

# Accessories Instruction Manual



**ProSet® XT3 Blind Rivet Tool – 76003**

**ProSet® XT4 Blind Rivet Tool – 76004**

# Hydro-Pneumatic Power Tool

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This instruction manual must be read by any person installing or operating this tool with particular attention to the following safety rules.

## 1. SAFETY DEFINITIONS

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.



**DANGER:** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.



**WARNING:** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



**CAUTION:** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

**CAUTION:** Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

**Improper operation or maintenance of this product could result in serious injury and property damage. Read and understand all warnings and operating instructions before using this equipment. When using power tools, basic safety precautions must always be followed to reduce the risk of personal injury.**

### SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE.

#### WARNING:

1. Do not use outside the design intent.
2. Use only parts, fasteners, and accessories recommended by the manufacturer.
3. Do not modify the tool in any way. Any modification undertaken by the customer to the tool, nose assemblies, accessories or any equipment supplied shall be the customer's entire responsibility.
4. The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained competent personnel. Any dismantling procedure will be undertaken only by trained personnel. Do not dismantle this tool without prior reference to the maintenance instructions.
5. The precautions to be observed when using this tool must be explained by the customer to all operators.
6. Always fully disconnect the tool from the hydraulic pump unit before attempting to adjust, remove or fit the nose assembly.
7. Do not operate a tool that is directed towards any person(s) or the operator.
8. Always adopt a firm footing or a stable position before operating the tool.
9. The operating pressure shall not exceed 550bar (8,000 PSI).
10. Operators and others in work area must wear approved safety glasses with side shields. Always wear safety glasses and ear protection during operation.
11. Take care to avoid entanglement of loose clothes, ties, long hair, cleaning rags etc. in the moving parts of the tool which should be kept dry and clean for best possible grip.
12. Do not operate the tool if it is not fitted with a complete nose assembly.
13. Care shall be taken to ensure that spent stems are not allowed to create a hazard.
14. The flexible pintail deflector must always be attached to the tool and in good condition. The deflector must be aimed away from the user and in a safe direction away from hazard.
15. When carrying the tool from place to place keep hands away from the trigger/lever to avoid inadvertent start up.
16. Keep tool handles dry, clean and free from oil and grease.
17. Do not fit flexible hoses rated at less than 700bar (10,000 PSI) working pressure.
18. Avoid damaging hydraulic hoses. Avoid sharp bends and kinks when routing hydraulic hoses. Using a bent or kinked hose will cause severe back-pressure. Sharp bends and kinks will internally damage the hose leading to premature hose failure.
19. Do not drop heavy objects on hoses. A sharp impact may cause internal damage to hose wire strands and lead to premature hose failure.
20. Do not lift the placing tool by the hoses. Always use the placing tool handle.

21. Do not pull or move the hydraulic pump unit using the hoses. Always use the pump unit handle or roll cage.
22. Contact with hydraulic fluid should be avoided. To minimise the possibility of rashes, care should be taken to wash thoroughly if contact occurs.
23. Never leave operating tool unattended. Turn off hydraulic unit when tool is not in use.
24. Do not abuse the tool by dropping or using it as a hammer.
25. Ensure that there is adequate clearance for the tool operator's hands before proceeding.
26. Keep dirt and foreign matter out of the hydraulic system of the tool as this will cause the tool to malfunction.
27. It is recommended that only Enerpac® hydraulic pump units are to be used to drive the installation tool as other makes of hydraulic power units may not operate at the safe designed working pressures.
28. C.O.S.H.H (Control of Substances Hazardous to Health Regulation) data for all hydraulic oils and lubricants is available on request from your tool supplier
29. The machine shall at all times be operated in accordance with relevant Health & Safety legislation. In the UK the "Health & Safety at Work etc. Act 1974" applies. Any question regarding the correct operation of the machine must be directed to STANLEY Engineered Fastening.

**STANLEY Engineered Fastening policy  
is one of continuous product development and improvement  
and we reserve the right to change the specification  
of any product without prior notice.**

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## **2. SAFETY RULES**

**This technical datasheet must be read with particular attention to the safety warnings and operating instructions listed in the ProSet XT3 and ProSet XT4 Instruction Manual, by any person fitting or operating the nose assemblies and hand tools.**

## **3. INTENT OF USE**

The accessories in combination with the ProSet XT3 and ProSet XT4 tools are designed for placing Stanley Engineered Fastening blind rivets only.

## 4. STRAIGHT & RIGHT ANGLED SWIVEL HEAD NOSE ASSEMBLIES

Swivel Heads are supplied separately for fitting to a base tool. Jaws and nose tips vary depending on the rivet to be placed, but all other components remain the same within each type of swivel head. Refer to the rivet capability tables 1 below and table 2 on page 6 to select the correct swivel assembly for the rivet to be placed. For the Constant components refer to table 3 on page 10.

Dimensions 'A' and 'B' in Tables 1 & 2 and fig. 1, 2, 3 and 4 will help assess the accessibility of the application.

**Table 1 - STRAIGHT SWIVEL HEAD Capability**

RIVET TYPE	RIVET DIAMETER		RIVET MATERIAL	SWIVEL HEAD	NOSE TIP	DIMENSIONS		JAWS
						A	B	
AVEX	3,2	1/8	AL. ALLOY	76003-06000	07345-03600	7,87	3,81	07340-00213
	3,2	1/8	STEEL	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	AL. ALLOY	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	STEEL	76003-06200	07345-03800	7,87	3,81	07490-04602
	4,8	3/16	AL. ALLOY	76003-06200	07345-03800	7,87	3,81	07490-04602
BULBEX	4,0	5/32	AL. ALLOY	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,8	3/16	AL. ALLOY	76003-06200	07345-03800	7,87	3,81	07490-04602
AVINOX	3,2	1/8	ST. STEEL	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	ST. STEEL	76003-06200	07345-03800	7,87	3,81	07490-04602
AVSEAL II	4,0	-	AL. ALLOY	76003-06300	71213-16401	6,35	1,95	07340-00213
	4,0	-	AL. ALLOY	76003-06400	71213-16402	6,35	4,11	07340-00213
	5,0	-	AL. ALLOY	76003-06500	71213-16403	7,62	2,00	07340-00213
	5,0	-	AL. ALLOY	76003-06600	71213-16404	7,62	4,11	07340-00213
STAVEX	3,2	1/8	STEEL	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	STEEL	76003-06200	07345-03800	7,87	3,81	07490-04602
	3,2	1/8	ST. STEEL	76003-06100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	ST. STEEL	76003-06200	07345-03800	7,87	3,81	07490-04602

Fig. 1

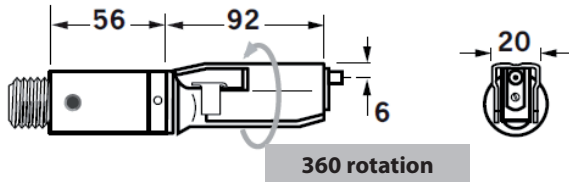
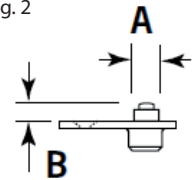
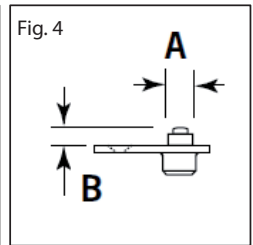
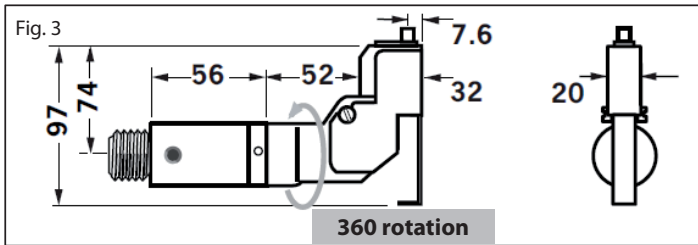


