

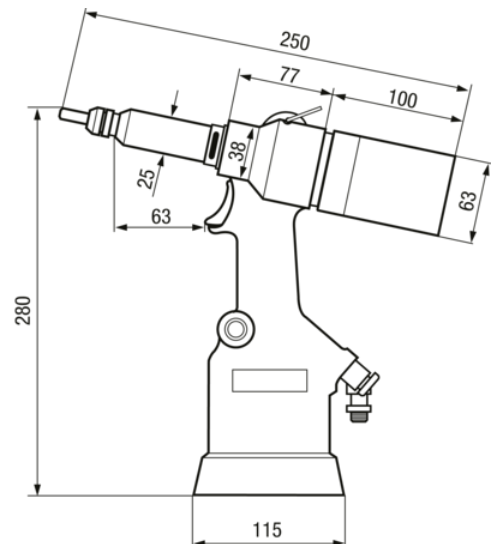
## NUTSERT TOOL – 0742

A versatile air tool for nutsert sizes M3-M12 in all material

Nutsert tool 0742 is a quality gun that represents excellent value for the installation M3-M12 nutserts in all material including stainless. This gun comes complete with M3-M12 mandrels and anvils, so there are no extra charges. The tool features a heavy-duty polymer body and a simple to use single trigger, that pulls the nutserts to a set stroke. New to nutserts? Check out our [blog article](#) for more information.



NT-0742 Specifications	
Weight	2.2Kg
Pull Force	19.1Kn
Stroke	7mm
Cycle Time	2.5 seconds
Air Pressure	5 – 7 bar
Fastener Capacity	M3-12 threaded inserts in all material



## Specifications

### Tool Specification

<b>Air Pressure</b>	Minimum - Maximum	5-7 bar (75-100 lbf/in <sup>2</sup> )
<b>Free Air Volume Required</b>	@ 5 bar/75 lbf/in <sup>2</sup>	8 litres (.28 ft <sup>3</sup> )
<b>Stroke</b>	Maximum	7 mm (.276 in)
<b>Motor Speed</b>	Spin On	2000 rpm
	Spin Off	2000 rpm
<b>Pull Force</b>	@ 5 bar/75 lbf/in <sup>2</sup>	19.1 kN (4300 lbf)
<b>Cycle time</b>	Approximately	2.5 seconds
<b>Noise Level</b>	Less than	75 dB(A)
<b>Weight</b>	Without nose equipment	2.2 kg (4.85 lb)
<b>Vibration</b>	Less than	2.5 m/s <sup>2</sup> (8 ft/s <sup>2</sup> )

### Intent of Use

This hydro-pneumatic tool is designed to place threaded inserts at high speed, making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries.

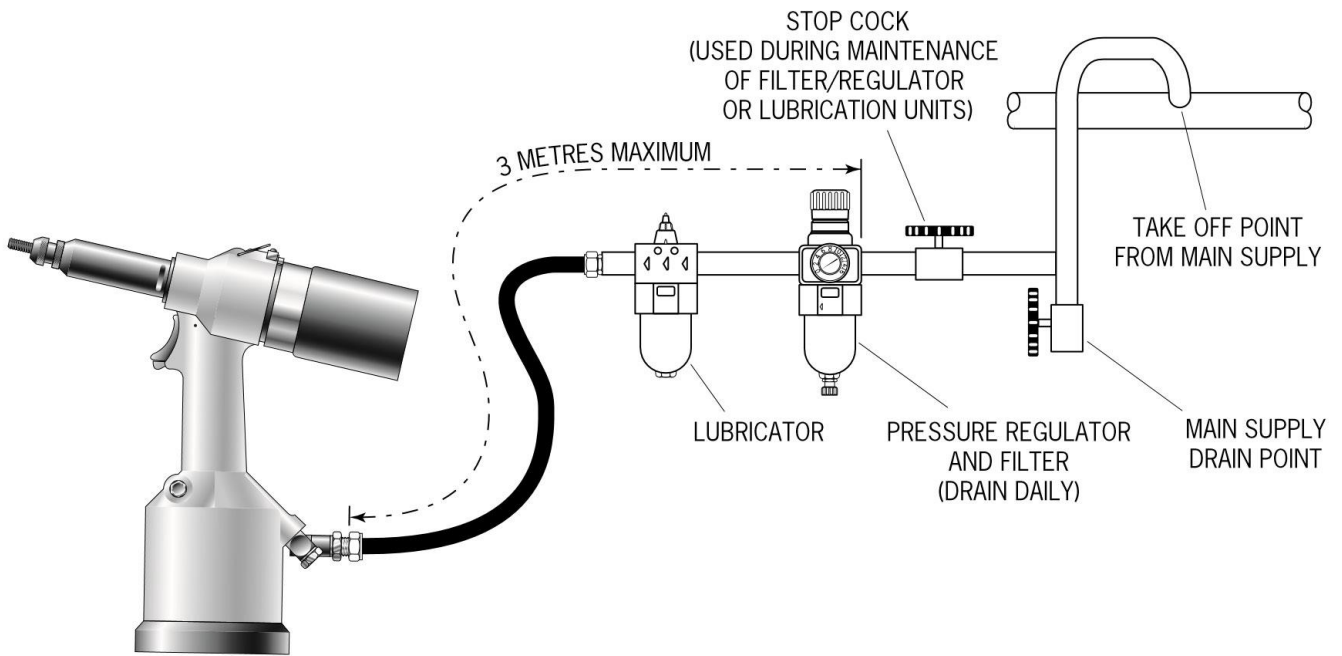
A complete tool is made up of the base tool (part number NT-0742) and the appropriate nose assembly for the insert, as described on page 9.

