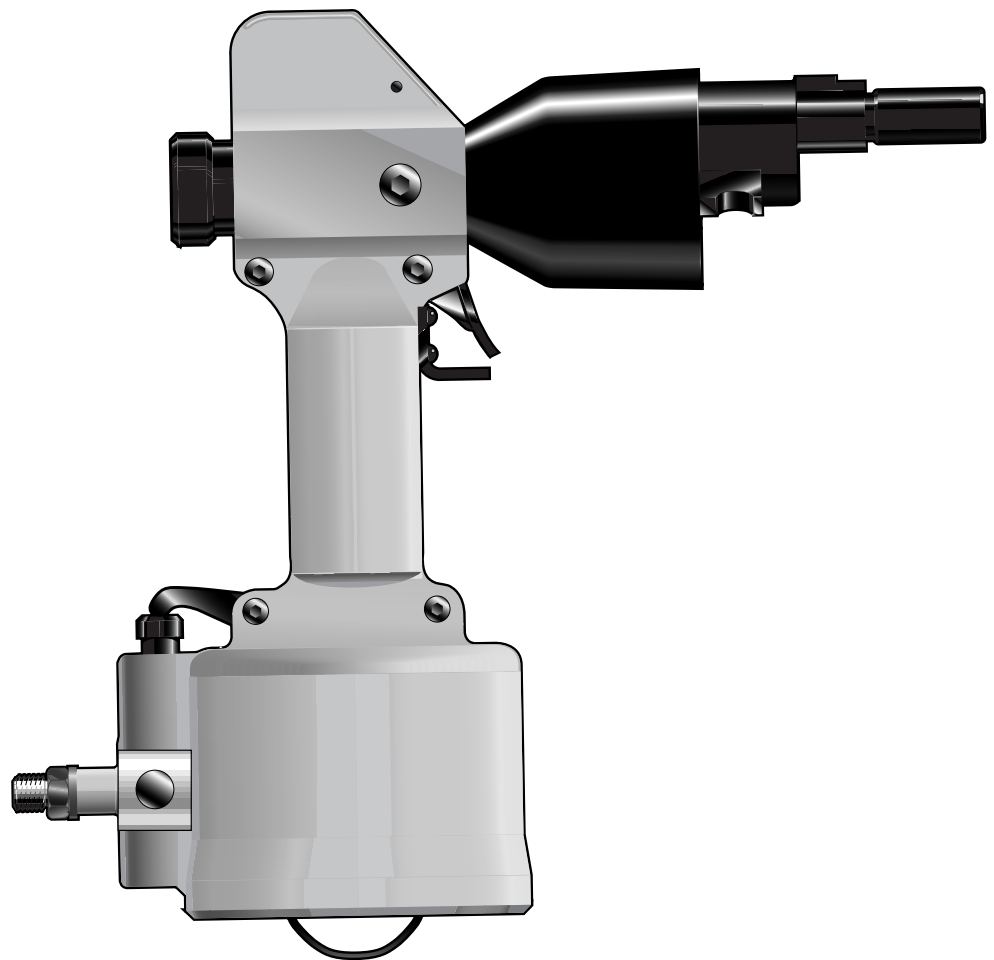


**TEXTRON** Fastening Systems  
*Commercial Solutions*

# Instruction Manual



Pneumatic Power Tool

**0720 type**

07200-07201 models

 Avdel®

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## **Warranty**

Textron Fastening Systems installation tools carry a 12 month warranty against defects caused by faulty materials or workmanship, the warranty period commencing from the date of delivery confirmed by invoice or delivery note.

The warranty applies to the user/purchaser when sold through an authorised outlet, and only when used for the intended purpose. The warranty is invalidated if the installation tool is not serviced, maintained and operated according to the instructions contained in the Instruction and Service Manuals.

In the event of a defect or failure, and at its sole discretion, Textron Fastening Systems undertakes only to repair or replace faulty components.

# Safety Rules

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

- 1 Do not use outside the design intent.
- 2 Do not use equipment with this tool/machine other than that recommended and supplied by Textron Fastening Systems.
- 3 Any modification undertaken by the customer to the tool/machine, nose assemblies, accessories or any equipment supplied by Textron Fastening Systems or their representatives, shall be the customer's entire responsibility. Textron Fastening Systems will be pleased to advise upon any proposed modification.
- 4 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 Textron Fastening Systems procedures. Do not dismantle this tool/machine without prior reference to the maintenance instructions. Please contact Textron Fastening Systems with your training requirements.
- 5 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 Textron Fastening Systems.
- 6 The precautions to be observed when using this tool/machine must be explained by the customer to all operators.
- 7 Always disconnect the airline from the tool/machine inlet before attempting to adjust, fit or remove a nose assembly.
- 8 Do not operate a tool/machine that is directed towards any person(s) or the operator.
- 9 Always adopt a firm footing or a stable position before operating the tool/machine.
- 10 Ensure that vent holes do not become blocked or covered and that the hoses are always in good condition.
- 11 The operating pressure shall not exceed 6.5 bar (95 lbf/in<sup>2</sup>).
- 12 Do not operate the tool without full nose equipment in place.
- 13 Care shall be taken to ensure that spent stems are not allowed to create a hazard.
- 14 07200 tools must be fitted with an undamaged pintail deflector before operating.
- 15 Avoid holding the head of the tool during initial connection as it may move and could cause injury.
- 16 When using the tool, the wearing of safety glasses is required both by the operator and others in the vicinity to protect against pin ejection, should a fastener be placed 'in air'. We recommend wearing gloves if there are sharp edges or corners on the application.
- 17 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.
- 18 When carrying the tool from place to place keep hands away from the trigger/lever to avoid inadvertent start up.
- 19 Ensure the plug filling the circlip removal aperture is in place at all times.

