

STANLEY[®]
Engineered Fastening



PB2500N ACCESSORIES
SETTING AND CROPPING



PB2500N Neobolt[®] Tool

Battery Power Tool Accessories

STANLEY[®]
Assembly Technologies

PB2500N ACCESSORIES

PRODUCT

1. Setting front ends

3/16" - 19mm diameter (standard and extended lengths)

1/4" - 26 mm and 19 mm diameter (extended length)

5/16" - 26 mm and 19 mm diameter (extended length)

3/8" - 26 mm diameter

2. Collar croppers

1/4"

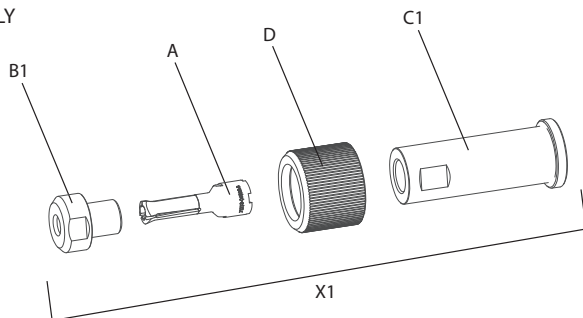
5/16"

SAFETY

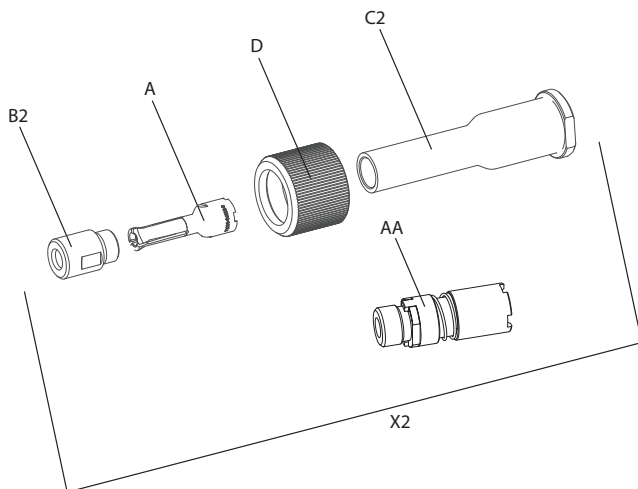
- **Before use, read and understand safety and operating instructions of the tool and front end**
- **Always use eye protection when using this tool**
- **Use of protective gloves is recommended**
- **Avoid placing hands in potential pinch points, as tool will move while cutting**
- **Verify that equipment is in good working condition and properly set up before using**

1. SETTING FRONT ENDS

26 mm ASSEMBLY



19 mm ASSEMBLY



**SEE INTRUCTIONS
BEFORE STROKE
ADJUSTMENTS**



WARNING:

**Disassembly of the tool beyond
the removal of the Front End
Assembly could result in voiding
the warranty.**

STANLEY
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NOTE:

WHEN A NEW NOSE ASSEMBLY IS PUT ONTO A TOOL, THE STROKE ADJUSTMENT MUST BE RECALIBRATED

AVAILABLE NOSE ASSEMBLIES					
NOSE SIZE		3/16"	1/4"	5/16"	3/8"
DESCRIPTION	TAG				
COLLET	A	65120-00027	65110-00054	65120-00026	65120-00073
26 MM ASSEMBLY	X1	N/A	65120-00022	65120-00040	65120-00066
26 MM ANVIL	B1		65120-00057	65110-00286	65120-00472
26MM NOSE HOUSING	C1		65110-00056	65110-00285	65110-00473
19 MM ASSEMBLY	X2	65120-00071 (STD) 65120-00072 (Long)	65120-00023	65120-00041	N/A
19 MM ANVIL	B2	65110-00356	65110-00120	65110-00349	
19MM NOSE HOUSING	C2	65110-00523 (STD) 65110-00031 (Long)	65110-00155	65110-00350	
COLLET EXTENSION	AA	65120-00020			65110-00474
NOSE HOUSING NUT	D	65110-00083			