Fig. 2



**Table 2 - RIGHT-ANGLE SWIVEL HEAD Capability**

RIVET TYPE	RIVET DIAMETER		RIVET MATERIAL	SWIVEL HEAD	NOSE TIP	DIMENSIONS		JAWS
						A	B	
AVEX	3,2	1/8	AL. ALLOY	76003-07000	07345-03600	7,87	3,81	07340-00213
	3,2	1/8	STEEL	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	AL. ALLOY	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	STEEL	76003-07200	07345-03800	7,87	3,81	07490-04602
	4,8	3/16	AL. ALLOY	76003-07200	07345-03800	7,87	3,81	07490-04602
BULBEX	4,0	5/32	AL. ALLOY	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,8	3/16	AL. ALLOY	76003-07200	07345-03800	7,87	3,81	07490-04602
AVINOX	3,2	1/8	ST. STEEL	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	ST. STEEL	76003-07200	07345-03800	7,87	3,81	07490-04602
AVSEAL II	4,0	-	AL. ALLOY	76003-07300	71213-16401	6,35	1,95	07340-00213
	4,0	-	AL. ALLOY	76003-07400	71213-16402	6,35	4,11	07340-00213
	5,0	-	AL. ALLOY	76003-07500	71213-16403	7,62	2,00	07340-00213
	5,0	-	AL. ALLOY	76003-07600	71213-16404	7,62	4,11	07340-00213
STAVEX	3,2	1/8	STEEL	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	STEEL	76003-07200	07345-03800	7,87	3,81	07490-04602
	3,2	1/8	ST. STEEL	76003-07100	07345-03700	7,87	3,81	07340-00213
	4,0	5/32	ST. STEEL	76003-07200	07345-03800	7,87	3,81	07490-04602



**PREPARING THE BASE TOOL TO ACCEPT SWIVEL HEAD EQUIPMENT**

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE SWIVEL HEAD NOSE ASSEMBLIES.**

Refer to fig. 5 and fig. 6 and the table on page 10.

- The air supply must be disconnected.
- Rotate the Stem Collector (76003-05200) anti-clockwise and remove from the Collector Adapter (76003-05104).
- Unscrew and remove the Deflector Retaining Nut (76003-05102) together with the Stem Deflector (76003-05101).
- Place the Collector Adapter Cover (27) over the Collector Adapter (76003-05104) and then install Safety Cap (26) until the end face of the Collector Adapter Cover (27) is secure against the mating face of the Collector Adapter (76003-05104).
- If necessary, remove the complete Nose Assembly (76003-15000) as described on page 9 of the Proset XT3 and Proset XT4 instruction manual.
- Remove Locknut (71210-02103) and Seal Housing (71210-02104).

- Attach the Stop Nut (**25**) onto the tool piston as far as it will go by hand.
- Fit the Jaw Spreader Housing (**24**) fully onto the tool piston and then tighten the Stop Nut (**25**) against the Jaw Spreader Housing (**24**).
- The tool is now ready to be fitted with a swivel head.

Item numbers in **bold** refer to fig. 3 and fig. 4 and the table on page 10.

Fig. 5

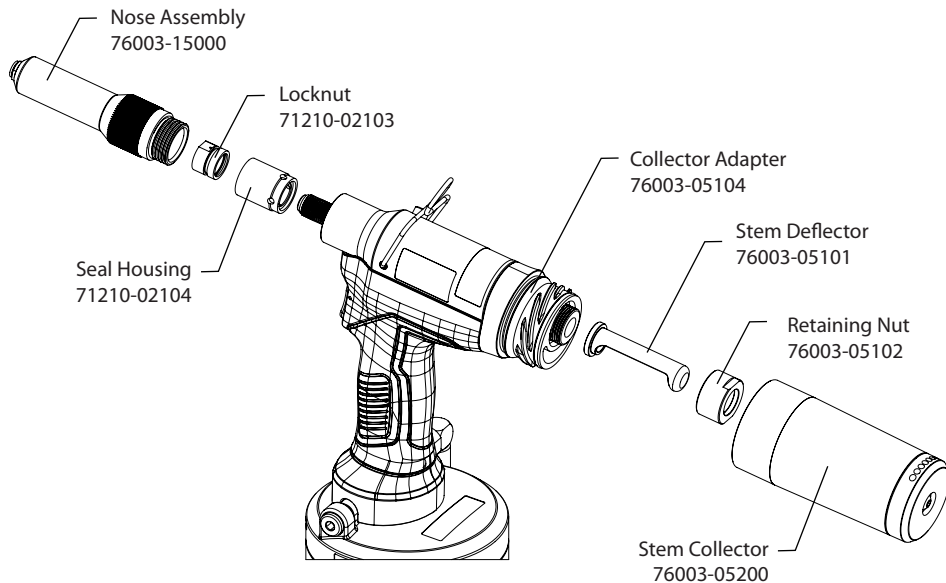
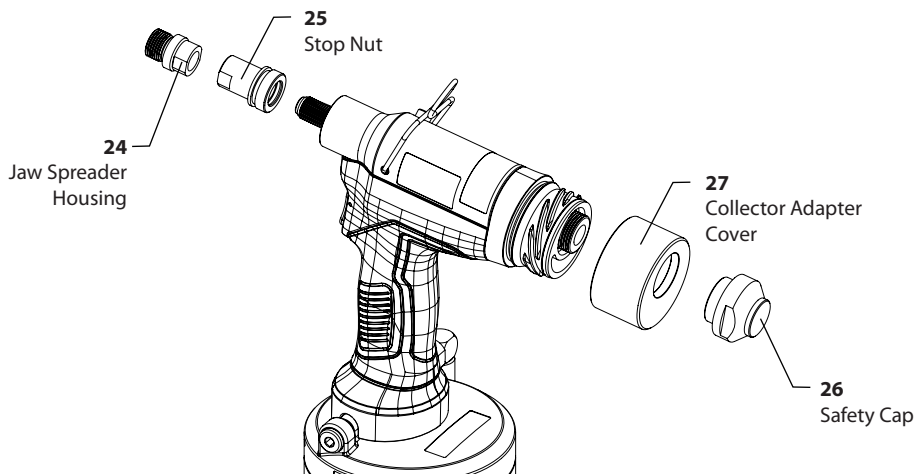


Fig. 6



## SWIVEL HEAD FITTING INSTRUCTIONS

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

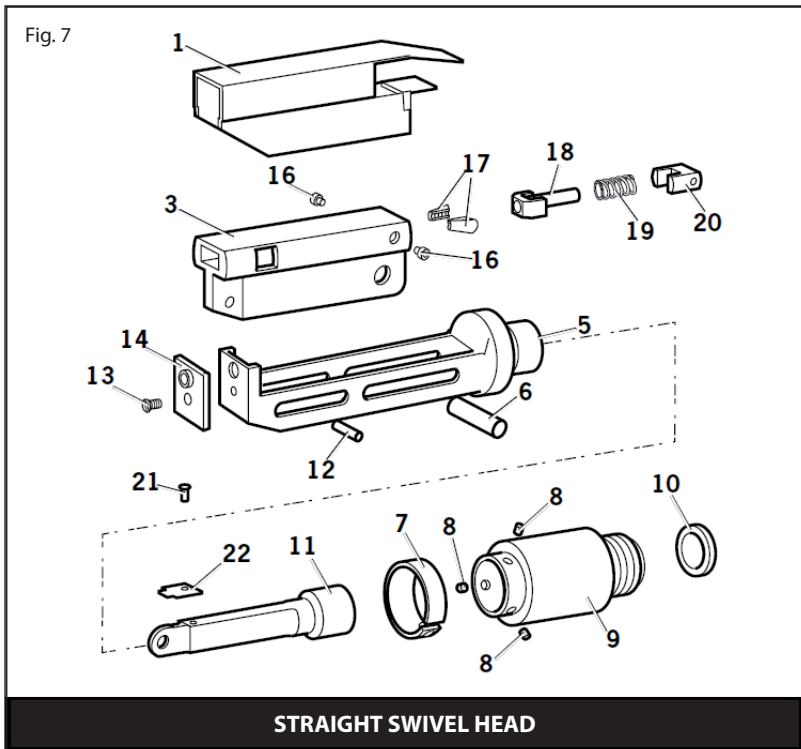
**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE SWIVEL HEAD NOSE ASSEMBLIES.**

The following procedure will allow you to assemble and fit either of the swivel heads to the tool. If you order a complete swivel head rather than individual components, you will only need to start at step 'L'

All moving parts should be lubricated. Unless stated otherwise use Moly Lithium grease. Text highlighted in grey tint refer only to the right-angle swivel head fitting instructions.

