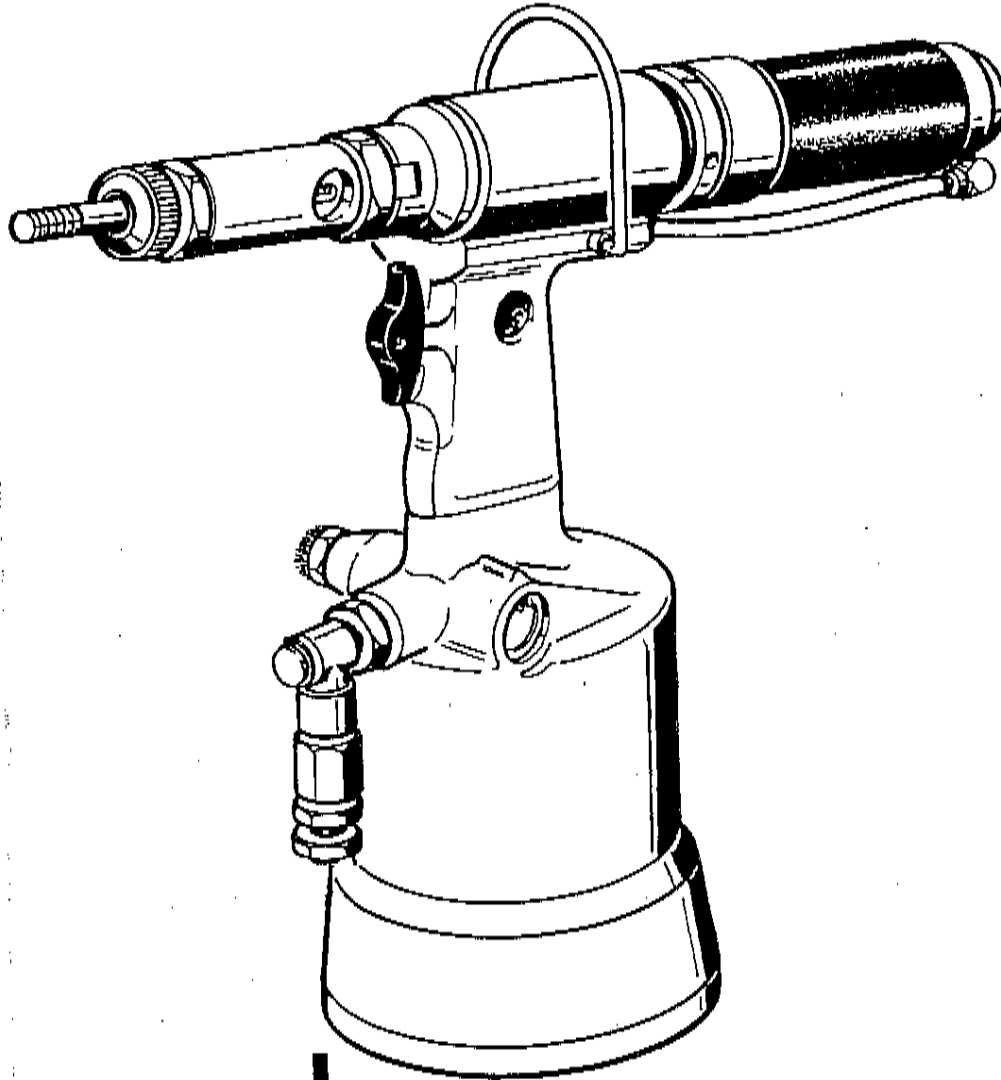


CAT. NO. 150-SPI 291

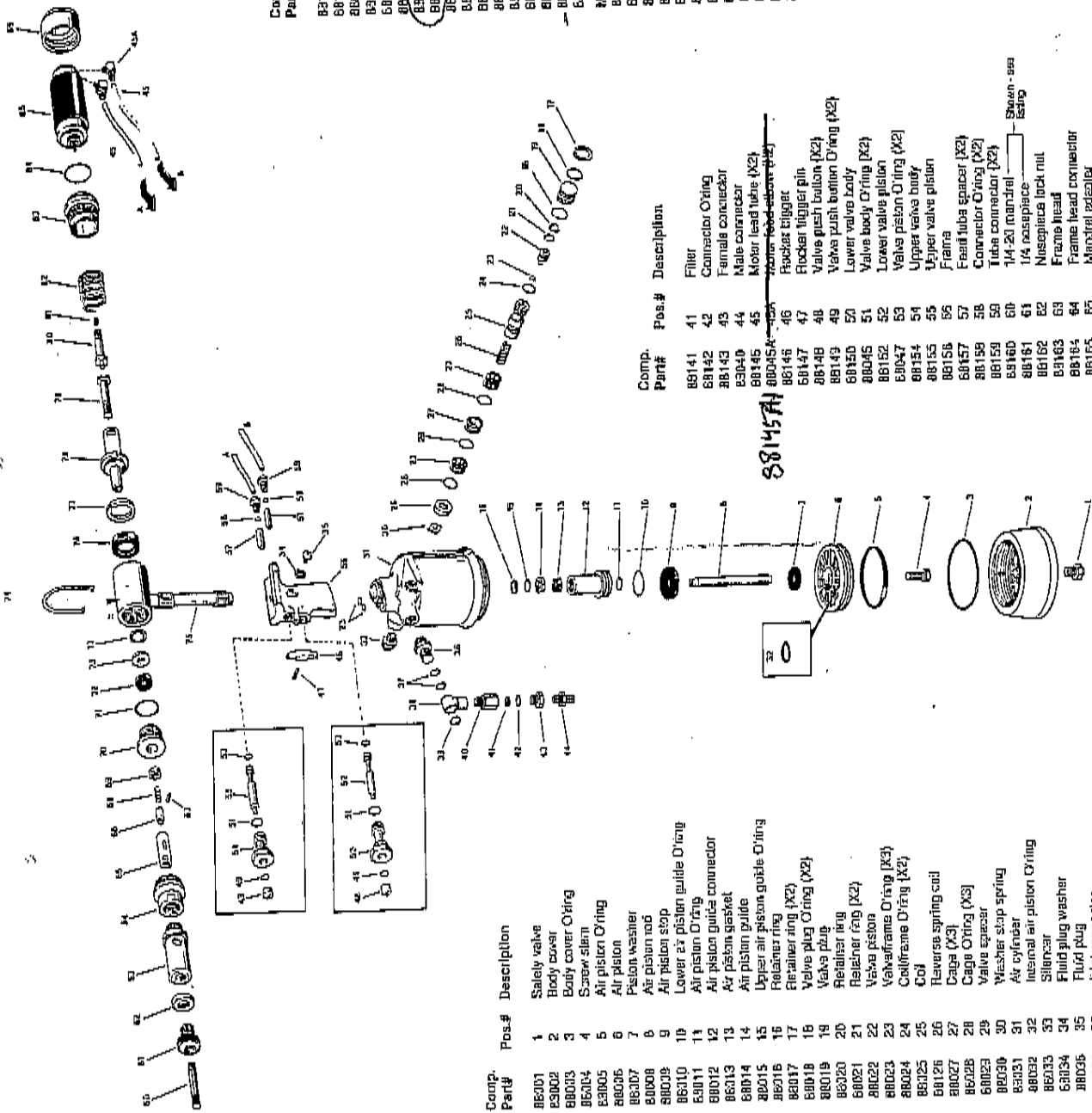
SUPER BRUTE SPIN PULL INSTRUCTIONS

Model 150-SP Pneumatic Rivet Nut® Setting Tool



44 Campanelli Parkway • Stoughton, MA 02072-3796

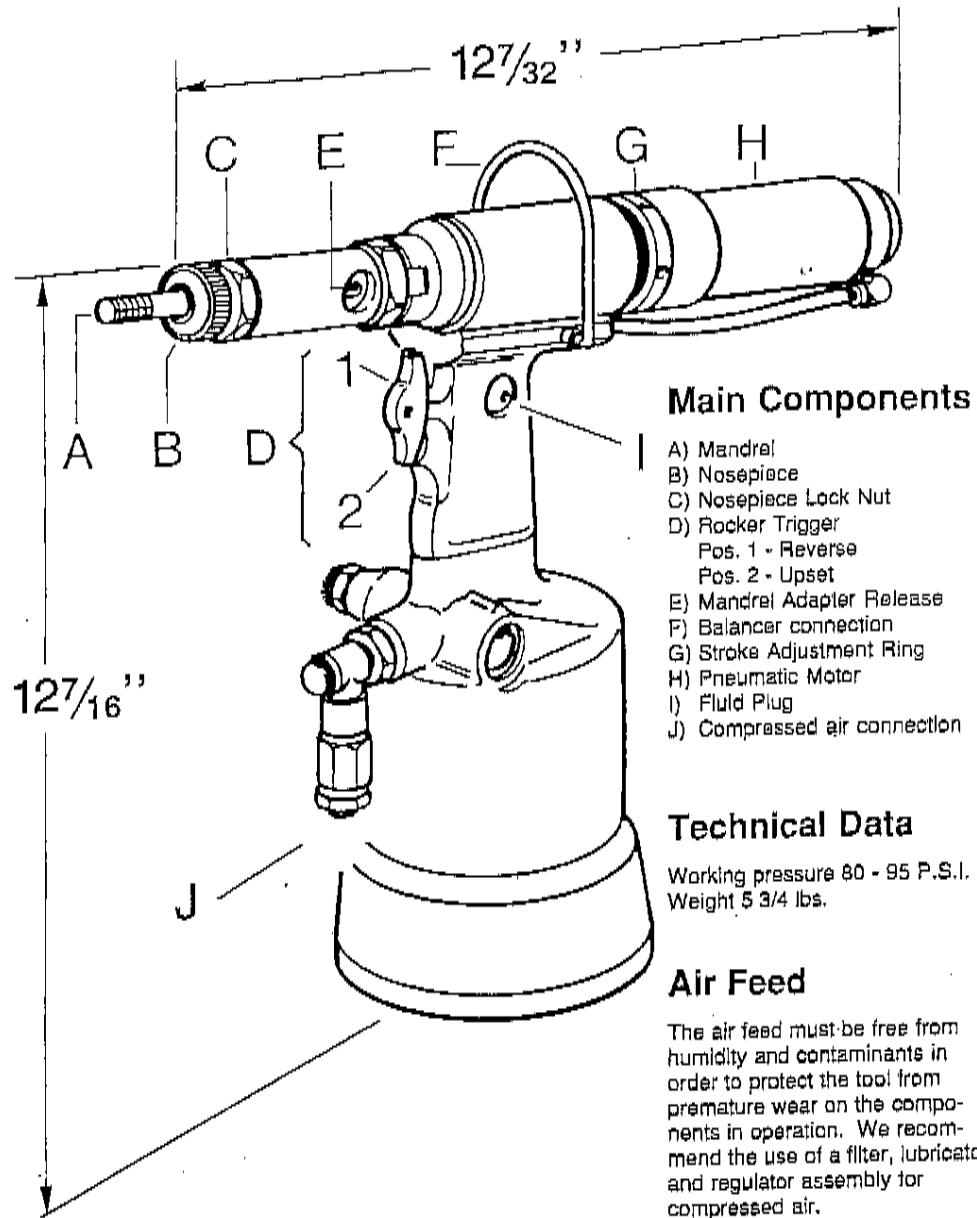
Parts



Comp. Part#	Pos.#	Description
88170	70	Gasket sleeve
88171	71	Gasket sleeve O ring
88068	72	Shaft gasket
83063	73	Washer
88220-16	74	Balancer connection
88175	75	Inlet valve cylinder
88176	76	Oil piston gasket
88177	77	Oil piston gasket ring
88178	78	Oil piston
88179	79	Female clutch
88180	80	Male clutch
88181	81	Dowel
88182	82	Reverse spring
88183	83	Stroke adjustment connector
88184	84	Stroke adjustment connector O ring
88185	85	Pneumatic motor
88186	86	Air distributor
Mandrel Selection		
88187		4-40 mandrel
88188		6-32 mandrel
88189		8-32 mandrel
88190		10-32 mandrel
88191		1/4-24 mandrel