INITIAL STROKE SETTING

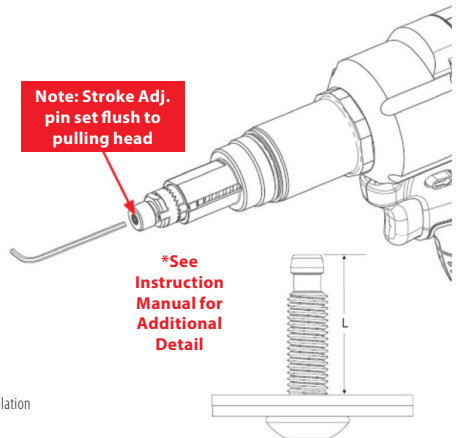
- Determine application pin stick out length in millimeters
- Remove battery back from tool
- Remove nose housing and collet to expose the Stroke Adjustment Pin
- Set the Stroke Adjustment Pin to flush with Pulling Head Adapter
- Rotate the Stroke Adjustment Pin clockwise according to the following:

Length (L)	Pin Adjustment (Number of Rotations)	Length (L)	Pin Adjustment (Number of Rotations)
15mm	10 full rotations (CW)	20mm	5 full rotations (CW)
16mm	9 full rotations (CW)	21mm	4 full rotations (CW)
17mm	8 full rotations (CW)	22mm	3 full rotations (CW)
18mm	7 full rotations (CW)	23mm	2 full rotations (CW)
19mm	6 full rotations (CW)		

- Mount the Nose Housing and Collet and tighten the Nose Housing Nut
- Verify setting by installing Neobolt® in Application Grip

STROKE ADJUSTMENT

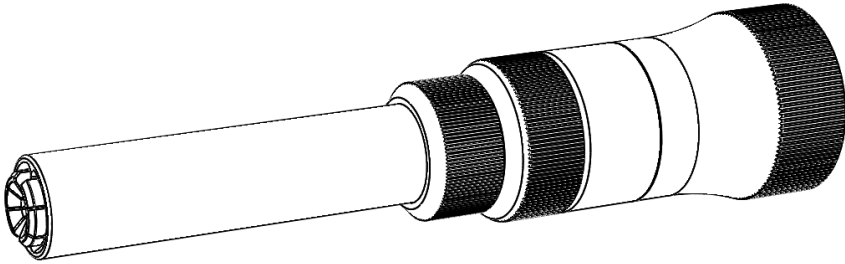
- Remove battery pack from tool
- Insert 2.0mm Hex Key into front of the tool through the hole in the collet stop
- Adjust the tool stroke by rotating the Stroke Adjustment Pin to achieve the desired Neobolt® installation
 - Each rotation of the Stroke Adjustment Pin changes tool stroke by 1mm
 - To increase the stroke, rotate Stroke Adjustment Pin counter-clockwise
 - To reduce the stroke, rotate Stroke Adjustment Pin clockwise
- Verify setting by installing Neobolt® in Application Grip
- Repeat Adjustment as needed



***See Instruction Manual for Additional Detail**



2. COLLAR CROPPERS

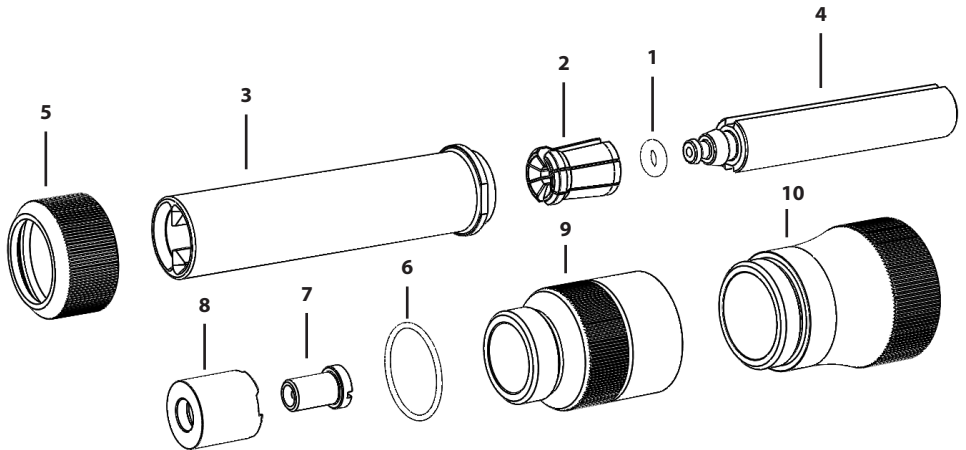


2.1 CROPPER TECHNICAL SPECIFICATIONS

	Neobolt size	
	1/4"	5/16"
Cropper Assembly	65120-00068	65120-00069
Use with	PB2500N	PB2500N
Cropper Stroke (mm)	25	25
Cropper weight (kg)	0.28	0.33
Cropper Dia/Length (mm)	38 / 167	38 / 153

