



## **PT-100 Air Hydraulic Riveter Operating Instructions**

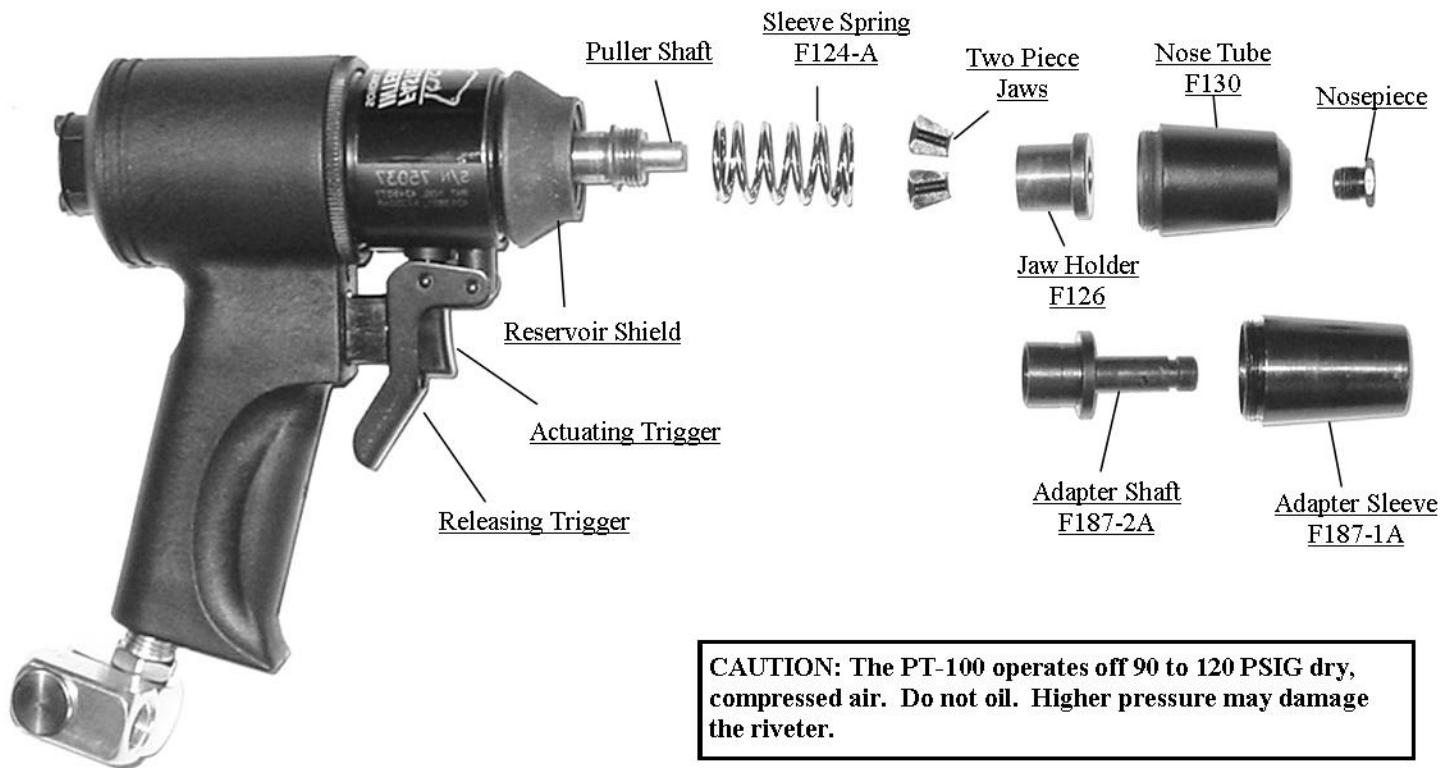


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## PT-100 SERIES RIVETER

NSN 5130-01-397-6805

### ASSEMBLY DIAGRAM/OPERATING INSTRUCTIONS



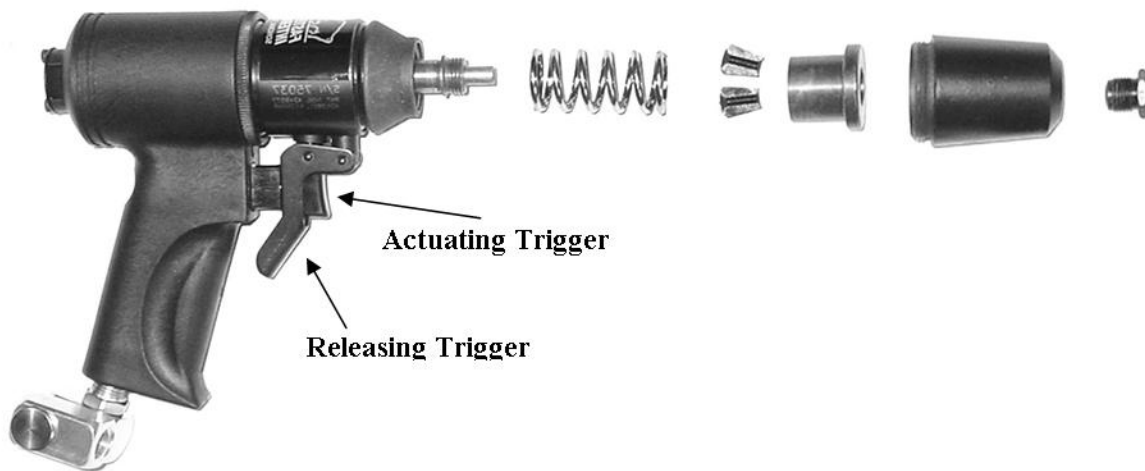
**CAUTION:** The PT-100 operates off 90 to 120 PSIG dry, compressed air. Do not oil. Higher pressure may damage the riveter.

#### Assembly Procedures:

1. Place the **Two Piece Jaws (F122-A)** inside the **Jaw Holder (F126)**.
2. Place the assembled item into one end of **Sleeve Spring (F124-A)**. The flange on the **Jaw Holder** should bottom out on the **Sleeve Spring**. These two items fit together firmly, thus some pressure may be required.
3. Next, point the tool downward, and place the open end of the **Sleeve Spring (F124-A)** over the **Puller Shaft** and thread the **Jaw Holder** onto the **Puller Shaft** until it bottoms out against **Puller Shaft** flange. (**WARNING: FAILURE TO BOTTOM OUT AGAINST THE FLANGE MAY DAMAGE THREAD AND/OR CAUSE RIVETS TO JAM**).
4. Place the **Nose Tube (F130)** over the complete assembly and hand tighten. Threads on the outer sleeve should disappear and the **Reservoir Shield** should be stationary.
5. Now select the proper nosepieces for the diameter and type of rivet being used and thread into the end of the **Nose Tube** until it bottoms out. It may be necessary to extend the nose tube by actuating the trigger (see operating instructions) in order to thread the nosepiece completely into place.

**CAUTION:** Nosepieces can loosen with use and may cause damage to the threads if not kept tight. Check periodically, and if no other nosepieces are going to be needed for the day, tighten with a wrench.

