304-E Heavy Duty Riveter / 39064

This is our most powerful air/hydraulic riveter, with its fully 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 4200 lbs. allows this tool to easily set structural rivets such as Klik-Lock® and other structural blind rivets. Its long 7/8" stroke enables the tool to set most rivets in one pull. In addition to the nosepieces for structural rivets, nosepieces to install 3/16" and 1/4" standard rivets are also included 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: 5 1/2 lbs.

INDUSTRIES MIRATECH
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Alcoa Fastening Systems

ALCOA

marson

Industries Miratech Inc.
900, boul. Michèle-Bohec
Blainville, Qc , J7C 5E2
Tel: 450-939-5289
Fax : 450-939-5290
www.miratech.ca

AIR FEED

(171)

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 304-E is a heavy-duty, light weight, ergonomically designed long stroke tool used for upsetting 3/16", ¼" and 5/16'' standard and structural break mandrel blind rivets. It has a traction pulling power of 4200 lbs. 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)
NOTE: When setting Structural Rivets such as Marson Klik-Lock™, Huck Maga-Lock™ or any other similar type Structural Rivets, it will be necessary for you to change supplied collet case (96), jaws (95) and use the appropriate size nosepieces (91, 92, 93 or 94) for the rivet diameter you are installing.

WARNING:
ALWAYS WEAR SAFETY GLASSES WHEN OPERATING TOOL

Install mandrel container (33) onto back of tool. (Refer to drawing). 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.

Rivet mandrels after setting are ejected into mandrel container (33) automatically if the vacuum system is activated. Vacuum system is activated by moving lever (43) which turns vacuum system on or off.

WARNING! If mandrel container is not going to be used you must insert part number (32) into back of tool after removing mandrel container (33) so that spent will be deflected downward.

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 (50). Screw hydraulic fluid bottle container (87) 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 such as Mobil DTE 24 or equivalent air tool oil.

CHANGING NOSEPIECES

1. Select proper nosepiece from nosepiece holder (88)
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 (88).
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 (44) & release.

CLEANING & CHANGING OF JAWS

With use, the jaws of the tool may become dirty or worn. 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 (9). 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 the factory for service.

LIMITED TOOL WARRANTY

Alcoa Fastening Systems - 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 Systems - Marson under this warranty. In no event shall Alcoa Fastening Systems - 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.

