
28	07005-00041	DOUBLE MALE CONNECTOR	1	1	63	07640-00241	STEM CATCHER BODY	1	1
29	07340-00417	VALVE PLUNGER	1	-	64	07610-00314	LOCKING RING	1	-
30	07340-00414	FILTER	1	1	65	07003-00067	'O' RING	1	-
31	07007-00016	LOCATING PIN	1	-	66	07348-00600	STEM CATCHER ADAPTOR	1	-
32	07340-00208	TRIGGER CAM LEVER	1	-	67	07348-00601	STEM CATCHER ADAPTOR BODY	1	-
33	07340-00217	BACK UP RING	2	2	68	07003-00029	'O' RING	1	-
34	07001-00393	SOCKET BUTTON HEAD SCREW 3/8 LG	4	4	69	07348-00603	RETURN SPRING	1	-
35	07340-04900	TRIGGER ASSEMBLY	1	-	70	07348-00602	STEM CATCHER ADAPTOR SLEEVE	1	-

Priming is **ALWAYS** necessary after the tool has been dismantled and prior to operating. It may also be necessary to restore the full stroke after considerable use, when the stroke may be reduced and rivets are not fully placed by one operation of the trigger.

## OIL DETAILS

The recommended oil for priming is Hyspin VG32 available in 0.5l (part number 07992-00002) or one gallon containers (part number 07992-00006). Please find specific table and safety data below.

H Y S P I N V G 3 2 O I L S A F E T Y D A T A			
<b>FIRST AID</b> SKIN: Wash thoroughly with soap and water as soon as possible. Casual contact requires no immediate attention. Short term contact requires no immediate attention. INGESTION: Seek medical attention immediately. DO NOT induce vomiting. EYES: Irrigate immediately with water for several minutes. Although NOT a primary irritant, minor irritation may occur following contact. <b>FIRE</b> Suitable extinguishing media: CO2, dry powder, foam or water fog. DO NOT use water jets.		<b>ENVIRONMENT</b> WASTE DISPOSAL: Through authorised contractor to a licenced site. May be incinerated. Used product may be sent for reclamation. SPILLAGE: Prevent entry into drains, sewers and water courses. Soak up with absorbent material. <b>HANDLING</b> Wear eye protection, impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area. <b>STORAGE</b> No special precautions.	
PROPERTIES	RESULT	PROPERTIES	RESULT
ISO oil type	HL	Foaming tendency/stability	
ISO viscosity grade	32	ml @ 24°C	Trace/Nil
Kinematic viscosity		ml @ 93.5°C	20/Nil
	cS @ 40°C	ml @ 24°C after test @ 93.5°C	Trace/Nil
	@ 100°C		
Relative density	at 20°C	Air release value minutes to	
Viscosity Index		0.2% air content @ 50°C	4
Pour point	°C	Seal compatability index	10
Open Flash point	°C	Water separation time	
Neutralisation value mg KOH/g		in minutes to 40-40-0 @54°C	15
		@83°C	15

## PROCEDURE

### IMPORTANT

**CONNECT AIR SUPPLY (this causes the piston to bottom, allowing more priming oil into the tool).**

**DO NOT OPERATE THE TRIGGER WHILE THE BLEED SCREW IS REMOVED.**

All operations should be carried out on a clean bench, with clean hands in a clean area.

Ensure that the priming pump is free from foreign matter

and that the oil is perfectly clean and free from air bubbles.

Care **MUST** be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

The use of a priming kit is necessary to implement the priming procedure. Ensure you select the correct kit to suit your tool model. The part number of the kit to be used with the 07340/4/7/8 model is 07900-03401. For the 07345 and 07346 the part number is 07900-03421.

7340, 4, 7, 8 PRIMING KIT		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00013	1/8" A/F ALLEN KEY	1
07900-00078	5/32" A/F ALLEN KEY	1
07900-00192	PRIMING PUMP ASSEMBLY	1
07900-00638	PRIMING SPACER	1

7345 & 7346 PRIMING KIT		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00013	1/8" A/F ALLEN KEY	1
07900-00078	5/32" A/F ALLEN KEY	1
07900-00192	PRIMING PUMP ASSEMBLY	1
07900-00638	PRIMING SPACER	1
07340-00306	NOSE CASING	1

Item numbers in text refer to the nose assemblies pages 12 to 15. Item **numbers in bold** refer to the general assembly and parts lists pages 22 to 27.