## PT-100 SERIES OPERATING INSTRUCTIONS



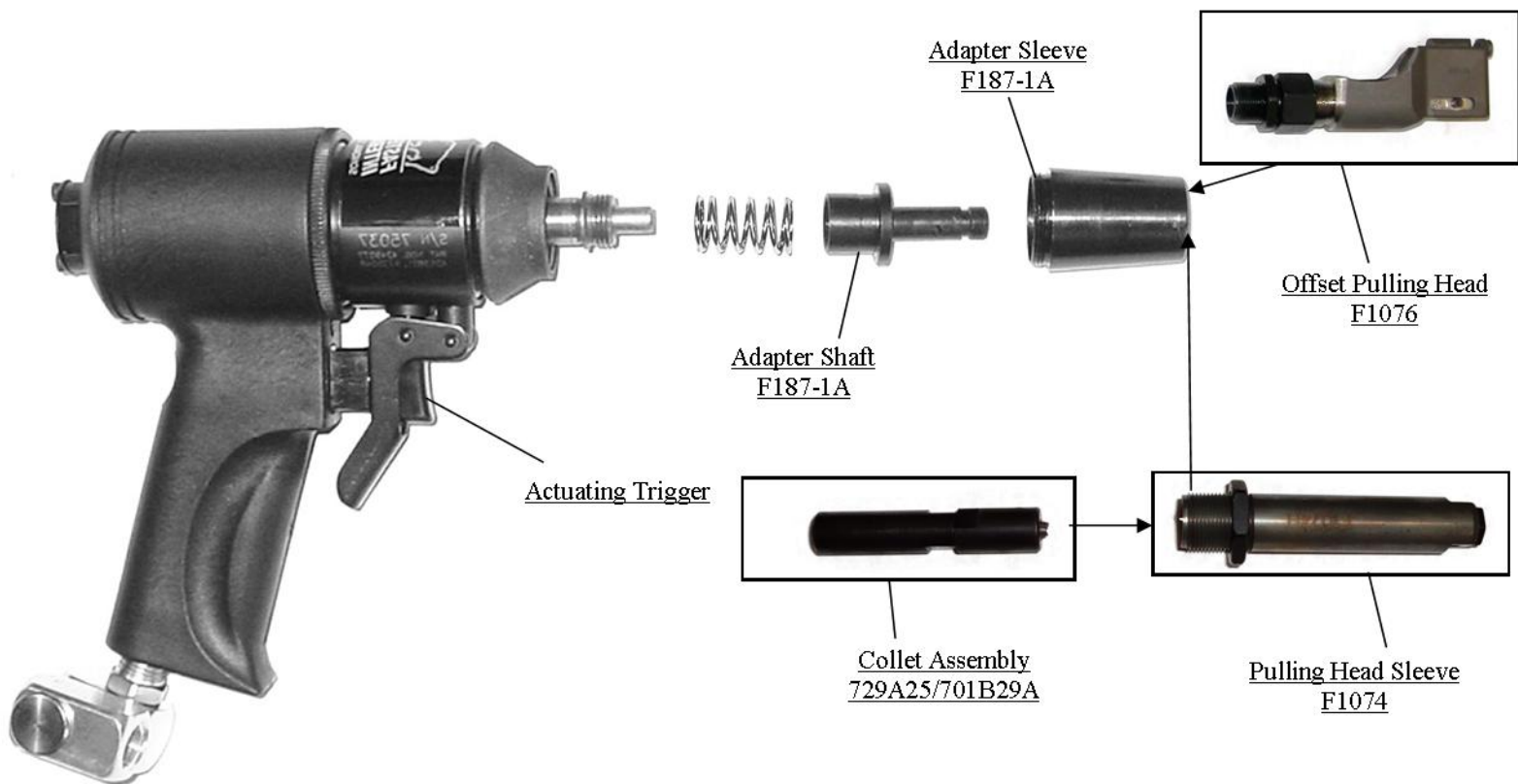
1. Connect **PT-100** riveter to air source. Be sure to utilize clean, dry compressed air over a 90 to 120 PSIG range. If using a multi-plane swivel be sure swivel is properly tightened into tool before installing air fitting into swivel.
2. Select the proper nosepiece for installing the blind rivet being used and hand tighten it into the nose tube. If frequent changing of the nosepiece is not required, slight tightening with a wrench is recommended in order to prevent the nosepiece from backing out during riveting operation. If rivet nosepiece will not easily install into nose tube simply actuate the **Actuating Trigger** and cause the nose tube to move forward thus allowing ease of nosepiece installation.
3. Insert rivet into nosepiece being sure that the riveter is in the fully retracted position. (If nose tube is partially extended, simply depress **Releasing Trigger** until the nose tube fully retracts to starting position.) Place rivet into properly prepared hole and hold riveter against materials being riveted using firm, steady pressure. Be sure to keep riveter as perpendicular to work surface as possible (within +/- 1.5 degrees from centerline). Next, depress **Actuating Trigger** being careful not to depress the **Releasing Trigger** at the same time. If you do, the tool will not actuate and the hydraulic fluid (no. 10 machine oil) will just circulate through the by-pass valve. The riveter has a maximum stroke of .625" and will set most blind fasteners in one stroke; however, if the tool reaches the end of its stroke before setting a fastener: **DO NOT CONTINUE TO DEPRESS THE ACTUATING TRIGGER.** Release the **Actuating Trigger** and depress the **Releasing Trigger**. The riveter will then retract and you can re-grip the fastener and reactivate the tool until you upset the fastener.
4. After the rivet stem breaks you may depress the **Releasing Trigger**, point the tool downward and the broken rivet stem will drop out of the nosepiece. *NOTE: If the rivet stem sticks in the nose-piece after the rivet is set, lightly tap the end of the rivet stem on a hard surface while holding the **Releasing Trigger** in the full depressed position. This should then free the jaws and permit the tool to release the rivet stem. If the rivet stem continues to bind or hang up in the nose assembly check the jaw holder by removing the nose tube to see if it is properly tightened into place. If loose, tighten and reassemble after checking the jaws to see that they are not severely worn. Replace if necessary.*