304-E Heavy Duty Riveter / 39064 Parts Breakdown

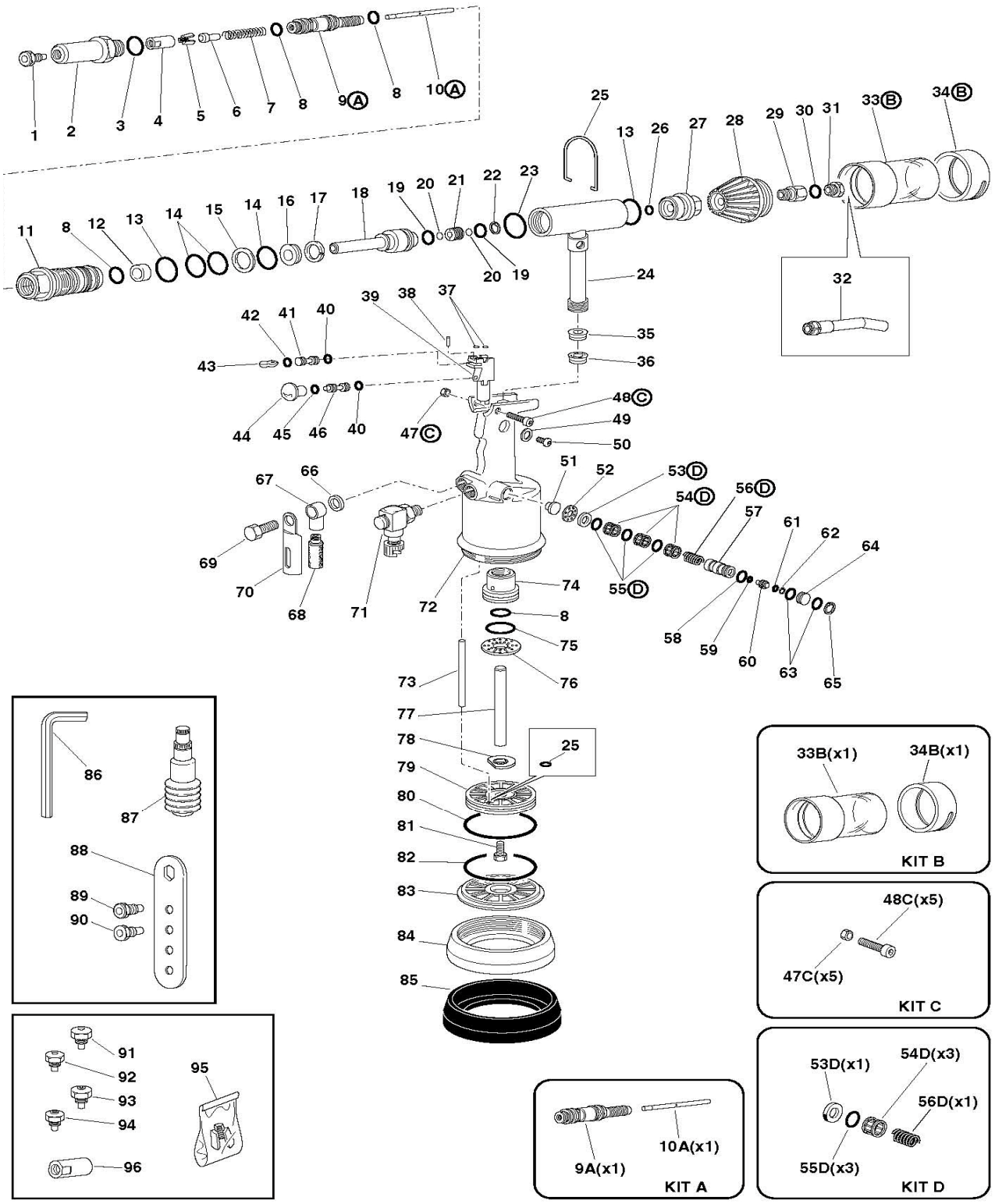

Fig. #	Part #	QTY per TOOL	DESCRIPTION	DESCRIZIONE	DESCRIPTION	BESCHREIBUNG
1	88055	1	3/16" Nosepiece	Ugello per rivetto ø 4,8 Cu/Acc.	Buse pour rivets ø 4,8 Cu/Acier	Mundstück für Nieten ø 4,8 Cu/Stahl
2	713253	1	Head carrying nozzle	Cannotto porta ugello	Tête porte buse	Düsenträger
3	88220-3	1	O-Ring 2-21	OR 2-21 Parker	O Ring 2-21 Parker	O Ring 2-21 Parker
4	88368	1	Jaw Case	Cono p.ta morsetti	Cône porte étaux	Spannbackenhalterkegel
5	88058	3	Jaw Set	Morsetti	Etaux	Spannbacken
6	88220-6	1	Jaw Piston 304-E	Apri morsetti	Ouvre-étaux	Spannbackenöffner
7	88026	1	Spring coil	Molla ritorno morsetti	Ressort retour étaux	Feder zum Rücklauf der Spannbacken
8	88220-9	4	O-Ring 2-114	OR 2-114 N674/70 Parker	O Ring 2-114 N674/70 Parker	O Ring 2-114 N674/70 Parker
9A	see below	1	Cone holder	Porta cono	Porte-cône	Kegelhalter
10A	see below	1	Expeller tube	Cannotto espulsione	Tube ejecteur	Auswerferrohr
11	713255	1	Front connector	Raccordo anteriore	Raccord anterieur	Vorderes Anschlusstück
12	711722	1	Balsele B-094063 NEI	Balsele B-094063 NEI	Balsele B-094063 NEI	Balsele B-094063 NEI
13	713272	2	O Ring 2-125 N674/70 Parker	OR 2-125 N674/70 Parker	O Ring 2-125 N674/70 Parker	O Ring 2-125 N674/70 Parker
14	713278	3	O Ring 2-121 N552/90 Parker	OR 2-122 N552/90 Parker	O Ring 2-121 N552/90 Parker	O Ring 2-121 N552/90 Parker
15	713277	1	Parbak 8.122	Parbak 8.122	Parbak 8.122	Parbak 8.122
16	713276	1	Balsele TSE 134094	Balsele TSE 134094	Balsele TSE 134094	Balsele TSE 134094
17	713258	1	Anti-extrusion ring	Anello anti estrusione	Bague anti-extrusion	Ring Antiextrusion
18	713251	1	Oil-dynamic piston	Pistone oleodinamico	Piston oleodynamique	Hydraulischer Kolben
