



D-180 Hand Riveter Operating Instructions



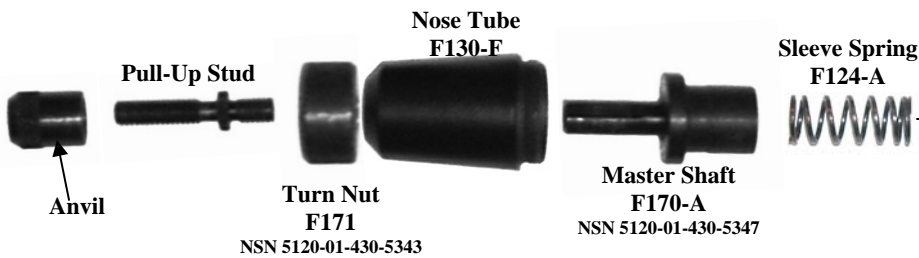
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D-100-MIL Configurations

Standard Configuration



Nutsetting Configuration



D-180 Specifications:

Pulling Force Max.	5,000 lbs
Stroke Max.	0.825"
Overall Dimensions:	6 1/4" H x 5 3/8" L x 1 3/4" W
Weight:	20.5 oz.
Power Source:	Hand Operated, Two valve, cylindrical hydraulic pump, with pressure relief valve.

Extended Straight Pulling Head
F1074
NSN 5120-01-430-5386



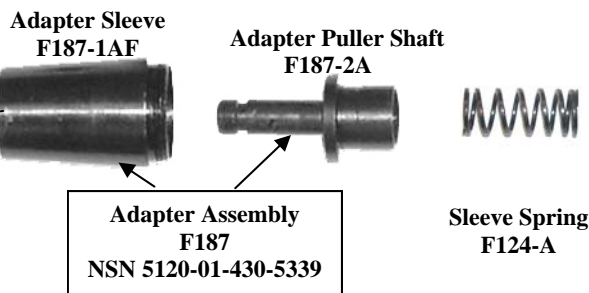
Right Angle Pulling Head
F1075
NSN 5120-01-430-5346