# Specifications

## TOOL SPECIFICATION

<b>Air Pressure</b>	Minimum - Maximum	5.4-6.5 bar (80-95 lbf/in <sup>2</sup> )
<b>Free Air Volume Required</b>	@ 5.4 bar/80 lbf/in <sup>2</sup>	6.2 litres (.22 ft <sup>3</sup> )
<b>Stroke</b>	Minimum	12.7 mm (.5 in)
<b>Pull Force</b>	07200 @ 5.4 bar/80 lbf/in <sup>2</sup>	14.68 kN (3300 lbf)
	07201 @ 5.4 bar/80 lbf/in <sup>2</sup>	18 kN (4050 lbf)
<b>Cycle time</b>	Approximately	1.5 seconds
<b>Noise Level</b>	07200	74.4 dB(A)
	07201	72.7 dB(A)
<b>Weight</b>	Without nose equipment	4.54 kg (10 lb)
<b>Vibration</b>	07200	2.58 m/s <sup>2</sup>
	07201	2.93 m/s <sup>2</sup>

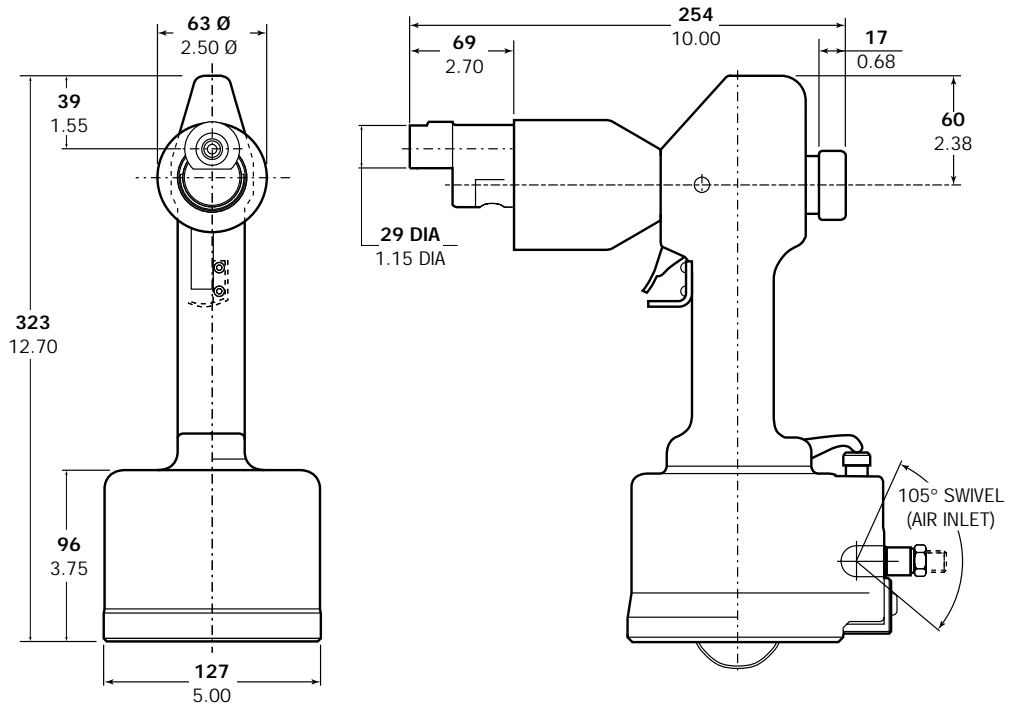
# Intent of Use

The pneumatic 0720 type tool is designed to place 3/16" & 1/4" Avdelok® pins and collars at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

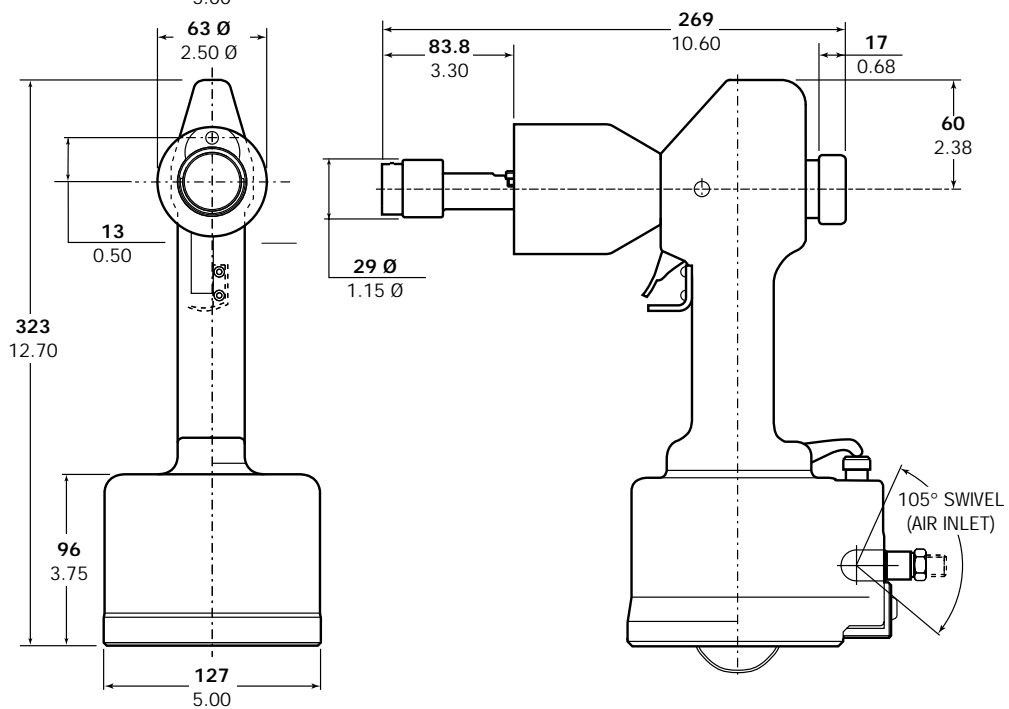
There are two models offering different access to your application. The base tool part number for the 07200 model is 07200-00200 and 07201-00200 for the 07201 model. Select the one most suited to your application requirements. All nose assemblies are available for both models (details pages 10-11).