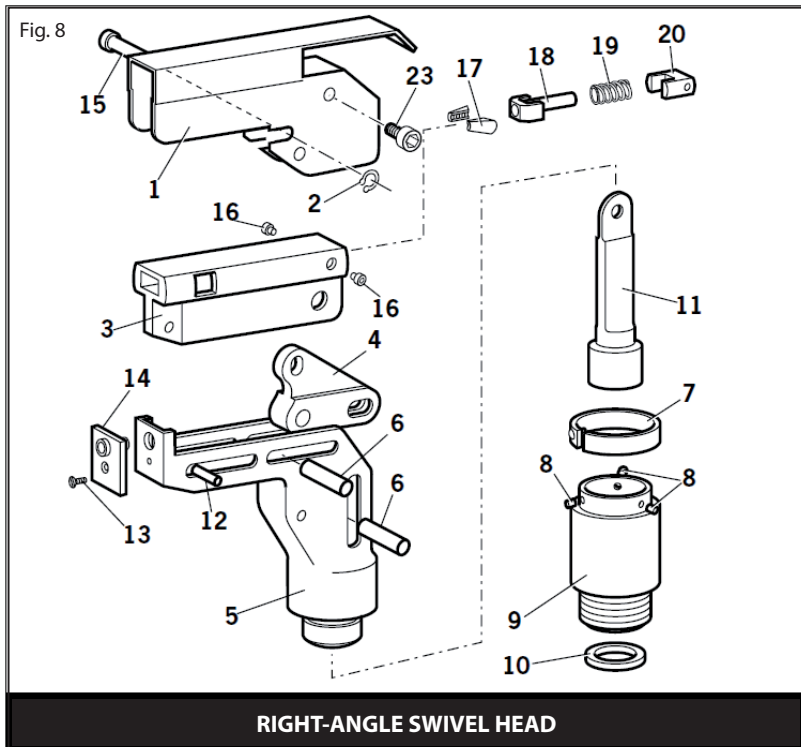
Item numbers in **bold** refer to the components in figures 7 and 8 and the table on page 10.

Note: Nose Tips (**14**) Jaws (**17**) vary to suit specific rivet. Refer to the table 1 and Table 2 to select the correct nose tip for the rivet being installed.





- A. Fit Locking Ring 10 over Jaw Spreader Housing (24).
- B. Coat Screw (13) with thread locking adhesive and use to secure Nose Tip (14) onto Body (5).
- C. Lightly lubricate items (17), (18), (19), (20) and insert into Jaw Carrier (3) as shown. Secure with Screws (16).
- D. Position Lever (4) into Body (5) and hold in place with pin (15) through the hole of Body (5) (not a slot).
- E. Lubricate the sides of the Jaw Carrier Assembly and insert into Body (5).
- F. Lubricate Rollers (8) and ENSURE that they will freely rotate in the holes of Adaptor (9). If necessary ream the holes.
- G. Position Spring Clip (7) over Adaptor (9) past the holes for the rollers and rotate until the locating peg is aligned with the corresponding hole in Adaptor (9) (smallest hole).
- H. Fit Adaptor (9) over the end of Body (5) and drop Rollers (8) into place. Push Spring Clip (7) over Rollers (8).
- I. Insert Spindle (11) through Adaptor (9) into Jaw Carrier (3) until the hole lines up with slot in Body (5). Temporarily hold in place with Pin (6).
- J. Insert Pin (12) through the front slot of Body (5) into Jaw Carrier (3).
- K. Hold the assembly vertical to prevent all pins dropping out and slide the jaw carrier assembly back and forth a few times to ensure free movement. Go to M.
- L. Remove Screws (23) (4 off) and Guard (1). On a straight swivel head also remove Screw (21) and Platform (22).
- M. Push Pin(s) (6) out and let Spindle (11) drop out. Screw Spindle (11) onto the Jaw Spreader Housing (24), leaving the small screw fixing hole uppermost for straight swivel. Tighten gently with a tommy bar.
- N. Screw the assembly over Spindle (11) onto the tool. Replace Pin(s) (6).
- O. On straight swivel heads attach Platform (22) onto the top of the Spindle (11) with Screw (21). Deburr the back end of Platform (22) so that it cannot catch on Guard (1).
- P. Snap Guard (1) over the assembly, align screw holes in guard with tapped holes in body assembly.
- Q. Insert Pivot Pin (15) through slots in guard and hole in body. Fit Circlip (2) onto pivot pin so that the circlip seats in groove provided.
- R. Coat the thread of Screws (23) (4 off) with thread locking adhesive and screw into body assembly securing guard to body assembly.



**Table 3 - PARTS LIST - STRAIGHT & RIGHT ANGLED SWIVEL HEAD**

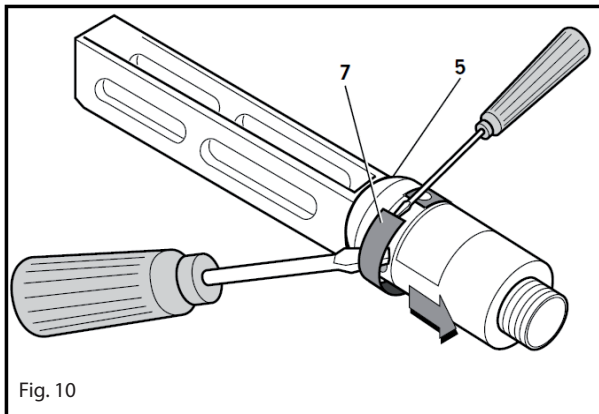
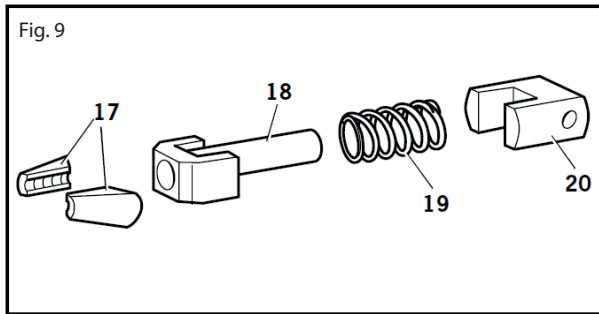
Item	Description	STRAIGHT SWIVEL	RIGHT ANGLED SWIVEL
<b>1</b>	Guard	07494-05000	07494-05000
<b>2</b>	Circlip	-	07004-00105
<b>3</b>	Jaw Carrier	07494-03026	07494-03026
<b>4</b>	Lever	-	07495-03004
<b>5</b>	Body	07494-03015	07494-03015
<b>6</b>	Pivot Pin	07343-02207	07343-02207
<b>7</b>	Spring Clip	07495-03900	07495-03900
<b>8</b>	Roller	07007-00039	07007-00039
<b>9</b>	Adapter	07345-03001	07345-03001
<b>10</b>	Locking Ring	07345-03003	07345-03003
<b>11</b>	Spindle	07345-03002	07345-03002
<b>12</b>	Dowel Pin	07007-00038	07007-00038
<b>13</b>	Screw	07342-02207	07342-02207
<b>14</b>	Nose Tip	See Table 1	See Table 2
<b>15</b>	Pivot Pin	-	07346-03102
<b>16</b>	Screw	07494-03028	07494-03028
<b>17</b>	Jaws	See Table 1	See Table 2
<b>18</b>	Jaw Spreader	07346-03101	07346-03101
<b>19</b>	Spring	07615-00305	07615-00305
<b>20</b>	Spring Guide	07494-03027	07494-03027
<b>21</b>	Screw	07001-00368	07001-00368
<b>22</b>	Platform	07345-00401	07345-00401
<b>23</b>	Screw	-	07210-00804
<b>24</b>	Jaw Spreader Housing	76003-06001	76003-06001
<b>25</b>	Stop Nut	71213-20202	71213-20202
<b>26</b>	Safety Cap	76003-06002	76003-06002
<b>27</b>	Collector Adapter Cover	76003-20103	76003-20103