- First remove the complete nose assembly off the tool.
- Insert priming spacer into the nose casing, ensuring that the spacer sits at the bottom.
- Fit the nose casing to the tool.
- Fill the priming pump with priming oil.
- Using a vice with a soft jaw place tool at a 45° incline.
- Remove bleed screw **2** and sealing washer **1** from the bottom of the handle with allen key\* .
- Screw priming pump into lower handle bleed screw port, complete with oil seal.
- Remove upper bleed screw **37** and sealing washer **11** from the handle using  $\frac{1}{8}$ " allen key\*.
- Pump oil through the tool until non-aerated oil flows freely from the bleed screw port.
- Fit bleed screw **37** and sealing washer **11**, paying particular attention to the sealing washer which, if worn or damaged **MUST** be replaced.
- Remove priming pump and fit lower bleed screw **2** and sealing washer **1**, checking washer - as above.
- Remove the tool from the vice.
- Remove the priming spacer from the nose casing and fit the nose casing to the tool.
- Lay the tool horizontal on the bench with bleed screw **37** uppermost.
- Remove bleed screw **37** and allow excess oil to flow out.
- Replace bleed screw **37**.
- Remove nose casing and priming spacer.
- Fit nose assembly.

\* refers to items included in the Avdel service kit. For complete list see page 18.

# FAULT DIAGNOSIS

## FAULT DIAGNOSIS TABLE

SYMPTOM	POSSIBLE CAUSE	REMEDY
Several pulls required to set rivet	→ Low air pressure.	→ Increase air pressure.
	→ Lack of lubrication.	→ Lubricate tool at air inlet point.
	→ Worn or broken jaws.	→ New jaws.
	→ Oil level in tool low or air in oil.	→ Prime tool. (see page 29)
	→ Worn or dirty jaws.	→ Clean jaws.
Jaws will not grip rivet stem	→ Worn or dirty jaws.	→ Clean or renew as necessary.
	→ Jaw housing loose.	→ Tighten against nylon locking ring.
	→ Weak or broken nose assembly spring.	→ Replace spring.
	→ Incorrect nose equipment fitted.	→ Replace as necessary.
	→ Bent jaw spreader assembly tube preventing it from moving forward into jaw housing.	→ Replace jaw spreader assembly.
Jaws will not release spent rivet stem.	→ Dirty jaws or jaw housing.	→ Clean.
	→ Jaw housing, nose tip or nose casing not properly seated.	→ Tighten nose equipment.
	→ Weak or broken spring around jaw spreader assembly.	→ New spring.
	→ Tool overprimed.	→ Reprime.
Spent rivet stem is jamming in tool.	→ Incorrect jaw spreader fitted.	→ Replace by correct part.
	→ Bent or dirty jaw spreader assembly tube.	→ Renew or clean as applicable.
	→ Collector bottle too full.	→ Empty and ensure bottle never exceeds half full.
	→ On 07347 tools, valve adjusting screw <b>69</b> out of adjustment.	→ Adjust.
Slow stroking tool	→ Lack of lubrication.	→ Lubricate tool at air inlet.









**Engineered Fastening and Assembly Systems****Declaration of Conformity**

We, *Avdel Systems Limited, Mundells, Welwyn Garden City, Herts, AL7 1EZ*

declare under our sole responsibility that the product

*type 0734*

*Serial N°*

to which this declaration relates is in conformity with the following standards or other formative documents

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

ISO PREN792 part 14

following the provisions of the Machine Directive 89/392/EEC  
(as amended by Directive 91/368/EEC, 93/44/EEC) and 93/68/EEC



Welwyn Garden City - date of issue

A R Dear - Engineering Design Manager

**World Headquarters:**

**Avdel Systems Ltd**, Mundells, Welwyn Garden City, Herts AL7 1EZ United Kingdom - Tel: (01707) 328161 Fax: (01707) 338828

**Overseas Companies:**

Avdel Pty Ltd, 2263 Princes Highway, Mulgrave, Victoria 3170 **Australia**

Avdel GmbH, Industriestrasse B 13/Halle 2, A-2345 Brunn/Gebirge **Austria**

Avdel Inc, 2696 Slough Street, Mississauga, Ontario L4T 1G3 **Canada**

Avdel SA, 33 bis, rue des Ardennes, BP4 75921 Paris Cedex 19 **France**

Avdel GmbH, Postfach 1463, D-30835 Langenhagen **Germany**

Avdel SRL, Via Manin 350-21, 20099 Sesto Giovanni, Milan **Italy**

Avdel KK, Takahashi Building, 9-3, 5 Chome, Nishi-tenma, Kita-ku, Osaka 530 **Japan**

Avdel SA, Poligono Prado Overa, Edificio Prado Park, Autovia Madrid Toledo KM 7.8, Leganes 28916, Madrid **Spain**

Avdel Korea Ltd, Samyung Building, 1486-2 Socho Dong, Socho Ku, Seoul **S. Korea**

Ejot & Avdel System AB, PO BOX 9013 S-700 09 Örebro **Sweden**

Avdel Corporation, 50 Lackawanna Avenue, Parsippany, New Jersey 07054 **USA**