## TOOL DIMENSIONS

### 07200 MODEL



### 07201 MODEL



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

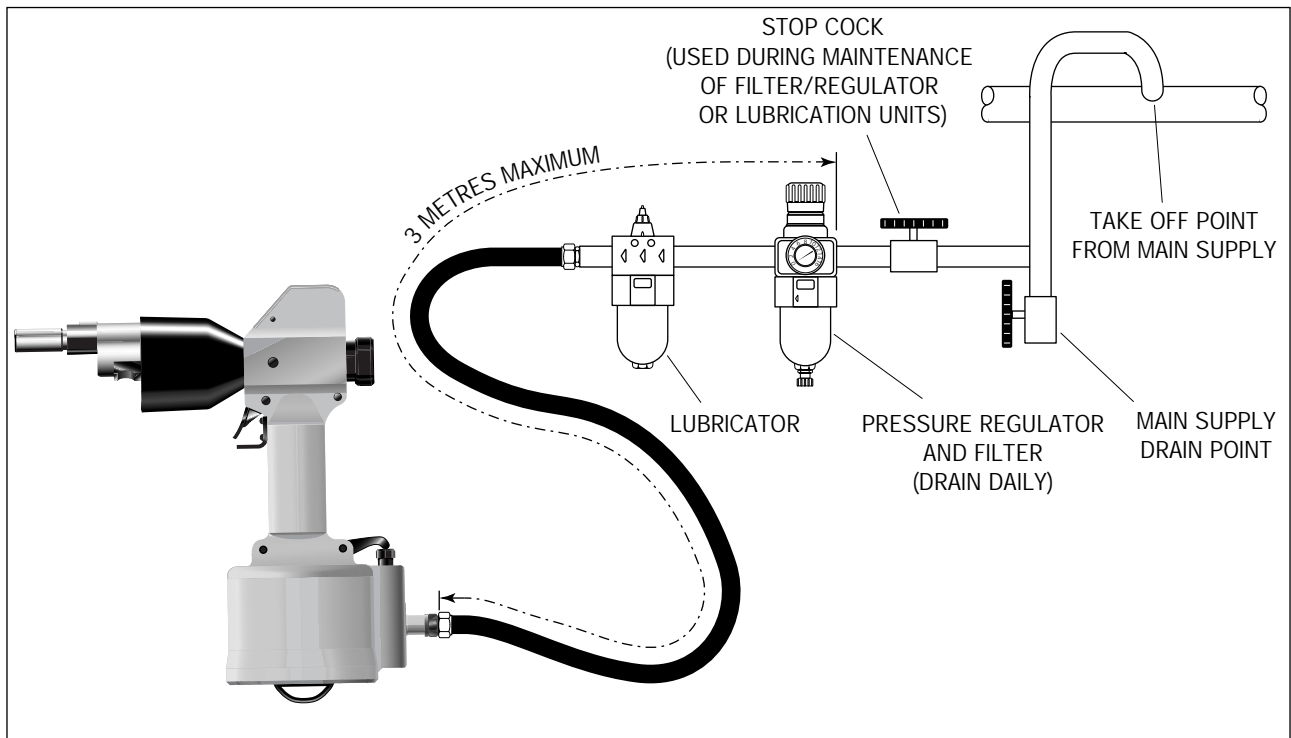
# Putting into Service

## AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.4 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.

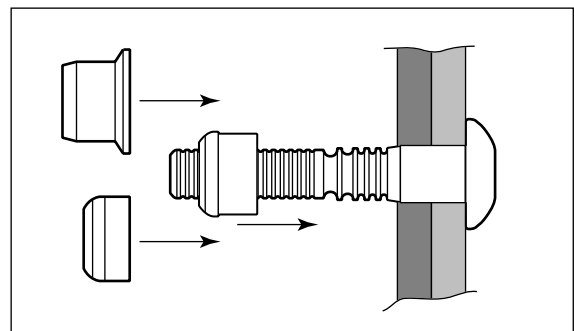
Air supply hoses should have a minimum working effective pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest. Air hoses should be oil resistant, have an abrasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged. All air hoses MUST have a minimum bore diameter of 6.4 millimetres or 1/4".

Read daily servicing details pages 12-13.



## OPERATING PROCEDURE

- Ensure that the correct nose assembly is fitted.
- Connect the tool to the air supply.
- Push the Avdelok® pin through the application hole .
- Place the collar on the pin (orientation as shown right).
- Keeping the head of the pin against the application, push the tool onto the protruding pin tail.
- Fully depress the trigger. One cycle will ensure that the collar is swaged into the lock grooves of the pin and the the pin breaks at the breaker groove.
- Release the trigger. The tool completes its cycle by pushing itself off the collar and ejecting the pin tail at the rear.

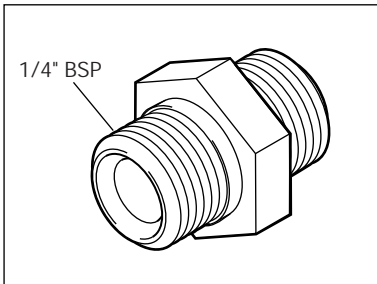


# Accessories

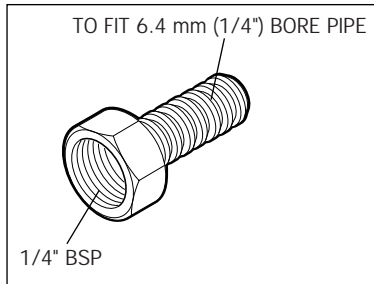
## ACCESSORIES

Three accessories are available to make the connection to your air supply.

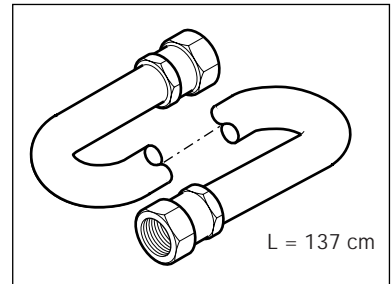
**Double Male Connector**  
part no 07005-00041



**Hose Connector**  
part no 07005-00276



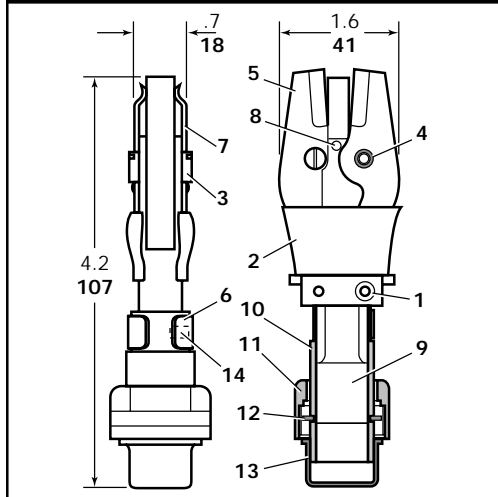
**Hose Assembly**  
part no 07008-00324



## COLLAR SPLITTERS

You can order collar splitters to cut the collars off placed  $\frac{3}{16}$ " &  $\frac{1}{4}$ " Avdelok®.