88192		5/16-18 mandrel
88193		3/8-16 mandrel
88194		1/2-13 mandrel
88195		3/4-16 mandrel
88196		1-12 mandrel
88197		1 1/2-10 mandrel
88198		2-8 mandrel
88199		2 1/2-8 mandrel
88200		3-6 mandrel
88201		3 1/2-6 mandrel
88202		4-4 mandrel
88203		4 1/2-4 mandrel
88204		5-4 mandrel
88205		5 1/2-4 mandrel
88206		6-4 mandrel
88207		6 1/2-4 mandrel
88208		7-4 mandrel
88209		7 1/2-4 mandrel
88210		8-4 mandrel
88211		8 1/2-4 mandrel
Nosepiece Selection		
88199	#9	nosepiece
88200	#8	nosepiece
88201	#7	nosepiece
88202	#6	nosepiece
88203	#5	nosepiece
88204	#4	nosepiece
88205	#3	nosepiece
88206	#2	nosepiece
88207	#1	nosepiece
88208	#0	nosepiece
88209	#-1	nosepiece
88210	#-2	nosepiece
88211	#-3	nosepiece
88212	#-4	nosepiece
88213	#-5	nosepiece
88214	#-6	nosepiece
88215	#-7	nosepiece
88216	#-8	nosepiece
88217	#-9	nosepiece
88218	#-10	nosepiece
88219	#-11	nosepiece

Comp. Part#	Pos.#	Description
88141	41	Filter