## SWIVEL HEAD SERVICING INSTRUCTIONS

Swivel heads should be serviced at weekly intervals.

- Remove the complete head using the reverse procedure to the 'Fitting instructions' omitting step 'L'.
- If Guard (**1**) is at all damaged it must be replaced by a new one.
- Any worn or damaged parts should be replaced.
- Pay particular attention to jaw carrier items in the upper illustration opposite as follows:
- Check wear on Jaws (**17**).
- Check that Jaw Spreader Tube (**18**) is not distorted.
- Check that Spring (**19**) is neither broken or distorted.
- Check that Spring Guide (**20**) is not damaged.
- Check that Spring clip (**7**) is not distorted. When removing Spring Clip (**7**), use two screwdrivers as shown in the lower illustration opposite.
- Check for excessive wear on slots of Body (**5**).
- Assemble according to fitting instructions.

Item numbers in bold refer to Swivel Head illustrations fig. 9 and fig. 10 on page 11. Guard (**1**) refers to fig. 7 and fig. 8 on page 8 and 9 and the table on page 10.



## 5. PIN TAIL DEFLECTOR KIT

The Pin Tail deflector is a very simple alternative to the standard stem collector and allows access in restricted areas. To replace the stem collector with the stem deflector proceed as follows:

### PREPARING THE BASE TOOL TO ACCEPT THE PIN TAIL DEFLECTOR KIT

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

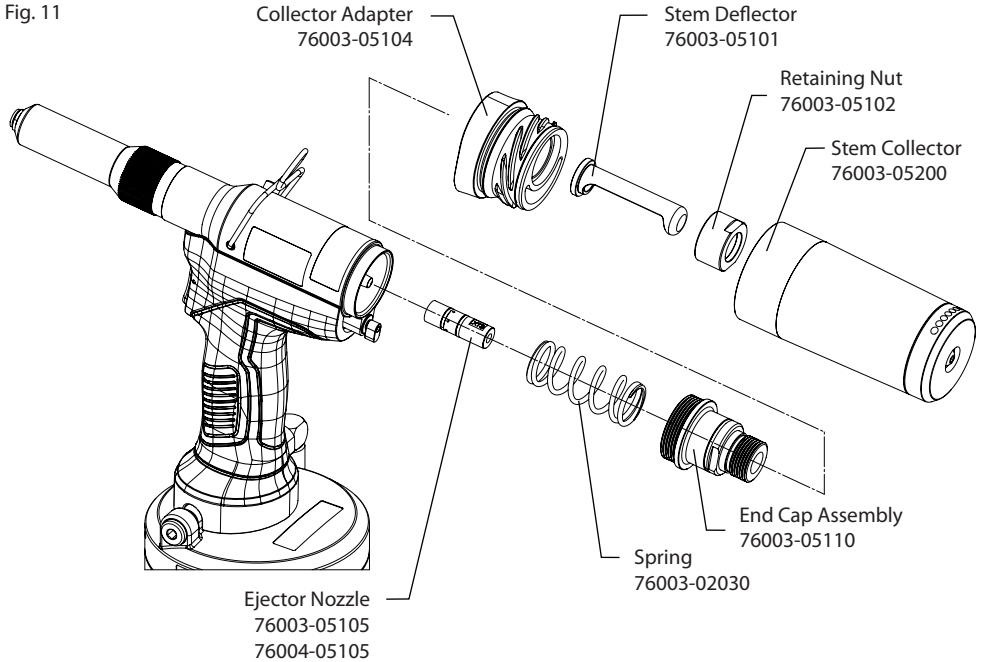
**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE PIN TAIL DEFLECTOR KIT.**

Refer to fig.11 and the table 4 on page 12. Refer also to the Proset XT3 and Proset XT4 Service Manuals 07900-09410 and 07900-09411.

- Operate the tool so that the Piston (76003-02120 or 76004-02120) moves to the fully rear position.
- Continue to depress the trigger, then turn off the air supply to the tool using the On/Off Valve (76003-03700). The Piston Assembly will then stop in the fully rear position.
- The air supply must be disconnected.
- Rotate Stem Collector (76003-05200) anti-clockwise and remove from the Collector Adapter (76003-05104).
- Unscrew and remove the Deflector Retaining Nut (76003-05102) and the Stem Deflector (76003-05101).
- Remove the Collector Adapter (76003-05104), including O Ring (07003-00530).

- Unscrew and remove the End Cap Assembly (76003-05110), including O Ring (07003-00508). Observe caution when removing the End Cap Assembly (76003-05110) as it will be subjected to a compressive force from Spring (76003-02030).
- Remove Spring (76003-02030).
- If vacuum extraction is not required when using the Pin Tail Deflector, unscrew and remove the Ejector Nozzle (76003-05105 / 76004-05105) from the Piston (76003-02120 or 76003-02120).

Fig. 11



**FITTING THE PIN TAIL DEFLECTOR KIT**

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

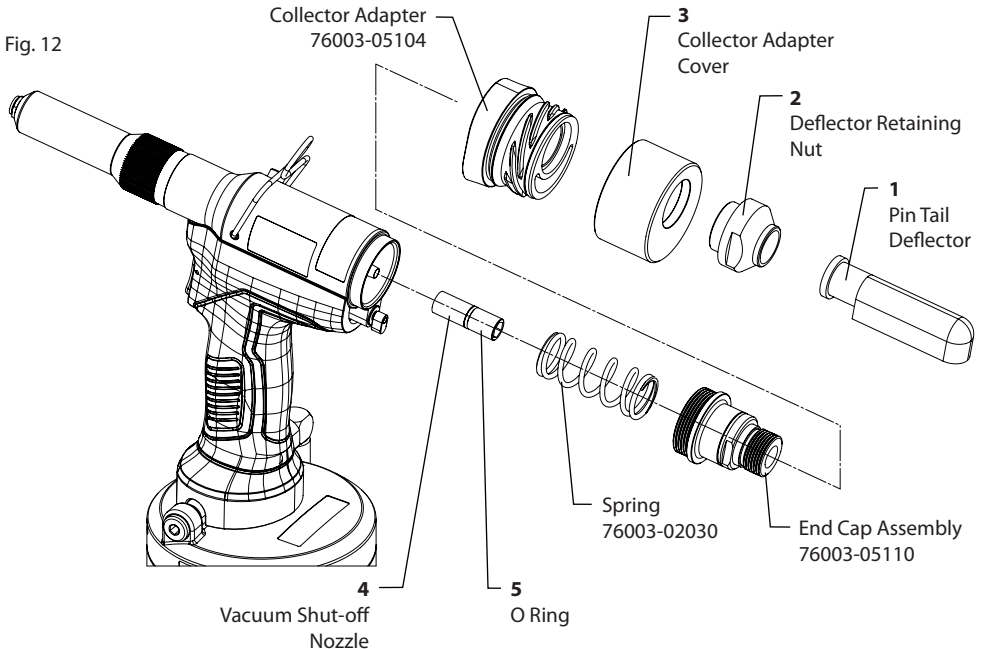
**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE PIN TAIL DEFLECTOR KIT.**

Refer to fig. 12 and the table 4 on below. Refer also to the Proset XT3 and Proset XT4 Service Manuals 07900-09410 and 07900-09411.

