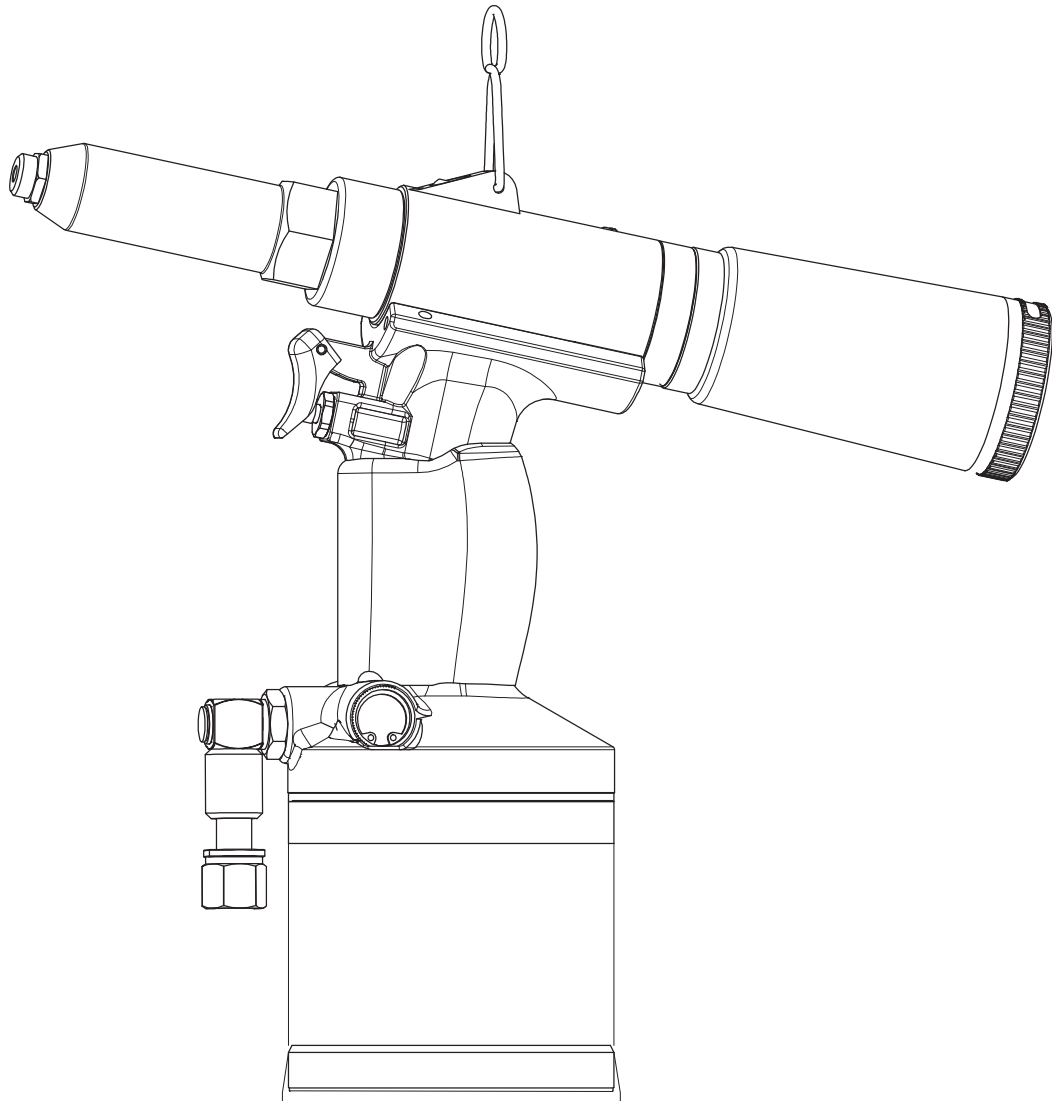


Operation, Maintenance and Parts Manual for 4208-V Air Hydraulic Riveter



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TOOL SPECIFICATIONS

Technical Data

Model Of Tool.....	4208-V
Dimensions.....	11.6" X 9.84" X 3.79"
(Length X Height X Width)	(290mm X 250mm X 96.5mm)
Weight.....	3.26 <i>lbs</i> [1.48 Kgs]
Air Inlet.....	1/4" NPT
Recommended Operating Pressure.....	85 to 95 <i>psi</i> [6 to 6.7 kg/cm ²]
Air Consumption.....	4CFM
Pulling Load.....	2000lbs. @ 85psi
Max. Stroke.....	0.59 <i>in</i> [15 mm]
Rivet Nut Size.....	3/16" ,5/32",1/8",3/32"

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, will result in death or serious injury.

