

MADE IN ITALY

302-E Heavy Duty Riveter / 39062



This durable air/hydraulic riveter, with its fully adjustable vacuum system that holds the rivet in the nosepiece, allowing the operator to rivet at any angle with one hand free. The vacuum system automatically collects the spent mandrel into a bottle creating a cleaner and safer work environment by preventing spent mandrels from falling to the floor. A traction pulling power of 2,000 lbs. allows this tool to easily install 3/32" to 3/16" diameter rivets in all alloys and 1/4" diameter open-end rivets in aluminum/steel combination. A swivel air inlet along with a push button trigger and a two piece molded frame provides the operator with maximum comfort using minimal effort.

WILL INSTALL!

3/16, 1/4 The recommended airline pressure is 85-95 PSI.
3/32, 5/32 Weight: 4 lbs.
1/8

**Alcoa
Fastening
Systems & Rings**



1925 N MacArthur Drive
Tracy, CA 95376

* COMES WITH !

- ✓ OIL AND APPLICATOR
- ✓ REPLACEMENT JAWS
- ✓ NOSE PIECES
- ✓ SERVICE WRONAPES

Tool Repair Department
800-826-2884 ext. 3032
<http://afs-idg.com/>

AIR FEED

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 an inline water filter and air pressure regulator. Normal working pressure is 85-95 PSI.

Air connection size 1/4" NPS.

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

NORMAL OPERATION

The 302-E is a durable, light weight, ergonomically designed rivet tool used for upsetting 3/32" to 3/16" diameter rivets in all alloys, and 1/4" diameter open-end rivets in aluminum/steel. The 304-E features 3 jaw construction and is fully self-adjusting. To change size of rivet simply change nosepiece. No other adjustments are necessary.

**WARNING:
ALWAYS WEAR SAFETY GLASSES WHEN OPERATING TOOL**

Install mandrel container on back of tool (refer to drawing). Install air fitting in connector. Attach tool to air pressure between 85-95 PSI. You are now ready to work. Pointing tool away from people and objects, test by pulling trigger once or twice. When tool is new, has been sitting idle overnight, or in the cold it may not function on first pull. THIS IS NORMAL.

Rivets mandrels are ejected from the back of the tool into a mandrel container. By turning the suction adjustment knob, you can adjust the vacuum power. If a larger container is required, mandrels may be ejected through a tube (not supplied) which must be connected directly to the riveting tool by the connector after removing the mandrel container.

WARNING: FAILURE TO USE COLLECTION BOTTLE OR TUBE AS INSTRUCTED MAY RESULT IN INJURY.

WARNING: DO NOT USE OXYGEN, COMBUSTIBLE GASES OR BOTTLED GASES AS A SOURCE FOR THIS TOOL. THESE MAY CAUSE THE TOOL TO EXPLODE.

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

MAINTENANCE

ADDITION OF HYDRAULIC FLUID

Tool is shipped with oil. If it becomes necessary to add oil, follow this procedure. Put tool in a horizontal position. Remove plug (35). Pour hydraulic fluid into container (84). Screw container into fluid plug receptacle. Oil level should reach edge of fill hole. With container still attached, reconnect to air supply. Actuate trigger button 5 or 6 six times, or until air bubbles inside the container stop. This releases any entrapped air.

IMPORTANT: Use only Anti-Foam Hydraulic Fluid or equivalent air tool oil. Recommended: Mobil DTE 24

CHANGING NOSEPIECES

1. Select proper nosepiece
2. Disconnect tool from air supply.
3. Using wrench (supplied), unscrew nosepiece from frame head & replace with proper size nosepiece. Store unused nosepiece in holder.
4. Reconnect air supply.
5. Pointing the tool away from people & objects, push trigger button & hold. Snug down with wrench. DO NOT OVERTIGHTEN.

