STANLEY 74200 Threaded Insert Tool Instruction Manual

STANLEY
Engineered Fastening

INSTRUCTION ANDSERVICE MANUAL
ORIGINAL INSTRUCTION

Hydro-Pneumatic Power Tool
Blind Rivet Nut Tool – 74200
ORIGINAL INSTRUCTION

Contents

74200 Threaded Insert Tool

	This instruction manual must be read by any person installing or operating this tool with particula r attention to the following safety rules.
	Always wear impact-resistant eye protection during operation of the tool. The grade of protection required should be assessed for each use.
	Use hearing protection in accordance with employer’s instructions and as required by occupatio nal health and safety regulations.
	Use of the tool can expose the operator’s hands to hazards, including crushing, impacts, cuts and abrasions and heat. Wear suitable gloves to protect hands.

SAFETY DEFINITIONS

The definitions below describe the level of severity for each signal word. Please read the manual and pay attention to these symbols.

DANGER: Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

WARNING: Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION: Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

CAUTION: Used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

Improper operation or maintenance of this product could result in serious injury and property damage. Read and understand all warnings and operating instructions before using this equipment. When using power tools, basic safety precautions must always be followed to reduce the risk of personal injury.

SAVE ALL WARNINGS AND INSTRUCTIONS FOR FUTURE REFERENCE

1.1 GENERAL SAFETY RULES

- For multiple hazards, read and understand the safety instructions before installing, operating, repairing,

maintaining, changing accessories on, or working near the tool. Failure to do so can result in serious bodily injury.

- Only qualified and trained operators must install, adjust or use the tool.
- DO NOT use outside the design intent of placing STANLEY Engineered Fastening Blind Rivet Nuts.
- Use only parts, fasteners, and accessories recommended by the manufacturer.
- DO NOT modify the tool. Modification can reduce the effectiveness of safety measures and increase the risks to the operate. Any modification to the tool undertaken by the customer will be customer's entire responsibility and void any applicable warranties.
- Do not discard the safety instructions; give them to the operator.
- Do not use the tool if it has been damaged.
- Prior to use, check for misalignment or binding of moving parts, breakage of parts, and any other condition that affects the tool's operation. If damaged, have the tool serviced before using. Remove any adjusting key or wrench before use.
- Tools shall be inspected periodically to verify that the ratings and markings required by this part of ISO 11148 are legibly marked on the tool. The employer/user shall contact the manufacturer to obtain replacement marking labels when necessary.
- The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained personnel. Any dismantling procedure will be undertaken only by trained personnel. Do not dismantle this tool without prior reference to the maintenance instructions.

1.2 PROJECTILE HAZARDS

- Disconnect the air supply from the tool before performing any maintenance, attempting to adjust, fit or remove a nose assembly or accessories.
- Be aware that failure of the work piece or accessories or even of the inserted tool itself can generate high-velocity projectiles.
- Always wear impact-resistant eye protection during operation of the tool. The grade of protection required should be assessed for each use.
- The risks to others should also be assessed at this time.
- Ensure that the work piece is securely fixed.
- Check that the means of protection from ejection of fastener and/or mandrel is in place and is operative is in place and is operative.
- DO NOT use the tool without mandrel collector installed.
- Warm against the possible forcible ejection of mandrels from the front of the tool.
- DO NOT operate a tool that is directed towards any person(s).

1.3 OPERATING HAZARDS

- Use of the tool can expose the operator's hands to hazards, including crushing, impacts, cuts and abrasions and heat.
  Wear suitable gloves to protect hands.
- Operators and maintenance personnel shall be physically able to handle the bulk, weight and power of the tool.
- Hold the tool correctly; be ready to counteract normal or sudden movements and have both hands available.
- Keep tool handles dry, clean, and free from oil and grease.