### **NOSE ASSEMBLIES MUST BE FITTED AS DESCRIBED ON PAGE 4.**

### **Air Supply**

All tools are operated with compressed air at an optimum pressure of 5.5 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 inch.



### Stroke Adjustment

This adjustment is necessary to ensure optimum insert deformation. It is suggested, therefore, that a test plate with the same thickness and hole size as workpiece be used.

If deformation is insufficient, the insert will rotate inside the application. If deformation is excessive, thread distortion will occur and possible drive screw fracture.

The stroke is adjusted by the amount the rear casing **86** is screwed in or out. To shorten stroke, screw in; to lengthen stroke, unscrew the rear casing but never more than 5 turns from the fully "IN" position unless dismantling the tool. Adjust until optimum deformation is obtained. Lock the stroke set finger **88** into the rear casing.



### Operating Procedure

- Connect tool to air supply.
- Offer up insert, lip first to drive screw. A light pressure will start the motor and automatically thread the insert up against nose and stop.
- Insert fastener into application squarely.
- Fully depress trigger. This will both place the insert into the application and reverse it off the drive screw.

Item numbers in **bold** refer to the General Assembly drawing and parts list (pages 6-7).

## Nose Assemblies

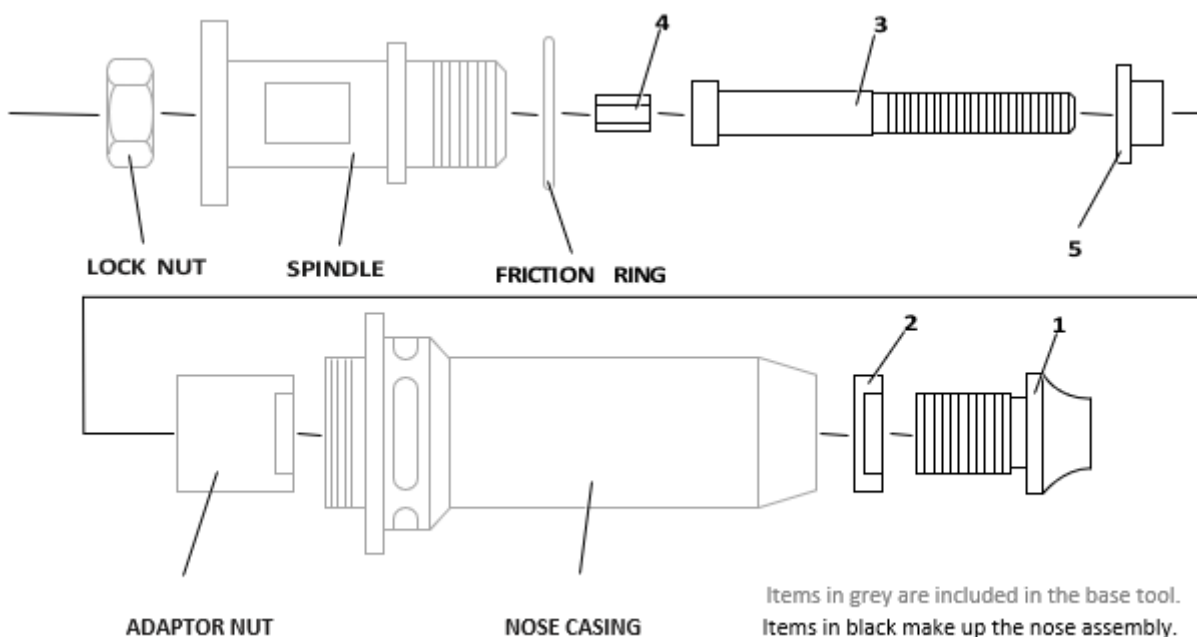
It is essential that the correct nose assembly is fitted prior to operating the tool.

