

**STANLEY**<sup>®</sup>  
Engineered Fastening



Service Aid



XGRIP N09Q1

Hydro-Pneumatic Tool

**STANLEY**<sup>®</sup>  
Assembly Technologies

All rights reserved.

The information provided may not be reproduced and/or made public in any way and through any means (electronically or mechanically) without prior explicit and written permission from STANLEY Engineered Fastening. The information provided is based on the data known at the moment of the introduction of this product. STANLEY Engineered Fastening pursues a policy of continuous product improvement and therefore the products may be subject to change. The information provided is applicable to the product as delivered by STANLEY Engineered Fastening. Therefore, STANLEY Engineered Fastening cannot be held liable for any damage resulting from deviations from the original specifications of the product.

The information available has been composed with the utmost care. However, STANLEY Engineered Fastening will not accept any liability with respect to any faults in the information nor for the consequences thereof. STANLEY Engineered Fastening will not accept any liability for damage resulting from activities carried out by third parties. The working names, trade names, registered trademarks, etc. used by STANLEY Engineered Fastening should not be considered as being free, pursuant to the legislation with respect to the protection of trademarks.

## Contents

1. Abbreviations:.....	4
2. General instructions: .....	4
3. Service kit: .....	4
4. Proper function of riveting tool: .....	5
5. Assembly drawing of riveting tool:.....	6
6. Informative list of spare parts of riveting tool: .....	7
7. Instructions for assembling and disassembling – steps 1-11:.....	9

## **1. Abbreviations:**

CA - Compressed air

MP - Special tool (assembly jig)

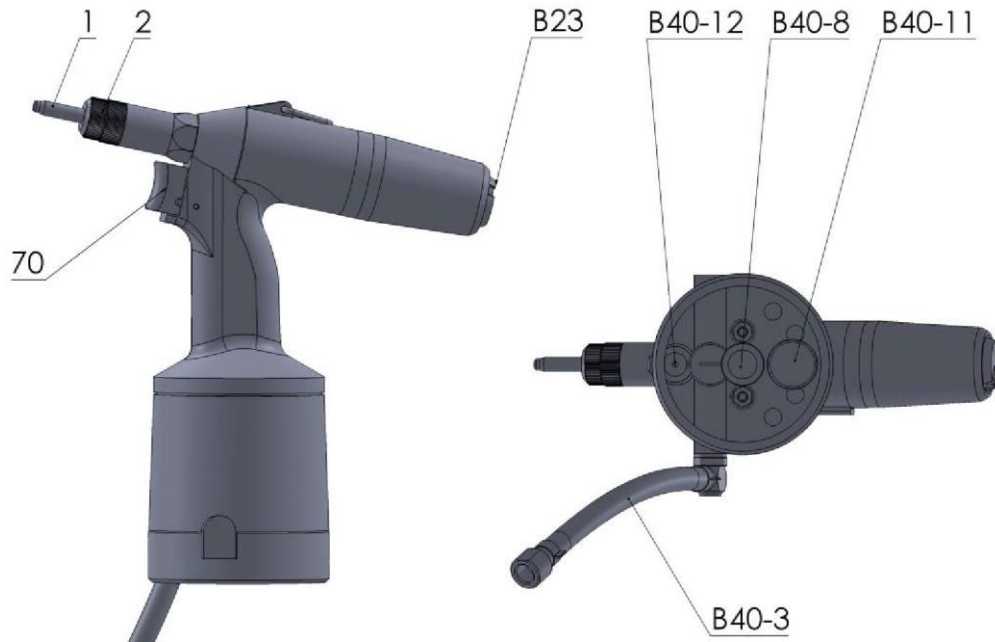
## **2. General instructions:**

1. Riveting tool is always disconnected from the compressed air, unless otherwise stated.
2. All threads are clockwise.
3. Riveting tool is gripped in a stand (see chapter 8) while assembling and disassembling, unless otherwise stated.
4. Before assembling, wash the disassembled parts in degreasing solution and insufflate with compressed air, wipe with a cloth without hairs.
5. While assembling, lubricate the sealing (O-rings, pneumatic seals) and related opposite surfaces with oil MOGUL LV 2-3, unless stated otherwise.

## **3. Service kit:**

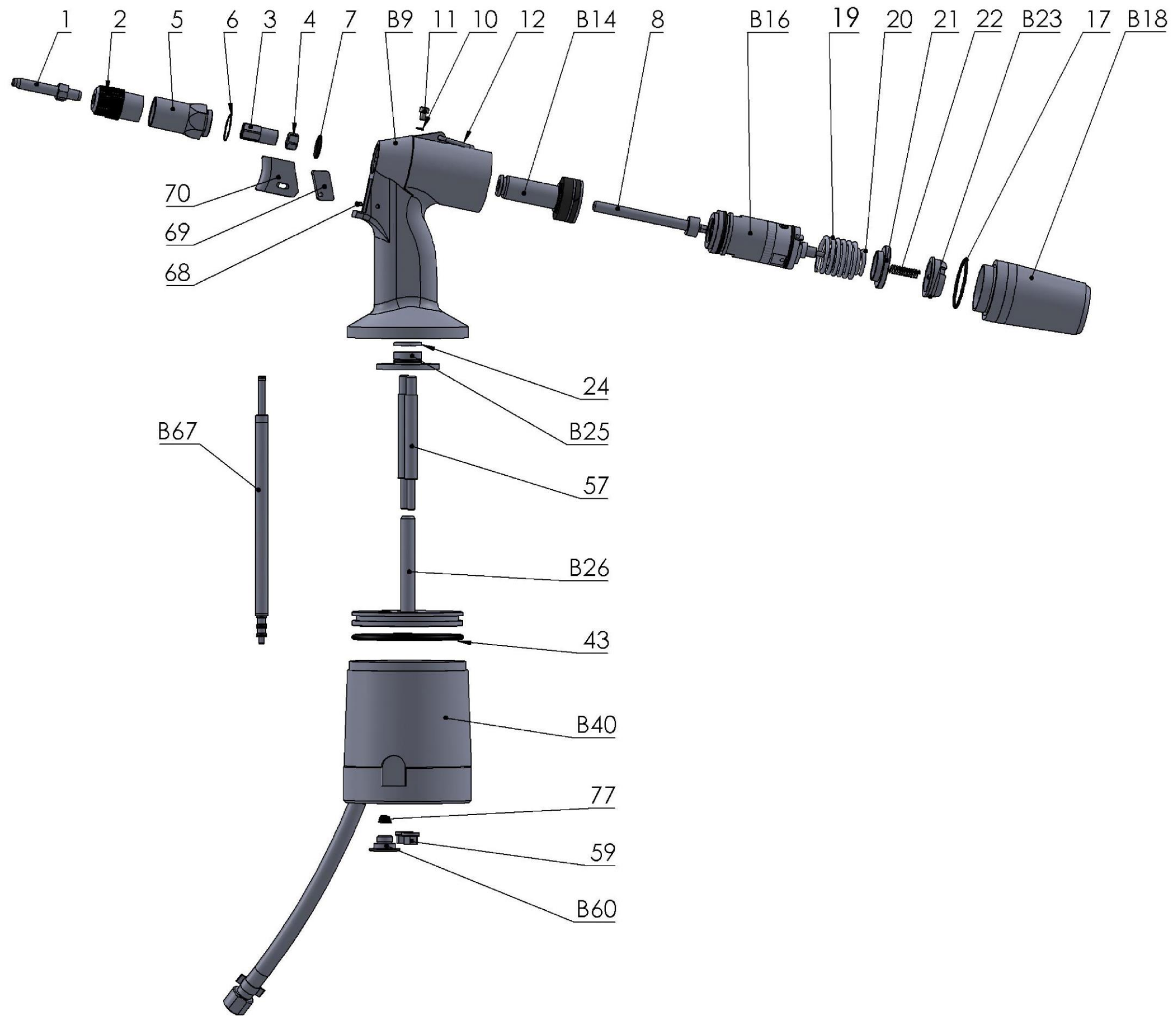
The part number for service kit is: S-1008000