NOTE

Alerts the operator to useful information.

GENERAL DESCRIPTION

The 4208-V Rivet-Pull Tool illustrated in Fig. 1 with its pneumatic hydraulic system provides an efficient, lightweight, powerful, and quiet tool for rivet nut installation. It is designed to provide long life and trouble free services.

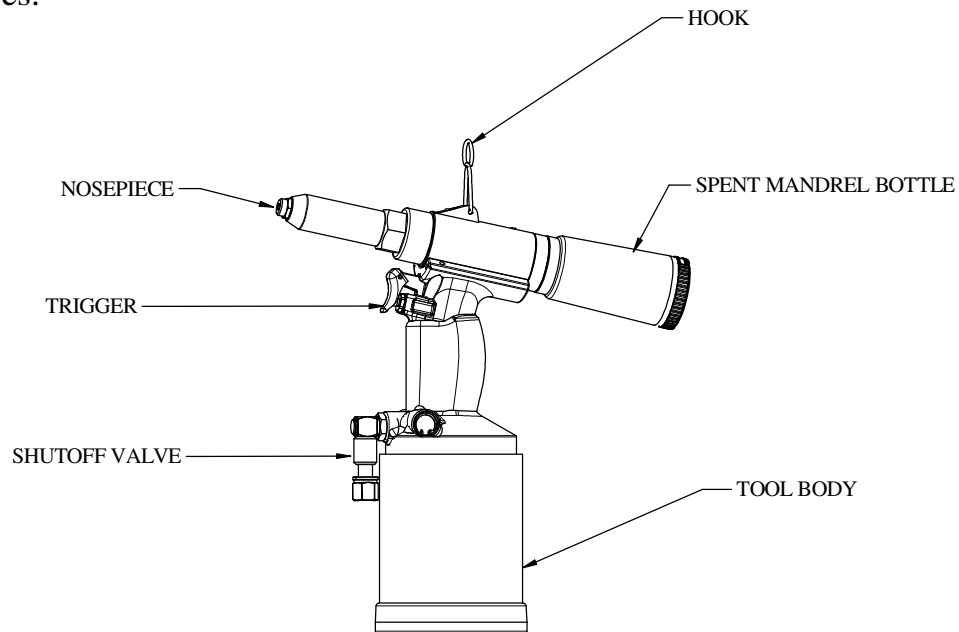


Fig. 1 4208-V Rivet-Pull Tool

FEATURES

- **Heavy-duty use.**
- **Lightweight rivet-pull tool.**
- **High efficient, powerful and quiet installation tool.**
- **Easy maintenance and operation.**

SAFETY INSTRUCTIONS

DANGER



- Read this manual and understand all safety instructions before operating the tool. If you have any questions, please contact our authorized representatives.



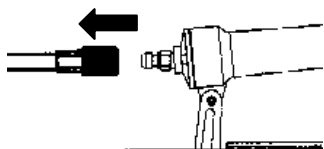
- Never allow the use of flammable gases (oxygen) as a power source for the tool. Use filtered, lubricated, and regulated compressed air only.



- Never use gasoline or other flammable liquids to clean the tool. Vapors in the tool can be ignited by a spark and cause the tool to explode.



- Do not exceed maximum permissible operating pressure of the tool (95 psig or 6.55 bars).



Disconnect the tool from air supply before servicing, adjusting, and during non-operation.

WARNING



- At the workplace, always wear protective equipment such as Z87.1 safety glasses, hearing protection and head protection.



- Repairing and cleaning operations must be done when the tool is not fed.

OPERATION INSTRUCTIONS

A. To prepare 4208-V

1. Following the steps below to install the desired nosepiece:
 - a. Loosen and remove the nosepiece (Index 37 in Figs. 2 & 5), then set up the desired nosepiece (Index 37~37-2 in Figs. 2 & 5) on frame head as shown in Fig. 2;
 - b. Loosen and remove the frame head (Index 38 in Figs. 2 & 5) from the oil cylinder body (Index 53 in Figs. 2 & 5) as shown in Fig. 2;
 - c. Loosen and remove the jaw housing (Index 39 in Figs. 2 & 5) from the jaw housing coupler (Index 42 in Figs. 2 & 5) as shown in Fig. 2;
 - d. Take out the jaw and jaw pusher (Index 40, 41, in Figs. 2 & 5), then change on the matching the jaw and jaw pusher.
 - e. Then assemble the jaw housing and adjust it's length to match the spanner gauge (Index 63 in Figs. 2 & 5) as shown in Fig. 2;
 - f. Then assemble the frame head and lock it with the corresponding ring nut loosen before.

