

RIV302-E Heavy Duty Riveter / 39062



This durable air/hydraulic riveter, with its fully adjustable vacuum system that holds the rivet in the nosepiece, allowing the operator to rivet at any angle with one hand free. The vacuum system automatically collects the spent mandrel into a bottle, creating a cleaner, safer work environment by preventing spent mandrels from falling to the floor. A traction pulling power of 2,000 lbs. allows this tool to easily install 3/32" to 3/16" diameter rivets in all alloys, and 1/4" diameter open-end rivets in aluminum/steel combination. A swivel air inlet along with a push button trigger and molded frame which provides the operator with maximum comfort using minimal effort.

The recommended airline pressure is 85-95 PSI.

Weight: 4 lbs.



**Alcoa
Fastening
Systems**



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AIR FEED

Use only compressed air. Check airline for damage from humidity & contaminants. In order to protect the tool from premature wear, we recommend the use of a filter, lubricator & regulator. Normal working pressure is 85-95 PSI. Air connection size ¼" NPT.

WARNING: Do not use air supply greater than recommended or tool may be damaged or burst.

NORMAL OPERATION

The 302-E is a durable, light weight, ergonomically designed rivet tool used for upsetting 3/32" to 3/16" diameter rivets in all alloys, and ¼" diameter open-end rivets in aluminum/steel. The 304-E features 3 jaw construction and is fully self-adjusting. To change size of rivet simply change nosepiece. No other adjustments are necessary. (To change nosepiece see section on changing nosepieces)

**WARNING:
ALWAYS WEAR SAFETY GLASSES WHEN OPERATING TOOL**

Install mandrel container (21) on back of tool. (Refer to drawing). Install air fitting in connection (44). Attach tool to air pressure between 85-95 PSI. You are now ready to work. Pointing tool away from people and objects, test by pulling trigger once or twice. When tool is new, or has been sitting idle overnight, or in the cold it may not function on first pull. THIS IS NORMAL.

Rivets mandrels are ejected from the back of the tool into a special container. By moving the lever (28) you can adjust the vacuum power. If a larger container is required, mandrels may be ejected through a tube (not supplied) which must be connected directly to the riveting tool by the connector (19) after removing the mandrel container (21).

WARNING: FAILURE TO USE COLLECTION BOTTLE, OR TUBE AS INSTRUCTED MAY RESULT IN INJURY.

WARNING: DO NOT USE OXYGEN, COMBUSTIBLE GASES OR BOTTLED GASES, AS A SOURCE FOR THIS TOOL IT MAY CAUSE IT TO EXPLODE.

**WARNING: ALWAYS WEAR SAFETY GLASSES
WHEN OPERATING AND PERFORMING MAINTENANCE ON TOOL**

MAINTENANCE

ADDITION OF HYDRAULIC FLUID

Tool is shipped with oil. If it becomes necessary to add oil, follow this procedure. Put tool in a horizontal position. Remove plug (43). Pour hydraulic fluid into container (77). Screw container into fluid plug receptacle. Oil level should reach edge of fill hole. With container still attached, reconnect to air supply. Actuate trigger button 5 or 6 six times, or until air bubbles inside the container stop. This releases any entrapped air.

IMPORTANT: Use only Anti-Foam Hydraulic Fluid or equivalent air tool oil.

CHANGING NOSEPIECES

1. Select proper nosepiece
2. Disconnect tool from air supply.
3. Using wrench (supplied), unscrew nosepiece from frame head (2) & replace with proper size nosepiece. Store unused nosepiece in holder (78).
4. Reconnect air supply.
5. Pointing tool away from people & object, push trigger button & hold. Snug down with wrench. DO NOT OVERTIGHTEN.

Your tool is now ready to work. Insert rivet mandrel into nosepiece. Insert rivet into predrilled hole in application material, push trigger button (29) & release.

CLEANING & CHANGING OF JAWS

With use, the jaws of the tool may become dirty. This will cause slipping of the rivet mandrel & and improper setting of the rivet. To clean the jaws follow this procedure.

1. Disconnect air supply
2. Use a suitable wrench, unscrew frame head (2) & remove
3. using a pair of wrenches, disassemble front jaw case (4) from rear jaw case (11).
DO NOT MOVE rear jaw case as this will affect tool operation.
4. To clean jaws, use a stiff dry wire brush.
5. If excessive wear is apparent, replace with new jaws.
6. Reassemble in reverse order.

