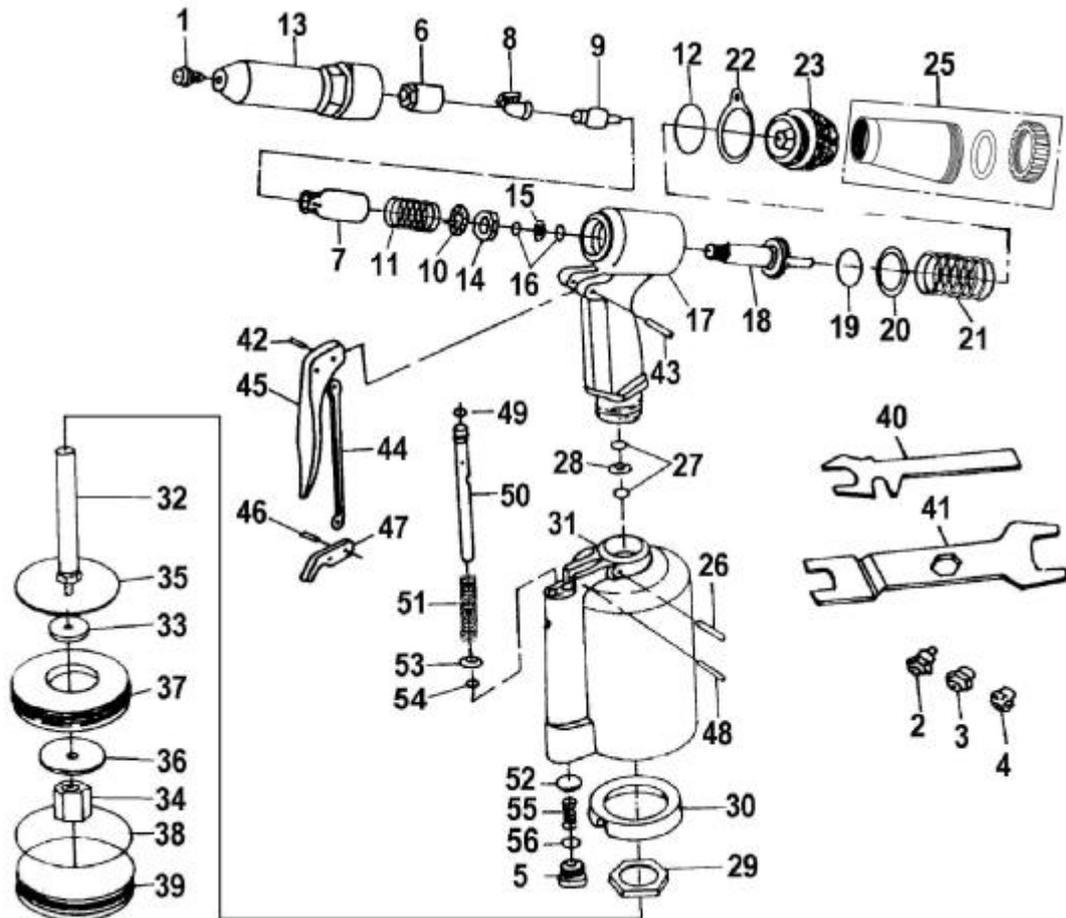




V-2 AIR / HYDRAULIC RIVETER TOOL



Ref. No.	Part No.	Description	Q'ty /Tool	Ref. No.	Part No.	Description	Q'ty /Tool
1	95760	Nosepiece(3/16") (4.8mm)	1	32	95813	Air Piston Stem	1
2	95763	Nosepiece(5/32") (4.5mm)	1	33	95924	Air Piston AI	1
3	95762	Nosepiece(1/8") (3.2mm)	1	34	95925	Air Piston Lock Nut	1
4	95761	Nosepiece(3/32") (2.4mm)	1	35	95926	Air Piston Disc Top	1
5	95910	Valve Cap	1	36	95927	Air Piston Disc Bottom	1
6	95765	Jaw Case Front	1	37	95928	Air Piston Ring	1
7	95771	Jaw Case Rear	1	38	95815	Cylinder O-Ring 67.94x2.62	1
8	95766	Jaw	1set	39	95929	Cylinder Cap	1
9	95767	Jaw Pusher	1	40	95818	Spanner Gague	1
10	95772	Case Washer Ring	1	41	95817	Spanner	1
11	95768	Jaw Pusher Spring	1	42	95930	Trigger Pin	1
12	95780	Frame Cap O-Ring 27x2	1	43	95931	Connector	1
13	95764	Frame Head	1	44	95932	Trigger Rod	1
14	95773	Case Lock Nut	1	45	95933	Trigger	1
15	95775	Back Up Ring	1	46	95934	Connector	1
16	95774	O-Ring 11.8x2.4	2	47	95935	Trigger Lever	1
17	95911	Frame	1	48	95936	Lever Pin	1
18	95912	Oil Piston	1	49	95799	Valve Pusher O-Ring P7	1
19	95778	O-Ring 21.7x3.5	1	50	95937	Valve Pusher	1
20	95913	Back Up Ring	1	51	95938	Valve Spring	1
21	95914	Return Spring	1	52	95939	Valve	1
22	95916	Hanging Clip	1	53	95940	Valve Collar	1
23	95917	Frame Cap	1	54	95941	Collar O-Ring P5	1
25	95755	Safety Cap	1	55	95942	Valve Spring	1
26	95920	Setting Screw Pin	1	56	95943	Valve Cap O-Ring 10.8x2.4	1
27	95848	O-Ring 11.8x2.4	2				
28	95921	Back Up Ring	1	RK	95944	Repair Kit Ref.No. -- 6, 7, 8, 9, 10, 11, 18, 21, 37	
29	95796	Frame Lock Nut	1				
30	95922	Rubber Cushion	1	SK	95945	Service Kit Ref.No.-- 15, 16(x2), 19, 20, 25, 26, 38, 49, 51, 52, 53, 54, 55, 56	
31	95923	Air Cylinder	1				

Safety glasses should be worn at all times while operating tool.