### Fitting Instructions

**IMPORTANT: The air supply must be disconnected when fitting or removing nose assemblies unless specifically instructed otherwise.**

Item numbers in bold refer to illustration below:

- If still fitted remove the nose casing and the adaptor nut.
- Insert drive shaft **4** into spindle.
- Fit drive screw **3** onto drive shaft **4**.
- Insert reducing sleeve **5** (if specified) into the adaptor nut.
- Screw the adaptor nut onto the spindle.
- Hold the spindle with a spanner and tighten the adaptor nut clockwise.
- While holding the adaptor nut with the spanner, tighten the lock nut anti-clockwise.
- Screw on the nose casing and nose tip **1** with the nose tip lock nut.
- The reverse operation is carried out for equipment removal.
- With tool still disconnected from air supply, screw one insert onto drive screw manually - making sure the insert is flush with the end of drive screw.
- Set nose tip in exact position and lock nose tip nut clockwise with a spanner\*.
- Remove the insert from drive screw.



## Servicing Instructions

Nose assemblies should be serviced at weekly intervals.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting Instructions'.
- Any worn or damaged part should be replaced by a new part.
- Particularly check wear on drive screw.
- Assemble according to fitting instructions.

## Servicing the Tool

Regular servicing should be carried out and a comprehensive inspection performed annually or every 500,000 cycles, whichever is sooner.

### Daily

- Check for air leaks. If damaged, hoses and couplings should be replaced by new items.
- 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.
- Check that the nose assembly is correct.
- Check the stroke of the tool is adequate to place selected insert.
- Inspect the drive screw in the nose assembly for wear or damage. If any, renew.

### Weekly

- Check for oil leaks and air leaks on air supply hose and fittings.

## Servicing the Tool

Service Kit: for all servicing we recommend the use of the service kit supplied in its own plastic case.

