

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

General Information

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

The Maximum Air Pressure is 95 PSI At Tool.

Specifications

Rivet Setting Capacity	1/4" diameter
Traction power	3055 lbs
Operating air pressure	85-95 PSI
Air consumption	5 CFM
Air Inlet	1/4" N.P.T.
Overall height	12"
Net weight	4.2 lbs.

Accessories

The V-4 is packaged in a compartment storage container. Wrenches needed to service the tool are included. Special SPANNER (41) and SPANNER GAUGE (40) has a cut-out gauge used in adjusting the tool as described below.

Also included: Safety Cap (26) to catch ejected mandrels when attached to the back of the tool.

Maintenance

In order to achieve maximum efficiency and economy, the Marson V-4 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 (5) 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-4 from the air pressure line before proceeding with inspection or repairs. Use SPANNER (41) to remove FRAME HEAD (13) and JAW CASE FRONT (3, 31). At the same time, hold the JAW CASE REAR (4) with the SPANNER GAUGE (40). 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 (7, 8) engages the conical parts of the JAWS. **DO NOT CHANGE THE POSITION OF PARTS (4) and (14).** If these parts are inadvertently changed, see readjustment instructions under "Malfunction."

2. Changing Nosepiece

Connect V-4 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 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 95 PSI at tool. Make sure all fittings including FRAME CAP (24) and FRAME HEAD (13) are tight. If malfunction persists, add oil as follows:

Disassemble AIR CYLINDER (33), 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 (3, 31) away from FRAME (17). OIL PISTON (18) should bottom its stroke automatically when removing FRAME HEAD (13). If JAW CASE FRONT (3, 31) moves downward by hand power, then RETURN SPRINGS (21, 22) may need replacing. 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 (33) or FRAME HEAD (13). If oil is found in any of these areas, replace O-RING (15, 16, 29) as needed. Reassemble tool.

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

CAUSE: JAW CASE REAR (4) 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 (3, 31) is approximately ". 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 (4) too far forward.

REPAIR: See procedure under Section 2 above.



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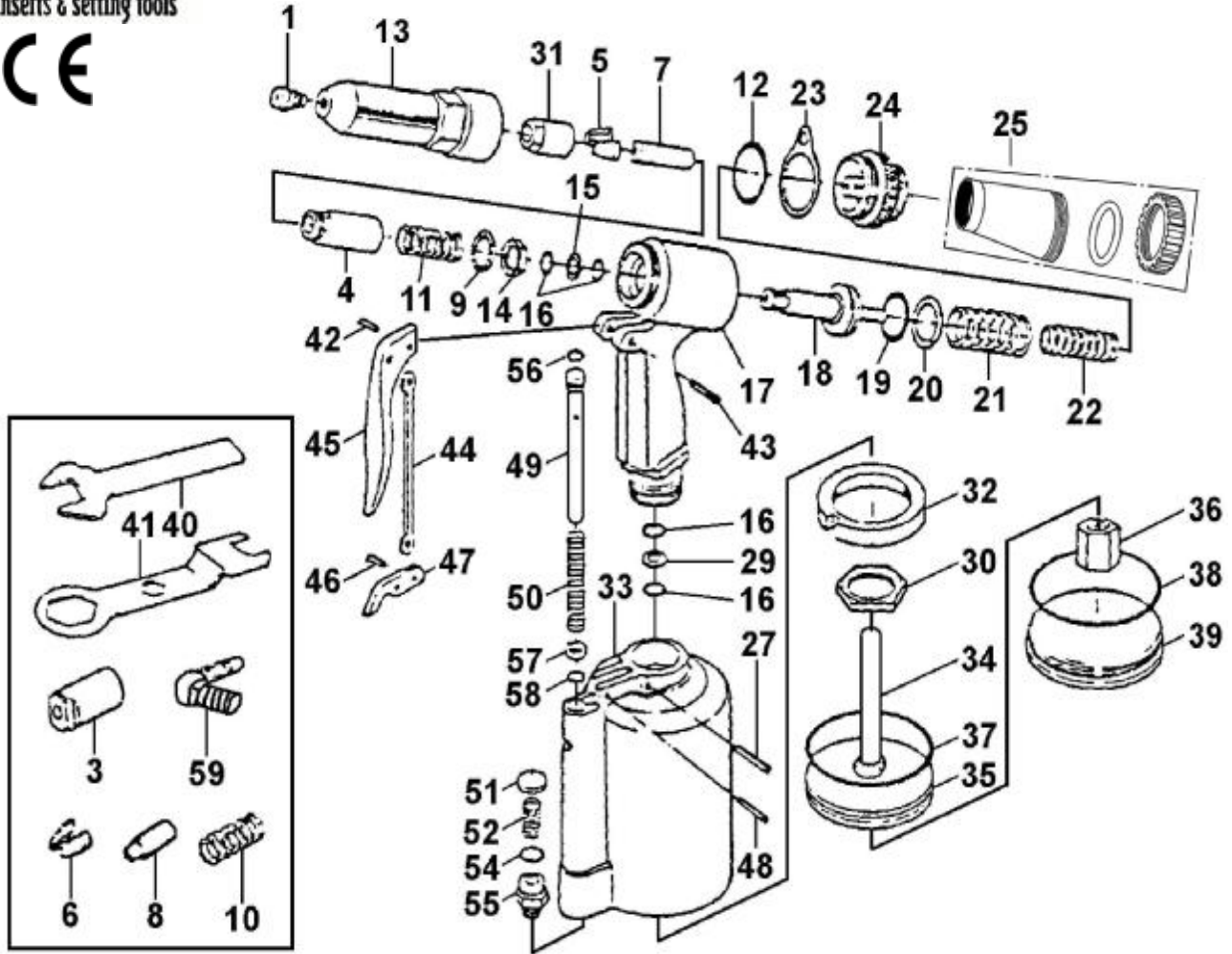