Item numbers in **bold** refer to fig. 12 and table 4.

<b>Table 4 - PARTS LIST - PIN TAIL DEFLECTOR KIT</b>			
<b>Item</b>	<b>Part Number</b>	<b>Description</b>	<b>Qty</b>
1	76003-20101	Pin Tail Deflector	1
2	76003-20102	Deflector Retaining Nut	1
3	76003-20103	Collector Adapter Cover	1
4	76003-20104	Vacuum Shut-off Nozzle	1
5	07003-00511	O Ring	1

- The air supply must be disconnected.
- If vacuum extraction is not required when using the Pin Tail Deflector, attach the Vacuum Shut-off Nozzle (4) to the Piston (76003-02120 or 76004-02120).
- Install the Spring (76003-02030).
- Attach the End Cap Assembly (76003-05110), including O Ring (07003-00508).
- Assemble the Collector Adapter (76003-05104), including O Ring (07003-00530).
- Place the Collector Adapter Cover (3) over the Collector Adapter (76003-05104).
- Insert the Pin Tail Deflector (1) into the Deflector Retaining Nut (2) so that the flange on the PinTail Deflector (1) sits within the internal groove of the Deflector Retaining Nut (2).
- Install Deflector Retaining Nut (2), together with the Pin Tail Deflector (1), on the End Cap Assembly (76003-05110). Ensure the end face of the Collector Adapter Cover (3) is secure against the mating face of the Collector Adapter (76003-05104).



## 6. NOSE EXTENSION KITS

Nose Extension Kits are supplied separately for fitting to a base tool. Attached between the tool and the nose assembly the extension allows access into deep channels. Refer to Table 5 below to select the correct Nose Extension Kit for the Nose Assembly being used.

Table 5 - NOSE EXTENSION KITS - Compatibility			
Part Number	Description	Compatible Nose Assemblies	
		Part Number	Description
76003-20200	Nose Extension Assembly XT3 (Standard)	76003-15000	Standard Nose Assembly - Proset XT3 & XT4 Tools
		76003-16000	Avdel Universal Nose Assembly - Proset XT3 & XT4 Tools
		76003-16100	Avseal II Nose Assembly - Proset XT3 & XT4 Tools
		76003-16200	Avseal II Nose Assembly - Proset XT3 & XT4 Tools
		76003-16300	1/4" Hemlok Nose Assembly - Proset XT3 & XT4 Tools
		76003-16400	Avinox XT & Avibulb XT Nose Assembly - Proset XT3 & XT4 Tools
		76004-16100	Avseal II Nose Assembly - Proset XT3 & XT4 Tools
76003-20300	Nose Extension Assembly XT3 (nGenesis Equipment)	71210-15000	Universal Nose Assembly for Genesis G2 tool
		71210-15200	Extended Nose Assembly for Genesis G2 tool
		71230-15800	Nose Assembly - 1/4" Hemlok
		71233-15000	Nose Assembly - 1/4" Avibulb XT & 1/4" Avinox XT
71230-20300	Standard Extension for Maxlok	76004-15100	3/16" Maxlok Nose Equipment
		76004-15200	1/4" Maxlok Nose Equipment

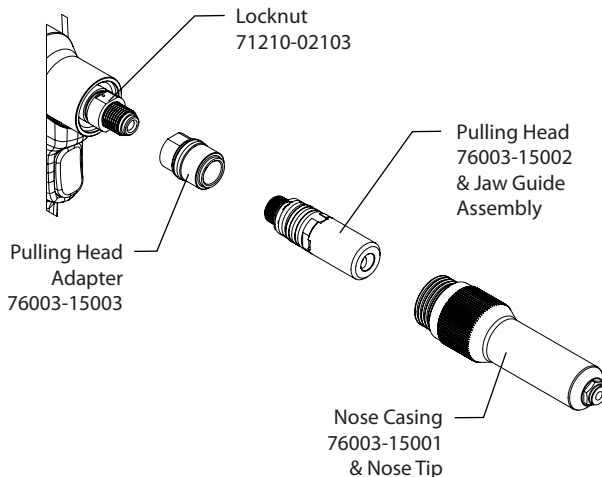
### PREPARING THE BASE TOOL TO ACCEPT NOSE EXTENSION ASSEMBLY 76003-20200

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE EXTENSION KITS.**

Refer to fig. 13.

Fig. 13



- The air supply must be disconnected.
- Unscrew the Nose Casing (76003-15001), including the Nose Piece, and O Ring.
- Using spanners, separate and remove the Pulling Head (76003-15002) and Jaw Guide Assembly from the Pulling Head Adapter (76003-15003).
- Using spanners, then unscrew the Pulling Head Adapter (76003-15003) from the tool piston.

#### FITTING THE NOSE EXTENSION ASSEMBLY 76003-20200

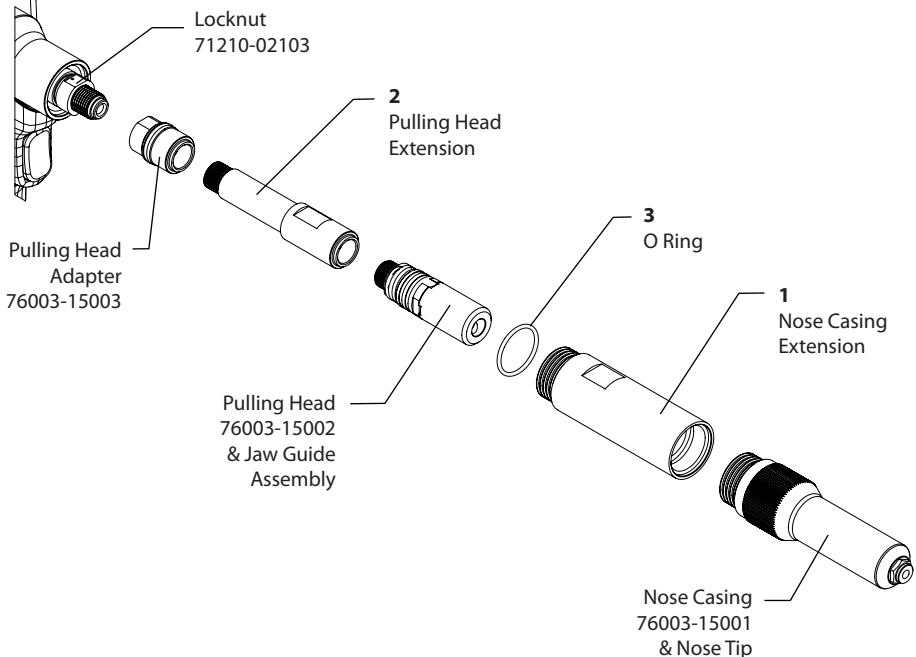
**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE EXTENSION KITS.**

Refer to fig. 14 and Table 6.