- Maintain a balanced body position and secure footing when operating the tool.
- Release the start-and-stop device in the case of an interruption of the air supply.
- Use only lubricants recommended by the manufacturer.
- Contact with hydraulic fluid should be avoided. To minimize the possibility of rashes, care should be taken to wash thoroughly if contact occurs.
- Material Safety Data Sheets for all hydraulic oils and lubricants is available on request from your tool supplier.
- Avoid unsuitable postures, as it is likely for these positions not to allow counteracting of normal or unexpected movement of the tool.
- If the tool is fixed to a suspension device, make sure that the fixation is secure.
- Beware of the risk of crushing or pinching if nose equipment is not fitted.
- DO NOT operate tool with the nose casing removed.
- Adequate clearance is required for the tool operator's hands before proceeding.
- When carrying the tool from place to place keep hands away from the trigger to avoid inadvertent activation.
- DO NOT abuse the tool by dropping or using it as a hammer.

1.4 REPETITIVE MOTIONS HAZARDS

- When using the tool, the operator can experience discomfort in the hands, arms, shoulders, neck or other parts of the body.
- While using the tool, the operator should adopt a comfortable posture whilst maintaining a secure footing and avoiding awkward or off-balance postures. The operator should change posture during extended tasks; this can help avoid discomfort and fatigue.
- If the operator experiences symptoms such as persistent or recurring discomfort, pain, throbbing, aching, tingling, numbness, burning sensations or stiffness, these warning signs should not be ignored. The operator should tell the employer and consult a qualified health professional.

1.5 ACCESSORY HAZARDS

- Disconnect the tool from the air supply before fitting or removing the nose assembly or accessory.
- Use only sizes and types of accessories and consumables that are recommended by the manufacturer of the tool; do not use other types or sizes of accessories or consumables.

1.6 WORKPLACE HAZARDS

- Slips, trips and falls are major causes of workplace injury. Be aware of slippery surfaces caused by use of the tool and of trip hazards caused by the air line or hydraulic hose.
- Proceed with care in unfamiliar surroundings. There can be hidden hazards, such as electricity or other utility lines.
- The tool is not intended for use in potentially explosive atmospheres and is not insulated against contact with electric power.
- Ensure that there are no electrical cables, gas pipes, etc., which can cause a hazard if damaged by use of the tool.
- Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewellery or long hair can be caught in moving parts.

1.7 NOISE HAZARDS

- Exposure to high noise levels can cause permanent, disabling hearing loss and other problems, such as tinnitus (ringing, buzzing, whistling or humming in the ears). Therefore, risk assessment and the implementation of appropriate controls for these hazards are essential.
- Appropriate controls to reduce the risk may include actions such as damping materials to prevent work pieces from “ringing”
- Use hearing protection in accordance with employer’s instructions and as required by occupational health and safety regulations.
- Select, maintain and replace the consumable/inserted tool as recommended in the instruction handbook, to prevent an unnecessary increase in noise.

1.8 VIBRATION HAZARDS

- Exposure to vibration can cause disabling damage to the nerves and blood supply of the hands and arms.
- Wear warm clothing when working in cold conditions and keep your hands warm and dry. If you experience numbness, tingling, pain or whitening of the skin in your fingers or hands, stop using the tool, tell your employer and consult a physician.
- Where possible Support the weight of the tool in a stand, tensioner or balancer, because a lighter grip can then be used to support the tool.
- Operate and maintain the assembly power tool for blind rivet nut fasteners as recommended in the instruction’s handbook, to prevent an unnecessary increase in vibration levels.
- Select, maintain and replace the consumable/inserted tool as recommended in the instruction handbook, to prevent an unnecessary increase in vibration levels.
- Hold the tool with a light but safe grip, taking account of the required hand reaction forces, because the risk from vibration is generally greater when the grip force is higher.

1.9 ADDITIONAL SAFETY INSTRUCTION FOR PNEUMATIC POWER TOOLS

- The operating supply air must not exceed 7 bar (102 PSI).
- Air under pressure can cause severe injury.
- Never leave operating tool unattended. Disconnect air hose when tool is not in use, before changing accessories or when making repairs.
- Never direct air at yourself or anyone else.
- Whipping hoses can cause severe injury. Always check for damaged or loose hoses and fittings.
- Prior to use, inspect airlines for damage, all connections must be secure. Do not drop heavy objects on hoses. A sharp impact may cause internal damage and lead to premature hose failure.
- Cold air shall be directed away from hands.
- Whenever universal twist couplings (claw couplings) are used, lock pins shall be installed and whip check safety cables shall be used to safeguard against possible hose-to-tool or hose-to-hose connection failure.
- DO NOT lift the placing tool by the hose. Always use the placing tool handle.
- Vent holes must not become blocked or covered.
- Keep dirt and foreign matter out of the hydraulic system of the tool as this will cause the tool to malfunction.

