

MP-3V Light Duty Riveter / 39045



This newly designed light-duty air/hydraulic riveter is ergonomically designed with the professional in mind. The light weight 2.9 lbs. well balanced MP-3V includes a *Vacuum System* and is designed to maximize a 3/4" stroke and 1,800 lbs. of pulling force along with a 3 jaw setup that gets the job done. The air supply can be connected directly or you can use the supplied air connection with the attached hose for operator convenience. Each tool is supplied with nosepieces to set 3/32" - 3/16" rivets in all alloys, adjustment service wrenches, hydraulic fluid, fluid applicator, spare jaws and a removable swivel air connection line with an air off/on valve built in. The adjustable *Vacuum System* control located inside the mandrel collection bottle allows you to control the force of the air needed to hold the rivet in place or you may operate with the vacuum system turned off. Recommended air pressure is 60-95 PSI.

WARNING: ALWAYS WEAR SAFETY GLASSES
WHEN OPERATING AND PERFORMING MAINTENANCE ON TOOL

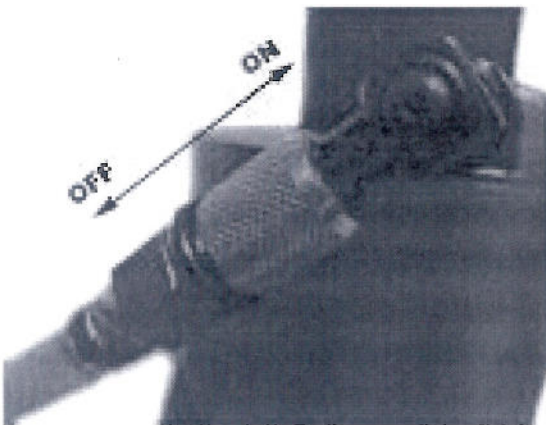
ADDITION OF HYDRAULIC

Use only compressed air. Check airline for damage from humidity & contaminants. In order to protect the tool from premature wear, we recommend the use of a filter, lubricator & regulator. Air connection size ¼" NPT.

WARNING:

Do not use air supply greater than recommended
or tool may be damaged or burst.

NORMAL OPERATION



1. Connect the air supply then switch ON/OFF valve to ON position.



2. To turn on and adjust the Vacuum system remove mandrel nail container and rotate bar counter-clockwise Adjust the amount of suction the vacuum system needs to hold the rivet in place and to eject spent mandrel into collection cup. Replace nail container.

If you don't want to use vacuum

system you can turn the vacuum system clockwise to shut it off. The tool will still be able to set rivets, but it must be tilted backwards to allow spent mandrel to fall into nail container.

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ADDITION OF HYDRAULIC FLUID

Tool is shipped with oil. If it becomes necessary to add oil, follow this procedure.
Please use the supplied priming pump as shown (fig. 4)

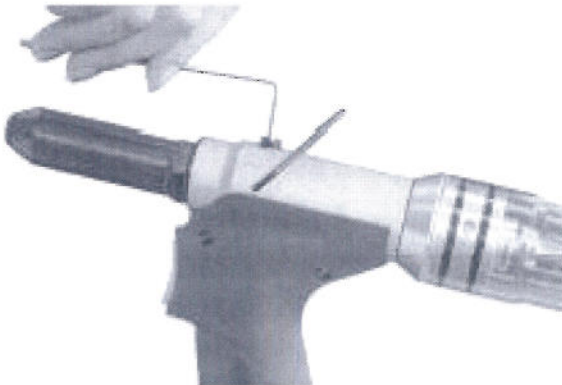


Fig 3

1. Disconnect air supply to tool and switch ON/OFF valve to OFF position.

2. Remove seal screw and seal (see Fig. 3)

3. Screw the priming pump of filled oil into the bleed screw hole. Actuate the priming pump by pressing down and releasing several times until resistance is felt. (Fig. 4)

4. Remove the priming pump and the excessive oil will flow out. Wipe away and clean out the excessive oil and replace the seal and screw.