**NOTE OF CAUTION:** If you cause the riveter to reach its maximum stroke you may cause the riveter to go into a by pass mode which causes a pressure relief valve to open (this occurs when approximately 4,400 lbs. of pulling force is reached). This condition will often cause the normal hand releasing pressure required to return the tool to its normal position to increase. Simply increase pressure on the releasing trigger and the tool will release.

## PT-100 SERIES ASSEMBLY DIAGRAM

### OFFSET PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Open **Offset Pulling Head (F1076)** 1/4" as shown.
2. Thread interior draw bolt of the **Offset Pulling Head (F1076)** onto the **Adapter Shaft (F187-2A)** 4 turns.
3. Push the **Offset Pulling Head (F1076)** into the **Adapter Sleeve (F187-1A)** and mate threads. Thread in until 1/4" head gap is fully closed. **DON'T GO BEYOND!**
4. Position head direction COUNTERCLOCKWISE ONLY. Set jamb nut.
5. Depress **Actuating Trigger** to install rivet. Rivet stems will push out the back. Reverse for disassembly.



### STRAIGHT EXTENSION PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Thread the **Collet Assembly (749A25/701B29A)** onto the **Adapter Shaft (F187-2A)**
2. Slide the **Pulling Head Sleeve (F1074)** over the **Collet Assembly (749A25/701B29A)** and into the **Adapter Sleeve (F187-1A)** and mate threads. Thread on and bottom out against assembly. **DON'T GO BEYOND!**
3. Set jamb nut. Reverse for disassembly.
4. Rivet may be forced in to open jaws initially.
5. Depress **Actuating Trigger** to install rivet.