Offset Pulling Head
F1076
NSN 5120-01-430-5328



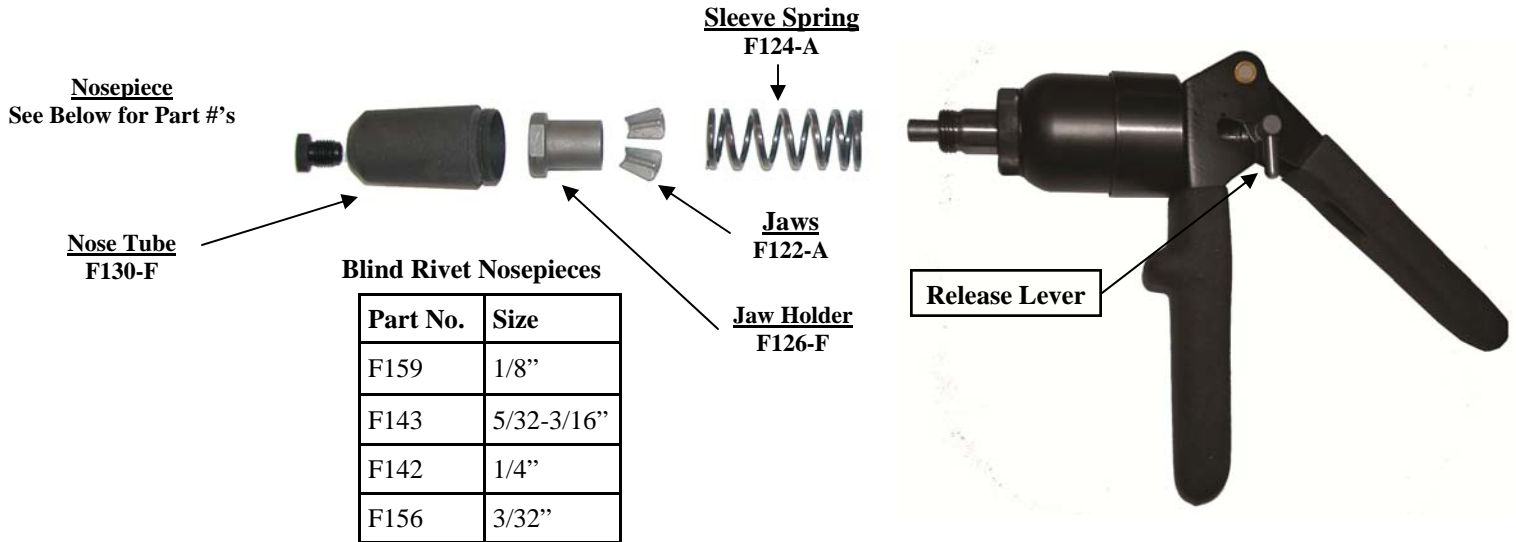
CherryMax® Pulling Head Configuration



D-180 Hand Hydraulic Riveter

Operating Instructions

Standard Configuration



1. Place the Jaws inside the Jaw Holder (F126-F)
2. Place the Jaw Holder (F126-F) into the end of the Sleeve Spring (F124-A).
3. Place other end of the Sleeve Spring over the Puller Shaft and thread the Jaw Holder (F126-F) onto the puller shaft hand tight until no threads are showing.
4. Place the Nose Tube (F130-F) over assembly and hand tighten until threads do not show.
5. Choose a Rivet Nose Piece as required and thread into the Nose Tube (F130-F), hand tight. Reverse for disassembly. It may be necessary to pump tool out 2 or 3 strokes before nose piece can be entirely threaded on to the Nose Tube (F130-F).

Operating Instructions: (WITH RIVETING ASSEMBLY IN PLACE PER DIAGRAM, TOOL IS READY TO OPERATE)

1. Pump handles 3 or 4 times, holding them together fully on last pump. Flip the directional lever while handles are together and nose assembly will retract.
1. Place rivet stem into the Rivet Nose Piece and insert rivet into desired hole.
2. Pump handles to install rivet. If more than 15 full pumps are required, re-grip rivet by turning the lever and bringing handles together, slide tool up on rivet stem and finish installing.
3. After stem breaks, turn the lever and bring handles together, point nose piece down and rivet stem will fall out, or can be removed by hand.

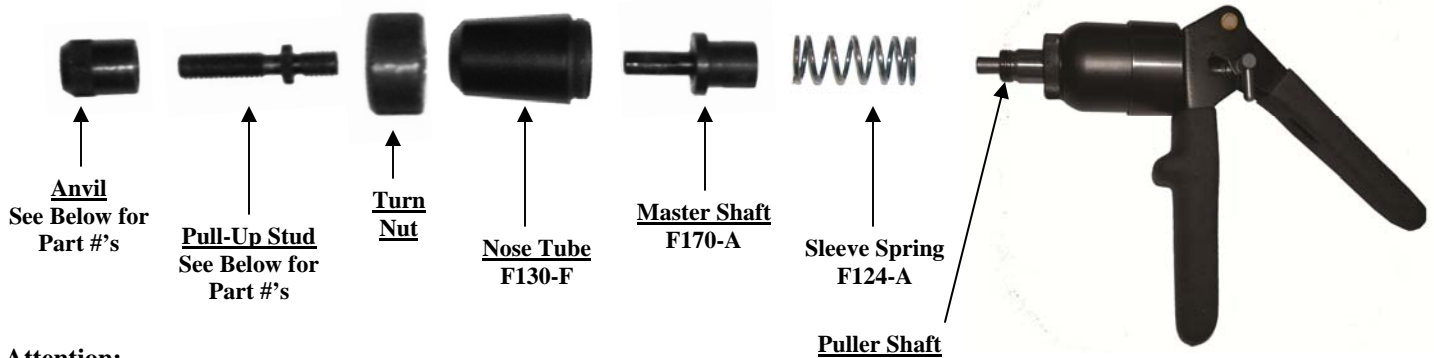
WARNING: DO NOT PUMP TOOL WHEN THE SLEEVE SPRING IS NOT IN PLACE, TO RETRACT TOOL WITH NO SPRING, BRING HANDLES TOGETHER, PUSH THE BUTTON WITH MIDDLE FINGER OR FREE HAND, PLACE THUMB AND FIRST FINGER OF SAME HAND ON FRONT OF PROTECTIVE SHIELD AND FORCE IT TO THE FULL RETRACTED POSITION. RELEASE BUTTON AND HANDLES.

