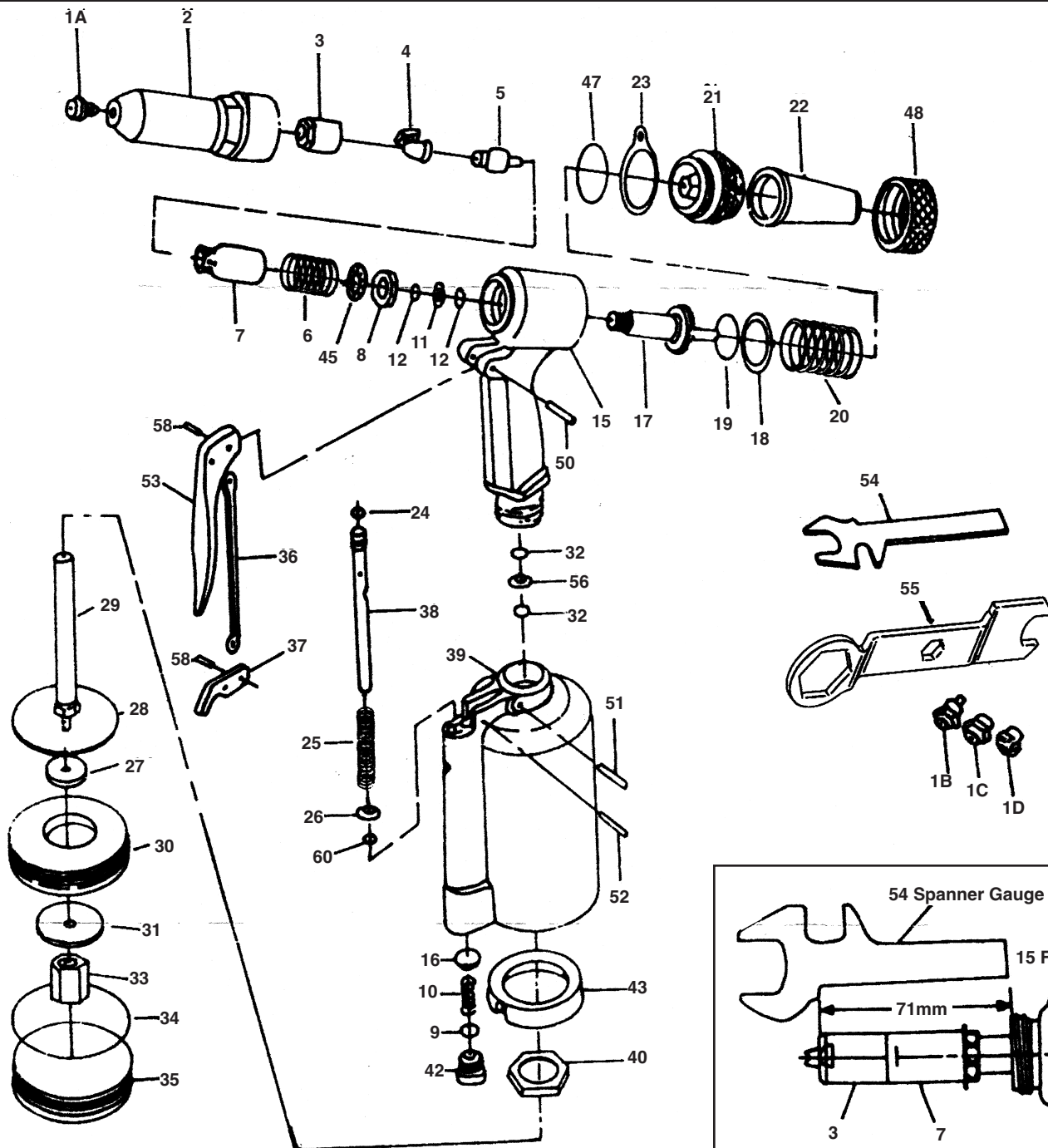


T-7891N 3/16" Heavy Duty Riveter



OILING INSTRUCTIONS: OIL AFTER EACH USE WITH 1 OR 2 TEASPOONS OF AIR TOOL OIL THROUGH THE AIR INLET. RUN FOR ONE SECOND TO COAT ALL INTERNAL PARTS.

FOLLOW INSTRUCTIONS ON BACK OF THIS SHEET TO MAINTAIN FLUID LEVEL IN HYDRAULIC PORTION OF TOOL.