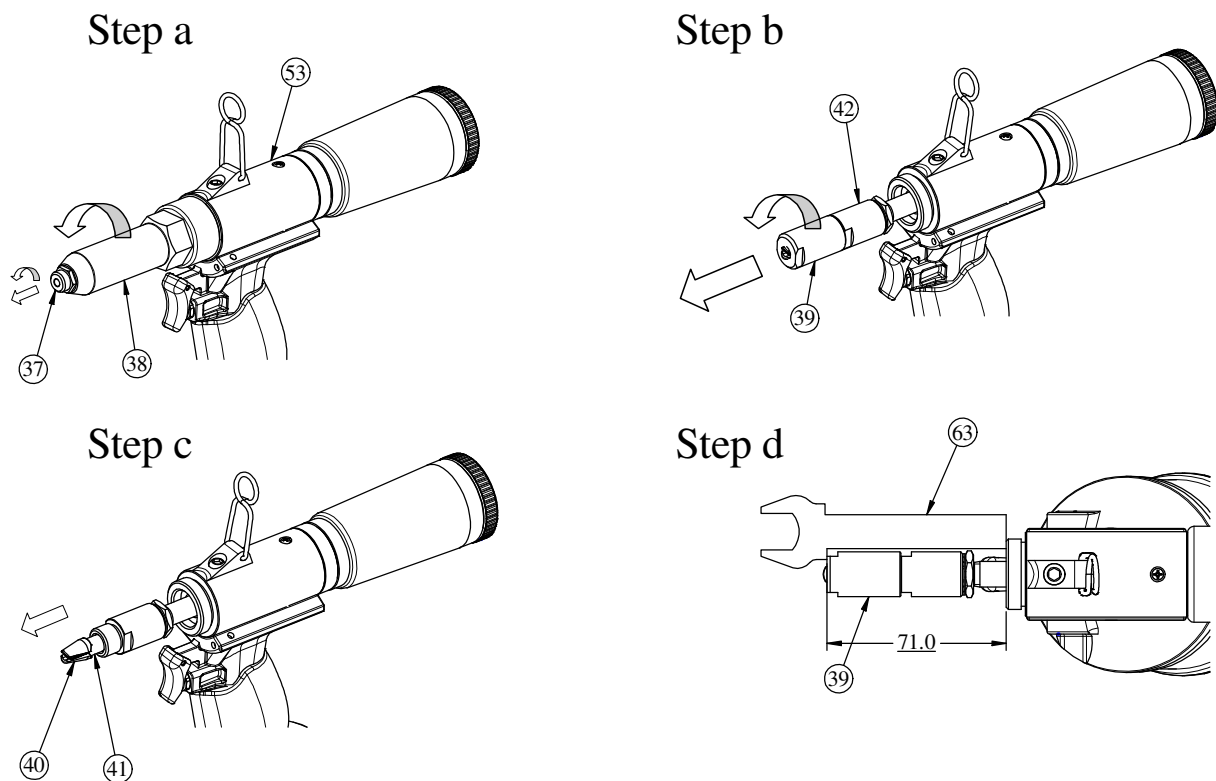


Fig. 2 Detail illustration of change the nosepiece, jaw, and jaw pusher.

B. To operate 4208-V

- a. Open the shutoff valve, let the air enter the 4208-V rivet-pull tool.
 - ※ When use the 4208-V rivet-pull tool, the shutoff valve must be in the open state, otherwise there was no suction to inhale the rivet.
- b. Is it make suction switch is it control suction to come, anticlockwise direction it is heavy for suction to, the clockwise suction is diminished to fasten, can close the suction(Index 48 in Figs.3 & 5)
- c. Put in the matching rivet into the nosepiece, then pressing the trigger to pulls and discharge the rivet's rod into the spent mandrel bottle.
- d. When the spent mandrel bottle is filled with rivet's rod, then pulls out the mandrel bottle adapter (Index 61 in Figs.3 & 5) and pours out all of them.
- e. After clean all of junk, plug the mandrel bottle adapter into the spent mandrel bottle. Then follow the normal operating step to use it.