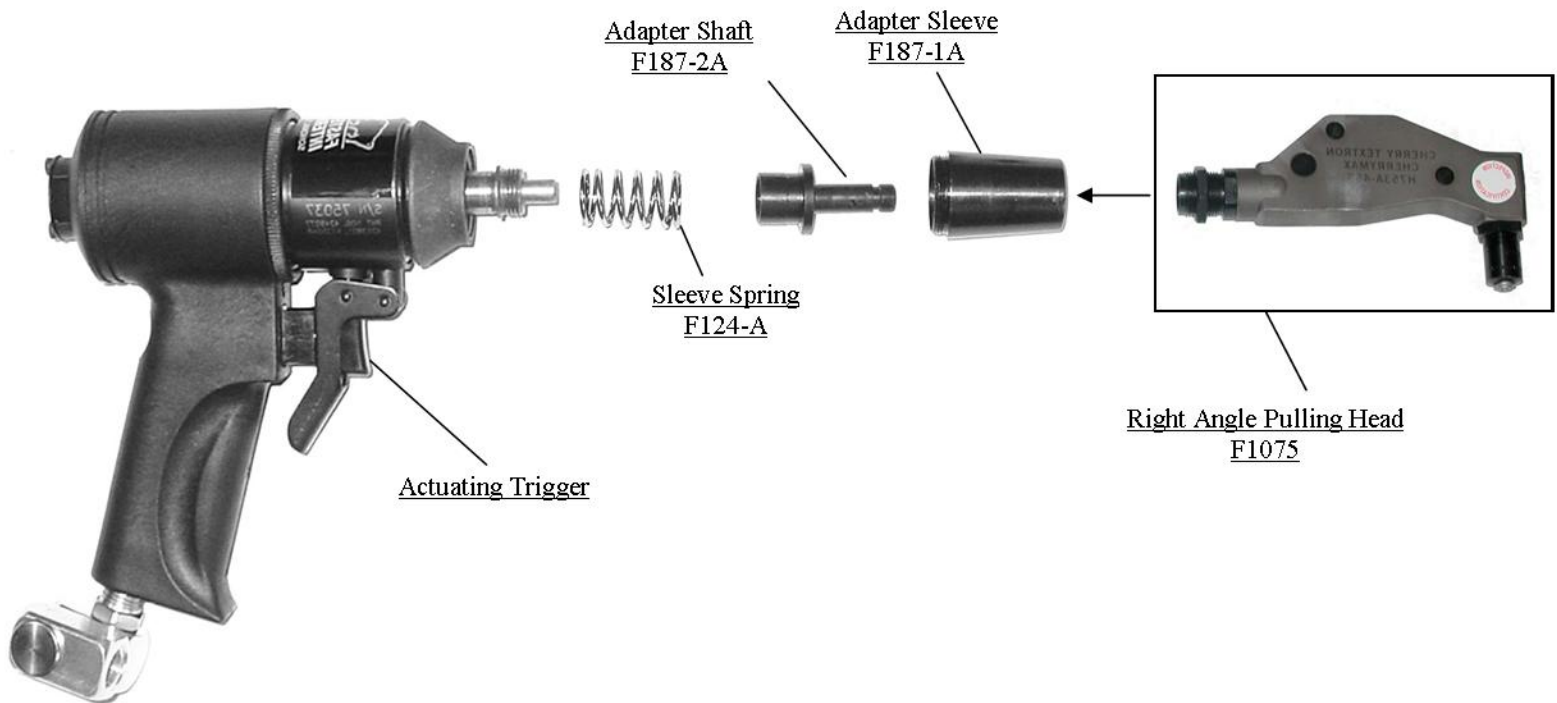


## PT-100 SERIES ASSEMBLY DIAGRAM

### F187 ADAPTER FOR SPECIAL PULLING HEADS INSTRUCTIONS:

1. Place the **Adapter Shaft (F187-2A)** into end of the **Sleeve Spring (F124-A)**
2. Place other end of the **Sleeve Spring (F124-A)** over the **Puller Shaft** and thread the **Adapter Shaft (F187-2A)** onto the **Puller Shaft** hand tight against it so no threads are showing.
3. Place the **Adapter Sleeve (F187-1A)** over assembly and hand tighten until threads disappear. Reverse for disassembly.

ASSEMBLY IS NOW READY FOR ANY OF THE SPECIAL PULLING HEADS.



### RIGHT ANGLE PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Thread interior draw bolt of the **Right Angle Pulling Head (F1075)** onto the **Adapter Shaft (F187-2A)** 3 turns.
2. Push the **Right Angle Pulling Head (F1075)** into the **Adapter Sleeve (F187-1A)** and mate thread. Thread at least 5 full turns until rivet stem fits easily into nose piece (Adjust nose piece in for larger diameters).
3. Position head direction and set jamb nut. Reverse for disassembly.
4. Depress **Actuating Trigger** to install rivet (see operating instructions).

