

Accessories Manual

Original Instruction



ProSet® XT1 Blind Rivet Tool – 76001
ProSet® XT2 Blind Rivet Tool – 76002

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:

- DO NOT use outside the design intent of Placing STANLEY Engineered Fastening Blind Rivets.
- Use only parts, fasteners, and accessories recommended by the manufacturer.
- DO NOT modify the tool in any way. Any modification to the tool is undertaken by the customer and will be the customer's entire responsibility and void any applicable warranties.
- Prior to use, check for misalignment or binding of moving parts, breakage of parts, and any other condition that affects the tool's operation. If damaged, have the tool serviced before using. Remove any adjusting key or wrench before use.
- The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained personnel. Any dismantling procedure will be undertaken only by trained personnel. Do not dismantle this tool without prior reference to the maintenance instructions.
- The operating supply air must not exceed 7 bar (100 PSI).
- Operators and others in work area must wear approved safety glasses with side shields. Always wear safety glasses and ear protection during operation.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.
- DO NOT operate a tool that is directed towards any person(s).
- DO NOT operate tool with the nose casing removed.
- Adopt a firm footing or a stable position before operating the tool.
- Prior to use, inspect airlines for damage, all connections must be secure. Do not drop heavy objects on Hoses. A sharp impact may cause internal damage and lead to premature hose failure.
- DO NOT lift the placing tool by the hose. Always use the placing tool handle.
- Vent holes must not become blocked or covered.
- Disconnect the air hose from the tool before performing any maintenance, attempting to adjust, fit or remove a nose assembly.
- Keep tool handles dry, clean, and free from oil and grease.
- When carrying the tool from place to place keep hands away from the trigger to avoid inadvertent activation.

- Never leave operating tool unattended. Disconnect air hose when tool is not in use.
- Adequate clearance is required for the tool operator's hands before proceeding.
- DO NOT abuse the tool by dropping or using it as a hammer.

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

2. SAFETY RULES

This technical datasheet must be read with particular attention to the safety warnings and operating instructions listed in the ProSet XT1 and ProSet XT2 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 XT1 and ProSet XT2 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 3 to select the correct swivel assembly for the rivet to be placed. For the Constant components refer to table 3 on page 6.

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

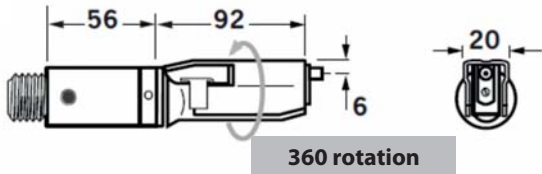


Fig. 2

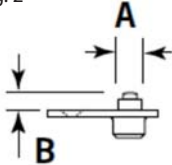
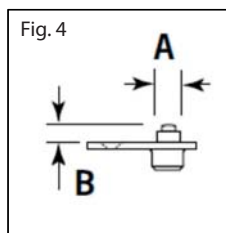
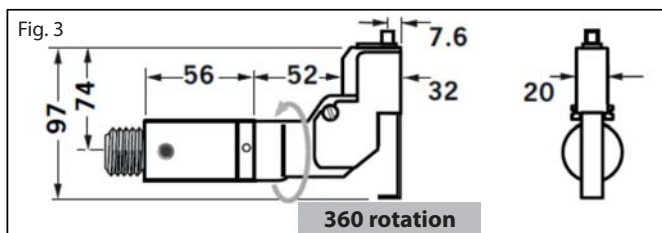


Table 2 - RIGHT-ANGLE SWIVEL HEAD Capability

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 XT1 AND PROSET XT2 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 7.

- The air supply must be disconnected.
- Rotate Collector Bottle Assembly (TRM00227) anti-clockwise and remove from Collector Adapter (TP153-111).
- Unscrew and remove Deflector Retaining Nut (TP144-064) together with Stem Deflector (71213-05101).
- Remove Collector Adapter (TP153-111) together with MCS Valve Pusher (TP144-142), O-Ring (TRM00250) from End Cap (TP153-112).
- Unscrew and remove End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).