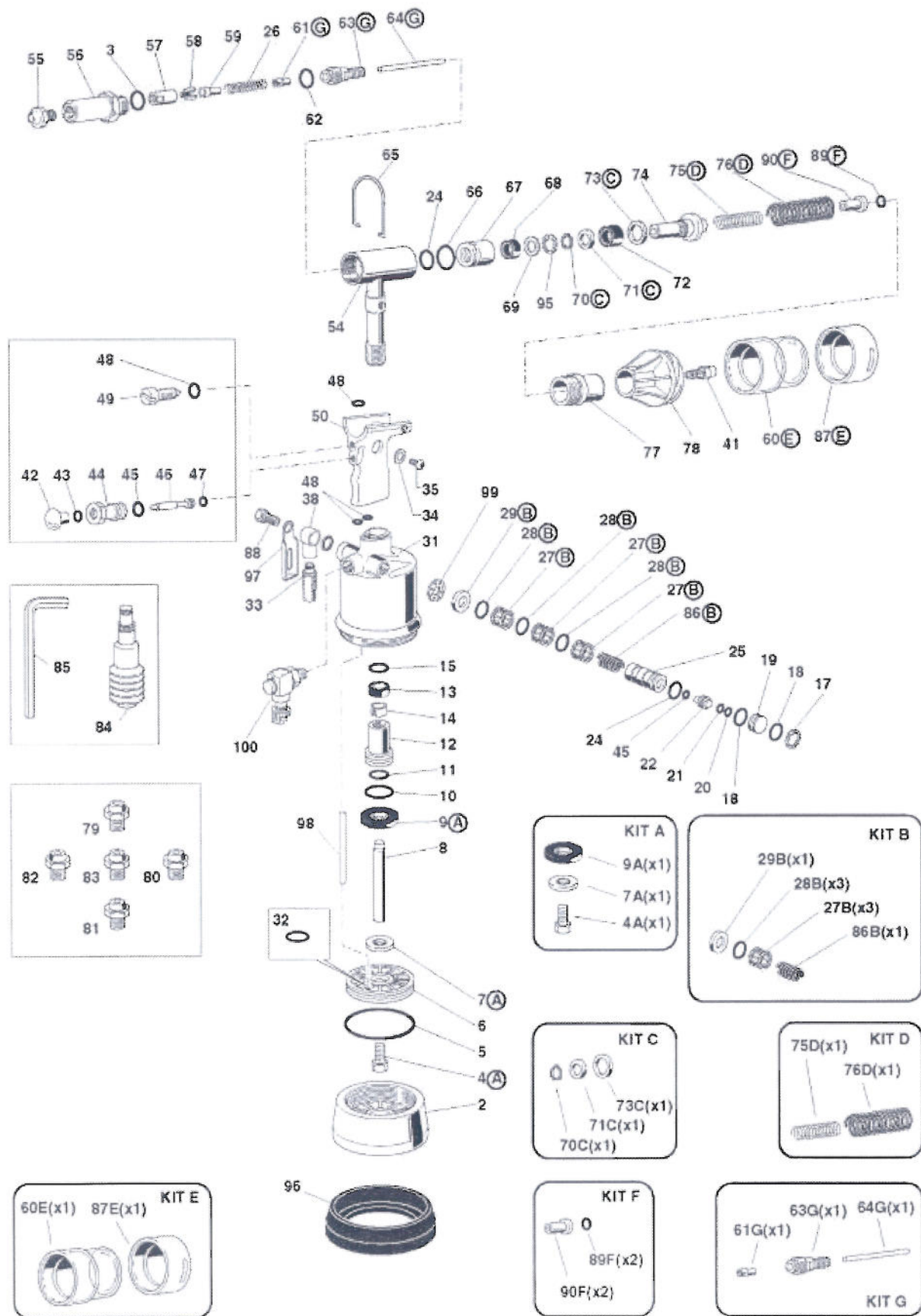
Your tool is now ready to work. Insert rivet mandrel into nosepiece. Insert rivet into predrilled hole in application material, pull trigger button & release.

CLEANING & CHANGING OF JAWS

With use, the jaws of the tool may become filled with debris. This may cause slipping of the rivet mandrel and improper setting of the rivet. To clean the jaws follow this procedure.

1. Disconnect air supply
2. Using a suitable wrench, unscrew frame head & 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. Clean inside of frame head and use a dry wire brush to clean the jaw grip area.
5. If excessive wear is apparent, replace with new jaws.
6. Reassemble in reverse order.