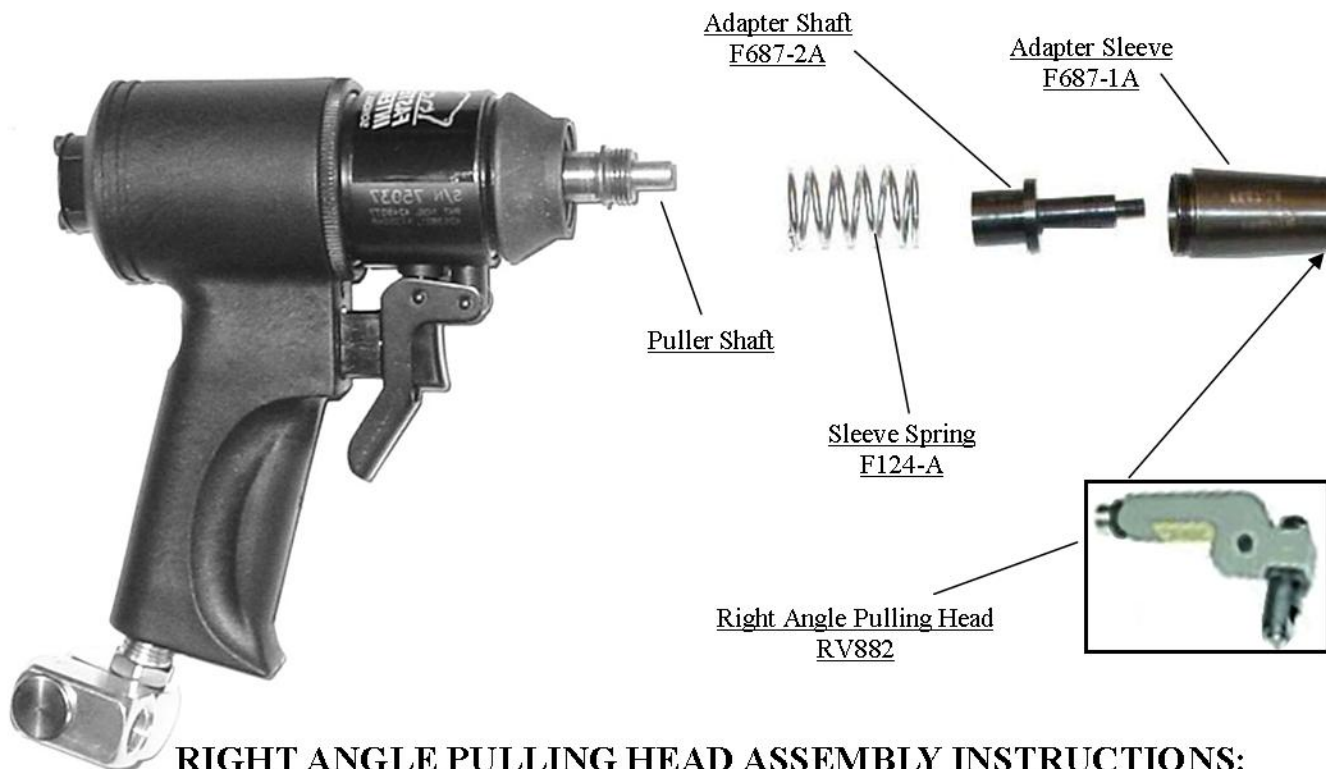
## ASSEMBLY DIAGRAM FOR OLYMPIC-LOK PULLING HEADS

- The Olympic-Lok (NAS1400 'A' Code) and the Cherry-Lok use the same non-shift tooling system
- One pulling head installs both flush and protruding head rivets in all grips
- No tool adjustment required with this system

### F687 ADAPTER FOR SPECIAL PULLING HEADS– INSTRUCTIONS

1. Place the **Adapter Shaft (F687-2A)** into the end of the **Sleeve Spring (F124-A)**.
2. Place other end of the **Sleeve Spring (F124-A)** over the **Puller Shaft** and thread the **Adapter Shaft (F687-2A)** onto the **Puller Shaft** hand tight against it.
3. Place the **Adapter Sleeve (F687-1A)** over assembly and hand tighten (threads should disappear). Reverse for disassembly.

ASSEMBLY IS NOW READY FOR ANY OF THE SPECIAL PULLING HEADS.