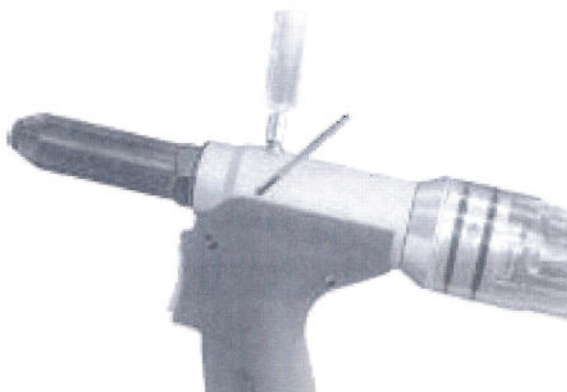


Fig 4

IMPORTANT: Use only Anti-Foam Hydraulic Fluid

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WHEN OPERATING AND PERFORMING MAINTENANCE ON TOOL**

CHANGING NOSEPIECES

1. After selecting the correct size nosepiece for the rivet being used Connect tool to air supply and pull trigger and hold trigger button.
2. Using wrench (supplied), unscrew nosepiece from frame head & replace with proper size nosepiece. Tighten down with wrench. DO NOT OVERTIGHTEN. Release trigger.

Your tool is now ready to work. Insert rivet mandrel into nosepiece. Insert rivet into predrilled hole in application and pull trigger button and hold until rivet sets then release the trigger. A second pull may be required.

CLEANING & CHANGING OF JAWS

With use, the jaws of the tool may become dirty or worn. This will cause slipping of the rivet mandrel & and improper setting of the rivet. To clean the jaws follow this procedure.

1. Disconnect air supply.
2. Use a suitable wrench, unscrew frame head and remove.
3. Using a pair of wrenches, disassemble front jaw case from rear jaw case. DO NOT MOVE rear jaw case as this will affect tool operation.
4. To clean jaws, use a stiff dry wire brush.
5. If excessive wear is apparent, replace with new jaws.
6. Reassemble the jaw case assembly.

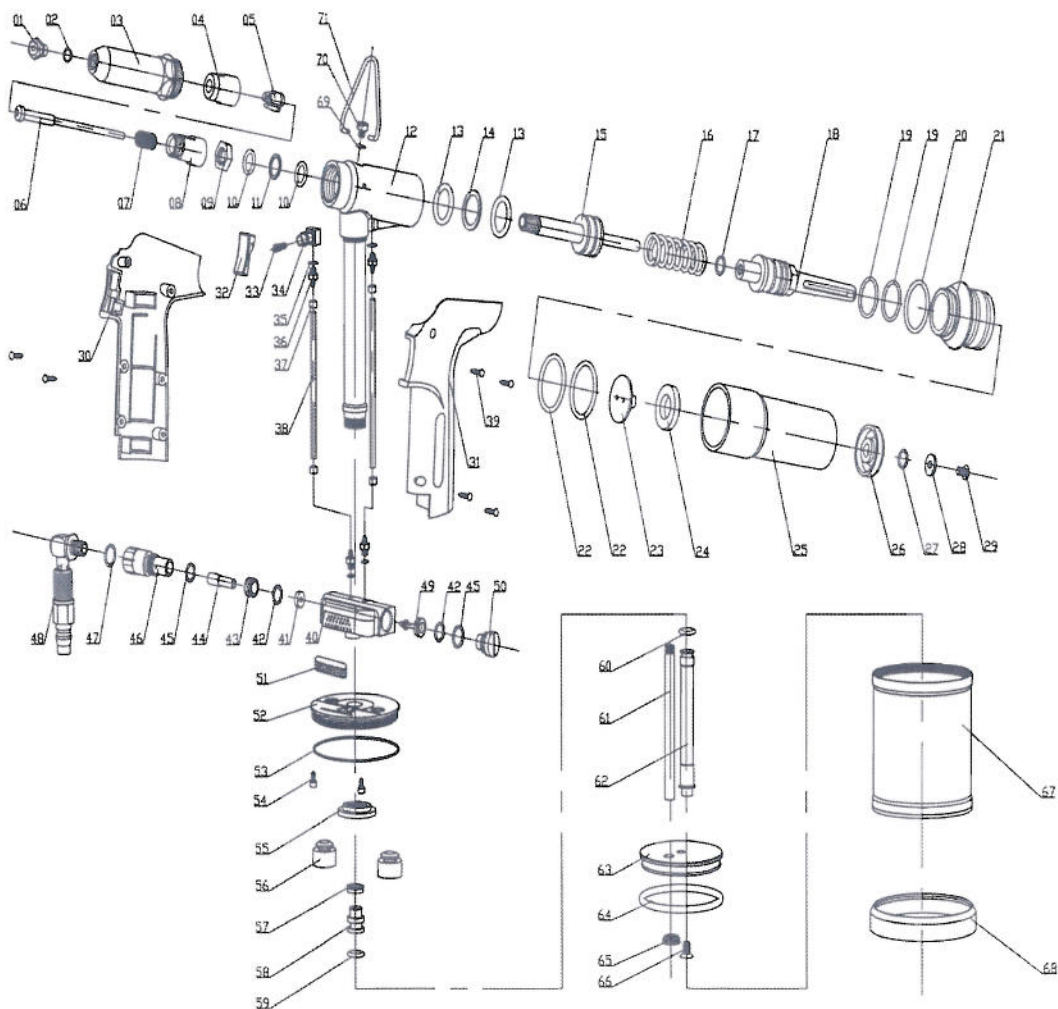
IF further maintenance is beyond the scope of this direction sheet and the tool fails to function properly, contact the factory or return it to the factory for service. Contact our Tool Repair Center at 317-704-8874 for further information.

