OPERATING INSTRUCTIONS

The APR-175A is a pneumatic tool designed to set from 1/8" up to and including 1/4 inch diameter steel, stainless steel, aluminum and plastic rivets by changing only the nosepiece. The APR-175A has a rated pull pressure of over 3,500 lbs. The APR-175A riveter will operate effectively at any air pressure between 90 and 120 psi. WHEN SETTING 1/4" RIVETS OR MAGNALOK® A MINIMUM AIR PRESSURE OF 110 p.s.i. MUST BE MAINTAINED. The maximum air pressure used with the tool should not exceed 120 psi.

The APR-175A utilizes totally different patented principles than any other riveter. The air pressure activates a reciprocating hydraulic pump which generates the force required to set the fastener.

The hydraulic system is sealed and, although there may be some visible residue around the trigger area, oil need not be added. If the APR-175A should become damaged and leaks oil from the tool, IT SHOULD BE RETURNED TO AN AUTHORIZED SERVICE CENTER.

ACCESSORIES
* NOSE EXTENSION KIT: P/N 205490
* MUFFLER KIT: P/N 201080

figure 1

201094
REV B
How to Use the Tool
General Instructions

The APR-175A pneumatic riveter installs fasteners by a pull and release system. Squeezing the ACTUATING TRIGGER "A" only (see fig. 2 below) will actuate the tool. The tool must be actuated when installing fasteners and changing nose pieces. After installing the fastener or changing the NOSE PIECE the tool must be returned to its original position, this releases the pintail if a fastener was installed.

To do this point the tool downward and squeeze RELEASING TRIGGER "B" only (see fig. 3, pg. 3). See sections on NOSE PIECE INSTALLATION and FASTENER INSTALLATION for detailed instructions.

![Typical Rivet](image)

**Nose Piece Installation:** Select the Proper Nose Piece for correct installation of fastener and function of the tool. To change the nose piece, remove the one in the tool by unscrewing it in a counterclockwise direction. Actuate tool until it is fully extended. There should be gap of approximately 3/4" in between the reservoir shield and the tool body. (see fig. 1, pg. 1) Hand tighten the nose piece into the nose tube and release the tool by squeezing the releasing trigger "B" only (see fig. 2 below).

**Fastener Installation:** Install correct nose piece on to tool (see Nose Piece Installation section). Insert pintail of rivet in to the NOSE PIECE. Then position the rivet body in to work piece to be fastened. Hold the tool steady against the work piece and squeeze the ACTUATING TRIGGER "A" only, until fastener is installed and rivet pintail is broken (see fig. 2).

![Rivet Diagram](image)

*The APR-175A has a 5/8 inch work travel and will set most rivets in one cycle. If the tool reaches the end of its travel before the rivet breaks, the hydraulic system will lug down. DO NOT continue lugging the tool. Release the tool by squeezing the RELEASING TRIGGER "B", regrip the rivet, squeeze the ACTUATING TRIGGER "A" and finish the installation.*
Rivet Pintail Removal: Once the rivet has been installed the rivet pintail must be removed. This is done by squeezing the RELEASING TRIGGER "B" only while pointing tool downward. It is necessary to REMOVE THIS PINTAIL BEFORE ATTEMPTING TO INSTALL ANOTHER RIVET (see fig. 3).

![Rivet Tool Diagram](image)

**RELEASING TRIGGER "B"**

**ACTUATING TRIGGER "A"**

**RIVET PINTAIL**

**figure 3**

Three Piece Jaw Installation and Removal: The jaws are installed at the factory and should only need to be removed for periodic inspection and cleaning.

1. To remove the jaws unscrew the NOSE TUBE from the tool in a counterclockwise direction.

![Jaw Removal Diagram](image)

2. Remove the JAW HOLDER by unscrewing it in a counterclockwise direction. Drop JAWS out from SPRING side. Actuate tool by squeezing the ACTUATING TRIGGER (see fig 3 above) until the jaw pusher is fully extended. Stop as soon as the JAW PUSHER is in the extended position.

![Jaw Pusher Diagram](image)
3. To replace JAWS, hold JAW HOLDER large end down and at a slight angle. Hold finger over small opening and place jaws in one at a time.

4. When jaws are in place, insert jaw holder into spring, being sure to keep large end of jaw holder pointing downward

5. Hold tool with the PULLER SHAFT pointing down and the JAW PUSHER fully extended, screw the jaw holder on to the PULLER SHAFT, HAND TIGHTEN ONLY.

6. Replace the NOSE TUBE and NOSE PIECE, HAND TIGHTEN ONLY. The tool is now ready to use.
Steps for Proper Tool Maintenance and Operation

USE THESE TIPS BEFORE RETURNING FOR REPAIR, FOR FURTHER ASSISTANCE CALL (800) 431-3091.

1. Disassemble and clean NOSE components periodically or if the pintails do not drop out freely, use a pick to clean the jaw grooves. Wash components in mineral spirits or isopropyl alcohol. Apply a small amount of light weight oil to the JAWS and inside of JAW HOLDER prior to assembly.
2. To ease NOSE TUBE and NOSE PIECE installation, extend tool by squeezing actuating trigger.
3. DO NOT USE TOOL AS A LEVER if rivet pin tail is jammed while regripping. Instead, with releasing trigger depressed, push tool nose against work piece for the jaws to get a deeper grip.
4. If rivet pintail is stuck in tool after breaking, lightly tap nose against a hard surface while squeezing the releasing trigger, pintail should then fall out.
5. Before operating tool, make sure that all NOSE PARTS have been screwed in HAND TIGHT.
6. For long life of tool, do not continue to run tool at the end of travel.
7. The APR-175A should not be used at temperatures below 35° F, unless it is first brought to room temperature and cycled several times, normal use of the tool after warming should keep it warm enough for proper operation.
8. If tool will not reverse, remove NOSE TUBE and inspect for any foreign matter that might have caused jamming between JAW HOLDER and inside of NOSE TUBE.
9. Frequently check that nose components do not vibrate loose during operation.

* Included in APR-175A kit

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<tr>
<th><strong>Nose Pieces</strong> (actual size)</th>
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