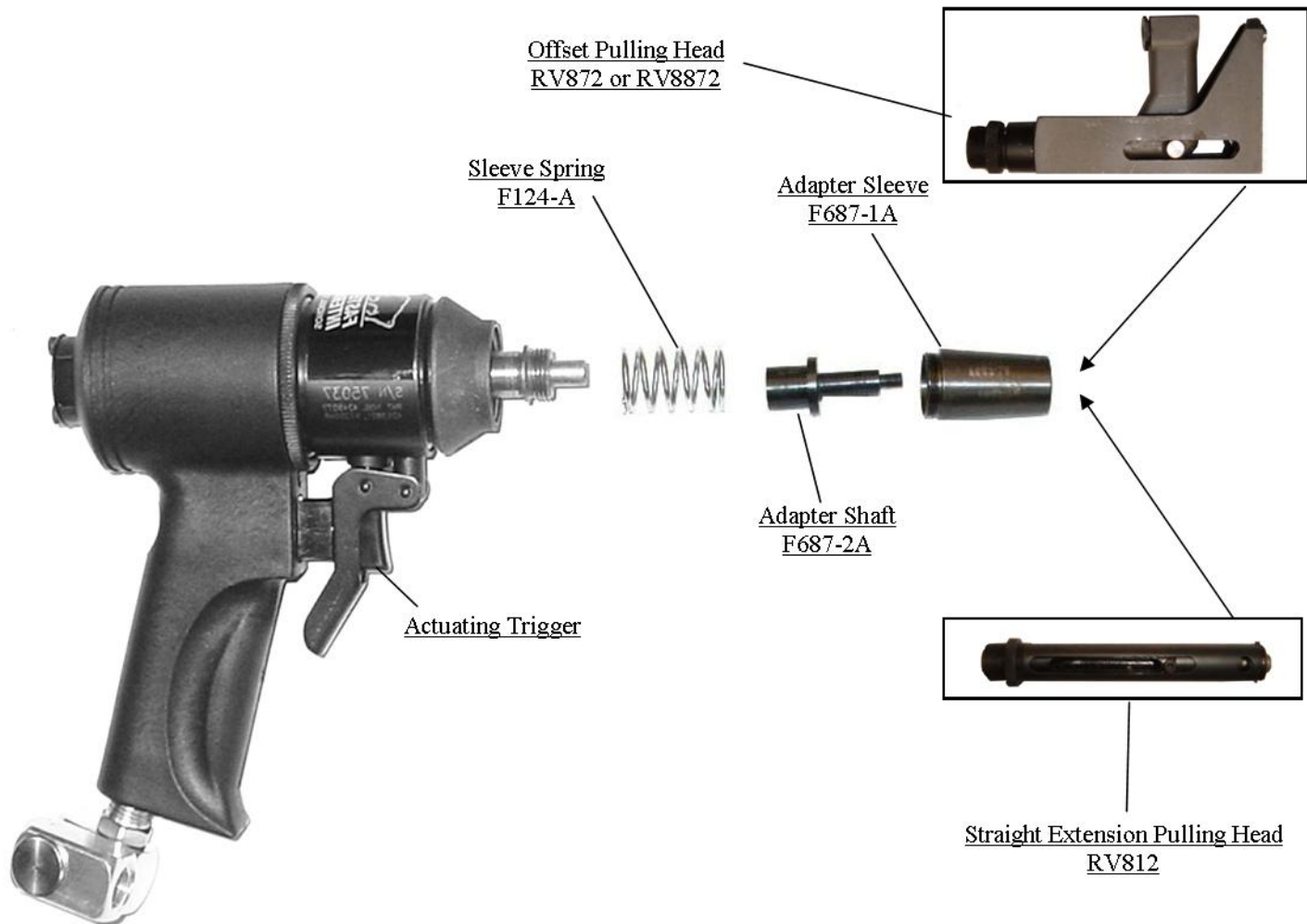


### RIGHT ANGLE PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Thread interior draw bolt of **RV882** onto the **Adapter Shaft (F687-2A)**, approx. 3 full turns.
2. Push **RV882** into the **Adapter Sleeve (F687-1A)** and mate threads. Thread at least 5 full turns until rivet stem fits easily into nose piece (adjust nose piece in for larger diameters).
3. Position head direction and set jamb nut. Reverse for disassembly.
4. Depress **Actuating Trigger** to install rivet. (see operating instructions)

## OFFSET PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Thread interior draw bolt of **RV872 or RV8872** onto the **Adapter Shaft (F687-2A)** approx. 4 turns.
2. Push **RV872 or RV8872** into the **Adapter Sleeve (F687-1A)** and mate threads. Thread in until head gap is fully closed. **DON'T GO BEYOND!**
3. Position head direction counterclockwise only. Set jamb nut.
4. Depress **Actuating Trigger** to install rivet. Rivet stem will push out the back. (see operating instructions) Reverse for disassembly.



## STRAIGHT EXTENSION PULLING HEAD ASSEMBLY INSTRUCTIONS:

1. Thread **RV812** onto the **Adapter Shaft (F687-2A)**.
2. Thread the sleeve of the **RV812** over assembly and into the **Adapter Sleeve (F687-1A)**. Thread on and bottom out against assembly. **DON'T GO BEYOND!**
3. Set jamb nut. Reverse for disassembly.
4. Rivet may be forced in to open jaws initially.
5. Depress **Actuating Trigger** to install rivet.