**COLLAR SPLITTERS (07500-06800/07500-06900)**



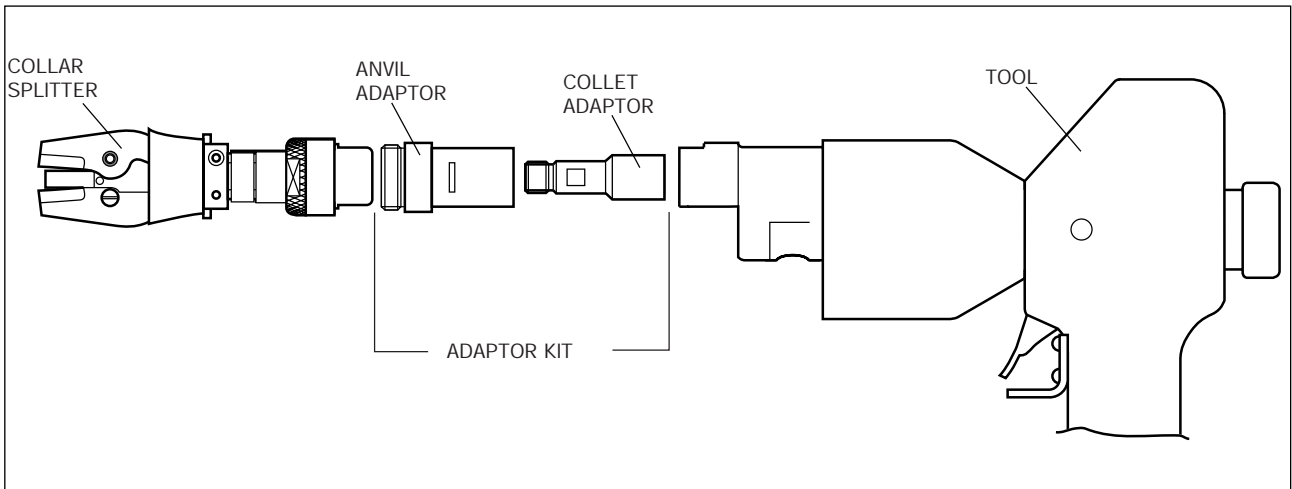
**COLLAR SPLITTERS - COMPONENT PART NUMBERS**

ITEM N°	DESCRIPTION	$\frac{3}{16}$ " COLLAR SPLITTER 07500-06800	$\frac{1}{4}$ " COLLAR SPLITTER 07500-06900	QTY
1	6-32 UNC x $\frac{3}{8}$ SOCKET CAP SCREW	07001-00004	07001-00004	2
2	SLEEVE	07210-02012	07210-02012	1
3	BLADE PIN	07210-02014	07210-02014	2
4	BLADE PIN SCREW	07210-02015	07210-02015	2
5	BLADE	07210-02016	07210-02104	2
6	SPRING CLIP ASSEMBLY	07500-08000	07500-08000	1
7	BLADE CARRIER ASSEMBLY	07210-02500	07210-02600	2
8	SPACER PIN	07210-02703	07210-02703	1
9	CAM ROD	07500-06801	07500-06801	1
10	OUTER SLEEVE	07500-06803	07500-06803	1
11	NOSE RETAINING NUT	07500-00212	07500-00212	1
12	EXTERNAL CIRCLIP	07004-00041	07004-00041	1
13	CAP	07007-00076	07007-00076	1
14	INDEPENDENT RETAINING PIN	07500-08003	07500-08003	1

Use 07500-06800 collar splitter to cut  $\frac{3}{16}$ " Avdelok® and 07500-06900 to cut  $\frac{1}{4}$ " Avdelok®. When using either of these splitters it is necessary to use adaptor kit (part number 07200-09000).

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

## COLLAR SPLITTER ASSEMBLY AND ADAPTOR KIT (07200-09000)



- To fit these collar splitters, first disconnect the air supply to the tool.
- Remove the nose assembly, if fitted.
- Screw collet adaptor onto the Offset Spindle **18** in offset adaptor assembly and tighten with a spanner\*.
- Push the anvil adaptor over the collet adaptor and lining up its bayonet with the matching slots of the offset adaptor assembly, push in and turn through 90°.
- Insert the assembled collar splitter into the anvil adaptor and screw Cam Rod 9 onto the end of the collet adaptor, slide in Outer Sleeve 10. Tighten the Nose Retaining Nut 11 onto the anvil adaptor with a spanner\*.
- To operate, push the centralising guides over the Avdelok® collar and depress trigger.

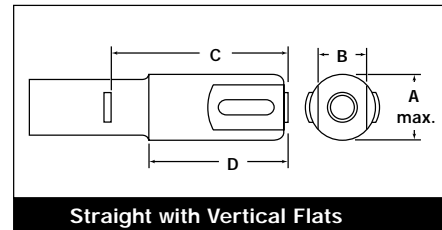
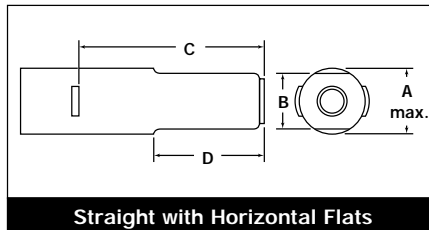
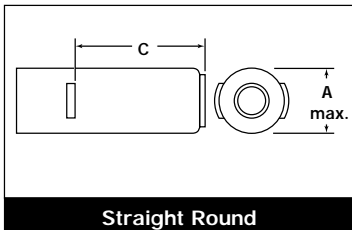
\* Refers to items included in the 07200 service kit. For complete list see page 13.  
Item numbers in **bold** refer to the general assembly drawing and parts list (pages 16-17).



# Nose Assemblies

## NOSE ASSEMBLIES

There are various straight nose assemblies available. Choose the type most suitable according to the access restrictions on your application. It is essential that the correct nose assembly is fitted prior to operating the tool.