#### 4. Proper function of riveting tool:



Operator activity	Tool function
Connect the riveting tool to CA, if the tool is equipped with main valve, turn it on. Pos. 70 is on the front extreme position, not pressed	CA does not leak, motor does not rotate
Put a rivet on pos. 1 and press towards the riveting tool, the rivet screws on	Motor turns right, outlet of CA through the outlets in pos. 23
The action is ready when the rivet is completely screwed on	Motor turns off, front of the rivet touches front of the pos. 2. CA does not leak
Press with hand pos. 23, the rivet screws out	Motor turns left, outlet CA through the outlets in pos. 23
Release pos. 23, screwing out stops	Pos. 23 gets back to the initial position, motor turns off, air does not leak
Turn with stroke force adjustment according to arrow direction +/- . Further instructions are in the Operations manual	The indicator of the manometer moves
Put a rivet on pos. 1 and press towards the riveting tool, the rivet screws on	Motor turns right, outlet of CA through the outlets in pos. 23, when the rivet is completely screwed on the motor turns off
Press pos. 70, the rivet is riveted in	The rivet is deformed, the movement ends when the set stroke force is reached
Stop pressing pos. 70, the rivet completely screws out	CA outlets from the space pos. B40, pos. 1 gets back, the motor turns, outlet of CA through the outlets ins pos. 23, in the end motor stops itself, CA does not leak

5. Assembly drawing of riveting tool:



## 6. Informative list of spare parts of riveting tool:

<i>Position</i>	<i>Part Number.</i>	<i>Description</i>	<i>Qty</i>
1	O900A00275	Mandrel M3	1
1	O900A00276	Mandrel M4	1
1	O900A00277	Mandrel M5	1
1	O900A00278	Mandrel M6	1
1	O900A00279	Mandrel M8	1
1	O900A00280	Mandrel M10	1
1	O900A00281	Mandrel M12	1
2	O900A00282	Anvil M3 complete	1
2	O900A00283	Anvil M4 complete	1
2	O900A00284	Anvil M5 complete	1
2	O900A00285	Anvil M6 complete	1
2	O900A00286	Anvil M8 complete	1
2	O900A00287	Anvil M10 complete	1
2	O900A00288	Anvil M12 complete	1
3	D-08650400	Joint sleeve	1
4	O900P01201	Contra-nut	1
5	D-08650600	Front nozzle	1
6	O920064019	O - ring 16/1,25 Sh 70	1
7	O920063006	O - ring 14,3/2,4 Sh 70	1
8	O900P01202	Tensile screw	1
9	S-08651900	Hydraulic body	1
10	O900S00136	O - ring 4/1,5 Sh 90	1
11	O920R50H12	Screw M4x6 imbus DIN 912	1
12	O920R50H13	Hanger	1
14	S-08650900	Hydraulic piston complete	1
	1402 N-2300007342283	Lip seal 34x22x8,3 (red color)	1
	1403 O900S00155	Guiding band 35	1
16	S-08655000	Motor complete	1
17	O900S00229	O - ring 36/2 Sh 70	1
18	S-08652700	Rear screwing complete	1
	1801 D-08652700	Rear screwing	1
	1802 D-08652800	Cover	1
19	D-08651500	Compression spring	1
20	O920N10024	Compression spring	1
21	D-08655600	Push button piston	1
22	O900P01210	Compression spring	1
23	S-08655500	Push button complete	1
	2302 N-3700000100400	Filtr SB Fi 10x4 mm/E	2
24	D-08653300	Washer PP	1
25	S-08653200	Cover plate D12 complete	1
	2501 D-08653200	Bottom	1
	2502 N-2040000000110	Stepseal 11	1
	2503 N-2103701310262	O - ring 13,1/2,62 Sh 70	1
	2505 O900S00215	O - ring 18/2,2 VITON	1
26	S-08653000	Pneumatic plunger	1
	2602 O920R50H22	Adjusting ring 14	3
	2603 O900S00127	O - ring 10/2 Sh 70	3
40	S-08650700	Pneumatic cylinder complete	1
	4001 D-08650700	Pneumatic cylinder	1
	4002 P-08604302	Bottom ring - red color	1
	4003 S-08654201	Aircoupling	1
	D-08654200	Body of aircoupling	1
	N-2103700910160	O - ring 9,1/1,6 Sh 70	1
	O900A00317	Air supply rot. part compl.	1
	4005 O900S00110	O - ring 17,17/1,78 Sh 70	2
	4006 D-08600601	Piston of stroke valve	1
	4007 N-2103701000220	O - ring 10/2,2 Sh 70	1
	4008 N-2104000700200	O - ring 7/2 VITON	1
	4009 D-08600604	Spring	1
	4011 N-8400000086504	Sticker of regulation key	1
	4012 D-08600800	Screw joint of pressure gauge	1
	4013 N-2103700975178	O - ring 9,75/1,78 Sh 70	1
	4014 O920N08045	Pressure gauge	1
	4015 N-8400000086506	Sticker of regulation scale	1
	4016 O920063014	O - ring 7/1,2 Sh 70	1
	4017 S-08653700	Outlet regulation	1
43	O920R50S39	O - ring 82,14/3,53 Sh 70	1
57	O920R50S37	Connecting screw	2
59	O920063026	Nut M6 DIN 6331 zinc.	2
60	S-08654300	Nut cap complete	1
	6001 D-08654300	Nut cap	1
	6002 O920063029	O - ring 4/2 Sh 70	1
67	S-07405100	Valve pin complete	1
	6701 O920R50S57	Valve pin	1
	6702 O900S00150	O - ring 4/1 Sh 70	1

	6703	O920N08074	O - ring 4/2,2 Sh 70	1
	6704	O920063029	O - ring 4/2 Sh 70	2
<b>68</b>		O920063035	Dowel pin 3 x 20 DIN 7	1
<b>69</b>		O920R50S60	Excentric trigger	1
<b>70</b>		O920R50S62	Trigger red	1
<b>77</b>		O920R50S46	Compression spring	1
<b>85</b>		N-8400000086500	Sticker of type (MS865)	1