LIMITED TOOL WARRANTY

Alcoa Fastening Systems - Marson division warrants that this tool will be free from defects in material and workmanship under normal service and for ninety (90) days from the date of purchase. This warranty applies to the purchaser of the tool for original use only. All other warranties, whether expressed or implied, including any warranties of merchantability or fitness for purpose are hereby excluded.

Should this tool fail during this ninety (90) day period, and no unauthorized repairs have been made, return the tool freight prepaid to the factory for free of charge replacement of any part or parts found by Alcoa Fastening System - Marson division to be defective due to faulty material or workmanship. This represents the sole obligation of Alcoa Fastening Systems - Marson under this warranty. In no event shall Alcoa Fastening Systems - Marson division be liable for any consequential or special damages arising from the purchase or use of this tool. You may have other rights which vary from state to state.

MP-3V (39045) Breakdown



Part Number	AFS Part No.	Description
1	M95200	3/32" NOSEPIECE
1	M95201	1/8" NOSEPIECE
1	M95202	5/32" NOSEPIECE
1	M95203	3/16" NOSEPIECE
2	M95204	O-RING 7x1
3	M95205	NOSEPIECE CASING
4	M95206	JAW CARRIER
5	M95207	JAWS (1set=3pcs)
6	M95208	PUSHER
7	M95209	JAW PUSHER SPRING
8	M95210	JAW HOUSING
9	M95211	LOCK RING
10	M95212	O-RING 12x2.4
11	M95213	TEFLON RING 12x1.4
12	M95214	HEAD ASSEMBLY
13	M95215	O-RING 20x3.5
14	M95216	TEFLON RING 20x1.4
15	M95217	PRINCIPAL AXIS UNIT
16	M95218	RESTORE SPRING
17	M95219	O-RING 7x2
18	M95220	VACUUM VALVE ASSEMBLY
19	M95221	O-RING 16x2.4
20	M95222	O-RING 27.2x1.9
21	M95223	AIRPROOF LID
22	M95224	O-RING 31.5x3.1
23	M95225	PARTITION
24	M95226	SILENCER
25	M95227	NAIL CONTAINER
26	M95228	REAR COVER
27	M95229	O-RING 8x2
28	M95230	WASHER
29	M95231	SCREW 5x8
30	M95232	HANDLE(LEFT)
31	M95233	HANDLE(RIGHT)
32	M95234	TRIGGER
33	M95235	TRIGGER VALVE
34	M95236	ON/OFF BASE