19	713273	2	O Ring 17,5x1,5	OR 17,5x1,5	O Ring 17,5x1,5	O Ring 17,5x1,5
20	713274	2	O Ring 8x1,5	OR 8x1,5	O Ring 8x1,5	O Ring 8x1,5
21	713247	1	Bush	Bussola	Douille	Hülse
22	711821	1	Seeger ring JV 20	Seeger JV 20	Bague seeger JV 20	Seeger ring JV 20
23	713275	1	O Ring 2-122 N674/70 P	OR 2-122 N674/70 P	O Ring 2-122 N674/70 P	O Ring 2-122 N674/70 P
24	723269	1	Oil-dynamic cylinder	Cilindro Oleodinamico	Cylindre oleodynamique	Hydraulischer Zylinder
25	88220-16	1	Balancer hook	Gancio bilanciatore	Crochet blancier	Ausgleichshaken
26	88032	2	Internal Air Piston O Ring	OR 2-109 N674/70 Parker	O Ring 2-109 N674/70 Parker	O Ring 2-109 N674/70 Parker
27	713250	1	Back connector	Raccordo posteriore	Raccord postérieur	Hinteranschlusstück
28	88220-19	1	Mandrel Container Connector	Raccordo contenitore	Raccord conteneur	Behälteranschlusstück
29	713256	1	Out put connector	Raccordo uscita	Raccord sortie	Austrittanschlusstück
30	713271	1	OR 2/014 N 674/70 P	OR 2/014 N 674/70 P	OR 2/014 N 674/70 P	OR 2/014 N 674/70 P
31	713257	1	Ring nut	Ghiera	Embout	Nutmutter
32	713248	1	Nails baffle	Deflettore chiodi	Déflecteur clous	Ablenker für Nägel
33B	see below	1	Nails container	Contenitore chiodi	Bol récupération clous	Behälter für Nägel
34B	see below	1	Air conveyor	Convogliatore aria	Convoyeur air	Luftconveyor
35	713282	1	Balsele TSE 16x23x6	Balsele TSE 16x23x6	Balsele TSE 16x23x6	Balsele TSE 16x23x6
36	713281	1	Gasket TTS 16x23x5,8/L	Guarnizione TTS 16x23x5,8/L	Garniture TTS 16x23x5,8/L	Dichtung TTS 16x23x5,8/L
37	88220-36	2	O Ring 2-8	OR 2-8 Parker	O Ring 2-8 Parker	O Ring 2-8 Parker
38	88220-87	1	Pin	Rullino INA 2x11,8	Molette INA 2x11,8	Bolzen INA 2x11,8
39	88220-75	1	Washer Piston	Corpo valvolina lunga	Corps soupape long	Körper lang kleines Ventil