SPECIFICATIONS

2.1 PLACING TOOL SPECIFICATION

Air Pressure	Minimum – Maximum	5-7 bar (75-100 lbf/in2)
Free Air Volume Required	@ 5 bar/75 lbf/in2	8 litres (0.28 ft3)
Stroke	Maximum	7 mm (0.276 in)
Motor Speed	Spin On Spin Off	2000 rpm 2000 rpm
Pull Force	@ 5 bar/75 lbf/in2	19.1 kN (4300 lbf)
Cycle time	Approximately	2.5 seconds
Weight	Without nose equipment	2.2 kg (4.85 lb)

Noise values determined according to noise test code ISO 15744 and ISO 3744.		**74200**
A-weighted sound power level dB(A), LWA	Uncertainty noise: kWA = 3.0 dB(A)	74.70 dB(A)
A-weighted emission sound pressure level at the work stati on dB(A), LpA	Uncertainty noise: kpA = 3.0 dB(A)	77.08 dB(A)
C-weighted peak emission sound pressure level dB(C), Lp C , peak	Uncertainty noise: kpC = 3.0 dB(C)	75.54 dB(C)
Vibration values determined according to vibration test code ISO 20643 and ISO 534 9.		**74200**
Vibration emission level, ahd :	Uncertainty vibration: k = 0.1 27 m/s2	0.317 m/s2
Declared vibration emission values in accordance with EN 12096		