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OPERATING INSTRUCTIONS FOR THE T-7891N RIVET TOOL (RED)



Always disconnect tool from air source before disassembling!!

1. Maintain fluid levels - Use 30 wt. non-detergent oil. Remove #02 with wrench #55. Mount tool in vice with bottom cap #35 up. Then remove #35 with wrench #55. Remove entire piston (part #27, 28, 29, 30, 31, 33) as an assembly, by grasping #33 with a pair of pliers and pulling straight up. After the piston is removed, fill with 30 weight non detergent oil to 1/2" below the #40 nut (no oil should be in the #39 cylinder). Lightly grease #30 and #34. Replace piston and #35 cap, remove tool from the vice then replace #02 with #55 wrench. Now the tool is ready for use. The total amount of oil should be about 2-1/2 tablespoons. A few drops of 30 wt oil or air tool oil through the air inlet every 10 to 15 minutes is recommended if no air line oiler is in place.
2. Adjusting the stroke - Remove #02 by using #55 wrench. For maximum stroke, loosen nut #08 and thread the nut all the way onto #17 piston. Then loosen #03 and #07 and thread them all the way to #08. Hold #08 with a wrench and tighten #3. For a shorter stroke, adjust #08 so that it is away from the shoulder of #17 by two or more threads, depending on how short you want the stroke to be.
3. Always use the correct size nosepiece for the rivet you are using. It is a good idea to use a silicone oil such as WD-40 to lubricate the jaws(#04) when pulling quantities of rivets, as there may be a build up of metal particles that could cause mandrels to stick in the jaws.
4. Air pressure - The maximum pressure should be 90 PSI. A higher pressure could cause damage to your tool. Using the lowest pressure possible for your application will extend the life of your tool dramatically.
5. As with all tools, make sure that all parts are tight from time to time, as vibration from use may loosen components.
6. Mandrels - The T-7891N comes complete with the #22 mandrel catcher. Once a rivet has been popped and the next rivet is mounted in the nosepiece, the last mandrel will slide into the #22. To remove mandrels, turn the tool upside down and they will fall out of the slot in #22, or remove #22 completely and empty.

USE 90 PSI MAXIMUM

Ref #	Part #	Description	Qty.	Ref #	Part #	Description	Qty.
1A	789101AN	3/16" Nosepiece	1	28	789128N3	Large Washer	1
1B	789101BN	5/32" Nosepiece	1	29	789129N3	Air Piston Rod	1
1C	789101CN	1/8" Nosepiece	1	30	789130N3	Air Piston Ring	1
1D	789101DN	3/32" Nosepiece	1	31	789131N3	Medium Washer	1
2	789102N	Frame Head	1	32	789132N	O-Ring	2
3	789103N	Jaw Case	1	33	789133N3	Lock Nut	1
4	789104N	Jaws	1Set(2)	34	789134N	O-Ring	1
5	789105N	Jaw Pusher	1	35	789135N3	Cylinder Cap	1
6	789106N	Jaw Case Spring	1	36	789136N3	Trigger Rod	1
7	789107N	Jaw Case Back	1	37	789137N3	Trigger Lever	1
8	789108N	Case Lock Nut	1	38	789138N3	Valve Pusher	1
9	789109N3	Valve Cap O-Ring	1	39	789139N3	Air Cylinder	1
10	789110N3	Valve Spring	1	40	789140N3	Frame Lock Nut	1
11	789111N	Back Up Ring	1	42	789142N3	Valve Cap	1
12	789112N	O-Ring	2	43	789143N3	Rubber Cushion	1
15	789115N3	Frame	1	45	789145N	Washer Ring	1
16	789116N3	Valve	1	47	789147N	Frame Cap O Ring	1
17	789117N3	Oil Piston	1	48	789148N	Catcher Nut	1
18	789118N	O-Ring	1	50	789150N3	Lever Pin	1
19	789119N	Back Up Ring	1	51	789151N3	Pin	1
20	789120N3	Return Spring	1	52	789152N3	Pin	1
21	789121N3	Frame Cap	1	53	789153N3	Trigger	1
22	789122N	Catcher	1	54	789154N3	Wrench	1
23	789123N	Hanging Clip	1	55	789155N3	Wrench	1
24	789124N3	O-Ring	1	56	789156N	Back Up Ring	1
25	789125N3	Spring	1	58	789158N3	Pin	2
26	789126N3	Valve Seat	1	60	789160N3	O-Ring	1
27	789127N3	Aluminum Washer	1				

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