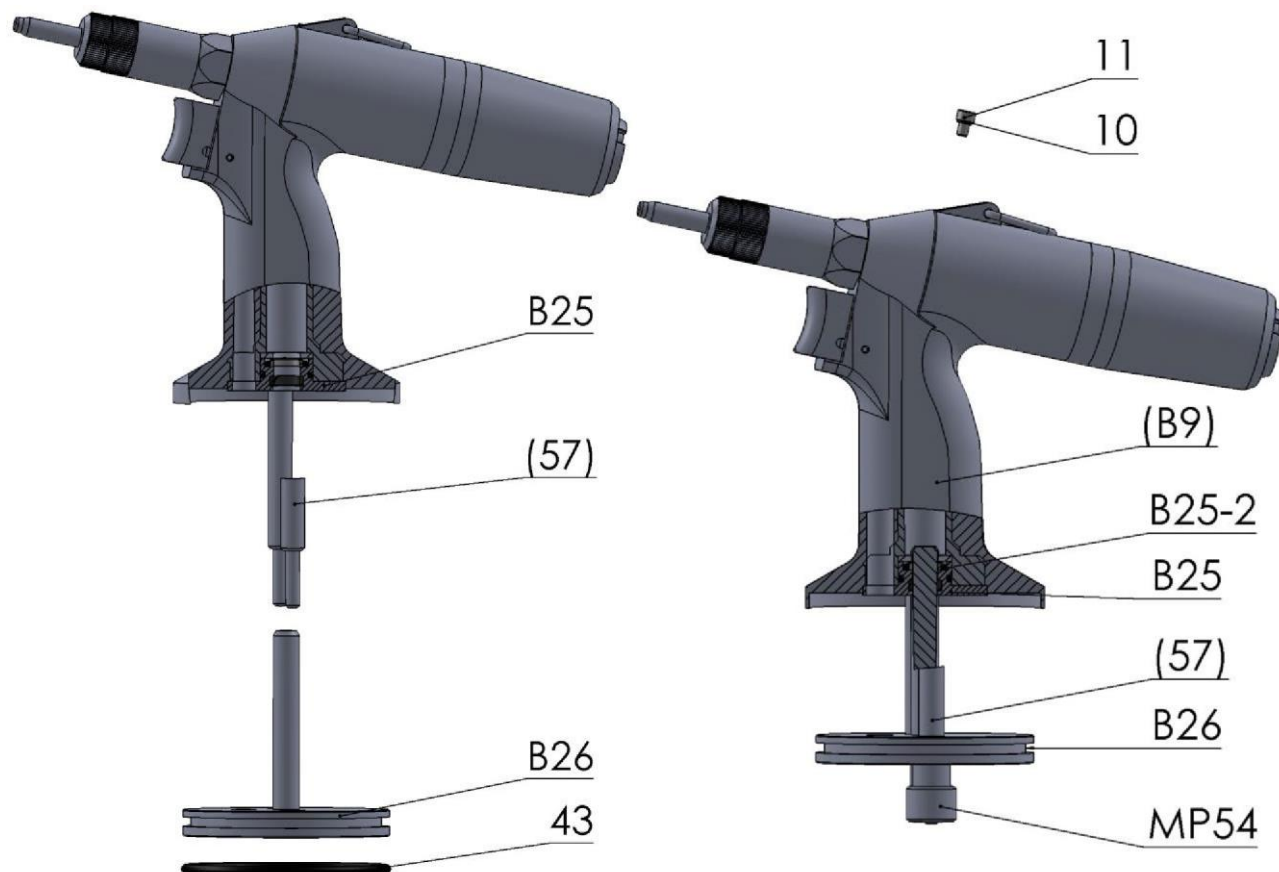




## Step 2

### Disassembly:

Put pos. B26 with pos. 43 out of pos. B25 and pos. 57 (2x), put pos. 43 out of pos. B26. Then pour out the hydraulic oil from the riveting tool to the suitable container.



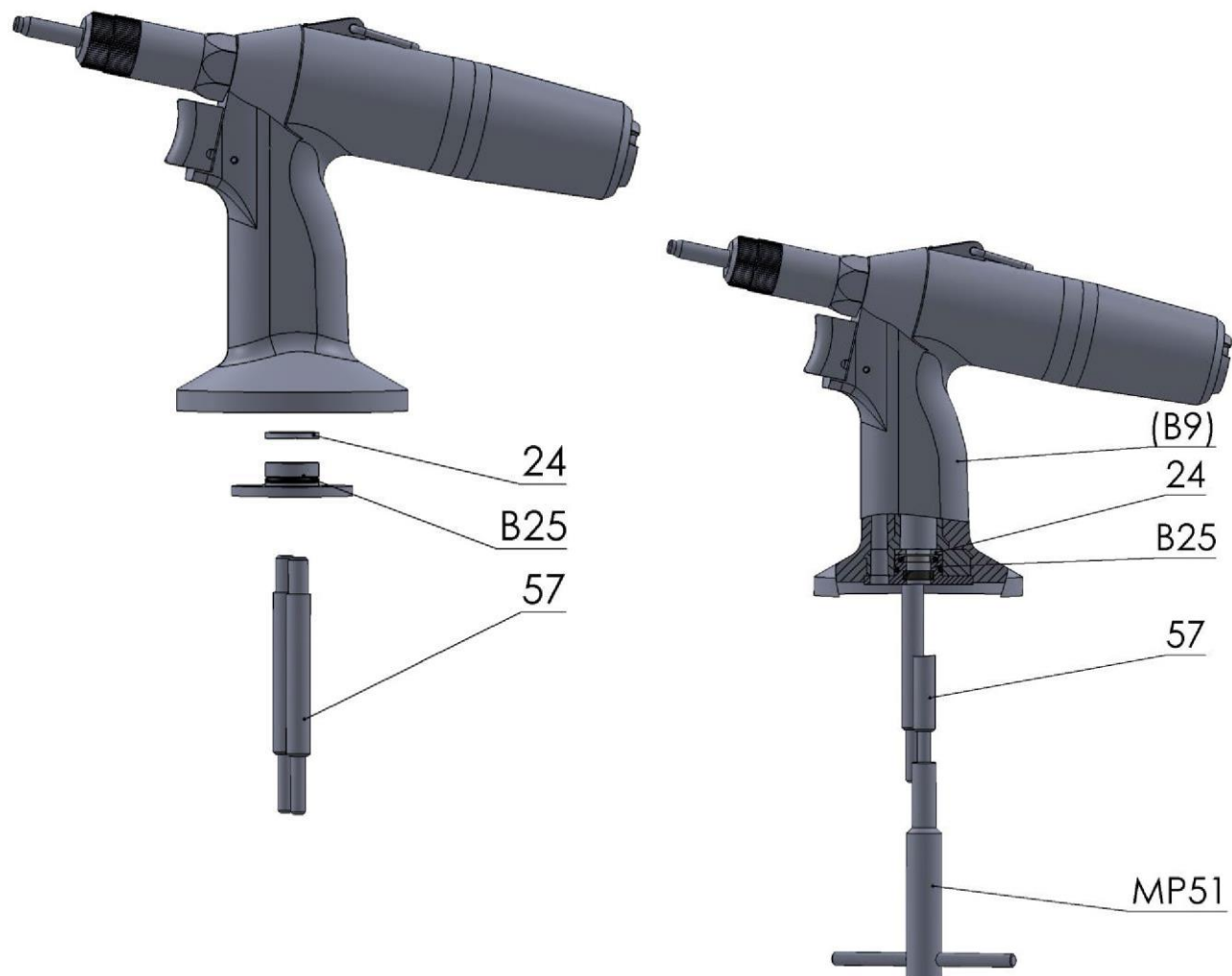
### Assembly:

Pour hydraulic oil into pos. B9 (we recommended hydraulic oil HYPIN AWHM 32 CASTROL or hydraulic oils grade HLP ISO VG 32), oil level up to 2. sealing (pos. B25-2) into pos. B25. Put pos. B26 on pos. 57 (2x) and into pos. B25. Then press and release pos. B26 toward pos. B9 cca 30 mm and wait until air bubbles stop leaking from the hydraulic system. After filling oil into hydraulic system of riveting tool (oil level up to 2. sealing (pos. B25-2) into pos. B25) press and release pos. B26 toward pos. B9, release pos. B26 and wait until air bubbles stop leaking from the hydraulic system (repeat this Step if necessary). Filling oil into hydraulic system of riveting tool. External surface pos. B26 lubricate with silicon paste LUKOSAN, put pos. B26 on and screw MP54 on pos. 57 to the stop position. Screw pos. 11 (ev. pos. 11 with pos. 10) out of pos. B9 with using socket-screw key no.3. Surplus oil leaks from pos. B9, screw pos. 11 with pos. 10 back to pos. B9 and tighten with using socket-screw key no.3. Take off MP54..

### Step 3

#### Disassembly:

Loosen and screw out pos. 57 (2x) with using nut and conranut on thread M6. Remove nut and conranut and screw pos. 57 (2x) to pos. B25 (thread M6). Pull both pos. 57 and pos. B25, put pos. 24 out.



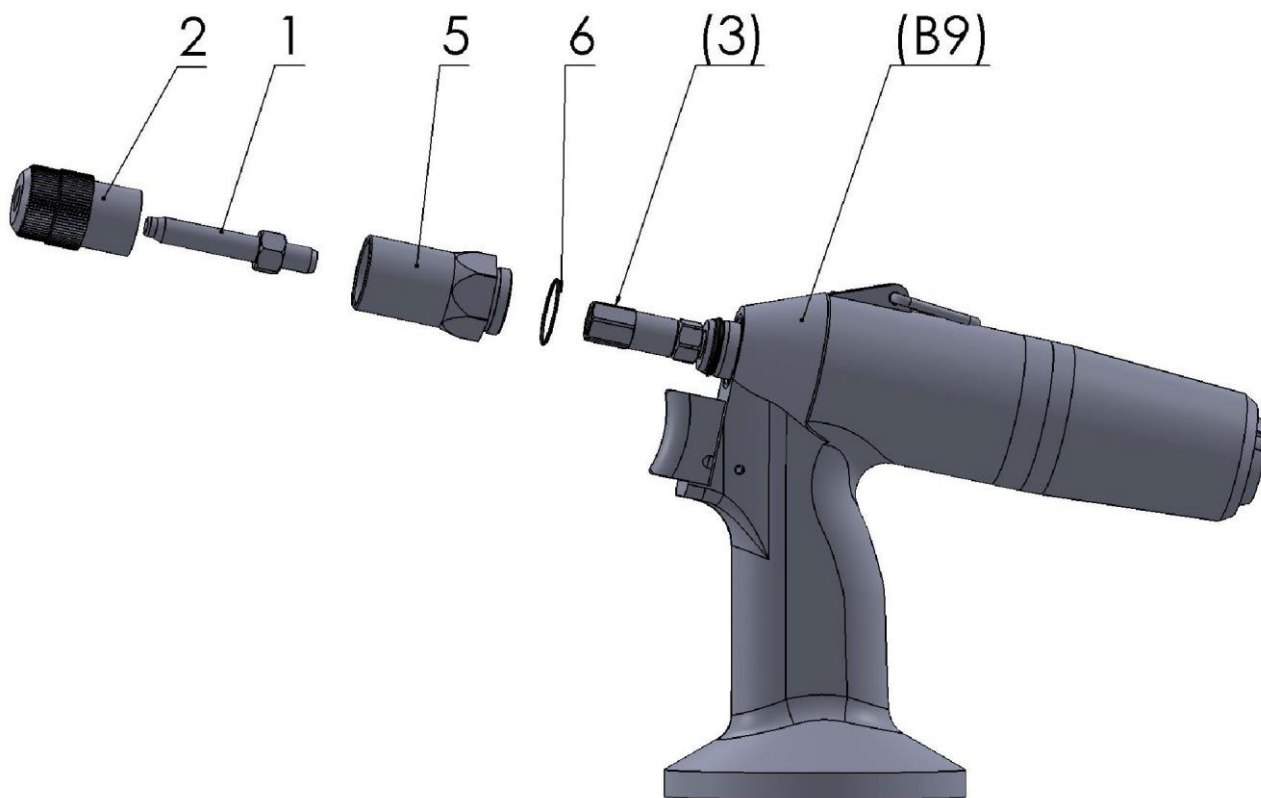
#### Assembly:

Put pos. 24 into pos. B9 groove to each other, put pos. B25 and screw pos. 57 (2x) on and tighten with using MP51.

## Step 4

### Disassembly:

Screw pos. 2 and pos. 1 out. Screw pos. 5 out of pos. B9 with using wrench 24 and put pos. 6 out with using MP32.