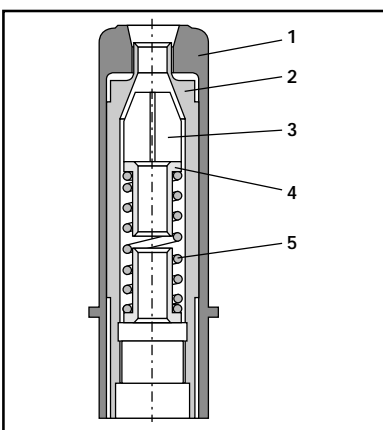


07200 NOSE ASSEMBLY SELECTION										
AVDELOK® SIZE	NOSE ASSEMBLY DESCRIPTION	A		B		C		D		NOSE ASSY. PART N°
		mm	inch	mm	inch	mm	inch	mm	inch	
3/16"	Straight with Horizontal Flats	21	.812	16	.625	54	2.12	25	1.0	07200-02700
	Straight with Vertical Flats	21	.812	16	.625	54	2.12	25	1.0	07200-02500
1/4"	Straight Round	21	.812	-	-	54	2.12	-	-	07200-03500
	Straight with Horizontal Flats	21	.812	16	.625	54	2.12	25	1.0	07200-02800
	Straight with Horizontal Flats (Stepped)	21	.812	16	.625	56	2.22	28	1.1	07200-03300
	Straight with Vertical Flats	21	.812	16	.625	54	2.12	25	1.0	07200-02600

Stepped anvils give a less severe deformation of the collars thus allowing placing of Avdelok® in softer materials like plastics, wood etc.

## NOSE ASSEMBLY COMPONENTS

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



COMPONENT PART NUMBERS OF ROUND, HORIZONTAL FLATS AND VERTICAL FLATS STRAIGHT NOSE ASSEMBLIES					
DESCRIPTION	ANVIL	CHUCK COLLET	CHUCK JAWS	SPRING GUIDE	SPRING
ITEM N°	1	2	3	4	5
QTY	1	1	3	2	1
NOSE ASSY					
07200-02500	07200-02501	07200-02101	07220-02102	07220-02104	07220-02103
07200-02600	07200-02601	07200-02201	07220-02302	07220-02104	07220-02103
07200-02700	07200-02701	07200-02101	07220-02102	07220-02104	07220-02103
07200-02800	07200-02801	07200-02201	07220-02302	07220-02104	07220-02103
07200-03300	07200-03301	07200-03302	07220-02302	07220-02104	07220-02103
07200-03500	07200-03501	07200-02201	07220-02302	07220-02104	07220-02103

# Nose Assemblies

## NOSE ASSEMBLY 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.
- Assemble Spring Guides 4 and Spring 5 and stand on end on a flat even surface.
- Balance the three Chuck Jaws 3 on the upper Spring Guide 4 (using a spent pintail to aid positioning if necessary).
- Carefully lower Chuck Collet 2 over the assembled components.
- Screw the assembled chuck collet onto the Offset Spindle **18** on 07200 tool or Extension **83** on 07201 tool and tighten with a spanner.
- Push the Anvil 1 over the Chuck Collet, lining up the bayonet with the matching slots of the offset adaptor assembly or straight adaptor assembly.

## FITTING NOSE ASSEMBLY TO TOOL

- Before placing 'Avdelok®' Pins ensure that the correct nose assembly is fitted to the tool.
- To fit nose assemblies to the tool it is first necessary to screw the Chuck Collet 2 complete, on to the offset spindle **18**.
- The Anvil 1 is then pushed on to the Offset Adaptor **16** ensuring that the lugs on the anvil enter the slots on the adaptor and then turned through 90°. This ensures that Latch **23** positively holds swaging anvil in position and prevents inadvertent removal from the tool.
- To remove the swaging Anvil 1 the Latch **23** is held back and the anvil turned until the lugs appear in the slots on the adaptor, The anvil can then be pulled off.
- The collet assembly is removed by unscrewing it from the Offset Spindle **18**. Care should be taken to keep the nose of the gun pointing downwards to maintain the correct position of the loose parts inside the collet.
- It is important that when the collet is replaced it is firmly tightened up to the shoulder on the spindle.

## SERVICING INSTRUCTIONS

- Nose assemblies should be serviced at weekly intervals.
- Remove the complete nose assembly using the reverse procedure to the 'Fitting Instructions'.
- Clean and inspect components, any worn or damaged part should be replaced by a new part.
- Particularly check wear on jaws.
- Ensure spring and spring guides (if fitted) are not worn or distorted.
- Assemble according to fitting instructions.

Item numbers in **bold** refer to the general assembly drawing and parts list (pages 16-17).

# Servicing the Tool

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.
- If there is no filter on the pressure regulator, bleed the air line to clear it of accumulated dirt or water before connecting air hose to tool. If a filter is fitted, drain it.
- Check that the nose equipment is correct.
- Ensure Pintail Deflector **11** is fitted to the tool.
- Check that the stroke of the tool meets the minimum specification (page 5). It is the distance travelled by the spindle with nose equipment fitted, measured **before trigger is pressed and when trigger is fully depressed**.
- Check offset adaptor setting (see page 15 "Re-setting 07200 & 07201 Tools").

### WEEKLY

- Check for air leaks on air supply hose and fittings.
- Dismantle and clean nose assembly, with special attention to jaws (lubricate with Moly Lithium grease EP 3753 before refitting).
- Lubricate cam faces and bearing faces on collar splitters with Moly Lithium grease EP 3753.

### MOLY LITHIUM GREASE EP 3753 SAFETY DATA

Grease can be ordered as a single item, the part number is shown in the service kit page 13.

#### First Aid

##### SKIN:

As the grease is completely water resistant it is best removed with an approved emulsifying skin cleaner.

##### INGESTION:

Ensure the individual drinks 30ml Milk of Magnesia, preferably in a cup of milk.

##### EYES:

Irritant but not harmful. Irrigate with water and seek medical attention.

#### Fire

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.

#### Environment

Scrape up for burning or disposal on approved site.

#### Handling

Use barrier cream or oil resistant gloves.

#### Storage

Away from heat and oxidising agent.

Item numbers in **bold** refer to the general assembly drawings and parts list pages 16-17.

# Servicing the Tool

## SERVICE KIT

For all servicing we recommend the use of the service kit (part number 07900-02000).

SERVICE KIT		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00009	$\frac{3}{32}$ " ALLEN KEY	1
07900-00036	TOMMY BAR PISTON EXTRACTOR	1
07900-00078	$\frac{5}{32}$ " ALLEN KEY	1
07900-00157	CIRCLIP PLIERS	1
07900-00174	$\frac{3}{16}$ " ALLEN KEY	1
07900-00222	$\frac{7}{32}$ " ALLEN KEY	1

SERVICE KIT (Continued)		
ITEM PART N°	DESCRIPTION	N° OFF
07900-00230	SPANNER	1
07900-00372	PISTON REMOVAL PUNCH	1
07900-00373	VALVE BUSH REMOVAL PUNCH (BOT)	1
07900-00374	VALVE BUSH REMOVAL PUNCH (TOP)	1
07900-00375	EXTERNAL CIRCLIP PLIERS	1
07900-00376	SPANNER (SPINDLE HOUSING CAP)	1

Every 500,000 cycles the tool should be completely dismantled and new components should be used where worn, damaged or when recommended. All 'O' rings and seals should be renewed and lubricated with Moly Lithium grease EP 3753 before assembling.