302-E Heavy Duty Riveter / 39062 Parts Breakdown



Parts List

Drawing #	Part #	Description	Qty
2	712716	Body Cover Bottom	1
3	88003	O-Ring 020	1
4A	see below	Screw Stem	1
5	88005	Air Piston O-Ring	1
6	88006	Air Piston	1
7A	see below	Flat Washer	1
8	88088	Stem	1
9A	see below	Dampener	1
10	88010	APGC Lower O-Ring	1
11	88011	Int. Air Piston Guide O-Ring	1
12	88012	Air Piston Guide Connector	1
13	88013	Air Piston Gasket	1
14	88014	Air Piston Guide	1
15	88015	Upper Air Piston Guide O-Ring	1
17	88017	Retainer Ring	1
18	88018	Valve Plug O-Ring	2
19	88019	Valve Plug	1
20	88020	Retainer Ring	1
21	88021	Outer Valve Piston O-Ring	1
22	88022	Valve Piston	1
24	88024	Coil Frame O-Ring	2
25	88025	Coil	1
26	88026	Jaw Return Spring	1
27B	see below	Valve Cage	3
28B	see below	Cage O-Ring	3
29B	see below	Valve Spacer	1
31	88031	Tool Body	1
32	88032	Internal Air Piston O-Ring	1
33	88033	Silencer	1
34	88034	Hermetic Plug Washer	1
35	88035	Oil Plug	1
38	88038	Silencer Rotating Connector	1
41	88041	Output Connector	1
42	88042	Push Button Trigger	1
43	88043	Trigger O-Ring	1
44	88044	Valve Body	1
45	88045	Valve Body O-Ring	2
46	88046	Valve Piston Trigger	1
47	88047	Valve Piston O-Ring	1
48	88023	Valve/Frame O-Ring	4
49	88049	Vacuum Adjustment Knob	1
50	88050	Frame	1
54	88054	Internal Frame Cylinder	1
55	88055	Nosepiece 3/16" Cu/Steel	1
56	88056	Frame Head	1
57	88057	Front Jaw Case	1
58	88058	Jaw Set	3
59	88059	Jaw Piston	1
60E	see below	Mandrel Container	1
61G	see below	Suction tube	1
62	88062	Jaw Case O-Ring	1
63G	see below	Cone Holder	1
64G	see below	Cone Holder Extension	1
65	88065	Balancer Hook	1
66	88066	Gasket Sleeve O-Ring	1
67	88067	Gasket Sleeve	1
68	88068	Sleeve Seal	1
69	88069	Washer	1
70C	see below	Retainer Ring	1

Drawing #	Part #	Description	Qty
71C	see below	Stop Ring	1
72	88072	Oil Piston Gasket	1
73C	see below	Anti-Extrusion Ring	1
74	88074	Oil Piston	1
75D	see below	Interior Oil Piston Spring	1
76D	see below	Exterior Oil Piston Spring	1
77	88077	Spring Guide Plug	1
78	88078	Mandrel Container Connector	1
79	717006	3/32" Nosepiece	1
80	717001	1/8" Nosepiece	1
81	717002	5/32" Nosepiece	1
82	717003	3/16" Nosepiece Al/Steel	1
83	88371	1/4" Nosepiece	1
84	88220-77	Oil Container	1
85	88220-76	5mm Allen Key	1
86B	see below	Coil Spring	1
87E	see below	Air Conveyor	1
88	88220-45	Connector 1631-01-1/4	1
89F	see below	Bushing O-Ring	1
90F	see below	Bushing	1
95	88095	Retainer Ring	1
96	88096	Rubber Cushion	1
97	712162	Air Silencer Shield	1
98	88098	Tube Air Piston	1
99	88030	Washer Stop Spring	1
100	88100	Rotating Connector	1

KIT A	Part #	Description	Qty
4A	88004	Screw Stem	1
7A	88007	Flat Washer	1
9A	88009	Dampener	1

KIT B	Part #	Description	Qty
27B	88027	Valve Cage	3
28B	710921	Cage O-Ring	3
29B	88029	Spacer	1
86B	88126	Coil Return Spring	1

KIT C	Part #	Description	Qty
70C	88070	Retainer Ring	1
71C	88071	Stop Ring	1
73C	88073	Anti-Extrusion Ring	1

KIT D	Part #	Description	Qty
75D	88075	Interior Oil Piston Spring	1
76D	88076	Exterior Oil Piston Spring	1

KIT E	Part #	Description	Qty
60E	710819	Mandrel container	1
87E	88220-22	Air Conveyor	1

KIT F	Part #	Description	Qty
89F	88089	Bushing O-Ring	2
90F	88090	Bushing	2

KIT G	Part #	Description	Qty
61G	88061	Suction Tube	1
63G	88063	Cone Holder	1
64G	710832	Cone Holder Extension	1

Further maintenance may be beyond the scope of this direction sheet. If the tool fails to function properly, either call an authorized Tool Repair center for advice or return the tool to an authorized Tool Repair center for service.

LIMITED TOOL WARRANTY

Alcoa Fastening Systems & Rings – Industrial Distribution Group 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 from defects in material and workmanship under normal service and no unauthorized repairs have been made, return the tool to an authorized tool repair center for warranty replacement of any part or parts found by Alcoa Fastening Systems & Rings – Industrial Distribution Group to be defective due to faulty material or workmanship. This represents the sole obligation of Alcoa Fastening Systems & Rings – Industrial Distribution Group under this warranty. In no event shall Alcoa Fastening Systems & Rings – Industrial Distribution Group 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.