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2.2 CROPPER COMPONENTS

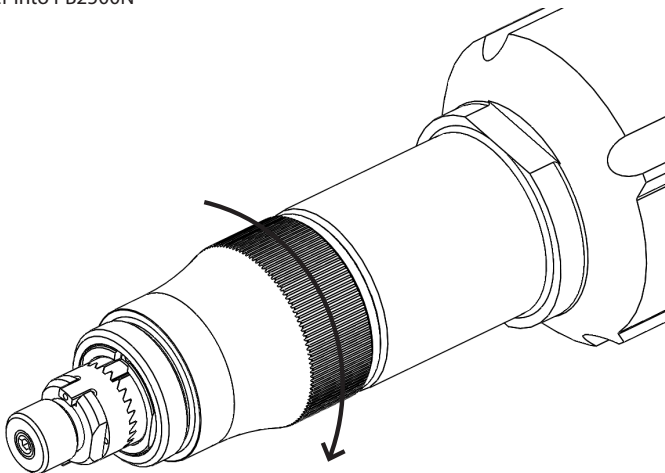


			Neobolt size	
			1/4"	5/16"
	Item	Quantity	65120-00068	65120-00069
O-ring *	1	1	65130-00008	65110-00358
Jaw *	2	6	65110-00089	65110-00282
Cutter *	3	1	65110-00269	65110-00482
Jaw holder	4	1	65110-00476	65110-00481
Nut	5	1	65110-00272	-
Nut O-ring	6	1	65110-00337	-
Threaded pin	7	1	65110-00485	65110-00485
Coupler	8	1	65110-00477	65110-00477
Nose housing	9	1	65110-00478	65110-00483
Adapter	10	1	65110-00479	65110-00479
Jaw assembly tool	11	1	65124-00007	-