2.2 TOOL DIMENSIONS

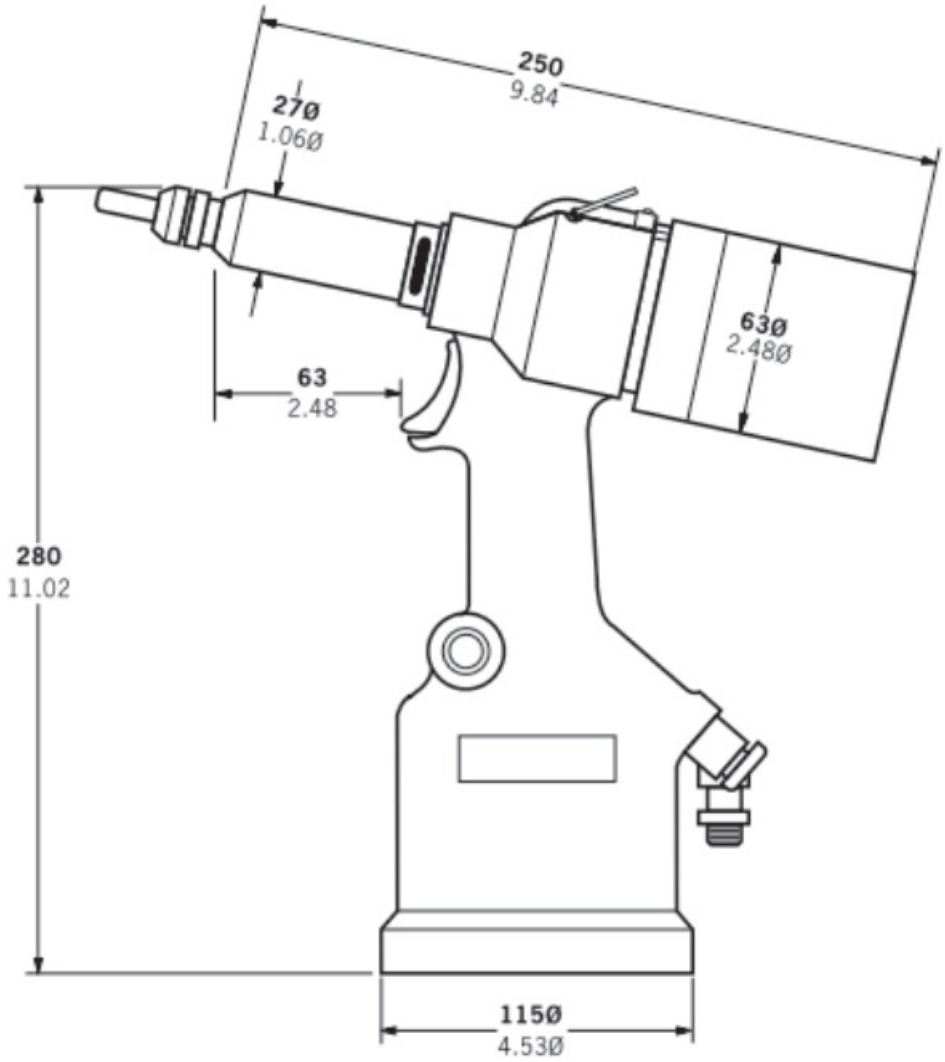


Fig. 1

Dimensions shown in bold are millimeters. Other dimensions are in inches.

INTENT OF USE

The hydro-pneumatic 74200 tool is designed to place Stanley Engineered Fastening Blind Rivet Nuts at high speed making it ideal for batch or flow-line assembly in a wide variety of applications throughout all industries. A complete tool is made up of the base tool (part number 74200-12000) and the appropriate nose assembly for the insert, as described on page 10.

NOSE ASSEMBLIES MUST BE FITTED AS DESCRIBED ON PAGE 10.

DO NOT use under wet conditions or in the presence of flammable liquids or gases.

PUTTING INTO SERVICE

IMPORTANT – READ THE SAFETY RULES ON PAGE 4 – 6 CAREFULLY BEFORE PUTTING INTO SERVICE.

Select relevant size nose equipment and install.

Connect the placing tool to the air supply. Test pull and return cycles by depressing and releasing the trigger 25. Set the tool for desired stroke/pressure.

CAUTION – Correct supply pressure is important for proper function of the installation tool. Personal injury or damage to equipment may occur without correct pressures. The supply pressure must not exceed that listed in the placing tool specification.

4.1 AIR SUPPLY

All tools are operated with compressed air at an optimum pressure of 5.5 bar. We recommend the use of pressure regulators and automatic oiling/filtering systems on the main air supply. These should be fitted within 3 metres of the tool (see diagram below) to ensure maximum tool life and minimum tool maintenance.
Air supply hoses should have a minimum working effective pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest. Air hoses should be oil resistant, have an abrasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged. All air hoses MUST have a minimum bore diameter of 6.4 millimetres or 1/4 inch.
Read servicing daily details page 13.