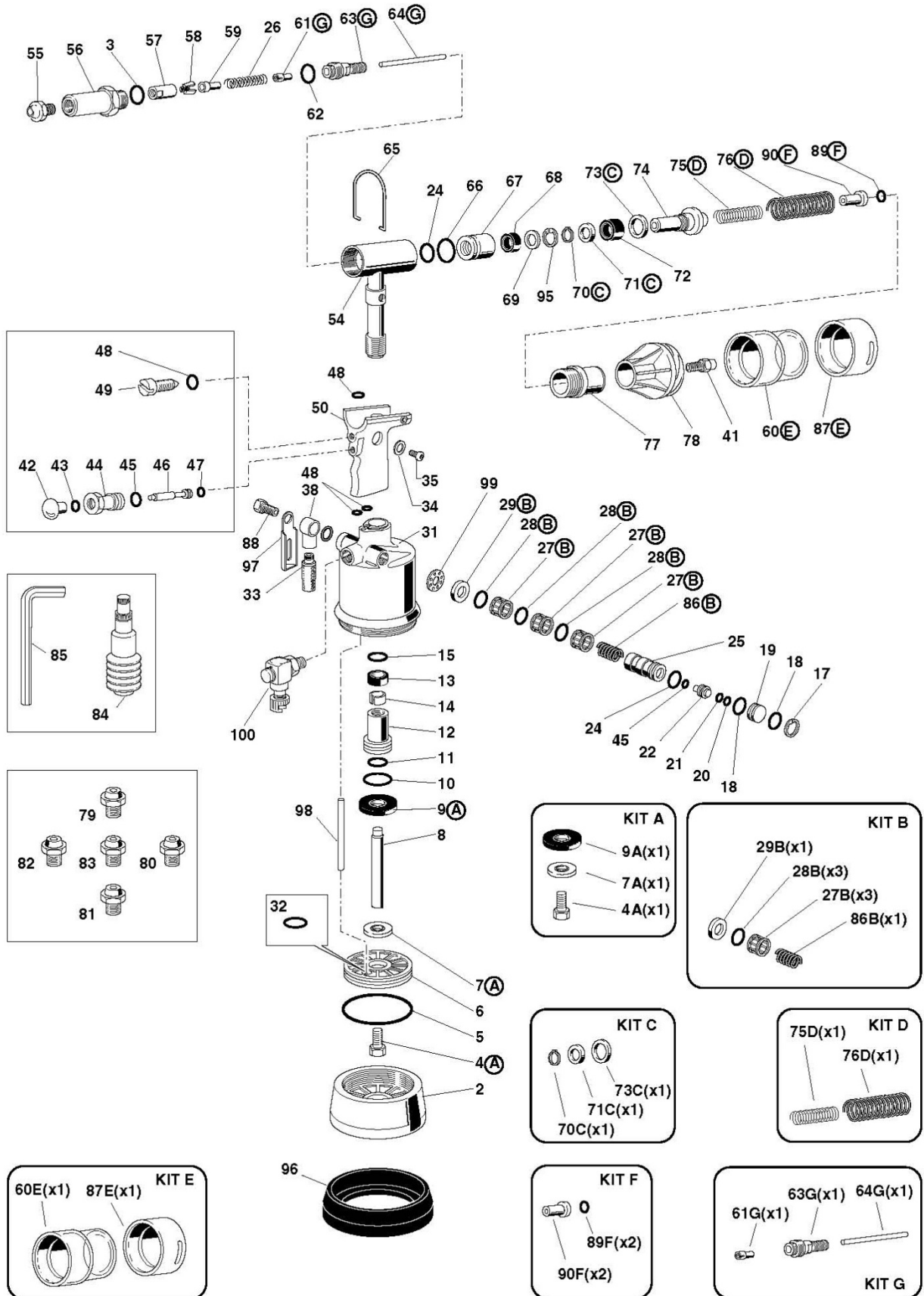
Further maintenance is beyond the scope of this direction sheet. If the tool fails to function properly, return to an authorized repair station or the factory for service.

LIMITED TOOL WARRANTY

Alcoa Fastening System Marson division warrants that this tool will be free from defects in material and workmanship under normal service and for ninety (90) days from the date of purchase. This warranty applies to the purchaser of the tool for original use only. All other warranties, whether expressed or implied, including any warranties of merchantability or fitness for purpose are hereby excluded.

Should this tool fail during this ninety (90) day period, and no unauthorized repairs have been made, return the tool freight prepaid to the factory for free of charge replacement of any part or parts found by Alcoa Fastening System Marson division to be defective due to faulty material or workmanship. This represents the sole obligation of Alcoa Fastening System Marson under this warranty. In no event shall Alcoa Fastening System Marson division be liable for any consequential or special damages arising from the purchase or use of this tool. You may have other rights which vary from state to state.