- Remove Return Spring (TP144-082) and Ejector Nozzle (TP143-047), Ejector Body (TP144-146) together with O-Ring (TP144-094), O-Ring (TP144-094).
- Rotate Nose Housing (TP144-048) anti-clockwise and remove together with Nosepiece and Nose Housing Nut (TRM00239).
- Rotate Jaw Guide (DPN275-001) anti-clockwise and remove together with Jaw (71210-15001).
- Remove Jaw Pusher (TP144-050) together with Urethane Washer (TP144-088), Jaw Pusher Spring (TP144-081) from Pulling Head (TRM00165).
- Remove Mandrel Guide (TP144-052) from Pulling Head (TRM00165).
- Rotate Lock Nut (TP144-060) anti-clockwise with locked Pulling Head (TRM00165).
- Remove Pulling Head (TRM00165) together with Jaw Guide Lock (TP144-051), Jaw Guide Lock Spring (TP144-080).
- Attach Jaw Spreader Housing (71210-02101) to Hydraulic Piston Adaptor (TRM00123).
- Attach Swivel Head Connector (TRM00496) to Handle Upper Assembly (TRM00222).
- Screw Piston Adaptor (TRM00123) to Hydraulic Piston by hand.
- Screw Lock Nut (TP144-060) to Hydraulic Piston Adaptor (TRM00123) by wrench.
- Install Ejector Assembly (TRM00494) and Return Spring (TP144-082).
- Screw End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).
- Fit Collector Adaptor (TP153-111) together with MCS Valve Pusher (TP144-142).
- Place Collector Adaptor Cover (TRM00033) over Collector Adaptor (TP153-111) and then install Cover Retaining Nut (TRM00090) until the end face of Collector Adapter Cover (TRM00033) is secure against the mating face of Collector Adapter (TP153-111).
- The tool is now ready to be fitted with a swivel head.

Item numbers in **bold** refer to fig. 5 and fig. 6 and the table on page 6.

Fig. 5

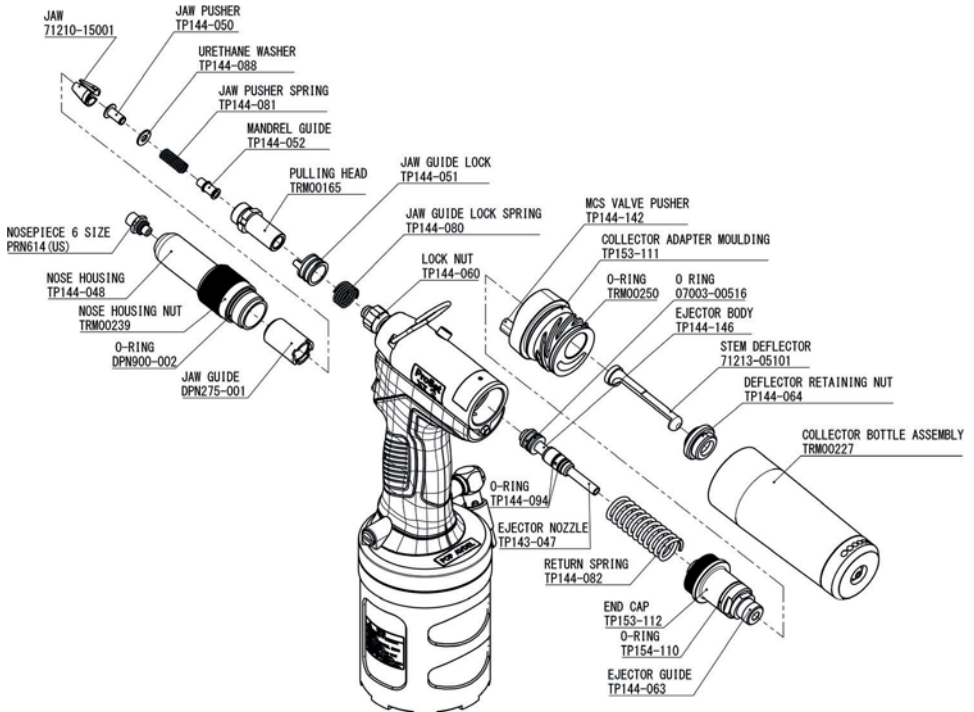
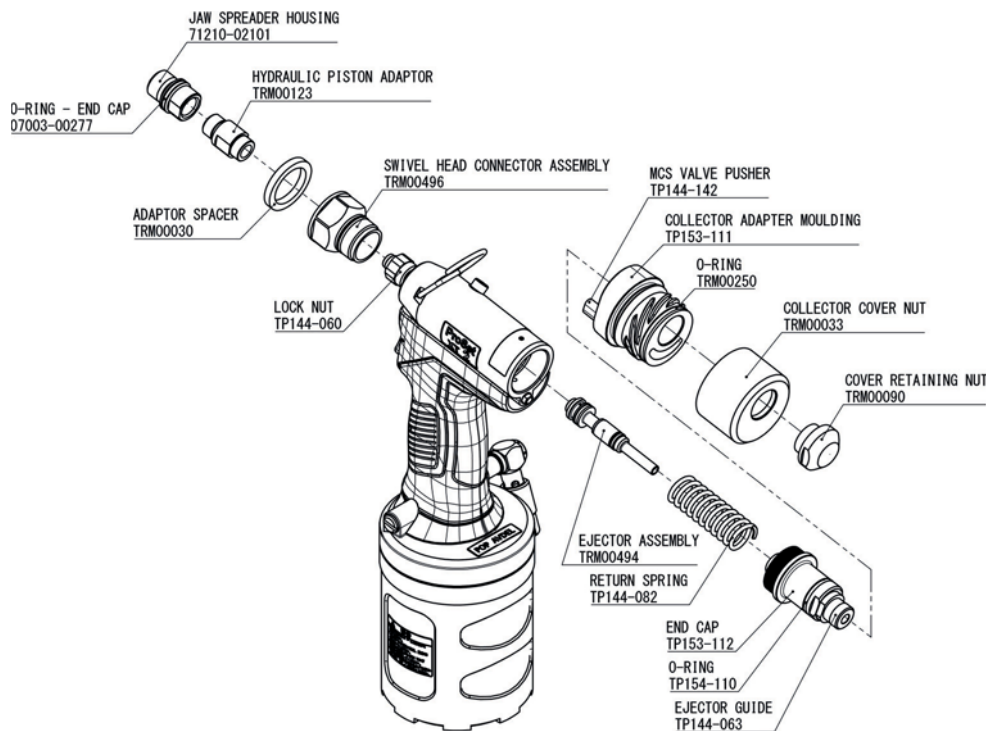