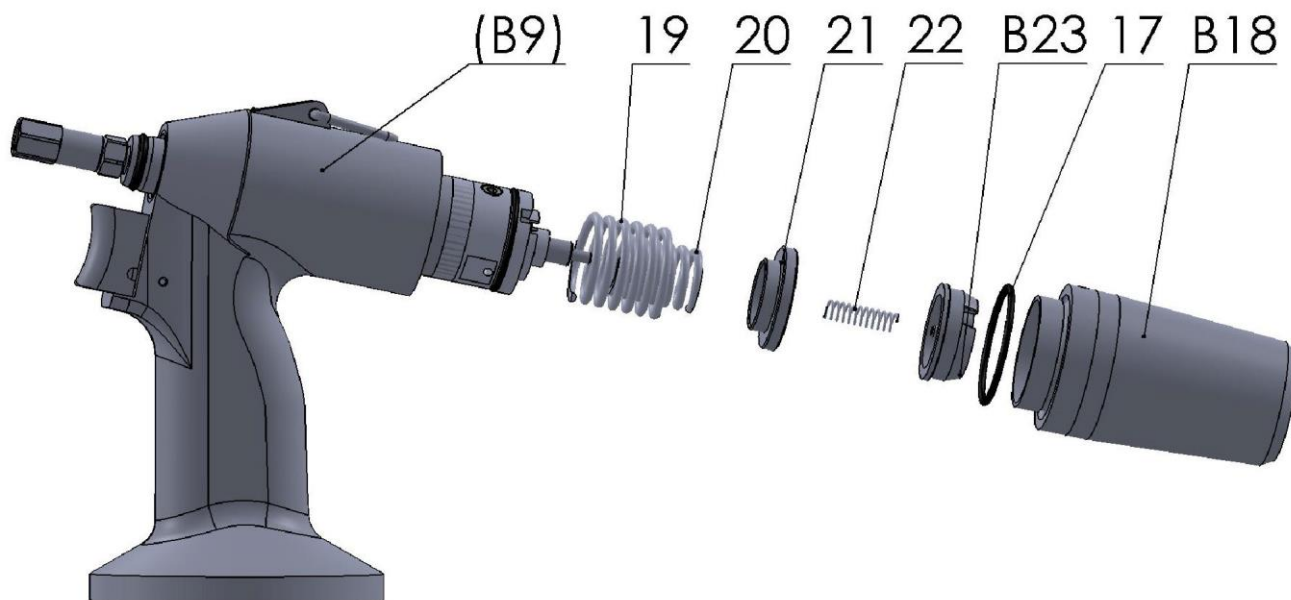
### Assembly:

Put pos. 6 on pos. 5, screw pos. 5 to pos. B9 and tighten with using wrench 24. Screw pos. 1 on pos. 6 to the stop and move back a slight amount, so that hexagon pos. 1 and pos. 3 match. Put pos. 2 on pos. 1 and pos. 3, so that hexagon socket pos. 2 match with hexagon pos. 1 and pos. 3, screw on to pos. 5. Tighten the backnut in pos. 2 to the front of pos. 5.

## Step 5

### Disassembly:

Screw pos. B18 out of pos. B9 with using hook spanner 30-32 (MP28). Be careful, pos. B18 is under spring pressure pos. 19 and pos. 20. Gradually slide pos. 19, pos.20, pos. 21, pos. 22, pos. 23 out and put pos. 17 out with using MP32.



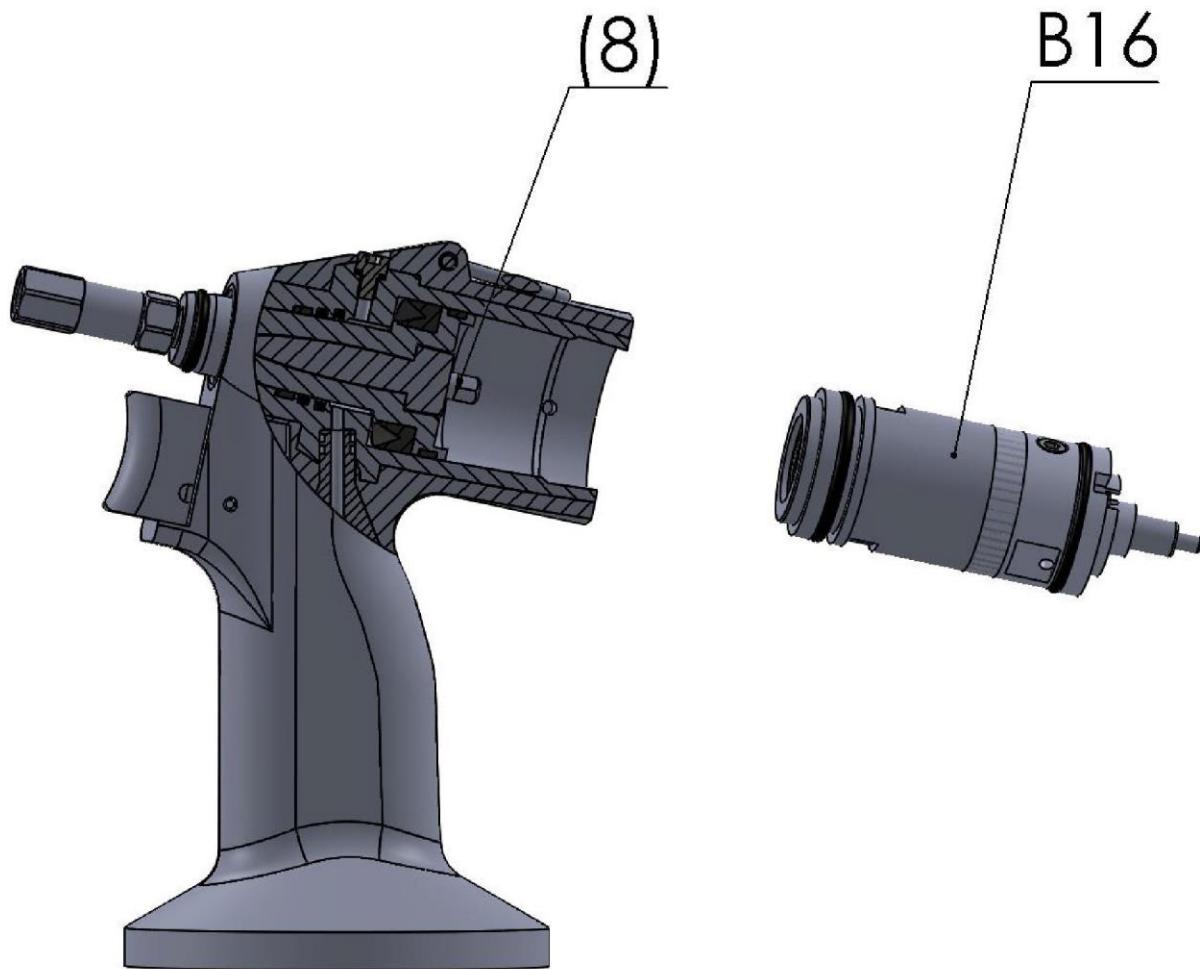
### Assembly:

Put pos. 17 onto pos. B18, gradually put pos. B23, pos. 22, pos. 21, pos. 20 and pos. 19 into pos. B18. Screw this complete into pos. B9 and tighten with using hook spanner 30-32 (MP28). During assembly it is necessary to overcome the force of the springs pos. 19 and pos. 20.

## Step 6

### Disassembly:

Put out pos. B16.