Table 6 - PARTS LIST - NOSE EXTENSION ASSEMBLY 76003-20200			
Item	Part Number	Description	Qty
1	76003-20202	Nose Casing Extension - XT3	1
2	76003-20201	Pulling Head Extension	1
3	07003-00067	O Ring	1

Fig. 14



- The air supply must be disconnected.
- Install the Pulling Head Adapter (76003-15003) fully onto the tool piston and then tighten the locknut (71210-02103) against it.
- Apply Loctite 243 to the mating threads of the Pulling Head Adapter (76003-15003) and the Pulling Head Extension (2).

- Attach the Pulling Head Extension (2) to the Pulling Head Adapter (76003-15003) and tighten with spanners.
- Apply Loctite 243 to the mating threads of the Pulling Head Extension (2) and the Pulling Head (76003-15002).
- Attach the Pulling Head (76003-15002) and Jaw Guide Assembly to the Pulling Head Extension (2) and tighten with spanners.
- Place O Ring (3) over the threads on the Nose Casing Extension (1).
- Place Nose Casing Extension (1) over the Pulling Head (76003-15002), Jaw Guide Assembly and Pulling Head Extension (2) and tighten fully onto the tool.
- Place Nose Casing (76003-15001) and Nose Tip over the jaw guide and tighten fully onto the Nose Casing Extension (1).

**PREPARING THE BASE TOOL TO ACCEPT NOSE EXTENSION ASSEMBLY 76003-20300 & 71230-20300**

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE SWIVEL HEAD NOSE ASSEMBLIES.**

- The air supply must be disconnected.
- Remove the complete Nose Assembly (76003-15000) as described on page 9 of the Proset XT3 and Proset XT4 instruction manual.

**FITTING THE NOSE EXTENSION ASSEMBLY 76003-20300 & 71230-20300**

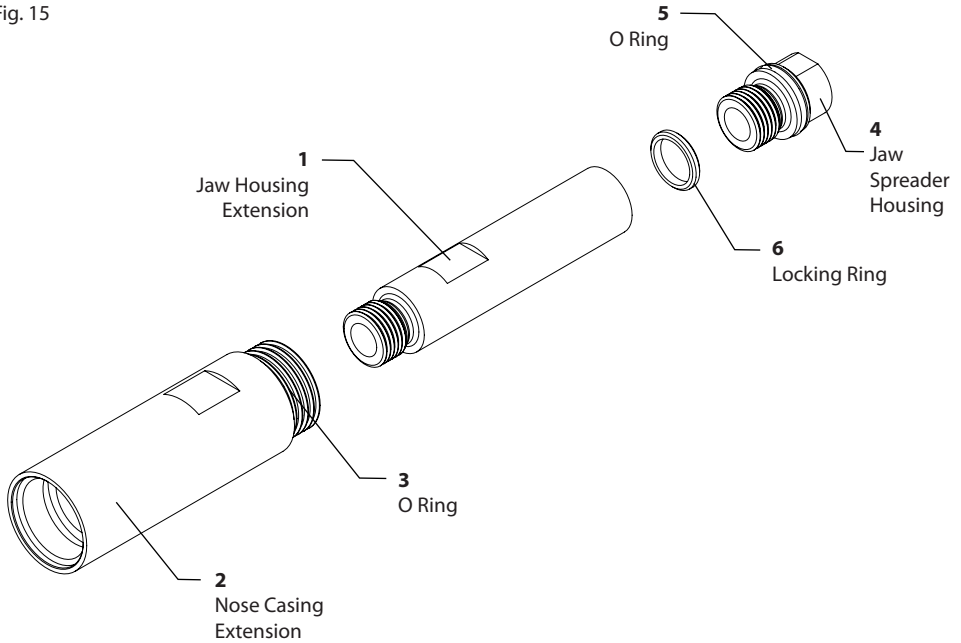
**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE NOSE EXTENSION KITS.**

Refer to fig. 15 and Tables 7 and 8.



Fig. 15


**Table 7 - PARTS LIST - NOSE EXTENSION ASSEMBLY  
76003-20300**

Item	Part Number	Description	Qty
1	71210-20301	Jaw Housing Extension	1
2	76003-20202	Nose Casing Extension - XT3	1
3	07003-00277	O Ring	1
4	71210-02101	Jaw Spreader Housing	1
5	07003-00067	O Ring	1
6	07340-00327	Locking Ring	1

**Table 8 - PARTS LIST - NOSE EXTENSION ASSEMBLY  
71230-20300**

Item	Part Number	Description	Qty
1	71230-20301	Jaw Housing Extension	1
2	71210-20302	Nose Casing Extension	1

**To fit Nose Extension Assembly 76003-20300**

- Remove any nose assembly components.
- Install the Jaw Spreader Housing (4) and O ring (5) fully onto the tool piston and then tighten the locknut (71210-02103) against it.
- Fit the Locking Ring (6) over the Jaw Spreader Housing (4) thread.
- Attach the Jaw Housing Extension (1) to the Jaw Spreader Housing (4) and tighten with spanners.
- Place Nose Casing Extension (2) over the Jaw Housing Extension (1) and tighten fully onto the tool.
- Fit the nose assembly onto the Jaw Housing Extension (1) and Nose Casing Extension (2).

**To fit Nose Extension Assembly 71230-20300**

- Remove any nose assembly components.
- Attach the Jaw Housing Extension (1) to the Jaw Spreader Housing (4) and tighten with spanners.
- Place Nose Casing Extension (2) over the Jaw Housing Extension (1) and tighten fully onto the tool.
- Fit the nose assembly onto the Jaw Housing Extension (1) and Nose Casing Extension (2).

## 7. FIXED COLLECTOR BOTTLE KIT

The Fixed Collector Bottle an alternative to the standard stem collector and allows greater storage capacity for collection of large rivet stems. To replace the stem collector with the Fixed Collector proceed as follows:

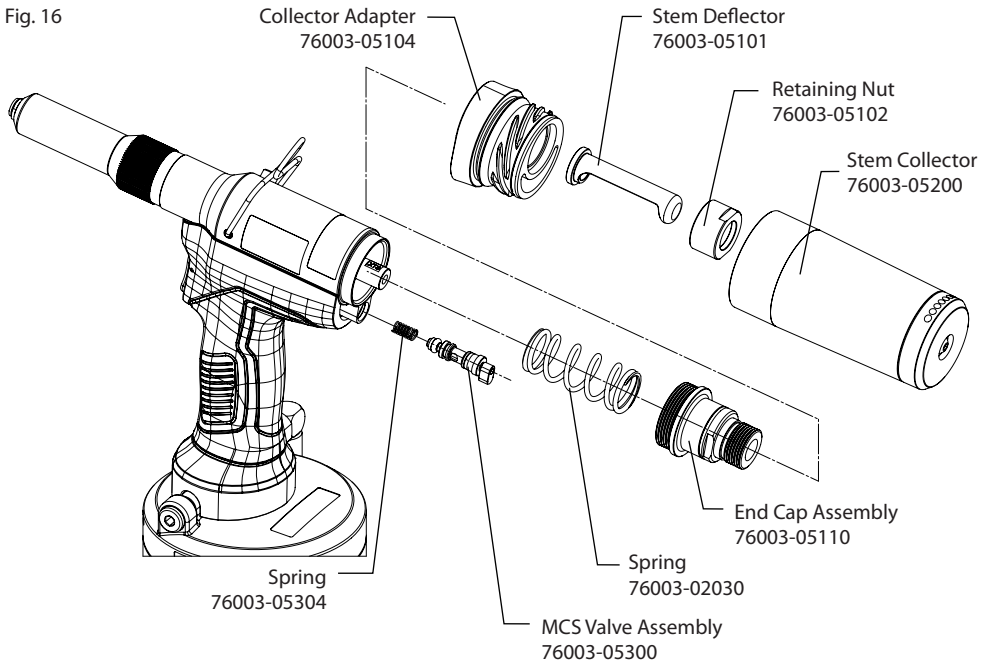
### PREPARING THE BASE TOOL TO ACCEPT THE FIXED COLLECTOR BOTTLE KIT

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE FIXED COLLECTOR BOTTLE KIT.**

Refer to fig.16 below. Refer also to the Proset XT3 and Proset XT4 Service Manuals 07900-09410 and 07900-09411.