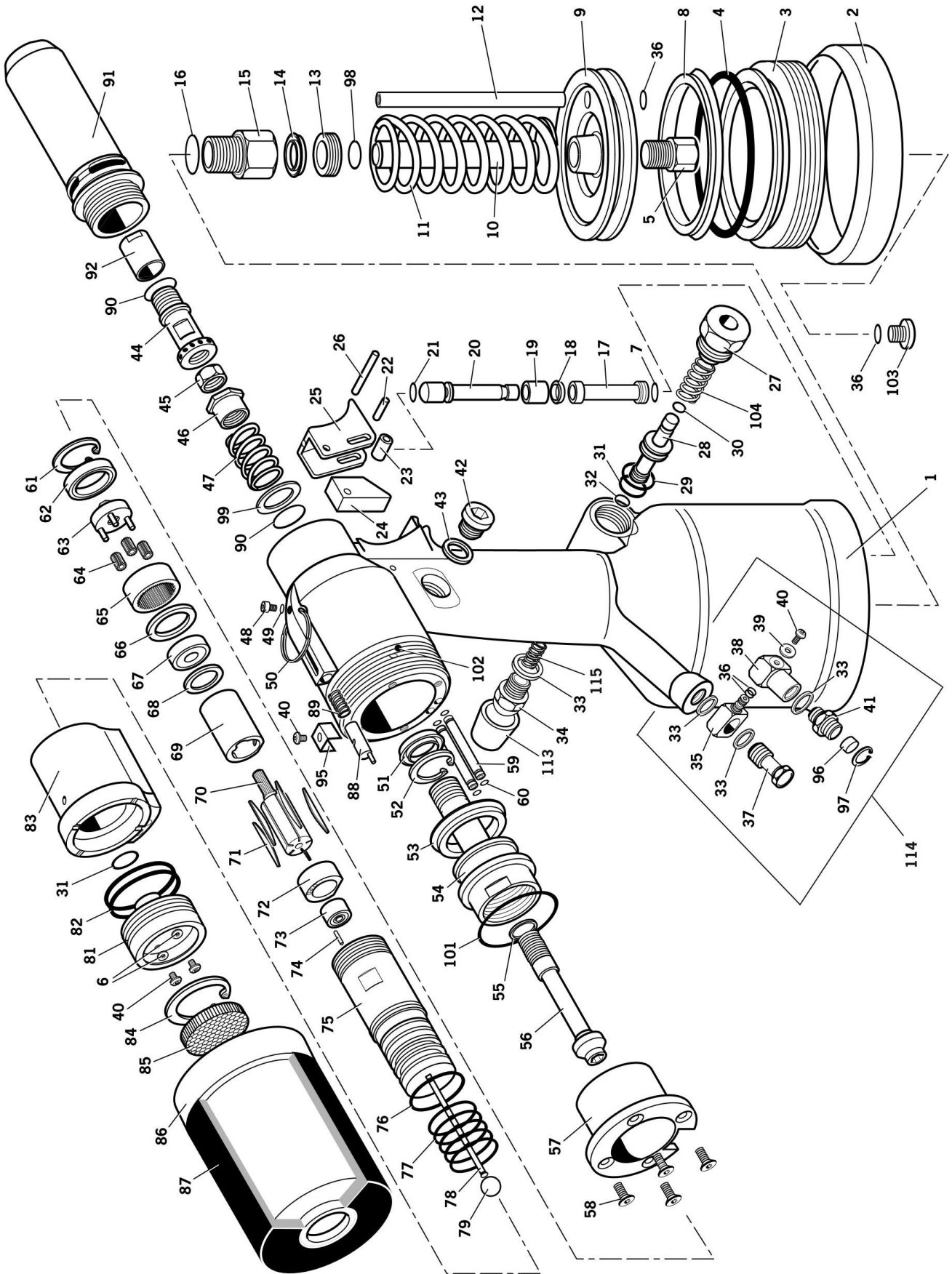
### SERVICE KIT

### SERVICE KIT (Continued)

00618	PUSHER	1
00478	∅ 3mm PIN PUNCH	1
00624	∅ 4mm PIN PUNCH	1
00157	INTERNAL CIRCLIP PLIERS	1
00161	EXTERNAL CIRCLIP PLIERS	1
00625	SOFT MALLET	1
00623	25mm SOCKET	1
00006	SPATULA	1
00434	32mm SPANNER	1
00621	28mm SPANNER	1
00637	17mm SPANNER	1
00643	PUSHER KNOB	1

00393	14mm/15mm SPANNER	1
00626	11mm SPANNER	1
00469	2.5mm ALLEN KEY	1
00351	3mm ALLEN KEY	1
00224	4mm ALLEN KEY	1
00225	5mm ALLEN KEY	1
00620	12mm ALLEN KEY	1
00456	T BAR	1
00075	MOLYKOTE 55M (100 gm TUBE)	1
00627	PLASTIC CASE	1
00632	17mm/19mm SPANNER	2