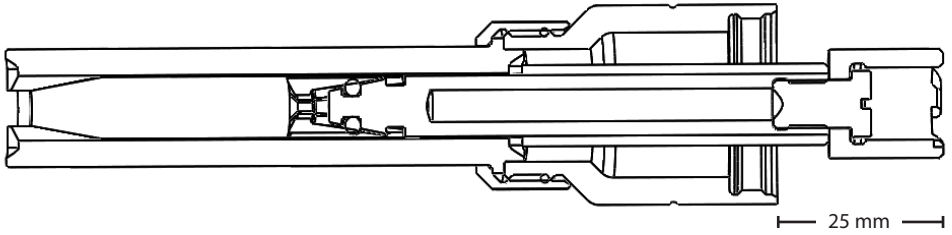
* Typical wear items

2.3 MOUNTING CROPPER TOOL ONTO PB2500N:

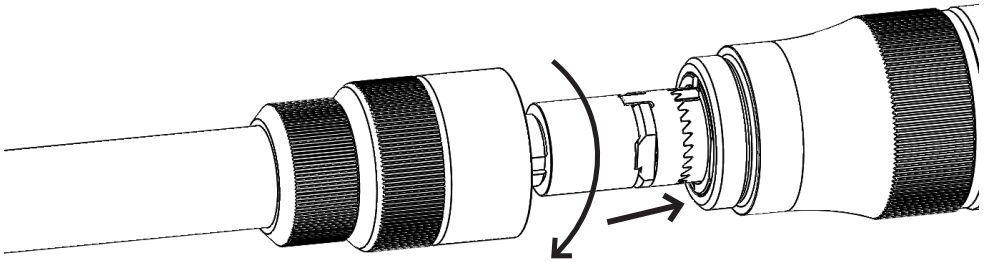
Thread Adapter into PB2500N



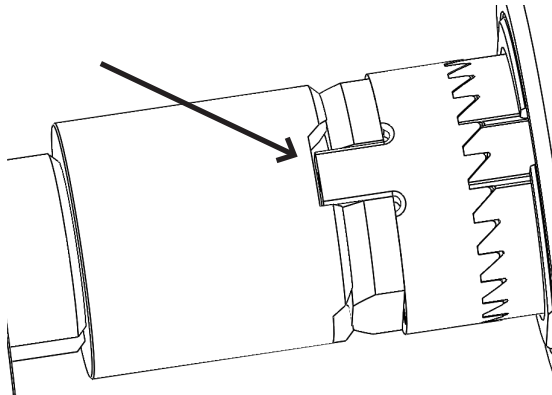
- Move coupler out of cutter until it protrudes approximately 25 mm (1").



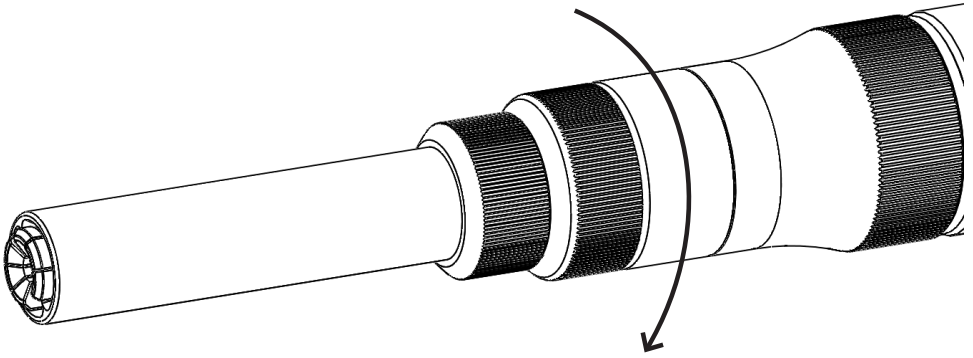
- Depress locking tabs and thread coupler clockwise all the way. Coupler must be secured in place by locking tabs.



Coupler must be secured in place by locking tabs.

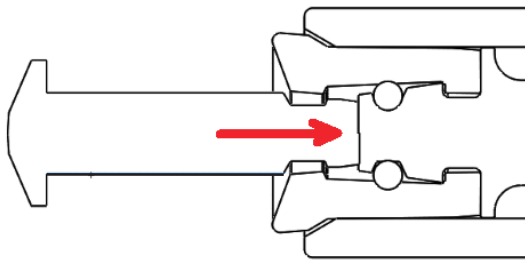


- Thread cropper all the way into tool. Cropper is now ready to use.



To remove cropper from tool, reverse assembly process.

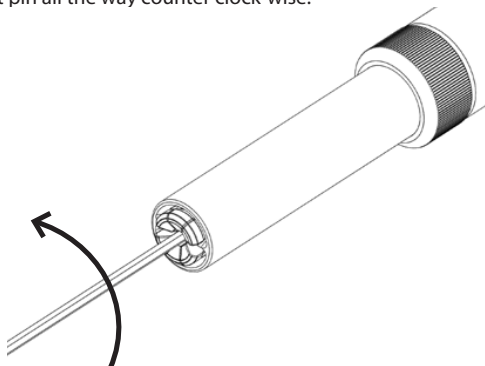
Verify that pintail from Neobolt pin fits inside the jaws



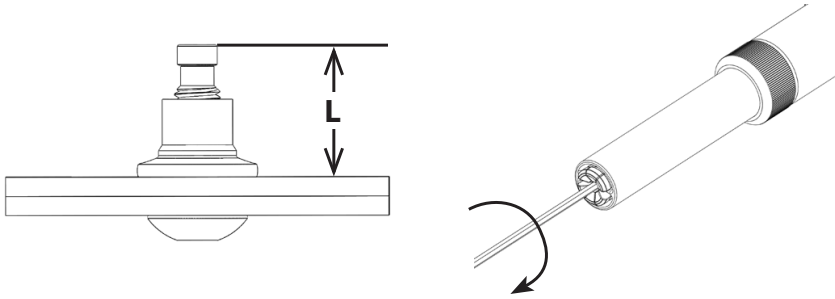
2.4 CUTTER USE:

2.4.1 Setting tool stroke:

Turn adjustment pin all the way counter clock-wise.