Fig. 16



- The air supply must be disconnected.
- Rotate Stem Collector (76003-05200) anti-clockwise and remove from the Collector Adapter (76003-05104).
- Unscrew and remove the Deflector Retaining Nut (76003-05102) and the Stem Deflector (76003-05101).
- Remove the Collector Adapter (76003-05104), including O Ring (07003-00530).
- Unscrew and remove the End Cap Assembly (76003-05110), including O Ring (07003-00508). Observe caution when removing the End Cap Assembly (76003-05110) as it will be subjected to a compressive force from Spring (76003-02030).
- Remove Spring (76003-02030).
- Remove the MCS Valve Assembly (76003-05300) and the Spring (76003-05304) from the Tool.

## FITTING THE FIXED COLLECTOR BOTTLE KIT

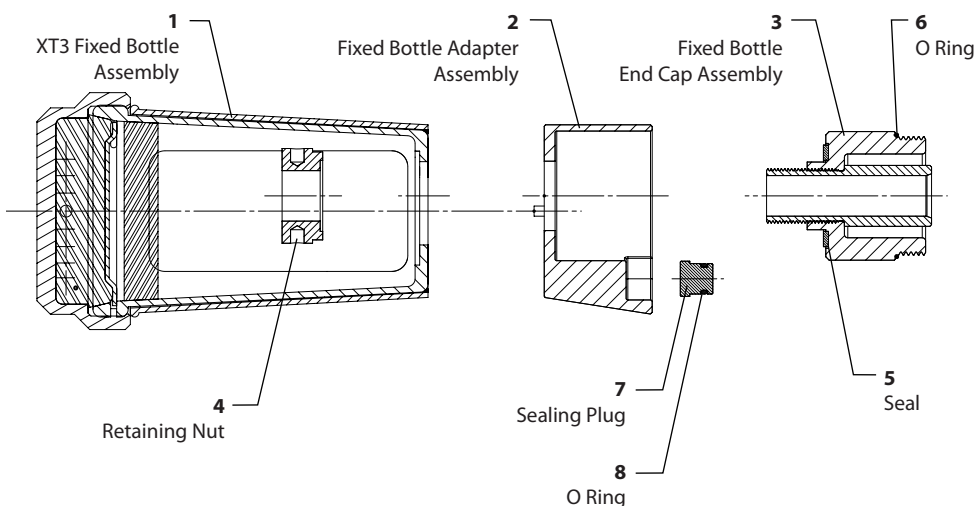
**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE FIXED COLLECTOR BOTTLE KIT.**

Refer to fig. 16 and 17 and the table 9 below. Refer also to the Proset XT3 and Proset XT4 Service Manuals 07900-09410 and 07900-09411.

Table 9 - PARTS LIST - FIXED COLLECTOR BOTTLE KIT 76003-20500			
Item	Part Number	Description	Qty
1	76003-20510	XT3 Fixed Bottle Assembly	1
2	76003-20520	Fixed Bottle Adapter Assembly	1
3	76003-20530	Fixed Bottle End Cap Assembly	1
4	76003-20501	Retaining Nut	1
5	71210-02029	Seal	1
6	07003-00278	O Ring	1
7	76003-20502	Sealing Plug	1
8	07003-00512	O Ring	1

Fig. 17



Item numbers in **bold** refer to fig. 17 and table 9.

- The air supply must be disconnected.
- Install the Spring (76003-02030) into the recess in the Fixed Bottle End Cap Assembly (**3**).
- Attach Fixed Bottle End Cap Assembly (**3**), together with the Seal (**5**), O Ring (**6**) and Spring (76003-02030) to the tool head assembly and tighten with a spanner.
- Insert the Sealing Plug (**7**), together with O Ring (**8**) fully into the bore in the tool head assembly.
- Assemble the Fixed Bottle Adapter Assembly (**2**) over the Fixed Bottle End Cap Assembly (**3**) and on to the tool.

- Fit the Fixed Bottle Assembly (1) over the locating pins in Fixed Bottle Adaptor Assembly (2).
- Rotate the Fixed Bottle Assembly (1) outer so that the aperture in the Fixed Bottle Assembly (1) inner is fully exposed.
- Screw on the Retaining Nut (4) and tighten using a tommy bar.

## 8. MCS5000 ADAPTER KITS

The MCS5000 Adapter Kits enable the tool to be connected the MCS5000 remote vacuum rivet stem collector. To replace the stem collector with the MCS5000 Adapter Kit proceed as follows:

### PREPARING THE BASE TOOL TO ACCEPT THE MCS5000 ADAPTER KITS

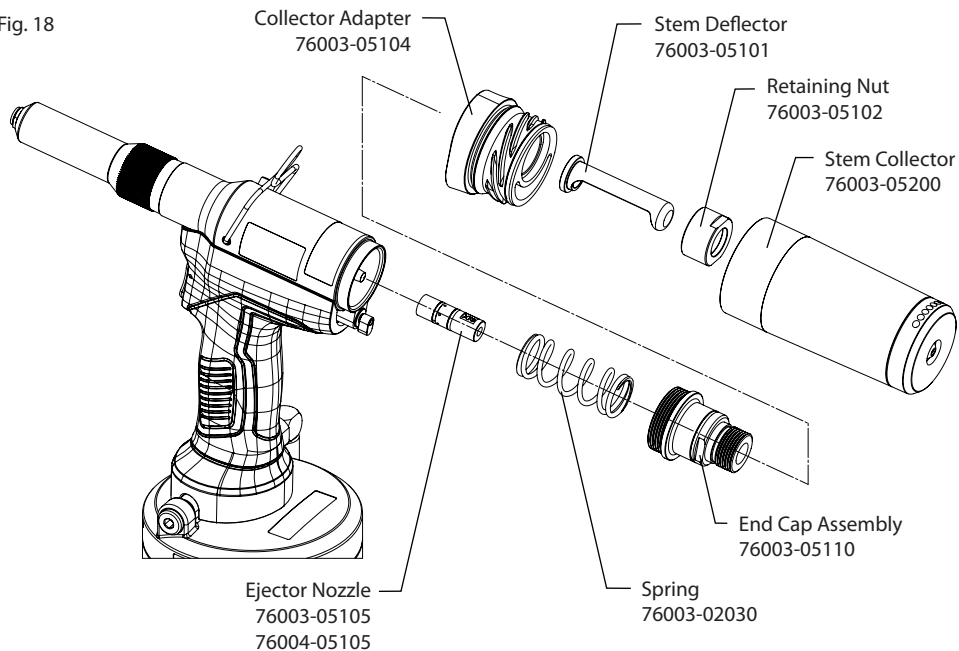
**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE MCS5000 ADAPTER KITS.**

Refer to fig.18 below. Refer also to the Proset XT3 and Proset XT4 Service Manuals 07900-09410 and 07900-09411.