Rivets, inserts & setting tools



Instructions and Parts List - #79060

V-4 AIR / HYDRAULIC RIVETER TOOL



Ref. No.	Part No.	Description	Q'ty /Tool	Ref. No.	Part No.	Description	Q'ty /Tool	Ref. No.	Part No.	Description	Q'ty /Tool
1	95835	Nosepiece (1/4")	1	18	95850	Oil Piston	1	42	95873	Connector	1
	95897	Nosepiece (3/32")	1	19	95851	O-Ring 23.7x3.5	1	43	95889	Hander Pin	1
	95898	Nosepiece (1/8")	1	20	95852	Back Up Ring	1	44	95977	Trigger Rod	1
	95899	Nosepiece (5/32")	1	21	95853	Return Spring (Large)	1	45	95978	Trigger	1
	95900	Nosepiece (3/16")	1	22	95854	Return Spring (Samll)	1	46	95875	Connector	1
3	95837	Jaw Case Front Tart (for 3/32", 1/8", 5/32")	1	23	95855	Hanging Clip	1	47	95877	Trigger Lever	1
				24	95856	Frame Cap	1	48	95864	Lever Pin	1
4	95843	Jaw Case Rear	1	25	95908	Safety Cap	1	49	95979	Valve Pusher 99	1
5	95839	Jaw (large)	1 set	27	95863	Frame Setting Pin	1	50	95980	Valve Spring	1
6	95840	Jaw (small)	1set	29	95971	Back Up Ring	1	51	95981	Valve	1
7	95841	Jaw Pusher for 1/4", 3/16"	1	30	95972	Frame Lock Nut	1	52	95982	Valve Spring	1
8	95842	Jaw Pusher for 3/32", 3/32", 1/8", 5/32"	1	31	95838	Jaw Case Front for 1/4",3/16"	1	54	95983	O-Ring 10.8x2.4	1
				32	95973	Rubber Cushion	1	55	95964	Valve Cap	1
9	95846	Case Washer Ring	1	33	95974	Air Cylinder	1	57	95965	Valve Collar	1
10	95844	Spring (5/32")	1	34	95990	Air Piston Stem	1	58	95986	O-Ring 4.8x1.9	1
11	95845	Spring (1/4")	1	35	95889	Air Piston	1	59	95987	Inlet Bushing Nut	1
12	95780	O-Ring 27X2	1	36	95870	Air Piston Lock Nut	1	RK	95988	Repair Kit Ref. No.-- 5, 6, 10, 11, 20, 21, 22	1
13	95836	Frame Head	1	37	95868	O-Ring 69.6x5.7	1				
14	95847	Case Lock Nut	1	38	95871	O-Ring 73x2.8	1				
15	95849	Back Up Ring	1	39	95872	Cylinder Cap	1	SK	95989	Service Kit Ref.No.-- 10, 11, 12, 16(x4), 19, 37, 38, 50, 52, 54, 56, 58	1
16	95848	O-Ring 11.8x2.4	1	40	95894	Spanner Gauge	1				
17	95970	Frame	4	41	95976	Spanner	1				