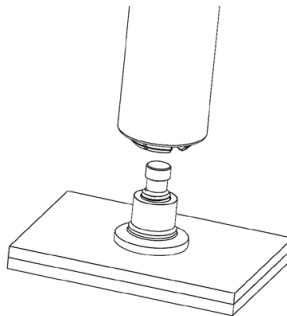
Measure pin stickout. Consult table below and turn adjustment pin clockwise as recommended by table.

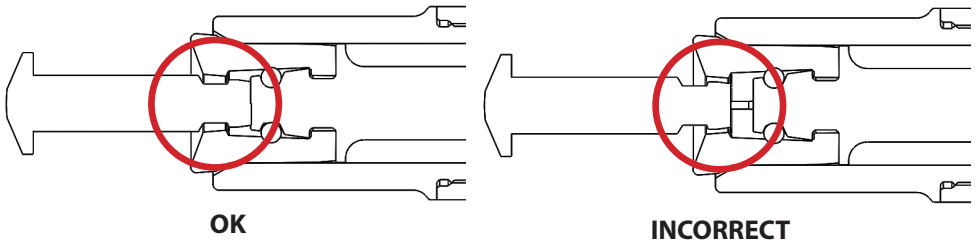


Pin stick-out "L"	1/4" Neobolt Clockwise Rotations	5/16" Neobolt Clockwise Rotations
15 mm	12	14
16 mm	11	13
17 mm	10	12
18 mm	9	11
19 mm	8	10
20 mm	7	9
21 mm	6	8
22 mm	5	7
23 mm	4	6

2.4.2 Cropping parts:

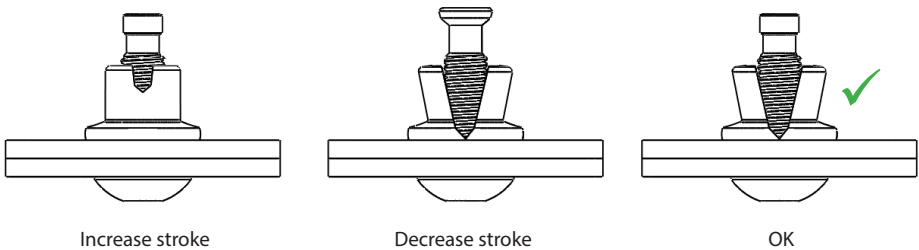
Once tool has been adjusted, slide cropper over part to be cut and hold trigger to crop part. Adjust stroke if needed.





- Check tool to verify that jaws and cutting surfaces are intact and free of debris.
- Pin tail must be fully inserted into cutter.
- Tool must be aligned with the fastener to be removed.

2.4.3 Stroke adjustment:

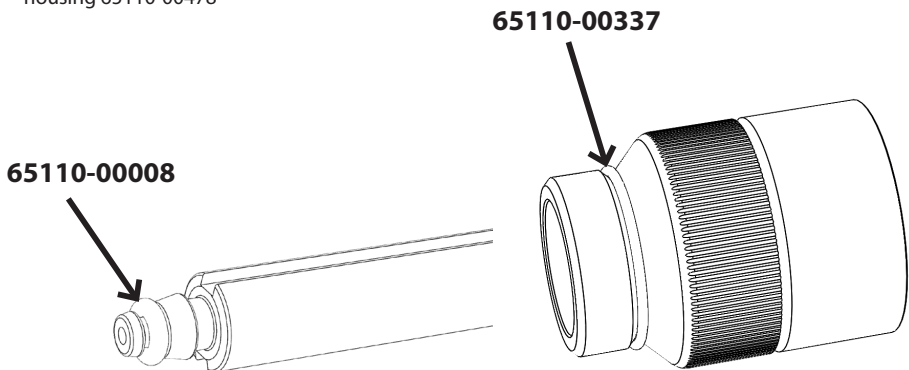


Each rotation of the Stroke Adjustment Pin (N) changes tool stroke by 1 mm (0.04")

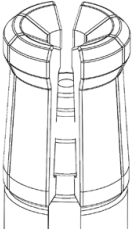
- To increase the stroke, rotate Stroke Adjustment Pin (N) counter-clockwise (CCW).
- To reduce the stroke, rotate Stroke Adjustment Pin (N) clockwise (CW).