Table 4 - TRM00313 - Swivel Adaptor KIT for XT2			
Item	Part Number	Description	Qty
1	71210-02101	Jaw Spreader Housing	1
2	07003-00277	O-Ring	1
3	TRM00123	Hydraulic Piston Adaptor	1
4	TRM00030	Adaptor Spacer	1
5	TRM00496	Swivel Head Connector Assembly	1
6	TRM00494	Ejector Assembly	1
7	TRM00033	Collector Adaptor Cover	1
8	TRM00090	Cover Retaining Nut	1

Fig. 6



SWIVEL HEAD FITTING INSTRUCTIONS

IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.

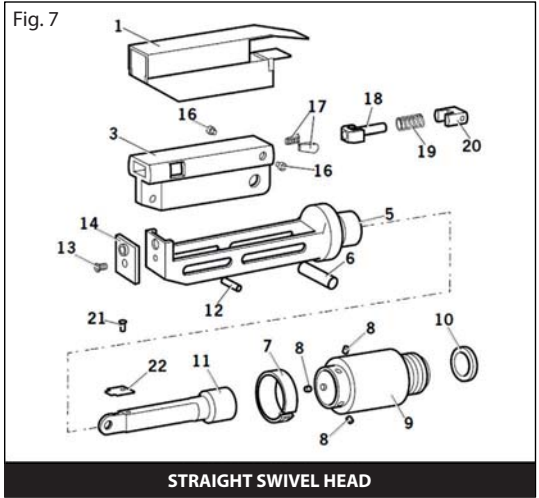
IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE SWIVEL HEAD NOSE ASSEMBLIES.

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'.

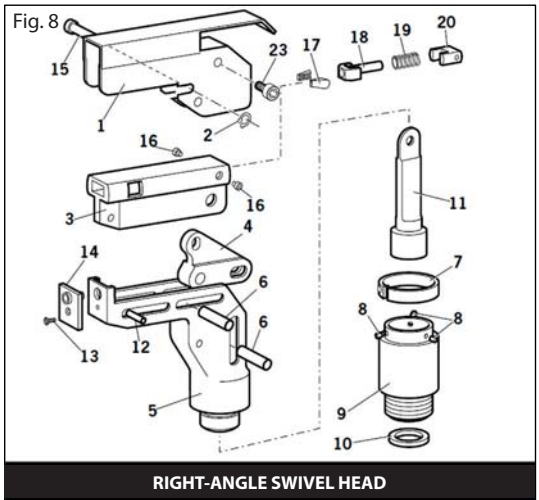
All moving parts should be lubricated. Unless stated otherwise use Moly Lithium grease. Text highlight in grey tint refer only to the right-angle swivel head fitting instructions.

Item numbers in **bold** refer to the components in figures 7 and 8 and the table on page 6.

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.