40	88047	2	Valve Piston O-Ring	OR 2-5 Parker	O Ring 2-5 Parker	O Ring 2-5 Parker
41	88220-31	1	Valve Piston	Pistoncino valvola	Piston soupape	Kleiner Ventilkolben
42	88220-30	1	O-Ring 2-3	OR 2-3 Parker	O Ring 2-3 Parker	O Ring 2-3 Parker
43	88220-28	1	Vacuum Adjustment Lever	Levetta apertura aspirazione	Levier ouverture aspiration	Hebel für Einlaßöffnung
44	88042	1	Push Button	Pulsante	Bouton poussoir	Drucktaste
45	88043	1	Trigger O Ring	OR 2-4 Parker	O Ring 2-4 Parker	O Ring 2-4 Parker
46	88220-34	1	Valve piston	Pistoncino valvola	Piston soupape	Kleiner Ventilkolben
47C	see below	1	Nut M3 UNI 5587-68	Dado M3 UNI 5587-68	Ecrou M3 UNI 5587-68	Mutter M3 UNI 5587-68
48C	see below	1	Screw TCE M3 x 20 UNI 5931	Vite TCE M3 x 20 UNI 5931	Vis TCE M3 x 20 UNI 5931	Schraube TCE M3 x 20 UNI 5931
49	88034	1	Plug Washer	Rondella ermetica 400-020	Rondelle ermetique 400-020	Hermetische Unterlegscheibe 400-020
50	88035	1	Fluid plug	Tappo serbatoio olio	Orificie de remplissage d'huile	Stopsel Olbehälter
51	88220-50	1	Cap	Tappo di servizio	Bouchon	Verschluss
52	88030	1	Washer stop spring	Rondella arresto molla	Rondelle arrêt ressort	Unterlegscheibe Federstop
53D	see below	1	Valve spacer	Distanziale valvola	Entretoise soupape	Distanzstück Ventil
54D	see below	3	Casing	Gabbia	Cage	Käfig
55D	see below	3	O Ring 2-115 Parker	OR 2-115 Parker	O Ring 2-115 Parker	O Ring 2-115 Parker
56D	see below	1	Coil return spring	Molla ritorno spoletta	Ressort retour bobine	Feder Rücklauf Zünder
57	88025	1	Coil	Spoletta	Bobine	Zünder
58	88024	1	Coil/Frame O-Ring	OR 2-15 Parker	O Ring 2-15 Parker	O Ring 2-15 Parker
59	88045	1	Valve Body O-Ring	OR 008 D.	O Ring 008 D.	O Ring 008 D.
60	88022	1	Valve Piston	Pistoncino valvola	Piston soupape	Kleiner Ventilkolben