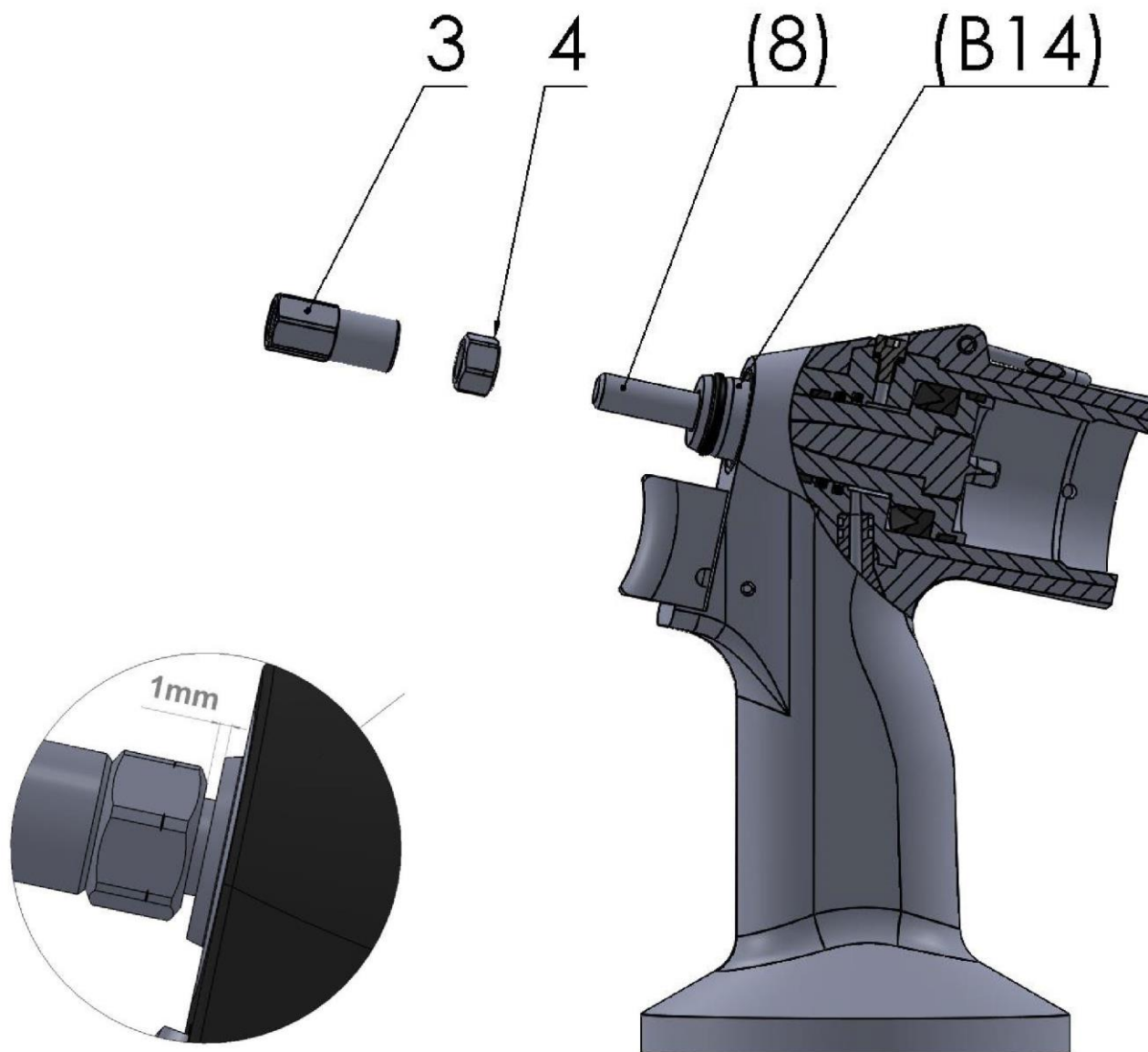
### Assembly:

Put on pos. B16 and move around a slight amount so that hexagon pos. B16 and pos. 8 match, then move pos. B16 to the stop. Turn pos. 3 to check if the installation was successful, rotation in pos. B16 must be obvious and audible.

## Step 7

### Disassembly:

Put wrenches 12 (2x) on pos. 3 and pos. 4, loosen and screw out pos. 3, put hex key on pos. 8 from the inside and screw out pos. 4.



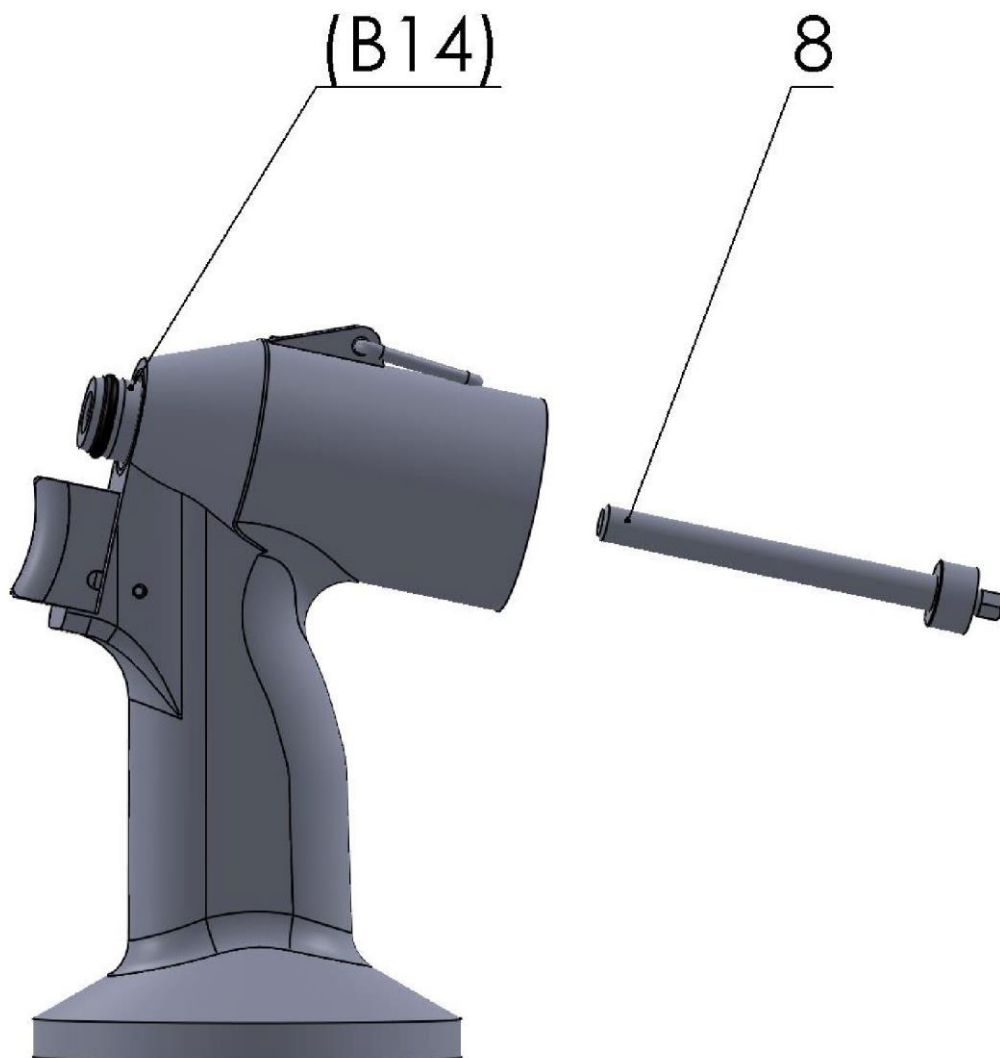
### Assembly:

Screw pos. 4 on pos. 8 (recess in direction to pos. B14) so that the length between pos. 4 and pos. B14 is 1 mm (see the detail). Put several drops of glue LOCTITE 243 on thread of pos. 8, screw on pos. 3, put wrenches 12 (2x) on pos. 3 and pos. 4 and properly tighten towards pos. 4.