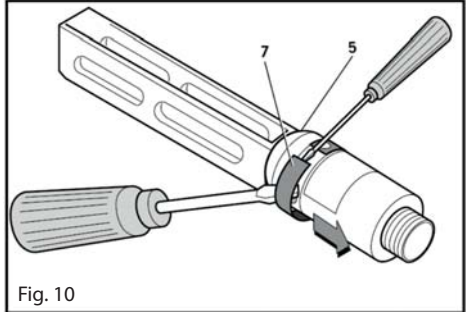
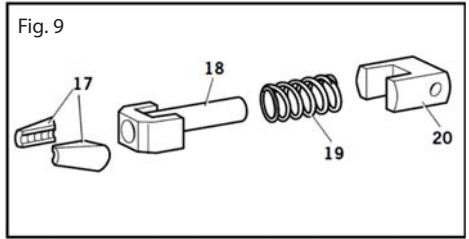
Table 3 - PARTS LIST - STRAIGHT & RIGHT ANGLED SWIVEL HEAD

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

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

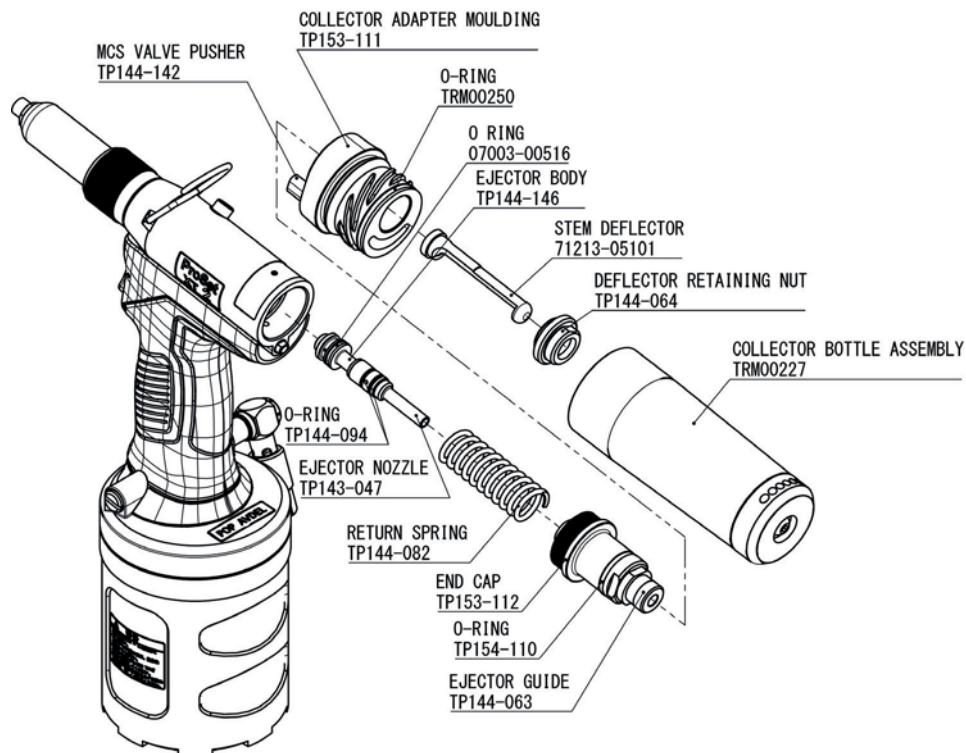
IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.

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 9. Refer also to the ProSet XT1 and ProSet XT2 Service Manuals.

- The air supply must be disconnected.
- Rotate Collector Bottle Assembly (TRM00227) anti-clockwise and remove from the Collector Adapter (TP153-111).
- Unscrew and remove Deflector Retaining Nut (TP144-064) together with the Stem Deflector (71213-05101).
- Remove Collector Adapter (TP153-111) together with MCS Valve Pusher (TP144-142), O-Ring (TRM00250) from End Cap (TP153-112).
- Unscrew and remove End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).
- Remove Return Spring (TP144-082) and Ejector Nozzle (TP143-047), Ejector Body (TP144-146) together with O-Ring (TP144-094), O-Ring (TP144-094).

Fig. 11



FITTING THE PIN TAIL DEFLECTOR KIT

IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 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 page 9. Refer also to the ProSet XT1 and ProSet XT2 Service Manuals.