General Information

The Marson ValueRivet™ V-2 pneumatic/ hydraulic riveting tool is designed to set rivets in all materials in sizes from 3/32" to 3/16" diameter. Model V-2 is supplied with 3/16" NOSEPIECE (1) installed in the operating position. Standard nosepieces for 3/32" (4), 1/8" (3) and 5/32" (2) diameter rivets is included among the accessories supplied with the tool.

The Maximum Air Pressure is 95 PSI At Tool.

Specifications

Rivet Setting Capacity	3/16" diameter
Traction power	1940 lbs
Operating air pressure	85-95 PSI
Air consumption	4 CFM
Air Inlet	1/4" N.P.T.
Overall height	11.5"
Net weight	3.0 lbs.

Accessories

The V-2 is packaged in a compartment storage container. Wrenches needed to service the tool are included. Special SPANNER GAUGE (40) has a cut-out gauge used in adjusting the tool as described below.

Also included: Safety Cap (25) to catch ejected mandrels when attached to the back of the tool.

Maintenance

In order to achieve maximum efficiency and economy, the Marson V-2 pneumatic/hydraulic riveting tool should be serviced and maintained on a regular basis. No special skills or tools other than the ones provided are needed to properly service and maintain the device.

The operative parts of the tools requiring regular inspection and maintenance are as follows:

1. The JAWS (8) should be periodically inspected, cleaned, and when necessary, replaced with new jaws (see Cleaning and Changing Jaws under Procedures below).
2. The FRAME (17) of the tool should be checked periodically to ensure that the oil level is maintained and that there are no leaks or breakdowns in the seals. (See Repair sections under Malfunction for procedures).

Maintenance Procedures

1. Cleaning and Changing Jaws

IMPORTANT – Disconnect the V-2 from the air pressure line before proceeding with inspection or repairs. Use SPANNER (41) to remove FRAME HEAD (13). Use SPANNER GAUGE (40) to remove JAW CASE FRONT (6) while at the same time holding the JAW CASE REAR (7) with the SPANNER (41) open-end wrench. Clean jaws with solvent or a steel brush. Replace with new jaws if excess wear is apparent. Always coat outer or smooth surface of jaws with an oil film before assembling.

Reassemble by reversing order of above procedure. It is important that JAW PUSHER (3) engages the conical parts of the JAWS. **DO NOT CHANGE THE POSITION OF PARTS (7) and (14).** If these parts are inadvertently changed, see readjustment instructions under "Malfunction."

2. Changing Nosepiece

Connect V-2 to air pressure and press TRIGGER (45) until nosepiece has been removed and new nosepiece fully tightened. When TRIGGER (45) has been released and tool is at rest there should be a circular opening visible in the nosepiece.

Malfunction

1. Mandrel gripped by JAWS (6) but rivet does not set and mandrel does not break:

CAUSE: Low air pressure or loss of oil.

REPAIR: Increase air pressure but do not exceed 100 PSI at tool. Make sure all fittings including FRAME CAP (23) and FRAME HEAD (13) are tight. If malfunction persists, add oil as follows:

Disassemble AIR CYLINDER (31), FRAME (17) and FRAME HEAD (13). Before adding oil, check to be sure OIL PISTON (18) is at the bottom of its stroke, by hand pulling JAW CASE FRONT (6) away from FRAME (17). OIL PISTON (18) should bottom its stroke automatically when removing FRAME HEAD (13). If JAW CASE FRONT (6) moves downward by hand power, then RETURN SPRING (21) must be replaced. Care must be exercised to avoid damage to O-RINGS (15, 16). Pour MARSON OIL No. 39105 or equivalent into FRAME (17) while tool is upside down. Before assembling also check for oil appearing in AIR CYLINDER (31) or FRAME HEAD (13). If oil is found in any of these areas, replace O-RING (15, 16, 27, 28) as needed. Reassemble tool.

2. Mandrel does not enter nosepiece OR fails to eject.

CAUSE: JAW CASE REAR (7) and NUT (14) have changed position.

REPAIR: Adjust so that the distance between the plane underside of the FRAME (17) and the front edge of the securely-assembled JAW CASE FRONT (6) is approximately 2 -13/16". This can be measured with the cut-out gauge on SPANNER GAUGE (40) before assembling FRAME HEAD (13).

3. Tool takes more than one stroke under ideal conditions to set rivet and break mandrel.

CAUSE: Insufficient oil.

REPAIR: See repair instructions under Malfunction, 1.

CAUSE: Not enough air pressure.

REPAIR: Increase air pressure but do not exceed 95 PSI at tool.

CAUSE: Loose nosepiece.

REPAIR: Tighten nosepiece with SPANNER (41).

CAUSE: JAW CASE REAR (7) too far forward.



Rivets, inserts & setting tools

REPAIR: See procedure under Section 2 above.

**44 Campanelli Pkwy.
Stoughton, MA. 02072
Tel. (800) 344-9664
Fax (800) 644-2177**