**Step 8**

**Disassembly:**

Put pos. 8. out of pos. B14.



**Assembly:**

Put pos. 8 into pos. B14.

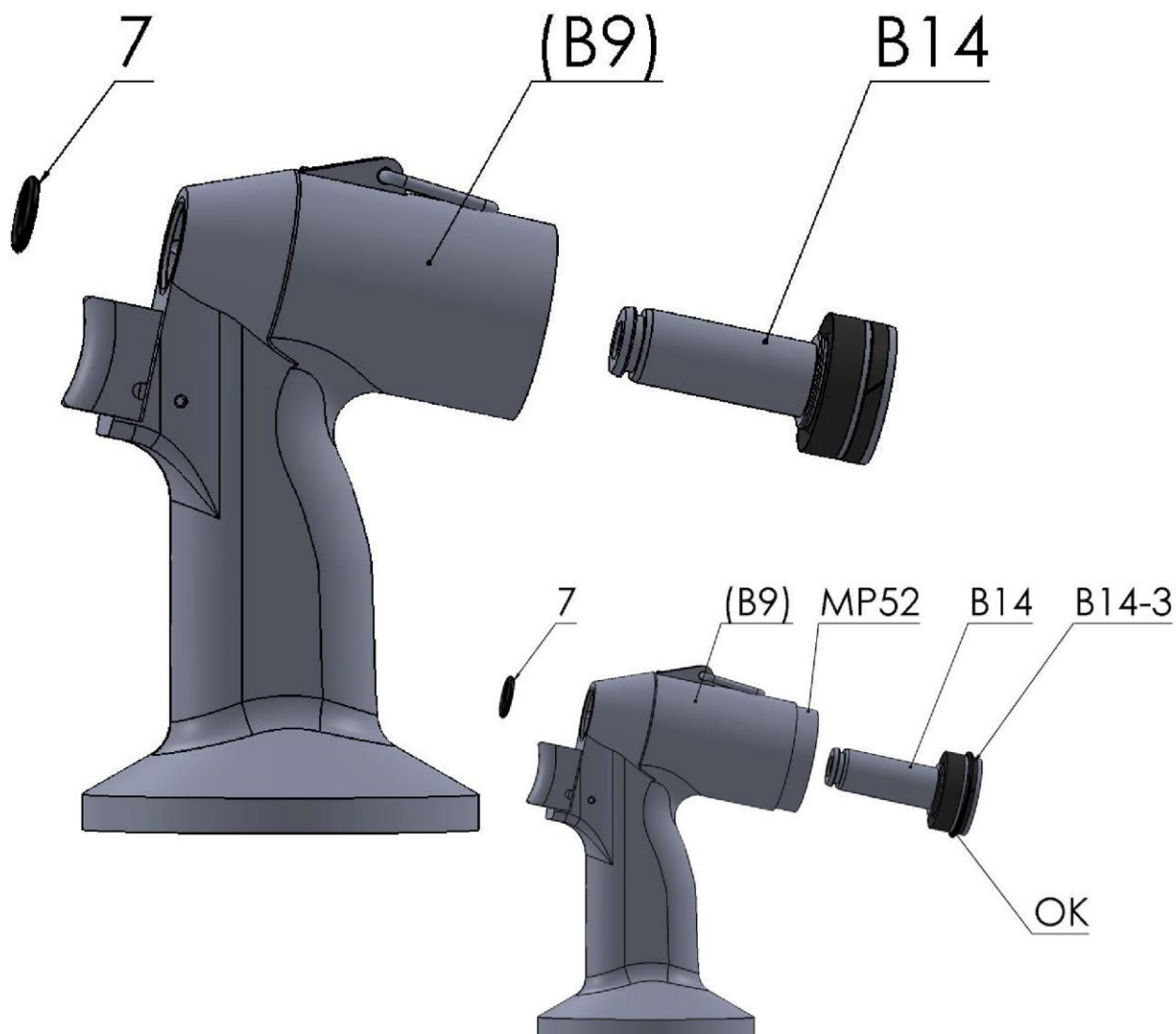


## Step 9

### Disassembly:

Put pos. 7 out of pos. B14 with using MP32. Put pos. B14 out of pos. B9.

! Be careful and do not damage the sealing in pos. B9!



### Assembly:

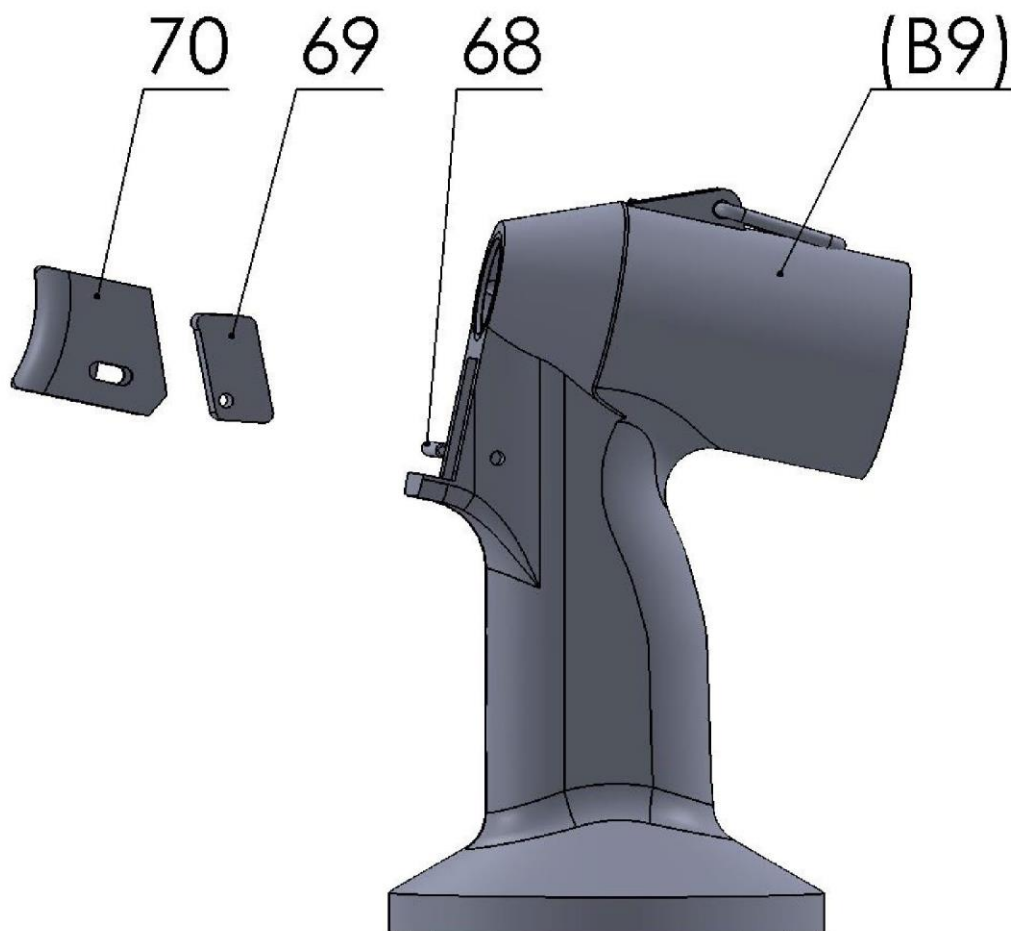
Screw MP52 into pos. B9. Lubricate external surface of pos. B14, inner surface of pos. B9 and related sealing of pos. B14 and pos. B9 with silicon paste LUKOSAN, secure pos. B14-3 in the pos. B14 with O ring 32/3 (see the picture, marked OK), then insert pos. B14 to the pos. B9 to the stop, pos. B14 must slide in pos. B9. Screw MP52 out of pos. B9. Put pos. 7 on pos. B14.