D-180 Hand Hydraulic Riveter

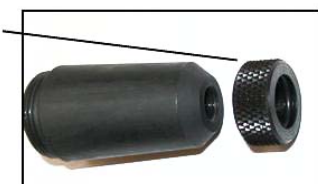
Operating Instructions (continued)

Nut Setting Configuration Assembly Instructions

1. Place the Master Shaft (F170-A) into the end of the Sleeve Spring (F124-A).
2. Place the other end of the Sleeve Spring (F124-A) over the Puller Shaft and thread the Master Shaft (F170-A) onto the puller shaft hand tight until no threads are showing.
3. Place the Nose Tube (F130-F) over assembly and hand tighten.
4. Place the Turn Nut (F171) on the keyed side of the Master Shaft (F170-A) and choose a Pull-Up Stud (as required for desired application) and left hand thread into the end of the Master Shaft (F170-A) until tight.



Attention:
Female Side
must face
forward



Part No.	Pull-Up Stud	Part No.	Driving Anvil	Part No.	Pull-Up Stud	Part No.	Driving Anvil
F360	6-32	F367	#6	F372	10-24	F176	#10 TSN
F361	8-32	F364	#8	F373	1/4-20	F177	1/4 TSN
F362	10-32	F365	#10	F374	5/16-18	F378	5/16-18
F363	1/4-28	F366	1/4	F375	3/8-16	F379	3/8

Operating Instructions

1. Thread fastener onto the Pull-Up Stud (apply pressure with your left- hand against the Pull-Up Stud and the Anvil to stop the left-hand thread on the Pull-Up Stud to back as the fastener goes in.
2. Pump handles to install fastener. Be sensitive to pressure changes that indicate the fastener has reached full upset and is properly installed. (Most blind nuts are properly installed after 3 or 4 complete pumps.)
3. Release handle pressure slightly, turn the lever and bring handles together sharply to release tool pressure against part.
4. Back out of part by turning the Turn Nut (F171).

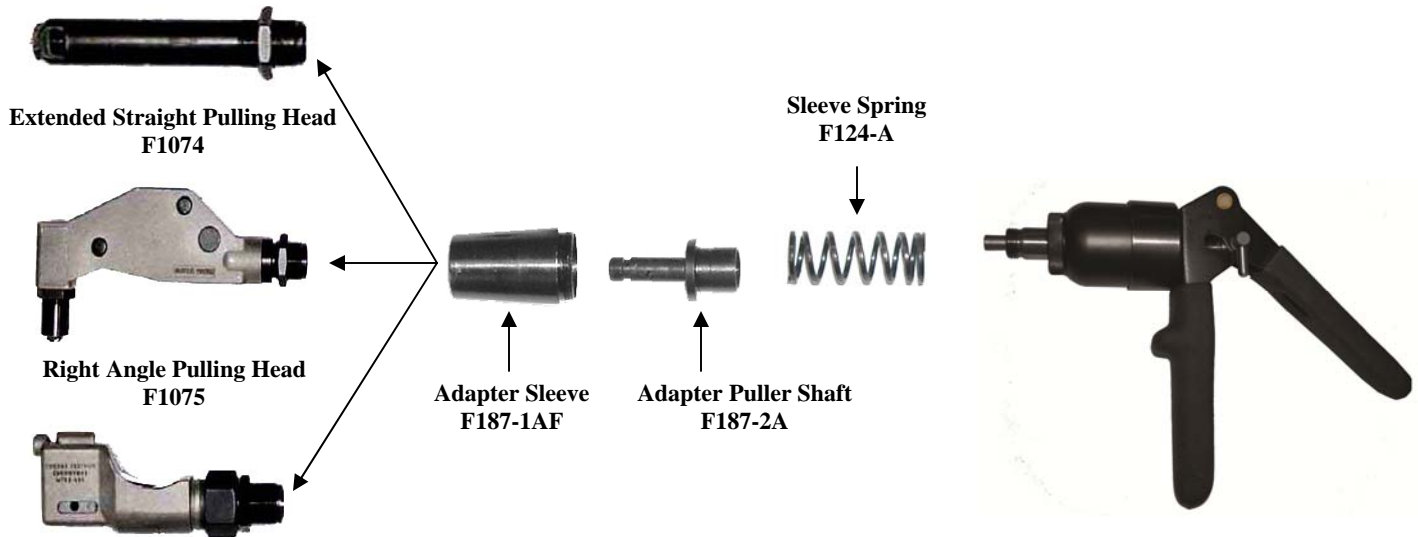
F187 Adapter for Special Pulling Heads Instructions (see diagram next page)