Other product and tool information (including our Tool Repair Form) can be found by visiting us on the web at: **<http://afsindustrial.com/distribution/>**

Automatic Tools

These next-generation, professional-series air/hydraulic riveters are designed to be light weight and well-balanced. Both are engineered to maximize stroke and pull force with a 3-jaw set. For added convenience, you can direct connect or use the attached swivel. Each tool is supplied with nosepieces to set rivets in all alloys, and comes complete with adjustment service wrenches, hydraulic fluid, fluid applicator, spare jaws, and a removable swivel air connection line with an air OFF/ON valve built in. An adjustable vacuum system control allows you to control the force of air needed to hold the rivet in place. Or, you may operate with the vacuum system turned off. Recommended air pressure is 70-95 PSI.



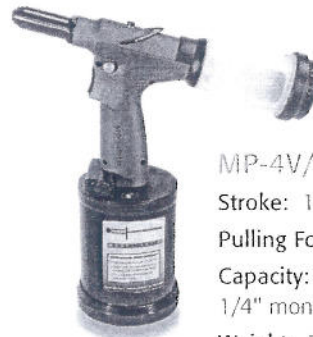
MP-3V/M39045

Stroke: 3/4"

Pulling Force: 1,800 lbs.

Capacity: 3/32" – 3/16", all alloys

Weight: 2.9 lbs.



MP-4V/M39048

Stroke: 1"

Pulling Force: 3,420 lbs.

Capacity: 5/32" – 1/4", all alloys,
1/4" monobolt nosepiece included

Weight: 3.7 lbs.

Each of these proven, professional tools features a one-piece molded frame and front swivel air inlet for maximum operator comfort and durability. An external vacuum adjustment offers convenient air flow control for rivet placement and mandrel disposal. This allows the operator to install rivets in any orientation using one hand, and freeing up the other for assembly. Spent mandrels are conveniently collected in the bottle for disposal, encouraging a safer, clean work environment. Tools come complete with oil, replacement jaws, and nosepieces. Recommended air pressure: 85-95 psi.



302-E/M39062

Stroke: .812"

Pulling Force: 2,000 lbs.

Capacity: 3/32" – 3/16" diameter in all alloys
and up to 1/4" in aluminum/steel combinations.

Weight: 4 lbs.

304-E/M39064

Stroke: 1"

Pulling Force: 4,200 lbs.

Capacity: 3/16" to 1/4"
all alloys including structural rivets

Also included are 3/16" and 1/4"
Monobolt® & Magna-lok assemblies.

Weight: 5.5 lbs.



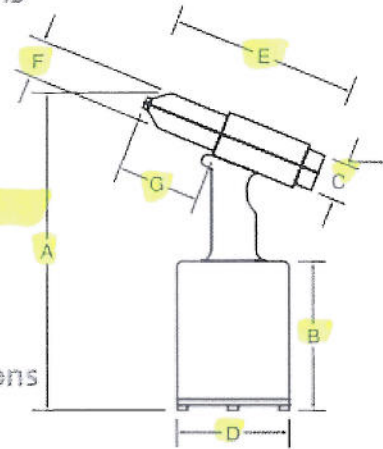
Extended head
Accessory
for 302-E and
304-E

171 New Style

Tool	Description	Part Number
302-E/M39062	5" Extension Head	M88062
302-E/M39062	8" Extension Head	M88086
304-E/M39064	5" Extension Head	M88220-39
304-E/M39064	5" Extension Head	M723358

Air/Hydraulic Rivet Tools — Dimensions

Tool	A	B	C	D	E	F	G	WT
39054	12"	6"	1¼"	3"	6"	1"	3"	4.2 lbs.
39055	11.5"	9.5"	1.75"	3"	7"	.915"	4"	4.6 lbs.
39058	12"	4.5"	1.5"	3.5"	7"	.987"	4.5"	6.6 lbs.
39062	11.125"	5"	2.375"	4.5"	13"	.828"	2.5"	4 lbs.
39064	13.125"	6"	2.375"	5.25"	13"	.9375"	2.5"	5.5 lbs.
39070	15"	4"		3.125"	9"	.875"	2.5"	3 lbs.



Air/Hydraulic Rivet Tools — Specifications

Tool	Work Force	Avg. Air Consumption	Stroke
39054	85-95 psi 1,983 lbs./8,820 n	4 cfm	.551" 14 mm
39055	85-95 psi 1,940 lbs./8,629 n	4 cfm	.551" 14 mm
39058	85-95 psi 3,099 lbs./13,784 n	5 cfm	.748" 19 mm
39062	85-95 psi 2,000 lbs./8,896 n	5 cfm	.812" 21 mm
39064	85-95 psi 4,200 lbs./18,882 n	5 cfm	.875" 22 mm
39070	85-95 psi 2,100 lbs./9341 n	4 cfm	.590" 15 mm