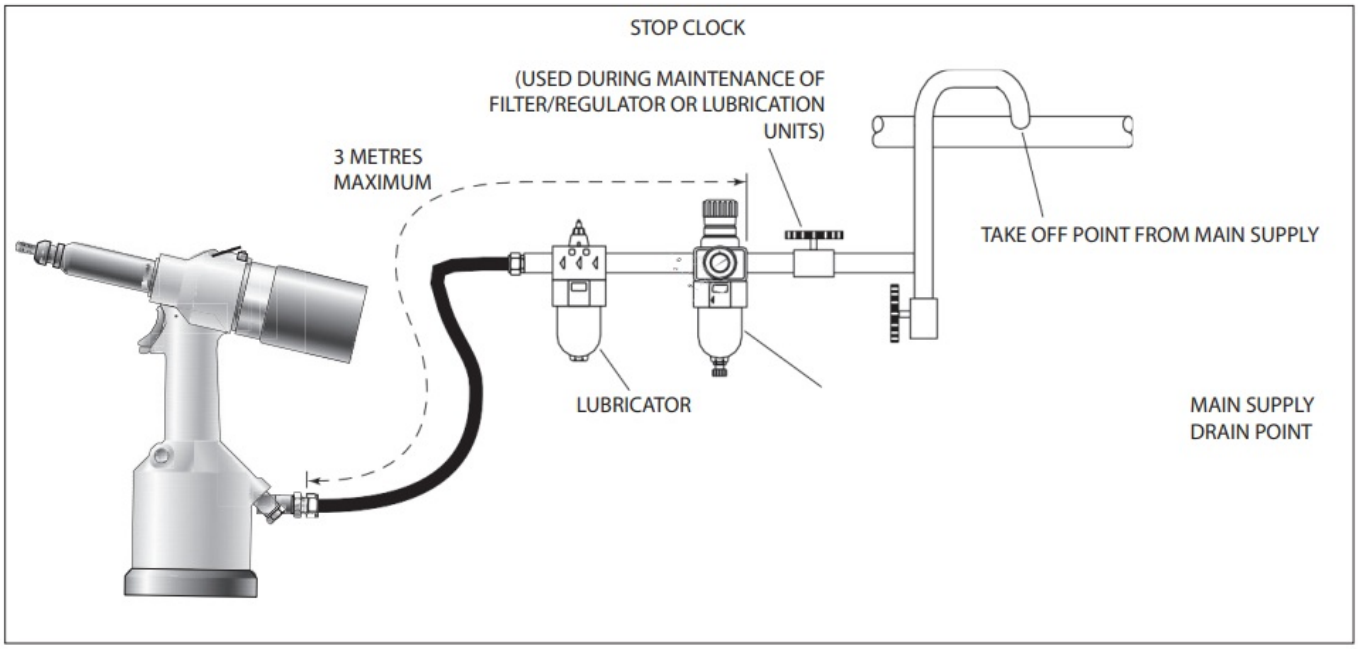


Fig. 2

4.2 STROKE ADJUSTMENT

This adjustment is necessary to ensure optimum insert deformation.
It is suggested, therefore, that a test plate with the same thickness and hole size as work piece be used.
If deformation is insufficient, the insert will rotate inside the application. If deformation is excessive, thread distortion will occur and possibly drive screw fracture.
The stroke is adjusted by the amount the rear casing 86 is screwed in or out. To shorten stroke, screw in; to lengthen stroke, unscrew the rear casing but never more than 5 turns from the fully “IN” position unless dismantling the tool. Adjust until optimum deformation is obtained.
Lock the stroke set finger 88 into the rear casing.

Fig. 3

4.3 PRINCIPLE OF OPERATION

- Connect tool to air supply.
- Offer up insert, lip first to drive screw. A light pressure will start the motor and automatically thread the insert up against nose and stop.
- Insert fastener into application squarely.
- Fully depress trigger. This will both place insert into the application and reverse it off the drive screw. Item numbers in bold refer to the General Assembly drawing and parts list (pages 18-19).

  CAUTION – do not attempt to force the installation of an insert as this will cause damage to the tool and/or application.

NOSE ASSEMBLIES

It is essential that the correct nose assembly is fitted prior to operating the tool. By knowing the details of the fastener to be placed, you will be able to order a new complete nose assembly using the selection tables on page 13.

5.1 FITTING INSTRUCTIONS

CAUTION: The air supply must be disconnected when fitting or removing nose assemblies unless specifically instructed otherwise.
Item numbers in bold refer to illustration below:

- If still fitted remove the nose casing and the adaptor nut.
- Insert drive shaft 4 into spindle.
- Fit drive screw 3 onto drive shaft 4.
- Insert reducing sleeve 5 (if specified) into the adaptor nut.

- Screw the adaptor nut onto the spindle.
- Hold the spindle with a spanner* and tighten the adaptor nut clockwise.
- While holding the adaptor nut with the spanner*, tighten the lock nut anti-clockwise.
- Screw on the nose casing and nose tip 1 with the nose tip lock nut.
- The reverse operation is carried out for equipment removal.
- With tool still disconnected from air supply, screw one insert onto drive screw manually – making sure the insert is flush with the end of drive screw.
- Set nose tip in exact position and lock nose tip nut clockwise with a spanner*.
- Remove the insert from drive screw.