## IMPORTANT

**Safety Instructions appear on page 4.**  
**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.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, pages 10-11.

For total tool servicing we advise that you proceed with dismantling of sub-assemblies in the order shown on page 11. The procedure is the same once the nose assembly has been removed.

### 07200 OFFSET ADAPTOR ASSEMBLY 07200 TOOL

- Before dismantling the 07200 tool the Offset Adaptor must be removed from the tool.
- Fold back the rubber Pintail Deflector **11** onto the Spindle Housing **4** and remove Screws **13** and **12**.
- Fold back rubber Spindle Housing Sleeve **25** onto the Offset Adaptor Housing **17**, then using circlip pliers\* remove Retaining Ring **24** from the groove in the Spindle Housing **4**.
- Unscrew the Offset Adaptor Assembly **16** from the tool.
- To dismantle the Offset Adaptor Assembly **16** remove the Retaining Ring **24** and slide off the rubber Spindle Housing Sleeve **25** from the Offset Adaptor Assembly.
- Remove the cross pin Guard **22**, align the Spindle Extension **20** and Spring Pin **27** with the access hole in the side of the Offset Adaptor Housing **17** and drive out the Spring Pin **27** using a pin punch.
- Align the Spindle Extension **20** and Spring Pin **27** with the elongated access hole in the bottom of the Offset Adaptor Housing **17**. Using a punch located through the access hole in the top of the Offset Adaptor Housing **17**, drive out the Cross Pin **19**.
- The Spindle Extension **20** and Offset Spindle **18** can be slid out of the adaptor housing.
- To remove Latch **23** tap out Spring Pin **26** to release Latch **23** and Spring **21**.

It is important when re-fitting the Cross Pin **19** that the pin tail disposal hole and the Spring Pin **27** holes are aligned correctly in the Offset Adaptor Housing **17**.

When refitting the Latch **23** and Spring **21** with a new Spring Pin **26** it is necessary to slightly curve the Spring Pin **26** to allow the Anvil Assembly to be located correctly on the tool.

When refitting the Offset Adaptor Assembly **16** to the tool refer to page 15 "Re-setting 07200 & 07201 Tools" before fitting Screws **12** and **13**.

### STRAIGHT ADAPTOR 07201 TOOL

- Before dismantling the 07201 tool the Straight Adaptor Assembly **82** must be removed from the tool.
- Remove Screws **12** and **13**.
- Using circlip pliers\* remove Retaining Ring **24**.
- Unscrew Straight Adaptor Assembly **82** from the tool.
- Remove Retaining Ring **24**, guide Screw **85** and slide out spindle Extension **83**.
- To remove Latch **23** tap out Spring Pin **26** to release Latch **23** and Spring **21**.

When refitting Straight Adaptor Assembly **82** to the tool refer to page 15 "Re-setting 07200 & 07201 Tools" section

Before re-assembly of Offset or Straight Adaptor Assemblies clean and inspect all parts and replace where necessary. Lubricate all moving parts prior to re-assembly, assemble in reverse order to dismantling.

### HANDLE ASSEMBLY

- Remove Nylon Plug **75**, and unscrew five Screws **28**, **31**, **37**, **64** and **70** with Lock Washers **29**, **34** and **86** using an Allen Key\*.
- Tap Castings **30** to split into two halves giving access to the trigger linkage **69**, **65**, **40** which can be removed from the casting.
- Remove rubber Plug **72**, Stripper Levers **71**, **35** along with Spacer **32**.
- Remove Circlip **14**, push out Cam Shaft **67** through the access hole in the casting and lift out Cam Assembly **33**.
- Lift off Spindle Housing Assembly **1**.

Inspect parts for wear i.e. Stripper Levers. Replace worn parts - Lubricate all moving parts prior to re-assembly, assemble in reverse order to dismantling.

\* Refers to items included in the 07200 service kit. For complete list see page 13. Item numbers in **bold** refer to general assembly drawings and parts list (pages 16-17).

## PNEUMATIC CYLINDER

- Remove Screws **50** using an Allen Key\*.
- Lift off Protection Ring **54** and remove Retaining Ring **55**.
- Extract Cylinder Head **57** by pulling on the Cylinder Head Clip **53**
- Locate a suitable diameter rod through the access hole inside the casting and through the Piston Rod **66** to hold in position and then remove Piston Rod Nut **52**. Pull Piston Rod **66** up out of its location in the air Piston **59** and locating bush.
- Using the Air Piston Removal Punch\*, knock out the air Piston **59** through the bottom of the cylinder and be sure to retrieve the Support Ring **51**.

Replace worn parts and all 'O' Ring Seals, lubricate all moving parts prior to re-assembly, assemble in reverse order to dismantling.

## AIR THROTTLE VALVE

Having removed the side casting and trigger linkage as in "Handle Assembly":

- Withdraw the Throttle Valve **44**.
- Unscrew Button Head Screw **48** and remove Silencer Housing **46** together with Silencer Disc **49**.
- Remove Screw **43**.
- Using a Removal Punch\* (bottom), inserted through the Top Valve Bush **41** and knock out Bottom Valve Bush **45**. Using a Removal Punch\* (top), insert through the bottom of the valve chamber and knock out the Top Valve Bush **41**.
- Replace all seals on Valve Bushes and Throttle Valve, lubricate and re-assemble in reverse order to dismantling.

The two locating screws **must locate correctly** in the pre-determined grooves in top and bottom valve bushes.

## SPINDLE HOUSING ASSEMBLY

- With the Spindle Housing Assembly **1** removed from the tool unscrew Spindle Housing Cap **9**, and with a screw driver through the slot in the Spindle Housing and push out Spindle Bumpers **10**.
- Remove Circlip **14** from one side of the Front Roller Shaft **6**, drift out Front Roller Shaft **6**, with a suitable punch, through the Spindle Housing **4** and Cam Roller Bearing **2**. Slide out Cam Roller Bearing and Spacer Rollers **8**.
- Push out Spindle **5** through rear of Spindle Housing **4**.
- Drift out Rear Roller Shaft **7** to release rear Spacer Roller **3** and Space Rollers **8**.