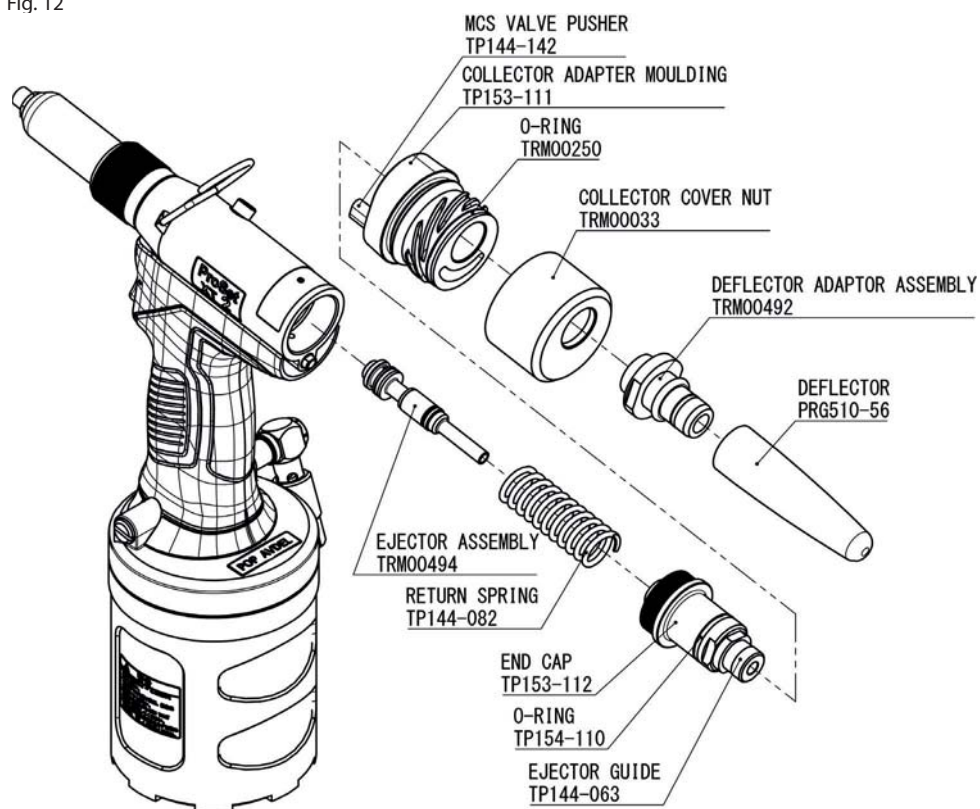
Item numbers in **bold** refer to fig. 12 and table 5, 6.

- The air supply must be disconnected.
- Install Ejector Assembly (TRM00494) and Return Spring (TP144-082).
- Screw End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).
- Fit Collector Adaptor (TP153-111) together with MCS Valve Pusher (TP144-142).
- Place Collector Adaptor Cover (TRM00033) over Collector Adaptor (TP153-111) and then install Deflector Adaptor (TRM00492) until the end face of Collector Adapter Cover (TRM00033) is secure against the mating face of Collector Adapter (TP153-111).
- Fit Deflector (PRG510-56) to Deflector Adaptor (TRM00492).

Table 5 - TRM00305 - DEFLECTOR KIT for XT1			
Item	Part Number	Description	Qty
1	TRM00033	Collector Adaptor Cover	1
2	TRM00492	Deflector Adaptor Assembly	1
3	PRG510-56	Deflector	1
4	TRM00493	Ejector Assembly	1

Table 6 - TRM00306 - DEFLECTOR KIT for XT2			
Item	Part Number	Description	Qty
1	TRM00033	Collector Adaptor Cover	1
2	TRM00492	Deflector Adaptor Assembly	1
3	PRG510-56	Deflector	1
4	TRM00494	Ejector Assembly	1

Fig. 12



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.

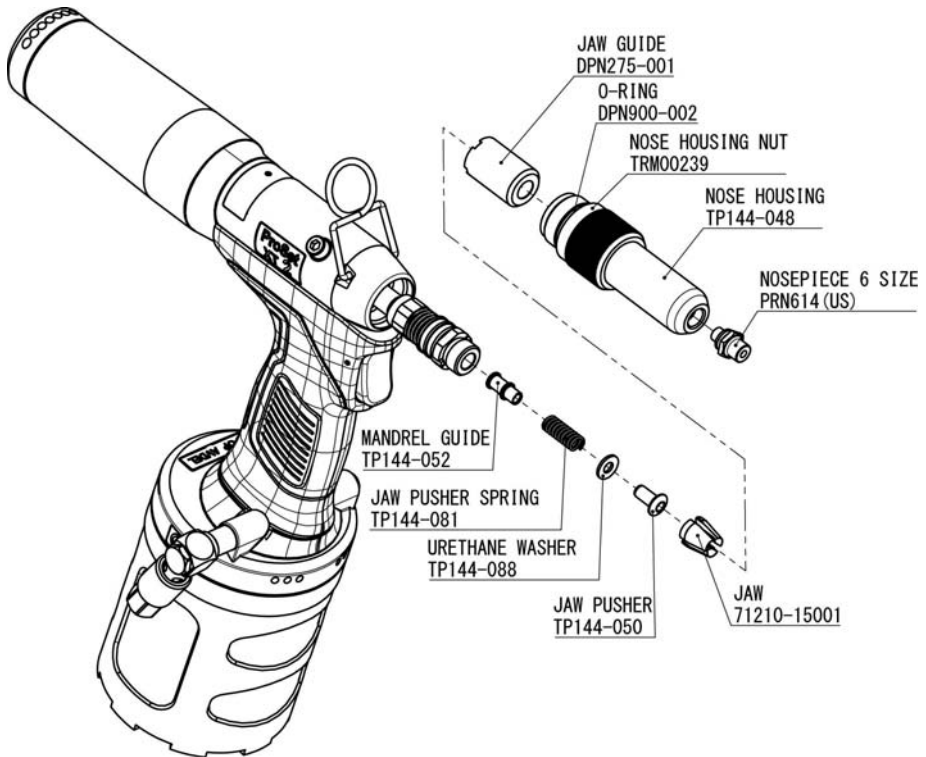
PREPARING THE BASE TOOL TO ACCEPT EXTENSION KIT.

IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 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. 13.

Fig. 13



- The air supply must be disconnected.
- Unscrew Nose Housing (TP144-048), including the Nose Piece (PRN614), Nose Housing Nut (TRM00239), and O Ring (DPN900-002).
- Remove Jaw Pusher (TP144-050) together with Urethane Washer (TP144-088), Jaw Pusher Spring (TP144-081) from Pulling Head (TRM00165).
- Remove Mandrel Guide (TP144-052) from Pulling Head (TRM00165).

FITTING THE NOSE EXTENSION ASSEMBLY

IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 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. 14 and Table 7, 8.

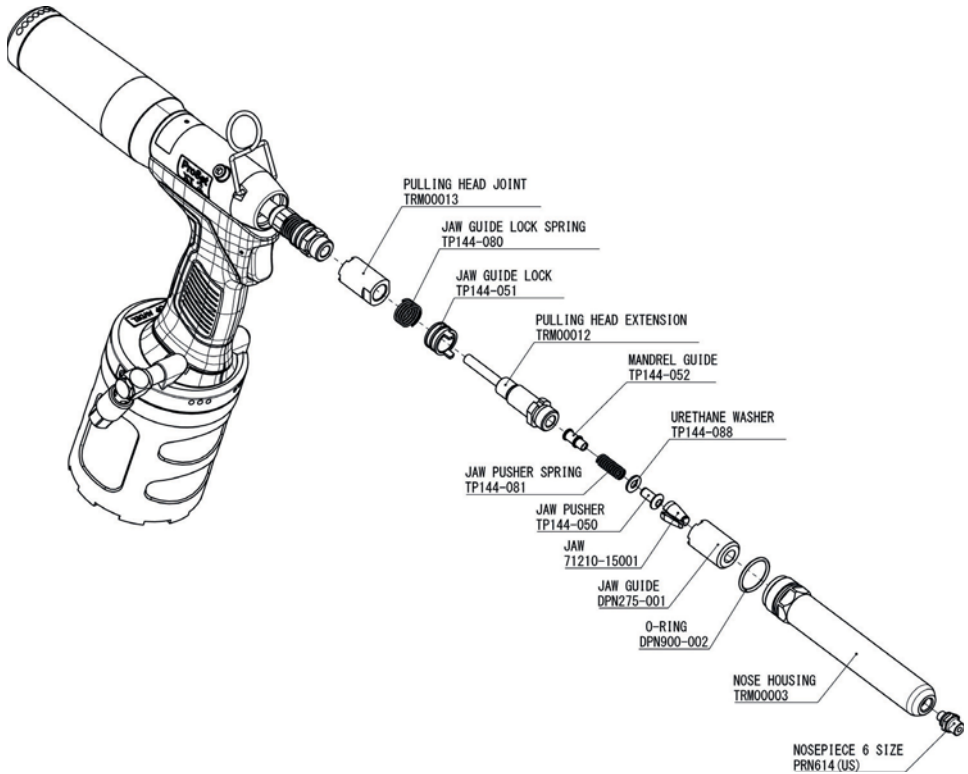
Table 7 - TRM00292 - EXTENSION KIT for XT1

Item	Part Number	Description	Qty
1	TRM00001	Nose Housing	1
2	DPN239-006	Jaw Guide	1
3	PRG402-8A	Jaw	1set
4	TP144-117	Jaw Pusher	1
5	TP144-118	Urethane Washer	1
6	TRM00010	Pulling Head Extension	1
7	TP144-113	Jaw Guide Lock	1
8	TP144-119	Jaw Pusher Spring	1
9	TP144-120	Mandrel Guide	1
10	TP144-114	Jaw Guide Lock Spring	1
11	TRM00011	Pulling Head Joint	1
12	DPN900-002	O-Ring	1
13	TRM00291	Jaw Pusher	1
14	TRM00290	Mandrel Guide Assembly	1