**General Assembly Base Tool**



**PARTS LIST**

ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES	ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES	ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES
01	12001	HEAD & HANDLE	1	-	38	12038	SEIVELLING INLET	1	-	75	12075	AIR MOTOR CASING	1	-
02	12002	RUBBER BASE	1	1	40	00420	M4 BUTTON SOCKET HD SCREW	4	4	76	00305	'O' RING	1	1
03	12003	END PLUG (SCREWED)	1	-	41	12041	1/4"DOUBLE MALE CONNECTOR	1	-	77	00306	'O' RING	5	5
04	12004	'O' RING	1	1	42	01274	OIL PLUG	1	1	78	12078	PUSH ROD 80 mm LONG	1	1
05	12005	PISTON ROD FASTENING BOLT	1	-	43	12043	OIL SEAL WASHER	1	1	79	12079	BALL (RUBBER)	1	1
06	00109	M4 SHAKEPROOF WASHER	2	-	44	12044	SPINDLE	1	1	80	01503	BOOKMARK LABEL	1	N/1
07	00027	'O' RING	2	2	45	00803	LOCK NUT	1	1	81	12081	AIR MOTOR END PLUG	1	-
08	12008	LIP SEAL (PNEUMATIC PISTON)	1	1	46	12046	RETURN SPRING LOCKNUT	1	1	82	12082	'O' RING	2	2
09	12009	PNEUMATIC PISTON	1	-	47	12047	RETURN SPRING	1	1	83	12083	DISTRIBUTOR	1	-
10	12010	PISTON ROD (INTENSIFIER)	1	-	48	00329	M5 BLEED SCREW	1	1	84	12084	CIRCLIP	1	1
11	00205	SPRING	1	1	49	00033	OIL SEAL BLEED WASHER	1	1	85	12085	SINTERED SILENCER	1	1
12	12012	AIR SUPPLY TUBE	1	1	50	03021	SUSPENSION RING	1	1	86	12086	REAR CASING	1	-
13	12013	LOCK NUT	1	-	51	02004	FRONT SEAL	1	1	87	12087	REAR CASING RUBBER BAND	1	1
14	12014	SEAL	1	1	52	00033	CIRCLIP	1	1	88	12088	STROKE SET FINGER	1	1
15	12015	ROD GUIDE	1	-	53	12053	SEAL	1	1	89	12089	SPRING	1	1
16	00100	'O' RING	1	1	54	12054	HYDRAULIC PISTON	1	-	90	00028	LOCKING RING	2	2
17	12017	PLUG	1	-	55	12055	SHIM ADJUSTMENT RING	1	1	91	12091	NOSE CASING	1	-
18	12018	LIP SEAL	1	1	56	12056	MOVEMENT PIVOT	1	1	92	12092	ADAPTOR NUT (UP TO M10)	1	1
19	12019	GUIDE	1	-	57	12057	STROKE STOP	1	-	93	12093	COLOURED LABEL	1	N/1
20	12020	TRIGGER ROD	1	-	58	00427	M5 CSK SOCKET HEAD SCREW	4	4	94	00354	TIE ON SAFETY LABEL	1	N/1
21	00315	'O' RING	1	1	59	12059	PNEU.MOTOR AIR SUPPLY TUBE	2	2	95	12095	BRIDGE WASHER	1	1
22	12022	PIN	1	1	60	12060	'O' RING	4	4	98	00134	'O' RING	1	1
23	12023	ROLLER	1	1	61	12061	CIRCLIP	1	1	99	12099	WASHER	1	1
24	12024	PUSH WEDGE	1	-	62	12062	BEARING	1	-	100	01526	'O' LABEL (AVDEL ITALY)	1	N/1
25	12025	TIRGGER	1	1	63	12063	PLANET GEAR SPINDLE	1	-	101	12121	'O' RING	1	1
26	12026	PIN	1	1	64	09208	PLANET	3	-	102	12121	PAWL (RUBBER)	1	1
27	12027	VALVE LOCKING PLUG	1	-	65	12065	PLANET GEAR	1	-	103	12103	PLUG	1	1
28	12028	VALVE PISTON	1	-	66	12066	SPACER	1	-	104	12104	SPRING	1	N/1
29	00086	'O' RING	1	1	67	09206	BEARING	1	-	113	12300	DEFLECTOR ASSEMBLY	1	N/1
30	00040	'O' RING	1	1	68	09210	FRONT END PLATE	1	-	114	12700	INLET ASSEMBLY	1	
31	00026	'O' RING	2	2	69	09211	STATOR	1	-	115	00401	SPRING	1	
32	00046	'O' RING	1	1	70	12070	ROTOR	1	-					
33	12033	1/16"NYLON WASHER	4	4	71	09213	ROTOR BLADE	5	5					
34	12034	1/16"SILENCER	1	1	72	09214	PEAR END PLATE	1	-					
35	12035	AIR INLET BLOCK	1	-	73	09215	BEARING	1	-					
36	00029	'O' RING	4	4	74	09216	PIN	1	1					