Replace all worn or damaged parts, lubricate all moving parts prior to re-assembly, assemble in reverse order to dismantling.

## RE-SETTING 07200 & 07201 TOOLS

### Tool 07200 in Normal Position "Air Off"

- Re-setting of the Offset Adaptor and before replacing screws **12** and **13** to obtain maximum pull and push off on 07200 tool it is necessary to position the Offset Adaptor correctly.
- Having re-assembled the Offset Adaptor Assembly **16** on to the Tool. Screw the Offset Adaptor Assembly fully in onto the spindle then unscrew until the Spindle Extension **20** is approximately flush with the end of the Offset Adaptor Housing **17**.
- Replace Screw **12**, the Offset Adaptor should rotate 90° either way.
- Return to the vertical position replace Screw **13** to lock Offset Adaptor in position.
- Check Dimensions (min. 0.450/max. 0.500). Refer to illustration on page 16.

### Tool 07201 in Normal Position "Air Off"

When resetting the Straight Adaptor on the tool it is necessary to adjust the Straight Adaptor to the required position.

- Screw the Straight Adaptor fully in onto the spindle then unscrew until the required dimensions at the front are obtained (1<sup>1</sup>/<sub>8</sub>" - 1<sup>1</sup>/<sub>16</sub>"). Refer to the illustration on page 16.
- Incorrect adjustment on both 07200 & 07201 tools will cause damage internally and to retaining rings.

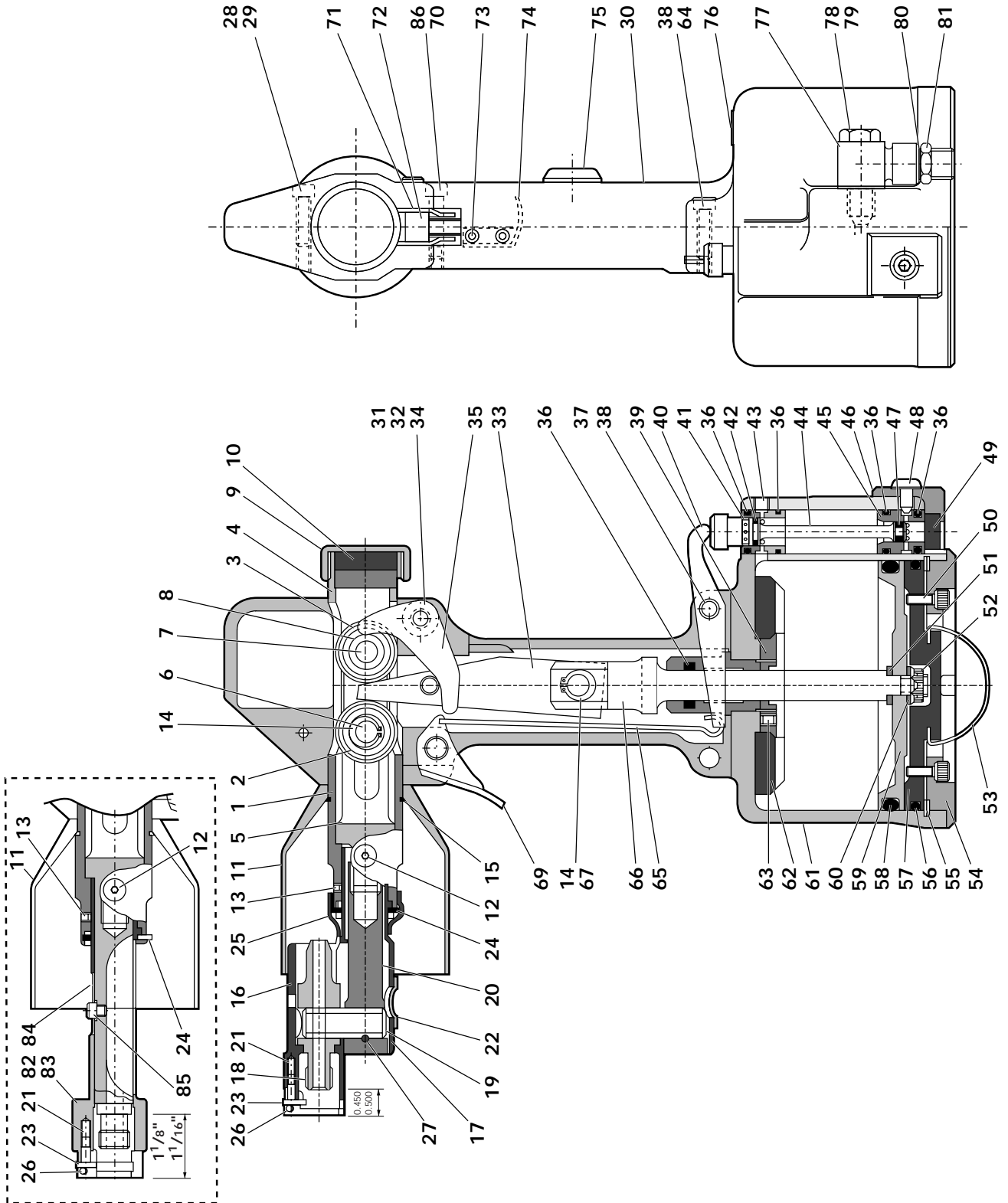
### IMPORTANT

Check the tool against daily and weekly servicing.