Table 8 - TRM00332 - EXTENSION KIT for XT2

Item	Part Number	Description	Qty
1	TRM00003	Nose Housing	1
2	DPN275-001	Jaw Guide	1
3	71210-15001	Jaw	1set
4	TP144-050	Jaw Pusher	1
5	TP144-088	Urethane Washer	1
6	TRM00012	Pulling Head Extension	1
7	TP144-051	Jaw Guide Lock	1
8	TP144-081	Jaw Pusher Spring	1
9	TP144-052	Mandrel Guide	1
10	TP144-080	Jaw Guide Lock Spring	1
11	TRM00013	Pulling Head Joint	1
12	DPN900-002	O-Ring	1
13	TRM00355	Jaw Pusher for 4,5size	1
14	TRM00295	Mandrel Guide Assembly for 4,5size	1

Fig. 14



- The air supply must be disconnected.
- Install Pulling Head Joint (TRM00013) together with Jaw Guide Lock (TP144-051) and Jaw Guide Lock Spring (TP144-080) to Pulling Head Extension (TRM00012).
- Attach Mandrel Guide (TP144-052) to Pulling Head Extension (TRM00012).
- Attach Jaw Pusher (TP144-050) together with Urethane Washer (TP144-088) and Jaw Pusher Spring (TP144-081) to Pulling Head Extension (TRM00012).
- Install Jaw Guide (DPN275-001) together with Jaw (71210-15001) to Pulling Head Extension (TRM00012).
- Screw Nose Housing (TRM00003) together with Nosepiece and O-Ring (DPN900-002) to Handle Upper Assembly (TRM00222).

7. 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

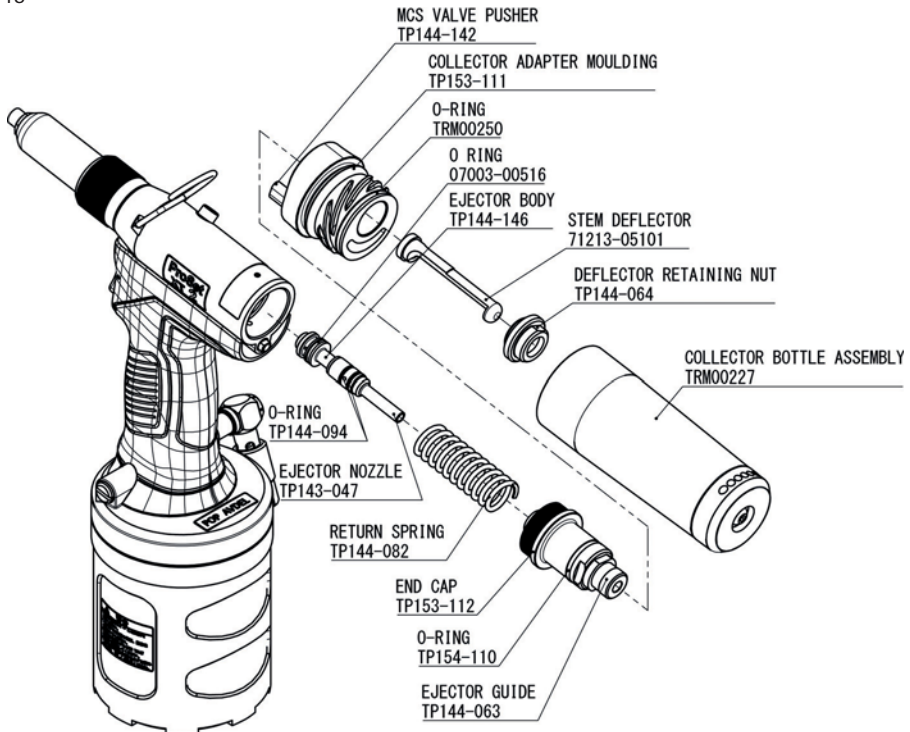
IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.

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 XT1 and ProSet XT2 Service Manuals.

- The air supply must be disconnected.
- Rotate Collector Bottle Assembly (TRM00227) anti-clockwise and remove from Collector Adapter (TP153-111).
- Unscrew and remove Deflector Retaining Nut (TP144-064) together with Stem Deflector (71213-05101).
- Remove Collector Adapter (TP153-111) together with MCS Valve Pusher (TP144-142), O-Ring (TRM00250) from End Cap (TP153-112).
- Unscrew and remove End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).
- Remove Return Spring (TP144-082) and Ejector Nozzle (TP143-047), Ejector Body (TP144-146) together with O-Ring (TP144-094), O-Ring (TP144-094).