2.5 TOOL ASSEMBLY:

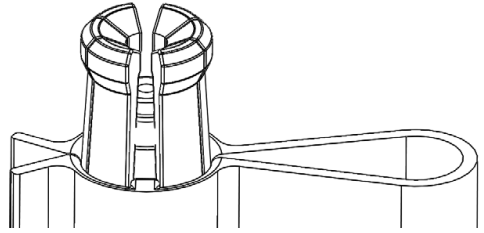
- Inspect components before assembly. Replace any components that show signs of damage or wear.
- Slide o-ring 65130-00008 into first slot in Jaw Holder 65110-00476 and o-ring 65120-00337 into nose housing 65110-00478



- Using tool 65130-00007, place six segments around jaw holder, as shown below:

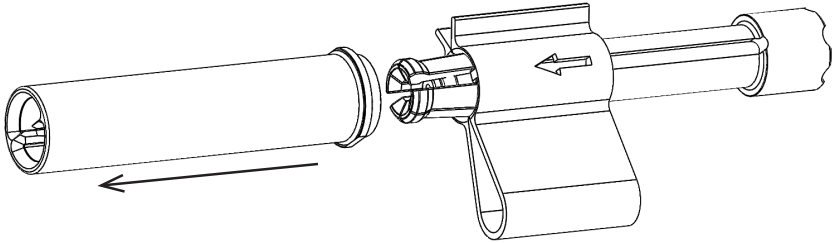


Proper orientation

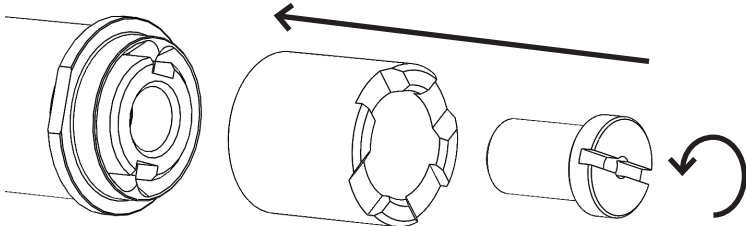


Use tool to assemble segments

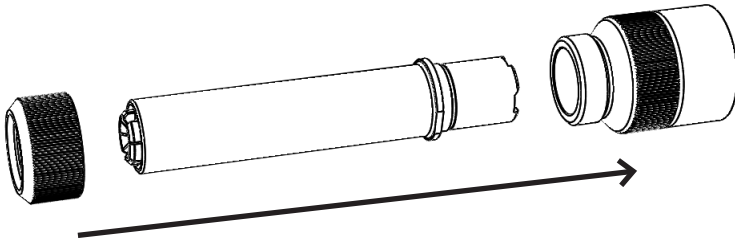
- Apply light coat of grease to inside of cutter. Slide assembly into cutter, with three jaws on either side of the cutting blades:



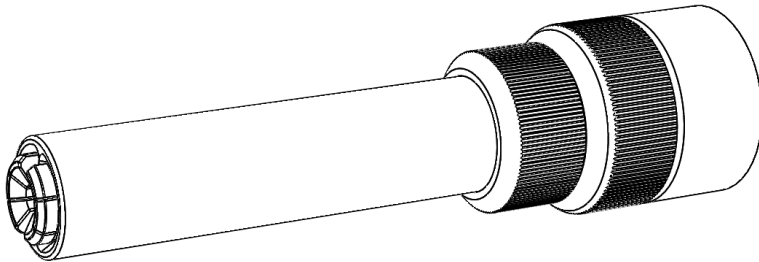
- Thread adapter (counter clock-wise) into jaw holder (use flat blade screw driver):



- Slide assembly into Nose Housing 65110-00478 and secure it with nut 65110-00272.



- Assembly is now ready to be mounted into tool. See section 4 for mounting instructions. Reverse these steps to disassemble the tool.



2.6 TOOL MAINTENANCE

For optimal performance, it is critical that the tool is kept clean and in good working order. Cleaning frequency will depend on usage and operating conditions.

To clean tool:

- Disassemble tool
- Clean components. Inspect for damage and replace any damaged components
- Apply a light coat of grease to inside of cutter using a cotton swab.
- Reassemble tool



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