61	88021	1	Outr Valve Piston O'Ring	OR 5-612 Parker	O Ring 5-612 Parker	O Ring 5-612 Parker
62	88020	1	Retainer Ring	Seeger 11 I	Bague seeger 11 I	Seeger ring 11 I
63	88018	2	Valve plug O'Ring	OR 018 Dowty	O Ring 018 Dowty	O Ring 018 Dowty
64	88019	1	Valve plug	Tappo guida molla	Bouchon guide ressort	Federführungverschluß
65	88017	1	Retaining ring	Seeger 22 I	Bague seeger 22 I	Seeger ring 22 I
66	88220-89	1	Safety Washer	Ranella di sicurezza S 12,7	Rondelle de sécurité S 12,7	Sicherheitsscheibe S 12,7
67	88038	1	Rotating connector	Raccordo 2023-1/4-1/4	Raccord 2023-1/4-1/4	Anschlusstück 2023-1/4-1/4
68	88033	1	Silencer	Silenziatore 1/4	Silencieur 1/4	Schalldämpfer 1/4
69	88220-45	1	Connector 1631-01-1/4	Raccordo 1631-01-1/4	Raccord 1631-01-1/4	Anschlusstück 1631-01-1/4
70	712162	1	Air Silencer Shield	Protezione esterna silenziatore	Protection extérieure silencieux	Außenschalldämpferschutz
71	88100	1	Rotating connector	Raccordo girevole	Raccord evoluable	Drehbares Anschlusstück
72	88220-49	1	Cylinder	Corpo rivettatrice	Corps outil	Nietmaschinenkörper
73	88220-98	1	Tube Ø 8x7	Tubo Ø 8x7	Tuyau Ø 8x7	Rohr Ø 8x7
74	713245	1	Guide stem connector	Raccordo guida stelo	Raccord guide tige	Führung Schaftanschlusstück
75	88220-66	1	O-Ring 2-129	OR 2-129 N674/70 Parker	O Ring 2-129 N674/70 Parker	O Ring 2-129 N674/70 Parker
76	713246	1	Dampener	Ammortizzatore	Ammortisseur	Stossdampfer
77	713243	1	Stem	Stelo	Tige	Schaft
78	713244	1	Washer piston	Rondella pistone	Rondelle piston	Unterlegscheibe Kolben
79	88220-68	1	Air Piston Stop	Pistone pneumatico	Piston pneumatique	Pneumatischer Kolben
80	88220-69	1	O Ring 2-343	OR 2-343 Parker	O Ring 2-343 Parker	O Ring 2-343 Parker
81	710596	1	Screw M10 x 1	Vite M10 x 1	Vis M10 x 1	Schraube M10 x 1
82	882220-86	1	Retainer Ring	OR 2-45 Parker	O Ring 2-45 Parker	O Ring 2-45Parker
83	88220-71	1	Cylinder Cap	Fondello	Culot	Bondenscheibe
84	88220-72	1	Stand	Coperchio cilindro	Couvercle cylindre	Zylinderdekel
85	88220-95	1	Bottom Protector	Fondello di protezione	Culot de protection	Schutzscheibe
86	88220-76	1	Allen key	Chiave a brugola 5 mm	Clé	Schlüssel
87	88220-77	1	Oil container	Contenitore olio	Conteneur d'huile	Ol Flasche
88	88220-78	1	Nosepiece holder	Chiave di corredo	Clé	Schlüssel
89	88371	1	1/4" Nosepiece	Ugello per rivetto ø 6÷**6,40**	Buse pour rivets ø 6÷**6,40**	Mundstück für Nieten ø 6:6,40
90	717007	1	5/16" Nosepiece	Ugello per rivetto ø 7,8	Buse pour rivets ø 7,8	Mundstück für Nieten ø 7,8
91	88220-82	1	3/16 Struct. Nosepiece	Ugello per rivetto Huck 3/16"	Buse pour rivets Huck 3/16"	Mundstück für Nieten Huck 3/16"
92	88220-83	1	1/4" Struct. Nosepiece	Ugello per rivetto Huck 1/4"	Buse pour rivets Huck 1/4"	Mundstück für Nieten Huck 1/4"
93	88220-84	1	1/4 Monobolt Nosepiece	Ugello per rivetto Farbolt, Monobolt 1/4"	Buse pour rivets Farbolt, Monobolt 1/4"	Mundstück für Nieten Farbolt, Monobolt 1/4"
94	88220-85	1	3/16 Monobolt Nosepiece	Ugello per rivetto Farbolt, Monobolt 3/16"	Buse pour rivets Farbolt, Monobolt 3/16"	Mundstück für Nieten Farbolt, Monobolt 3/16"
95	713213	3	Jaws for Monobolt, Magna-lok	Morsetti per Farbolt, Monobolt, Magna-lok	Etaux pour Farbolt, Monobolt, Magna-lok	Spannbacken für Farbolt, Monobolt, Magna-lok
96	88220-4	1	Front Jawcase	Cono p.ta morsetti per Farbolt,	Cône porte étaux pour Farbolt,	Spannbackenhalterkegel für Farbolt,
			Monobolt, Magna-lok	Monobolt, Magna-lok	Monobolt, Magna-lok	Monobolt, Magna-lok
						KIT
KIT "A"	**743254**		**Cone Holder Kit**	**Kit porta cono**	**Kit Porte-cône**	**Kit Kegelhalter**
contains						
9A	713254	1	Cone holder	Porta cono	Porte-cône	Kegelhalter
10A	713249	1	Expeller tube	Cannotto espulsione	Tube ejecteur	Auswerferrohr
KIT "B"	**740819**		**Bottle/Air conveyer kit**	**Kit contenitore chiodi**	**Kit conteneur clous**	**Kit Behälter für Nägel**
contains						
33B	710819	1	Nail container	Contenitore chiodi	Bol récupération clous	Behälter für Nägel
34B	88220-22	1	Air conveyor	Convogliatore aria	Convoyeur air	Luftconveyor
KIT "C"	**742144**		**Screw M3 kit**	**Kit vite M3**	**Kit Vis M3**	**Kit Schraube M3**
contains						
47C	88220-92	5	Nut M3 UNI 5587-68	Dado M3 UNI 5587-68	Ecrou M3 UNI 5587-68	Mutter M3 UNI 5587-68
48C	88220-93	5	Screw TCE M3 x 20 UNI 5931	Vite TCE M3 x 20 UNI 5931	Vis TCE M3 x 20 UNI 5931	Schraube TCE M3 x 20 UNI 5931
KIT "D"	**740840**		**Valve spacer kit**	**Kit distanziale valvola**	**Kit entretoise soupape**	**Kit Distanzstück Ventil**
contains						
53D	88029	1	Valve spacer	Distanziale valvola	Entretoise soupape	Distanzstück Ventil
54D	88027	3	Cage	Gabbia	Cage	Käfig
55D	710921	3	O Ring 2-115 Parker	OR 2-115 Parker	O Ring 2-115 Parker	O Ring 2-115 Parker
56D	88126	1	Coil return spring	Molla ritorno spoletta	Ressort retour bobine	Feder Rücklauf Zünder