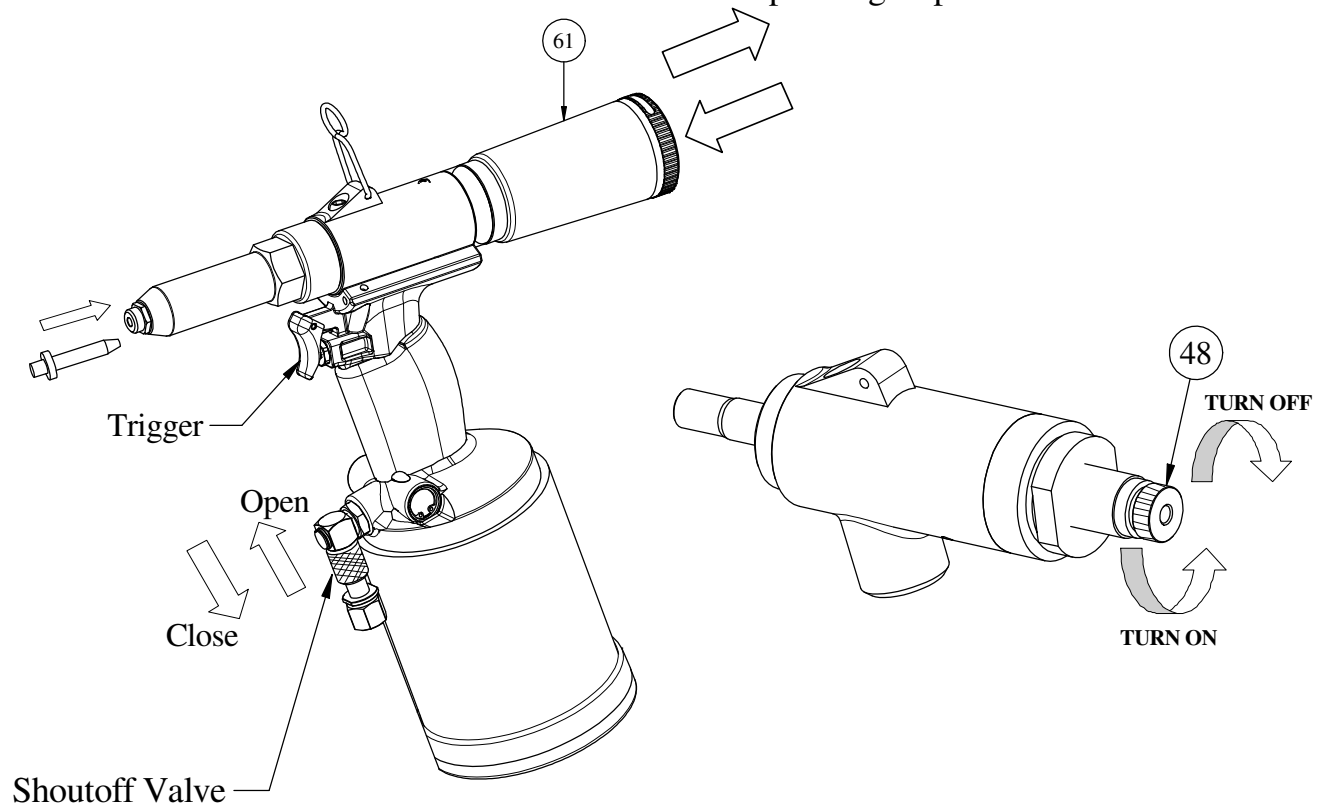
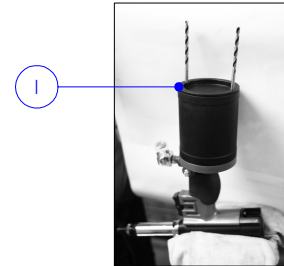


Fig. 3 Detail illustration of open the suction and clean up the spent mandrel bottle.

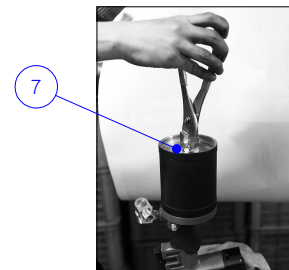
Maintenance

The maintenance required when the tool of 4208-V pulling strength were become lower, it is only necessary to add ISO VG46 oil or similar grade oil into the hydraulic system., the operation steps as below:

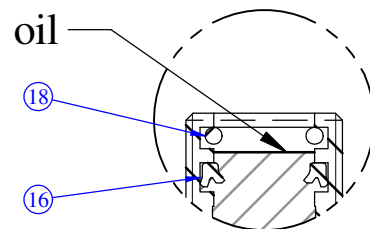
1. Unscrew and remove the front head (Index 38) Turn the tool upside down and well fixed, then use spanner remove No.1 parts.