! O ring 32/3 will loosen while inserting pos. B14 to pos. B9, it is not a part of the riveting tool!.

## Step 10

### Disassembly:

Place a pin cca 2,8 mm in diameter to the pos. 68 and knock out with a hammer from pos. B9, put out pos. 70 and pos. 69.



### Assembly:

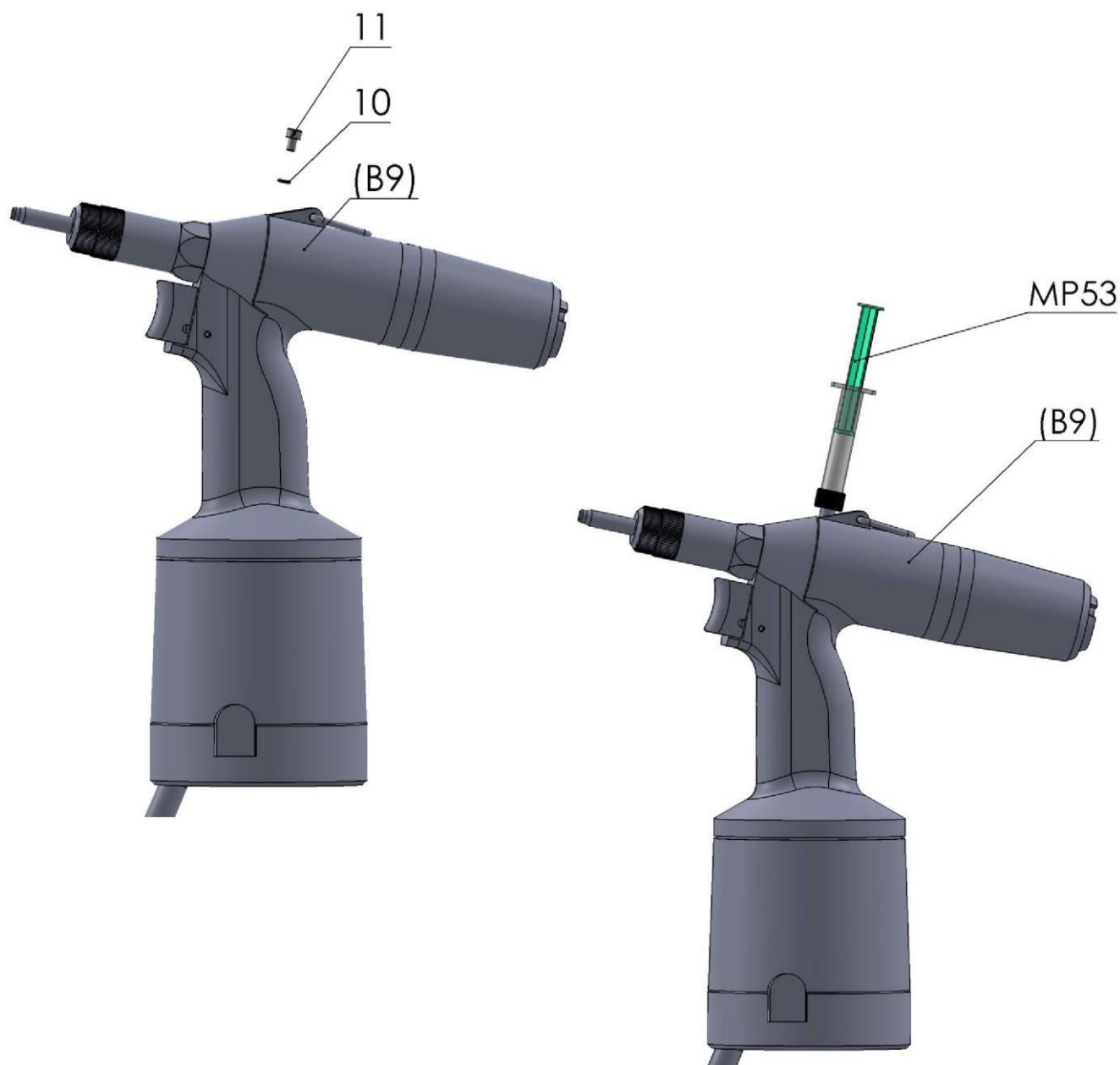
Put pos. 69 to pos. 70 and this complete put into pos. B9, put on pos. 68 and beat in with hammer and a pin cca 2,8 mm in diameter so that the pos. 68 is placed symmetrically in pos. B9 and secure both ends of pos. 68 with paint.

## Step 11

### Oil filling after assembling the tool:

**Connect the tool to the source of CA! Press and release the trigger several times.**

**Disconnect the tool from the source of CA!** Unscrew pos. 11 with socket-screw key no.3. Fill hydraulic oil (from the supplied bottle with hydraulic oil) into MP53, take extra care to avoid air sucking, air must not be present in the hydraulic oil. Screw the MP53 tool into pos. B9 and inject the hydraulic oil into the tool. When the moving part of MP53 tool is released, the redundant oil is returned back to the MP53 tool. Unscrew MP53, screw pos. 11 with pos. 10 back to pos. B9 and tighten with using socket-screw key no.3.



**STANLEY**<sup>®</sup>  
Engineered Fastening



## Holding your world together<sup>®</sup>

Find your closest STANLEY Engineered Fastening location on  
[www.stanleyengineeredfastening.com/contact](http://www.stanleyengineeredfastening.com/contact)  
For an authorized distributor nearby please check  
[www.stanleyengineeredfastening.com/econtact/distributors](http://www.stanleyengineeredfastening.com/econtact/distributors)

Manual Number	Issue	C/N
07900-09603	A2	22/009

© 2022 Stanley Black & Decker, Inc.

Avdel<sup>®</sup>, POP<sup>®</sup> are registered trademarks of Stanley Black & Decker, Inc. and its affiliates. The names and logos of other companies mentioned herein may be trademarks of their respective owners. Data shown is subject to change without prior notice as a result of continuous product development and improvement policy. Your local STANLEY Engineered Fastening representative is at your disposal should you need to confirm latest information.