88142	42	Connector O ring
88143	43	Female connector
83040	44	Male connector
88145	45	Motor lead tube (X2)
88045A	46	Motor lead tube (X2)
88146	47	Hook trigger
88147	48	Valve push button (X2)
88148	49	Valve push button O ring (X2)
88149	50	Lower valve body
88045	51	Valve body O ring (X2)
88152	52	Lower valve piston
88047	53	Valve piston O ring (X2)
88154	54	Upper valve body
88155	55	Upper valve piston
88156	56	Frame
88157	57	Front tube spacer (X2)
88158	58	Connector O ring (X2)
88159	59	Tube connector (X2)
88160	60	1/4-20 mandrel
88161	61	1/4 nosepiece
88162	62	Nosepiece lock nut
88163	63	Frame head
88164	64	Mandrel adapter
88165	65	Clutch pin
88166	66	Disengagement spring
88167	67	Adapter nut
88168	68	Adapter nut
88169	69	Adapter nut

1/4-20
88160
88161



General Notes

Model #150-SP pneumatic rivet nut setting tool handles Thread-Serts® in all sizes and metals. Rivet nuts in sizes 4/40 through 5/16 - 18/24 in all metals; 3/8 - 16/24 in aluminum and steel; 1/2 - 13/20 in aluminum only. Metric conversion kits also available.

Maintenance

Size Change

ADDING HYDRAULIC FLUID

Put tool in a horizontal position. Using the 5/16mm hex key, (provided), remove fluid plug. Add fluid (using special container provided) until its level reaches the edge of the fill hole. (see fig. 1) Rock tool in horizontal position to remove any air pockets. Add more fluid if needed. **IMPORTANT:** Use only Walker Anti-Foam hydraulic fluid #93294 or equivalent. To insure proper installation of fastener, mandrels should be oiled frequently.

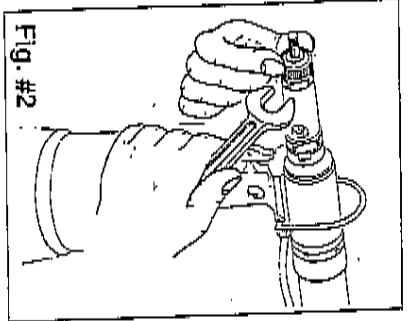
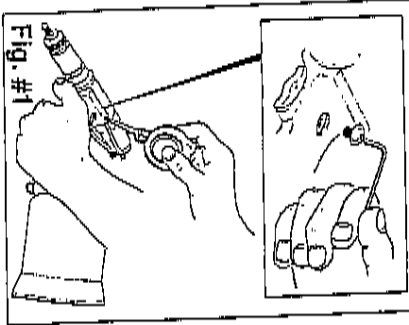


Fig. #2

REMOVING MANDREL AND NOSEPIECE

Working from the rear of the tool, use a 22mm wrench to turn nosepiece lock nut counter-clockwise until loose. (see fig. 2)