Part Number	AFS Part No.	Description
36	M95238	AIR INTERFACE
37	M95239	TIE RING
38	M95240	AIR TUBE
39	M95241	TAPPING SCREW
40	M95242	AIR VALVE BODY
41	M95243	AIR VALVE RING
42	M95244	O-RING 9.5x12.5x1.5
43	M95245	AIR VALVE BASE
44	M95246	SUBORDINATE TUBE
45	M95247	O-RING 11.5x14.5x1.5
46	M95248	CONNECTING BASE
47	M95249	O-RING 9.2x2.4
48	M95250	ON/OFF ASSEMBLY
49	M95251	AIR VALVE ROD
50	M95252	SCREW PLUG
51	M95253	SILENCER
52	M95254	CYLINDER COVER
53	M95255	O-RING 66x2
54	M95256	BOLT 3x6
55	M95257	ROCK NUT
56	M95258	BUFFER
57	M95259	LIP SEAL 8x14x6
58	M95260	AIR TUBE PISTON
59	M95261	O-RING 11.6x1.5
60	M95262	PISTON RING
61	M95263	TRANSFER TUBE
62	M95264	PISTON ROD
63	M95265	CYLINDER PISTON
64	M95266	O-RING 75x86x5.7
65	M95267	EL 8x14.2x5
66	M95268	BOLT 6x10
67	M95269	CYLINDER
68	M95270	BASE COVER
69	M95271	BS 5.7x10x1
70	M95272	SEAL SCREW 5x6
71	M95273	HOOK

Automatic Tools

Automatic Rivet Tools – Standard & Special Nosepieces

	3/32"	1/8"	Standard			T-Rivets / Klik-Split®	Monobolt**	
	3/32"	1/8"	5/32"	3/16"	1/4"	1/4"	3/16"	1/4"
MP-3V/M39045	M95200	M95201	M95202	M95203				
MP-4V/M39048			M95300	M95301	M95302		M95299	M95303
302-E/M39062	M717006	M717001	M717002	M717003	M717005			
304-E/M39064				M88220-1	M88220-79	M88220-83	M88220-85	M88220-84
IF-1/M39075				M95137-2	M95137			

*For Monobolt® structural rivets, the noted special nosepiece is required. For Marson brand Klik-Lock® structural rivets, no special insert is required.

Automatic Rivet Tools – Capacity Chart

	Steel				All Aluminum				Aluminum Steel				Stainless				Struc-tural*		"T" Rivets	
	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"	3/32"	1/8"	5/32"	3/16"	1/4"
M-3/M39054	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
MP-3V/M39045	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
M-4/M39058	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
MP-4V/M39048	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
302-E/M39062	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
304-E/M39064	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
BT-2/M39080	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
IF-1/M39075	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*

*For Monobolt® structural rivets, the noted special nosepiece is required. For Marson brand Klik-Lock® structural rivets, no special insert is required.

Automatic Rivet Tools – Dimensions

Tool	A	B	C	D	E	F	G	WT
M-3/M39054	12"	6"	1.25"	3"	6"	1"	2"	4.2 lbs.
MP-3V/M39045	10"	3.5"	1.5"	3.5"	6.5"	.925"	2.75"	2.9 lbs.
M-4/M39058	12"	4.5"	15"	3.5"	7"	.987"	4.5"	6.6"
MP-4V/M39048	12"	5.5"	2."	4.5"	7."	.925"	3.5"	3.7 lbs.
302-E/M39062	11.125"	5"	2.375"	4.5"	13."	.828"	2.5"	4 lbs.
304-E/M39064	13.125"	6"	2.375"	5.25"	13."	.938"	2.5"	5.5 lbs.
BT-2/M39080	9.5"	4"	2.25"	4.25"	8.25"	1"	2.75"	4.2 lbs.
IF-1/M39075	12"	5.56"	1.575"	4.99"	9.18"	12.79"	4.155"	4.8 lbs.

Automatic Rivet Tools – Specifications

Tool	Work Force	Stroke
MP-3/M39054	85-95 psi 2,000 lbs./8,896 n	.551" 14 mm
MP-3V/M39045	70-95 psi 1,800 lbs./8007 n	.75" 19 mm
MP-4/M39058	70-95 psi 3,420 lbs./15,213 n	.748" 19 mm
MP-4V/M39048	70-95 psi 3,420 lbs./15,213 n	1." 25.4 mm
302-E/M39062	85-95 psi 2,000 lbs./8,896 n	.812" 21 mm
304-E/M39064	85-95 psi 4,200 lbs./18,682 n	1." 25.4 mm
BT-2/M39080	2,373 lbs./10,000 n	.83" 21 mm
IF-1/M39075	4,600 lbs./20,500 n	1.125" 28.575 mm