- Operate the tool so that the Piston (76003-02120 or 76004-02120) moves to the fully rear position.
- Continue to depress the trigger, then turn off the air supply to the tool using the On/Off Valve (76003-03700). The Piston Assembly will then stop in the fully rear position.
- The air supply must be disconnected.
- Rotate Stem Collector (76003-05200) anti-clockwise and remove from the Collector Adapter (76003-05104).
- Unscrew and remove the Deflector Retaining Nut (76003-05102) and the Stem Deflector (76003-05101).
- Remove the Collector Adapter (76003-05104), including O Ring (07003-00530).
- Unscrew and remove the End Cap Assembly (76003-05110), including O Ring (07003-00508). Observe caution when removing the End Cap Assembly (76003-05110) as it will be subjected to a compressive force from Spring (76003-02030).
- Remove Spring (76003-02030).
- If vacuum extraction is not required when using the Pin Tail Deflector, unscrew and remove the Ejector Nozzle (76003-05105 / 76004-05105) from the Piston (76003-02120 or 76003-02120).

Fig. 18



### FITTING THE MCS5000 ADAPTER KITS

**IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT3 AND PROSET XT4 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.**

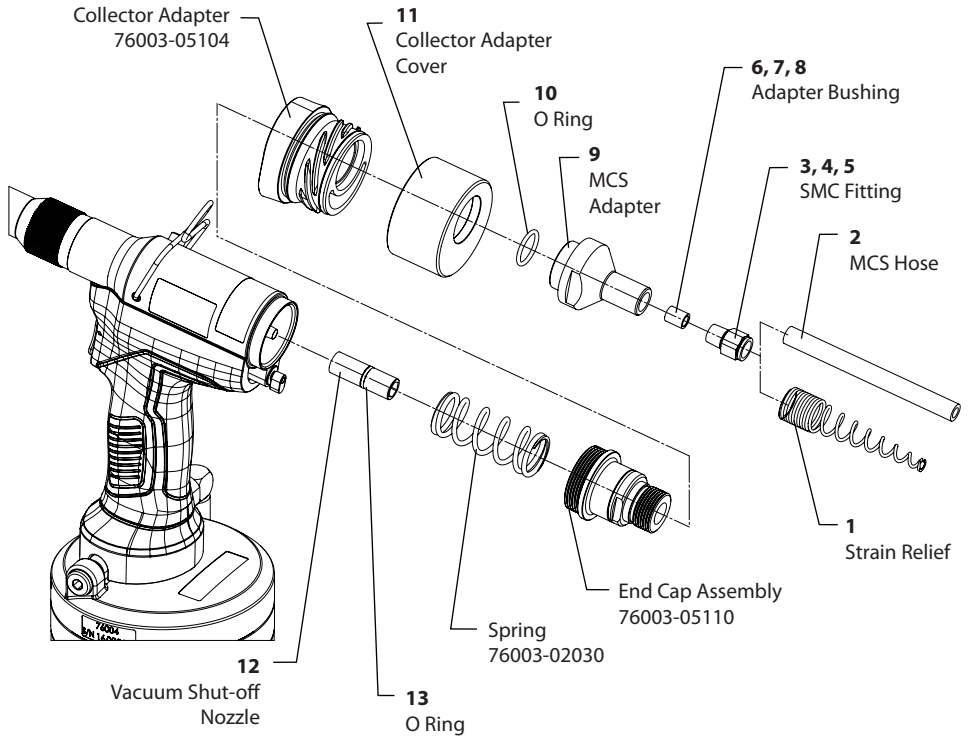
**IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE MCS5000 ADAPTER KITS.**

Refer to fig. 19 and the table 10 below.

**Table 10 - PARTS LIST - MCS5000 ADAPTER KITS**

Item	Description	76003-20600	76003-20700
		3.2MM (1/8") TO 4.8MM (3/16") RIVETS	6.4MM (1/4") RIVETS
1	Strain Relief	MCS5000-81	-
2	MCS Hose	-	MCS5000-24
3	SMC Fitting (1/8" Rivets)	PRT5250-99	-
4	SMC Fitting (5/32" & 3/16" Rivets)	PRT5250-98	-
5	SMC Fitting (1/4" Rivets)	-	MCS5000-23
6	Adapter Bushing (1/8" Rivets)	PRT5250-24	-
7	Adapter Bushing (5/32" & 3/16" Rivets)	PRT5250-26	-
8	Adapter Bushing (1/4" Rivets)	-	76003-20702
9	MCS Adapter	76003-20601	76003-20701
10	O Ring	07003-00277	07003-00277
11	Collector Adapter Cover	76003-20103	76003-20103
12	Vacuum Shut-off Nozzle	76003-20104	76003-20104
13	O Ring	07003-00511	07003-00511

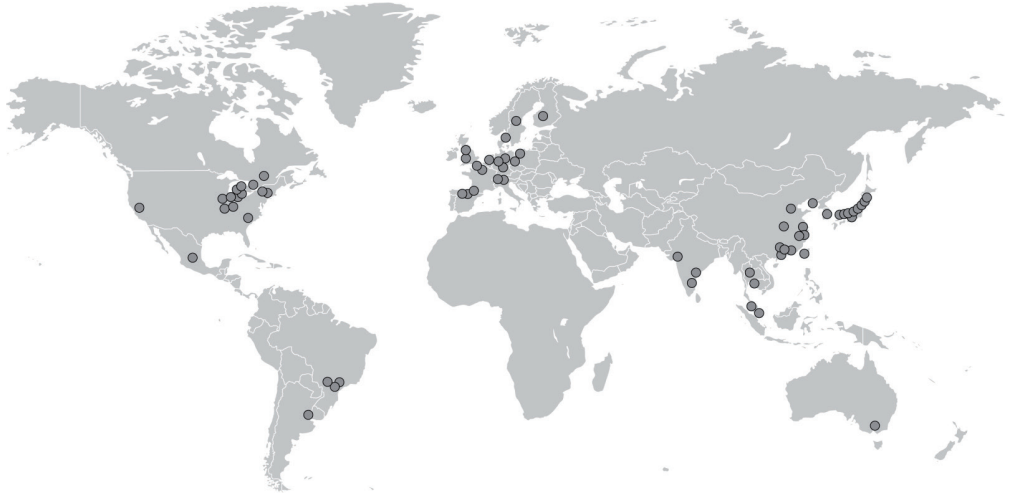
Fig. 19



Item numbers in **bold** refer to fig. 19 and table 10.

- The air supply must be disconnected.
- Attach the Vacuum Shut-off Nozzle (**12**) to the Piston (76003-02120 or 76004-02120).
- Install the Spring (76003-02030).
- Attach the End Cap Assembly (76003-05110), including O Ring (07003-00508).
- Assemble the Collector Adapter (76003-05104), including O Ring (07003-00530).
- Place the Collector Adapter Cover (**11**) over the Collector Adapter (76003-05104).
- Insert O Ring (**10**) into the recess with the MCS Adapter (9)
- Install MCS Adapter (**9**) on the End Cap Assembly (76003-05110) using a spanner. Ensure the end face of the Collector Adapter Cover (**11**) is secure against the mating face of the Collector Adapter (76003-05104).
- Insert the Adapter Bushing (**6, 7, or 8**) into the MCS Adapter (**9**) ensuring the correct size for the rivet to be placed and the correct orientation. The larger internal bore opening in the Adapter Bushing (**6, 7, or 8**) should face towards the MCS Adapter (**9**).
- Insert the SMC fitting (**3, 4 or 5**) into the MCS Adapter (**9**), ensuring the correct size for the rivet to be placed.
- For 3.2mm (1/8"), 4.0mm (5/32") and 4.8mm (3/16") rivets insert the Strain Relief (**1**) over the SMC Fitting (**3 or 4**) and fully on to the MCS Adapter (**9**).
- For 6.4mm (1/4") rivets insert the MCS Hose (**2**) into the SMC Fitting (**5**).
- Connect the Tool and MCS5000 kit to the MCS5000 unit as instructed within the MCS5000 datasheet.





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07900-09415	A	17/143

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