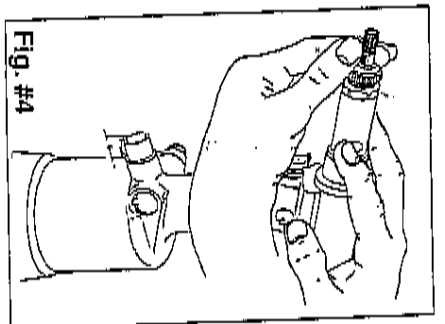


Fig. #4

REPLACING MANDREL AND NOSEPIECE

Using the same procedure as in fig. 3, insert the desired mandrel adapter. (Mandrel will stop at appropriate level when properly installed.) Thread nosepiece and lock nut back against frame head. Thread fastener onto mandrel, leaving .050 mandrel protruding. Unscrew nosepiece from frame head until it seats against flange of fastener. Tighten lock nut to frame head (while maintaining position of nosepiece). (see fig. 4)

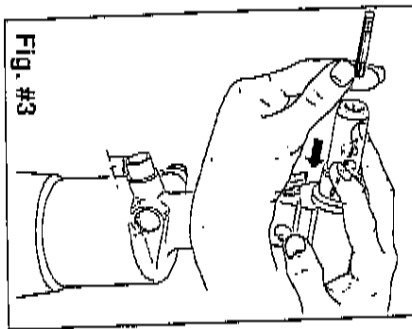


Fig. #3

Insert mandrel adapter pin through the mandrel release on frame head. Pull back on pin (towards rear of tool) to remove mandrel and nosepiece from tool. (see fig. 3)

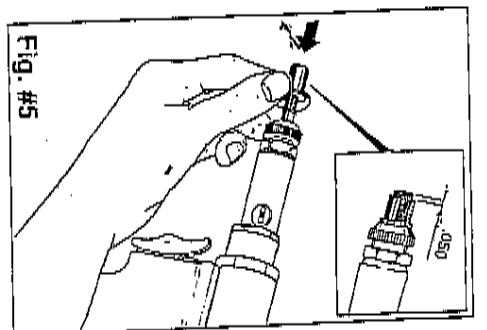


Fig. #5

Instructions

Install correct size mandrel and nosepiece in tool. (see fig. 2-4) Thread fastener (flange toward tool) on tool to the depth of 1 turn. Apply a light pressure and the fastener will automatically thread onto the mandrel. Make certain the flange of the fastener is touching the nosepiece and you have approximately .050 protrusion of the mandrel (see fig. 5). **FOR PROPER STROKE LENGTH**, turn the stroke adjustment ring (using the spanner wrench issued) clockwise until it stops. Insert into a sample application with desired thickness over fastener and actuate position 2 on rocker trigger (see fig. 6). Begin turning stroke adjustment ring counterclockwise until proper upset has been reached (see fig. 7). Actuate position 1 on rocker trigger to unthread mandrel from fastener. Your tool is now ready for production.

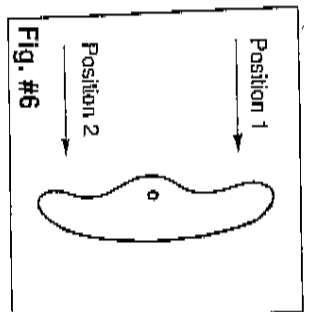


Fig. #6

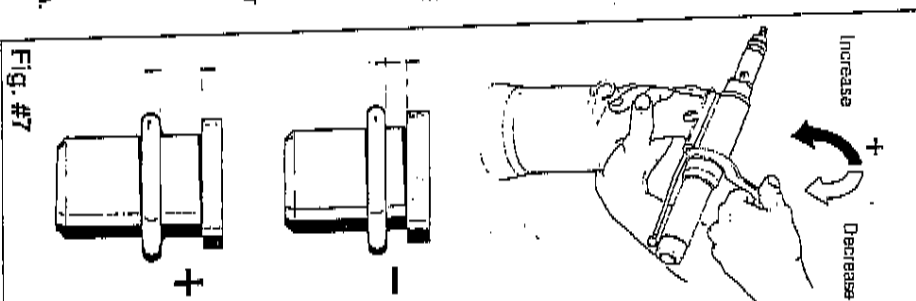


Fig. #7