2. Remove No.7 parts.



3. Take the oil pot fill the oil up to top of No.16 parts, installed No.7 parts press up and down twice ,get the No.7 out, refill the oil reach the top of No.16.



4. Lubricate all connected O Ring area by grease, No.7 insert it.

5. . Screw on No.1 ,Then assemble the jaw housing and adjust it's length to match the spanner gauge and fix front head (Index 38)

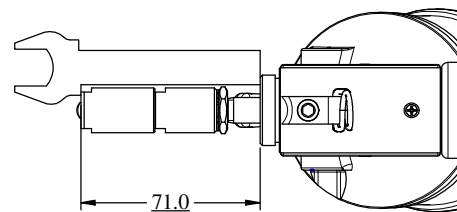
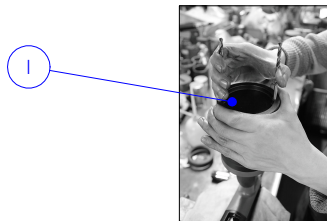


Fig. 4 ADD OIL.

TROUBLESHOOTING

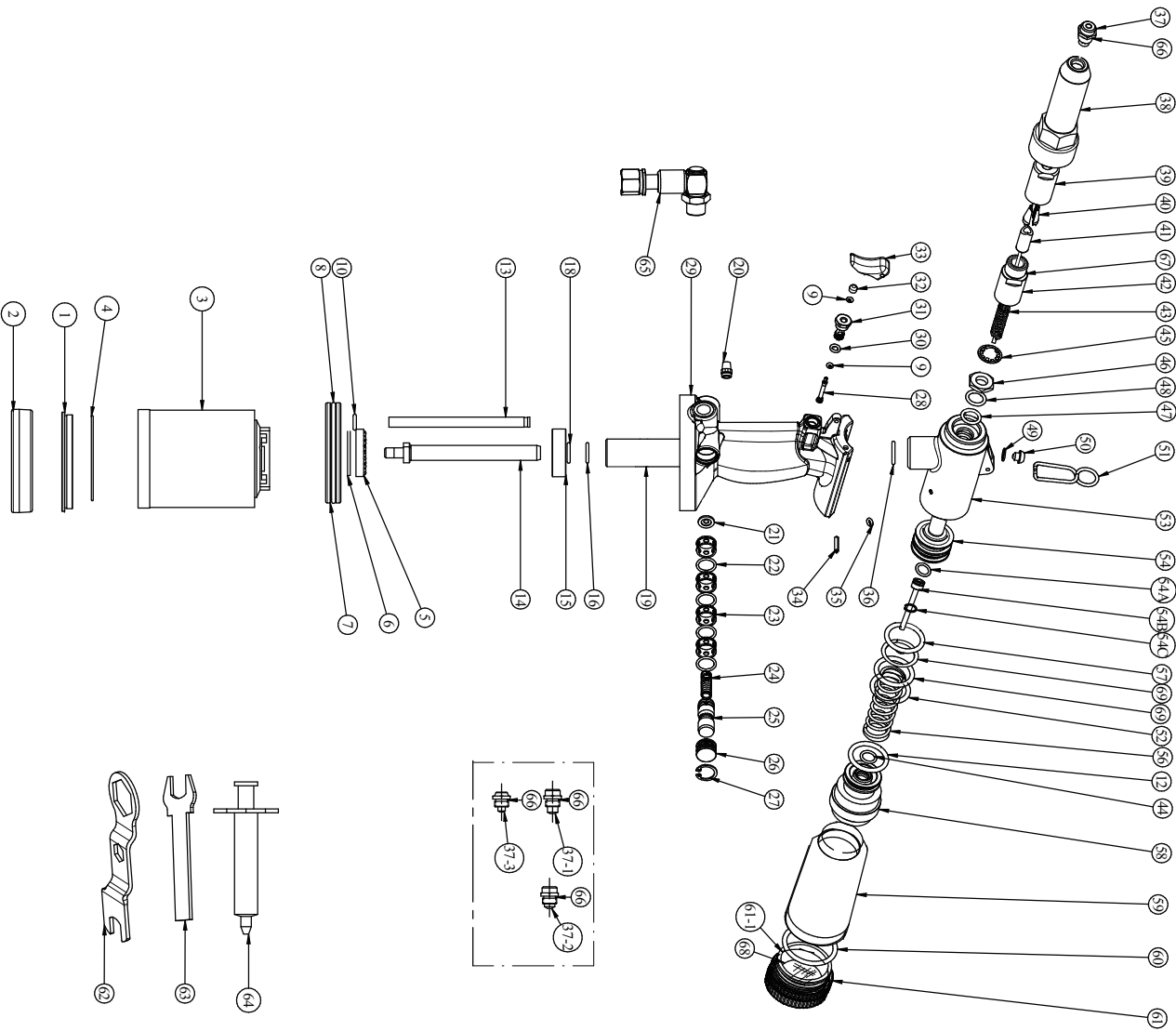
Stop using the tool immediately if any of the following problems occur. Any repairs or replacements must be done by a qualified person or an authorized service center only.