Fig. 18



FITTING THE MCS5000 ADAPTER KITS

IMPORTANT - READ THE SAFETY WARNINGS LISTED IN THE PROSET XT1 AND PROSET XT2 INSTRUCTION MANUAL CAREFULLY BEFORE PUTTING INTO SERVICE.

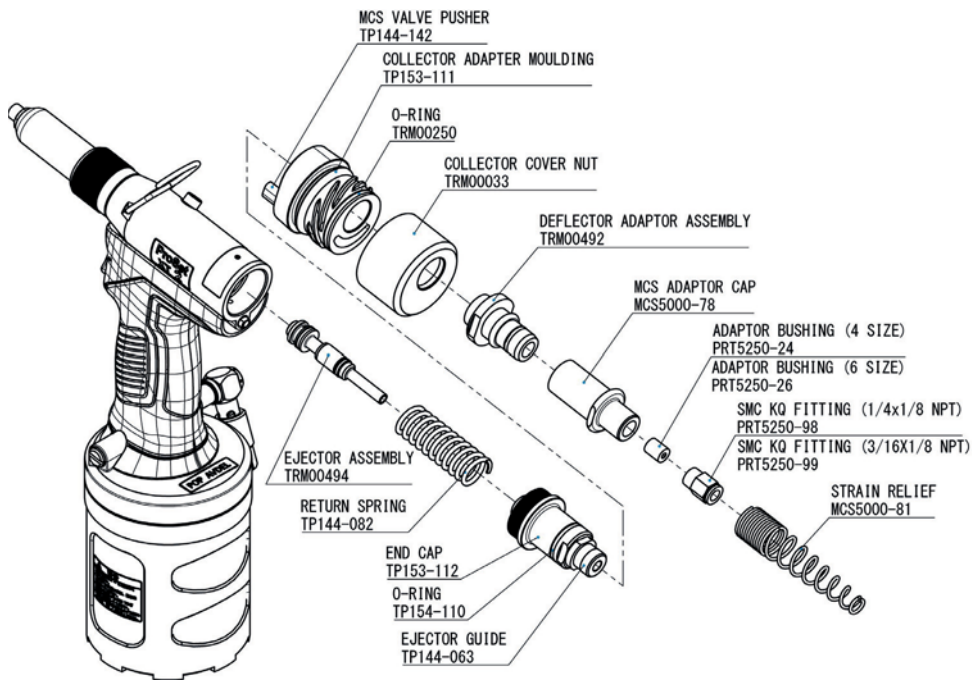
IMPORTANT - THE AIR SUPPLY MUST BE TURNED OFF OR DISCONNECTED BEFORE FITTING OR REMOVING THE MCS5000 ADAPTER KITS.

Refer to fig. 19 and the table 9,10 below.

Table 9 - TRM00309 - MCS5000 ADAPTOR KIT for XT1			
Item	Part Number	Description	Qty
1	TRM00033	Collector Adaptor Cover	1
2	TRM00492	Deflector Adaptor Assembly	1
3	TRM00493	Ejector Assembly	1

Table10 - TRM00310 - MCS5000 ADAPTOR KIT for XT2			
Item	Part Number	Description	Qty
1	TRM00033	Collector Adaptor Cover	1
2	TRM00492	Deflector Adaptor Assembly	1
3	TRM00494	Ejector Assembly	1

Fig. 19



Item numbers in bold refer to fig. 19 and table 9.

- The air supply must be disconnected.
- Install Ejector Assembly (TRM00494) and Return Spring (TP144-082).
- Screw End Cap (TP153-112) together with O-Ring (TP154-110), Ejector Guide (TP144-063).
- Fit Collector Adaptor (TP153-111) together with MCS Valve Pusher (TP144-142).
- Place Collector Adaptor Cover (TRM00033) over Collector Adaptor (TP153-111) and then install Deflector Adaptor (TRM00492) until the end face of Collector Adapter Cover (TRM00033) is secure against the mating face of Collector Adapter (TP153-111).
- Screw SMC KQ Fitting (PRT5250-98 or PRT5250-99) together with Adaptor Bushing (4 or 6 size) to MCS Adaptor Cap (MCS5000-78).
- Fit MCS Adaptor Cap (MCS5000-78) to Deflector Adaptor Assembly (TRM00492).
- Attach Strain Relief (MCS5000-81) to Adaptor Bushing (4 or 6 size).
- Connect the Tool and MCS5000 kit to the MCS5000 unit as instructed within the MCS5000 datasheet.



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