1. Place the Adapter Puller 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 Puller Shaft (F187-2A) onto the puller shaft.
3. Place the Adapter Sleeve (F187-1AF) over assembly and had 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 Puller Shaft (F187-2A) approx. 3 turns.
2. Push the Right Angle Pulling Head (F1075) into the Adapter Sleeve (F187-2A) and mate threads. Thread at least 5 full turns, and until rivet stem fits easily into the nose piece (adjust nose piece in for larger diameters).
3. Position head direction and set jamb nut. Reverse for disassembly.
4. Pump handles to install rivet. (See Operating Instructions)



Offset Pulling Head Assembly Instructions

1. Open the Offset Pulling Head (F1076) 1/4" (as shown)
2. Thread interior draw bolt of Offset Pulling Head (F1076) onto the Adapter Puller Shaft (F187-2A) approx. four turns.
3. Push Offset Pulling Head (F1076) into the Adapter Sleeve (F187-1AF) 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. Pump handles to install rivet. Rivet stems will push out the back. (See Operating Instructions). Reverse for disassembly.

Straight Extension Pulling Head Assembly Instructions

1. Thread the Collet Assembly onto the Adapter Puller Shaft (F187-2A).
2. Slide the Outer Sleeve (F1074) over assembly into the Adapter Sleeve (F187-1AF) 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. Pump handles to install rivet (See Operating Instructions)

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WARRANTY

Seller warrants that all goods shipped with this order will conform to applicable specifications and drawings and that such goods will be free from defects in materials or workmanship, said warranty to remain in effect if and only if such goods are used in accordance with all instructions as to maintenance, operation and use set forth in manuals and instruction sheets furnished by Seller. THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY.

Seller's Obligation under this warranty shall be limited to the repair or rework of the goods supplied or the replacement thereof, at Seller's option, and in no case is to exceed the invoice value of said goods. Under no circumstances will Seller be liable for incidental or consequential damages or for damages incurred by the Buyer or subsequent user in repairing or replacing defective goods or if goods covered by this warranty are reworked or subjected to any type of additional processing. This warranty is void if Seller is not notified in writing of any rejections or defects within 180 days after receipt of the material by customer.

WARRANTY CARD INSPECTION CERTIFICATION

We hereby certify that the following item checked has been supplied and that it meets all applicable specifications called out

_____ D-100-R (NSN 5120-01-430-5350)	_____ D-9000-MIL-1 (NSN 5180-01-470-6538)
_____ D-100A-RN (NSN 5120-01-430-5316)	_____ D-9000-MIL-2 (NSN 5180-01-470-6539)
_____ D-100-1 (NSN 5120-01-283-0320)	_____ PT-100 (NSN 5130-01-397-6805)
_____ D-100-MIL-1 (NSN 5180-01-201-4978)	_____ PT-100-1 (NSN 5130-373-6685)
_____ D-100-MIL-2 (NSN 5180-01-201-4979)	_____ PT-100-MIL-5 (NSN 5130-01-397-7379)
_____ D-700 (NSN 5120-01-430-5315)	_____ PT-3000 (NSN 5130-01-397-7379)
_____ D-100-MIL-1 (NSN 5180-01-430-5315)	_____ PT-3000-MIL-1 (NSN 5130-01-373-9384)
_____ D-700-MIL-2 (NSN 5180-01-430-5355)	_____ PT-4000-MIL-1

Inspector No. _____

Inspection Date _____

Tool Serial Number _____

WARRANTY REGISTRATION CARD

IMPORTANT: Please read, fill out and return immediately

Tool Serial Number _____

Tool Model Number _____

Owner's Name _____

Company _____

Address _____

State & Zip _____

I have read the enclosed operating instructions and understand the proper use of and applications for this tool.

Phone Number _____ Signed _____