302-E Heavy Duty Riveter / 39064 Parts Breakdown



Ref #	Part #	Description	Qty	Ref #	Part #	Description	Qty
2	712716	Cover	1	74	88074	Piston	1
3	88003	O'Ring 020	1	75D	see below	Interior spring reversal piston	1
5	88005	O'Ring 2-337	1	76D	see below	Exterior spring reversal piston	1
6	88006	Pneumatic piston	1	77	88077	Plug guide spring	1
8	88008	Stem	1	78	88078	Container connector	1
9A	see below	Dampener	1	79	717006	3/32" Nosepiece	1
11	88011	O'Ring 5/615 Parker	1	80	717001	1/8" Nosepiece	1
12	88012	Guide stem connector	1	81	717002	5/32" Nosepiece	1
14	88014	Seal TS 12-19-5,7/L	1	82	717003	3/16" Nosepiece	1
17	88017	Seeger ring I22	1	83	88371	1/4" Nosepiece	1
18	88018	O'Ring 018D	2	84	88220-77	Oil container	1
20	88020	Seeger ring I11	1	85	88220-76	Key 5mm	1
21	88021	O'Ring 5/612 Parker	1	86B	see below	Spring	1
22	88022	Valve piston	1	87E	see below	Air conveyor	1
24	88024	O'Ring 2/15 Parker	2	88	88220-45	Connector 1631/01-1/4	1
25	88025	Coil	1	89F	see below	O Ring 010 D	1
26	88026	Clamps return springs	1	90F	see below	Bush	1
27B	see below	Casing	3	95	88095	Seeger ring JV22	1
28B	see below	O'Ring 2/115 Parker	3	96	88096	Protection bottom	1
29B	see below	Valve spacer	1	97	712162	Outside silencer protection	1
31	88031	Tool body	1	98	88098	Tube 0 8x7	1
32	88032	O'Ring 2/109 Parker	1	99	88030	Washer stopper spring	1
33	88033	Silencer 1/4	1	100	88100	Rotating connector	1
34	88034	Hermetic washer 400-820	1				
35	88035	Oil tank plug	1	KIT A	740837	Screw Stem Kit	
38	88038	Connector 2023	1	4A	88004	Screw stem	1
41	88041	Out put connector	1	7A	88007	Flatwasher	1
42	88042	Push-button	1	9A	88009	Dampener	1
43	88043	O'Ring 2/4 Parker	1				
44	88044	Valve body	1	KIT B	748040	Valve spacer kit	
45	88045	O'Ring 008 D	2	27B	88027	Casing	3
46	88046	Valve piston	1	28B	710921	O Ring 2/15 Parker	3
47	88047	O'Ring 2/5 Parker	1	29B	88029	Spacer	1
48	88023	O'Ring 006 D	4	86B	88126	Spring	1
49	88049	Suction adjustment knob	1				
50	88050	Handgrip	1	KIT C	740821	Anti-extrusion ring kit	
54	88054	Oil-dynamic cylinder	1	70C	88070	Seeger ring AV16	1
55	88055	Nozzle for rivet ° 4,8 Cu/Steel	1	71C	88071	Stop ring	1
56	88056	Head carrying nozzle	1	73C	88073	Anti-extrusion ring	1
57	88057	Clamps holding cone	1				
58	88058	Clamps	3	KIT D	740851	spring reversal piston kit	
59	88059	Clamps opener	1	75D	88075	Interior spring reversal piston	1
60E	see below	Nails container	1	76D	88076	Exterior spring reversal kit	1
61G	see below	Suction tube	1				
62	88062	O'Ring 113 D	1	KIT E	740819	Nails container kit	
63G	see below	Cone holder	1	60E	710819	Nails container	1
64G	see below	Expeller extension	1	87E	88220-22	air conveyor	1
65	88065	Balancer hook	1				
66	88066	O'Ring 2/118 Parker	1	KIT F	741401	Bush kit	
67	88067	Sleeving gasket	1	89F	88089	O Ring 010D	2
68	88068	Balsele B086055	1	90F	88090	Bush	2
69	88069	Flat washer Al. 14x22x1,5	1				
70C	see below	Seeger ring AV16	1	KIT G	740858	Cone Holder kiit	
71C	see below	Stop ring	1	61G	88061	suction tube	1
72	88072	Balsele B102070	1	63G	88063	Cone holder	1
73C	see below	Anti-extrusion ring	1	64G	710832	Cone holderExpeller extension	1