PROBLEM	CAUSE	REMEDY
Rivet jammed	Wrong size rivet.	The different rivets need to change the compared nosepiece, jaw and jaw pusher. Please read the operation instruction, and check the rivet's size again, see Fig. 2
	Had some filings jam in the 39 part's internal.	Using the adjustable wrench or 62 part to dismantle the part 38, then using the 19mm spanner to dismantle the part 39 . Use hairbrush and airbrush to clean out filing; then smear the oil on them. Lock back the 38 and 39 part, see the Fig. 2d.
	Had some filings stick on the 37 part's top.	When you pull the aluminum rivet, it is happened frequently. Use the sharp thing to cancel the stuck filing.
No suction	The shutoff valve was not open.	Please see the Fig-3.
Air leaking.	Damaged o-rings.	O-rings need to be replaced.
	Loose screws.	Screws need to be tightened.
Frame Head (38) out of order.	Parts (16) (18) are damaged or deformed.	New parts (16)(18) need to be replaced.
Tool runs slow or has loss of power.	Air feeding tube loose.	Re-install and tighten the tube.
	Exhaust port in cap is blocked.	Exhaust port(20) needs to be cleaned.
	Operating pressure is too low.	Increase the operating pressure to 85-95psi.

ADVICE

1. Clean out the parts 38~42, and smear the oil in every 500 times' operated.
2. Advise you to change the parts 40~43 in every 20000 times, when to pull the 3/16" stainless steel rivets.
3. The part 59(spent mandrel bottle) need to clean out, when it filled 35 rivets' residues.

Part List for 4208-V Tool



Part No.	Part Name	Qty
01	Cylinder Cap	1
02	Rubber Bottom	1
03	Air Cylinder Body	1
04	O-Ring	1
05	Crash Washer	1
06	Washer	1
07	Air Piston	1
08	O-Ring	1
09	O-Ring	2
10	O-Ring	1
12	O-Ring	1
13	Tube	1
14	Rod	1
15	Stem Nut	1
16	Seal	1
18	O-Ring	1
19	Stem	1
20	Muffler	1
21	Pad	1
22	O-Ring	4
23	Cage	4
24	Spring	1
25	Valve	1
26	Valve Cap	1
27	Retaining Ring	1
28	Valve Piston	1
29	Handle Body	1
30	O-Ring	1
31	Trigger Insert	1
32	Trigger Head	1
33	Trigger	1
34	Spring Pin	1
35	O-Ring	1
36	O-Ring	1
37	Nosepiece (3/16")	1
37-1	Nosepiece (5/32")	1
37-2	Nosepiece (1/8")	1

Part No.	Part Name	Qty
37-3	Nosepiece (3/32")	1
38	Frame Head	1
39	Jaw Housing	1
40	Jaw	3
41	Jaw Pusher	1
42	Jaw Housing Coupler	1
43	Spring	1
44	O-Ring	1
45	Case Washer	1
46	Case Lock Nut	1
47	Seal	1
48	O-Ring	1
49	Oil Seal Washer	1
50	Hexagon Socket Screw	1
51	Hook	1
52	O-Ring	1
53	Oil Cylinder Body	1
54	Piston Rod II	1
54A	O-Ring	1
54B	Catheter	1
54C	Retaining Ring	1
56	Spring	1
57	Seal	1
58	Rotary Valve	1
59	Spent Mandrel Bottle	1
60	O-Ring	1
61	Mandrel Bottle Adapter	1
61-1	Silencer	1
62	Spanner	1
63	Spanner Gauge	1
64	Oil Can	1
65	Shut off Valve	1
66	O-Ring	4
67	O-Ring	1
68	Cushion	1
69	O-Ring	2

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Fig. 5 of 4208-V Tool.