\* Refers to items included in the 07200 service kit. For complete list see page 13.  
Item numbers in **bold** refer to general assembly drawings and parts list (pages 16-17)

# General Assembly of Base Tools 07200-00200 & 07201-00200

(MAIN DRAWING IS THE 07200-00200 - DRAWING INSIDE DOTTED AREA SHOWS 07201-00200 DIFFERENCES)



# Parts List for 07200-02000 & 07201-00200

07200-00200 & 07201-00200 PARTS LIST									
ITEM	PART N°	DESCRIPTION	QTY	SPARES	ITEM	PART N°	DESCRIPTION	QTY	SPARES
1	07200-00500	SPINDLE HOUSING ASSEMBLY	1	-	44	07200-00800	THROTTLE VALVE	1	-
2	07200-00510	CAM ROLLER BEARING	2	-	45	07200-00202	BOTTOM VALVE BUSH	1	-
3	07200-00511	SPACER ROLLER (LARGE)	2	-	46	07200-00238	SILENCER HOUSING	1	-
4	07200-00501	SPINDLE HOUSING	1	-	47	07003-00027	'O' RING	1	2
5	07200-00502	SPINDLE	1	-	48	07200-00239	BUTTON HEAD SCREW	1	-
6	07200-00503	FRONT ROLLER SHAFT	1	1	49	07007-00287	SILENCER DISC	1	2
7	07200-00504	REAR ROLLER SHAFT	1	1	50	07001-00019	SCREW	2	2
8	07200-00505	SPACER ROLLER	2	2	51	07200-00209	SUPPORT RING	1	-
9	07200-00506	SPINDLE HOUSING CAP	1	-	52	07002-00017	PISTON ROD NUT	1	2
10	07200-00507	SPINDLE BUMPER	2	2	53	07200-00214	CYLINDER HEAD CLIP	1	1
11	07200-00508	PINTAIL DEFLECTOR	1	2	54	07200-00213	PROTECTION RING	1	1
12	07200-00509	SCREW	1	2	55	07200-00231	RETAINING RING	1	1
13	07001-00022	SCREW	1	2	56	07003-00024	'O' RING	1	2
14	07004-00014	CIRCLIP	4	4	57	07200-00211	CYLINDER HEAD	1	-
15	07004-00015	RETAINING RING	1	2	58	07003-00025	'O' RING	1	2
16	07200-00600	OFFSET ADAPTOR ASSEMBLY	1	-	59	07200-00235	PISTON	1	-
17	07200-00602	OFFSET ADAPTOR HOUSING	1	-	60	07002-00007	WASHER	1	2
18	07200-00610	OFFSET SPINDLE	1	-	61	07220-00217	TRANSFER	1	-
19	07200-00604	CROSS PIN	1	1	62	07200-00230	PISTON BUMPER	1	1
20	07200-00605	SPINDLE EXTENSION	1	-	63	07001-00018	SCREW	1	2
21	07200-00606	LATCH SPRING	1	1	64	07200-00232	SHOULDER SCREW	1	1
22	07200-00607	GUARD	1	-	65	07200-00217	LINK	1	1
23	07200-00609	LATCH	1	-	66	07200-00206	PISTON ROD	1	-
24	07200-00612	RETAINING RING	1	-	67	07200-00215	CAM SHAFT	1	-
25	07200-00613	SPINDLE HOUSING SLEEVE	1	-	68	07200-00218	TRIGGER	1	1
26	07007-00007	SPRING PIN	1	-	69	07200-00237	SHOULDER SCREW	1	1
27	07007-00008	SPRING PIN	1	-	70	07200-00222	STRIPPER LEVER	1	1
28	07001-00235	SCREW	1	1	71	07200-00236	PLUG	1	1
29	07002-00003	LOCK WASHER	1	2	72	07200-00236	PLUG	1	2
30	07200-00300	BUSH AND CASTINGS SUB ASSEMBLY	1	-	73	01601-00512	RIVET	2	-
31	07200-00237	SCREW	1	1	74	07200-00224	TRIGGER GUARD	1	-
32	07200-00223	STRIPPER LEVER SPACER	1	-	75	07007-00006	PLUG	1	1
33	07200-00400	CAM ASSEMBLY	1	-	76	07200-00234	LABEL	1	-
34	07002-00005	LOCK WASHER	1	2	77	07220-00508	SWIVEL	1	-
35	07200-00221	STRIPPER LEVER	1	1	78	07003-00105	'O' RING	2	5
36	07003-00028	'O' RING	5	5	79	07220-00509	SWIVEL BOLT	1	-
37	07220-00227	SHOULDER SCREW	1	1	80	07005-00015	WASHER	1	2
38	07002-00004	LOCK WASHER	3	3	81	07005-00041	CONNECTOR	1	-
39	07200-00208	LOCKING NUT	1	2	82	07210-00800	STRAIGHT ADAPTOR ASSEMBLY	1	-
40	07200-00216	THROTTLE LEVER	1	-	83	07210-00801	EXTENSION	1	-
41	07200-00203	TOP VALVE BUSH	1	2	84	07210-00802	GUIDE SLEEVE	1	-
42	07003-00026	'O' RING	1	2	85	07210-00804	SCREW	1	-
43	07001-00015	SCREW	1	2	86	07002-00005	LOCK WASHER	1	-



# Fault Diagnosis

SYMPTOM	POSSIBLE CAUSE	REMEDY	PAGE REF
Short stroke or incomplete return	Offset adaptor setting incorrect	Reset adaptor	14-15
	Air leak	Tighten joints or replace components	
	Worn cam assembly	Replace	
	Worn roller shafts	Replace	
Tool fails to grip Lockbolt	Worn or dirty jaws	Clean or renew as necessary	11
	Broken jaws in nose assembly	Replace	11
	Incorrect nose assembly fitted	Change to correct nose assembly	10-11
Tool fails to break Lockbolt	Insufficient air pressure	Adjust air pressure	7
	Incorrect length of bolt	Change to correct length bolt	
	Tool exhaust silencer dirty	Clean silencer	
Tool fails to swage collar	Offset adaptor setting incorrect	Reset adaptor	14-15
	Insufficient air pressure	Adjust air pressure	7
	Worn anvils	Replace	11
	Swaging anvil cracked	Replace	
	Incorrect length of bolt	Change to correct length bolt	
Tool slows and fails to actuate	Insufficient air pressure	Check air supply	7
	Exhaust silencer dirty	Clean silencer	

Other symptoms or failures should be reported to your local TFS authorised distributor or repair centre.

# Declaration of Conformity

We, Textron Fastening Systems Limited, Mundells, Welwyn Garden City, Herts, AL7 1EZ  
declare under our sole responsibility that the product:

**Model Type 0720**

Serial No.

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

EN292 part 1 and part 2

ISO 8662 part 1

ISO 3744

ISO PREN792 part 14

EN 60742/0695

EN 50081-1

EN 55014

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



A R Dear - Design & Development Manager

Welwyn Garden City - date of issue



This box contains a power tool which is in  
conformity with Machines Directive  
89/392/EC. The 'Declaration of Conformity'  
is contained within.

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