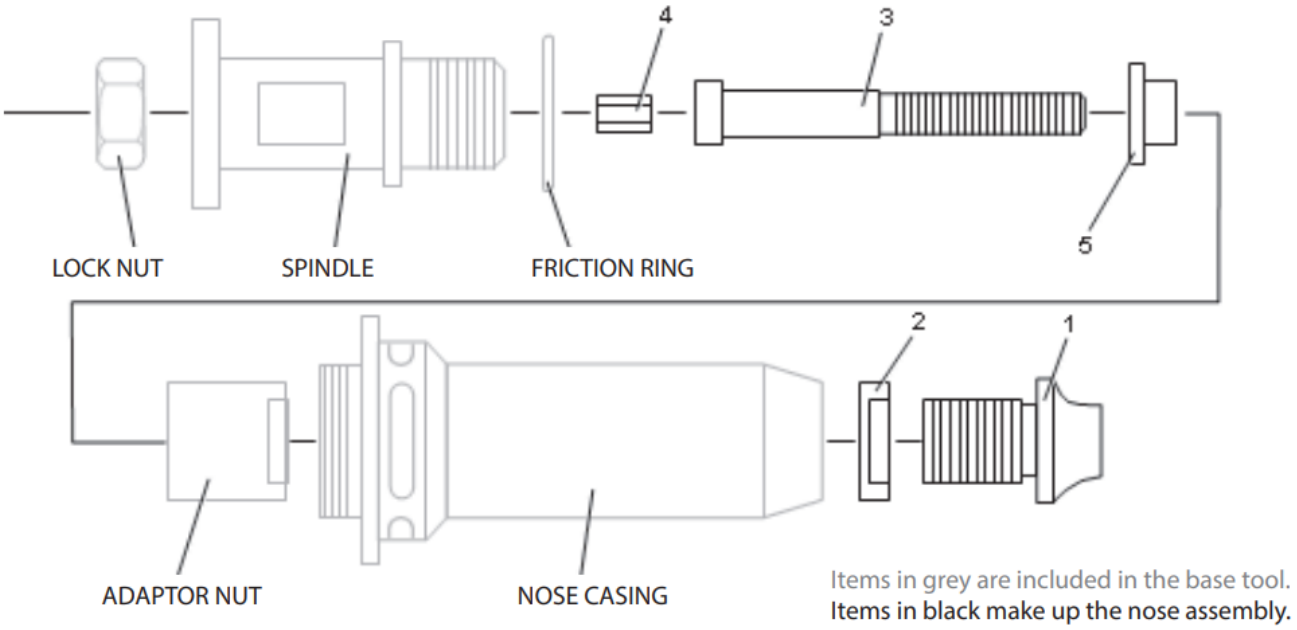


Fig. 4

5.2 SERVICE INSTRUCTIONS
Nose assemblies should be serviced at weekly intervals.

- Remove the complete nose assembly using the reverse procedure to the 'Fitting Instructions'.
- Any worn or damaged part should be replaced by a new part.
- Particularly check wear on drive screw.
- Assemble according to fitting instructions.

  Refers to items included in the 74200 service kit. For complete list see page 13.

5.3 74200 NOSE ASSEMBLY COMPONENTS
Nose tips vary in shape according to the insert type. Each nose assembly represents a unique assembly of components which can be ordered individually. All nose assemblies also include a nose tip locknut 2 (part number 07555-00901).
Component numbers refer to the illustration on the opposite page. We recommend some stock as items will need regular replacement. Read the Nose Assemblies servicing instructions opposite carefully.

INSERT SIZE	COMPLETE TOOL	NOSE ASSEMBLY	1	3	4	5

LARGEFLANGEINSERTS (9698,FS58,9408,9418,9498)+STANDARDNUTSERT®(9500)+SQUARESERT®(GK08)+EUROSERT®(GJ08)						
M3	74200-00083	07555-09883	07555-00903	07555-09003	07555-01003	07555-09103
M4	74200-00084	07555-09884	07555-00904	07555-09004	07555-01004	07555-09104
M5-	7420000085	07555-09885	07555-00905	07555-09005	07555-01005	07555-09105
M5-	74200-00485	07555-09185	07555-00915	07555-09005	07555-01035	07555-09105
M6	74200-00086	07555-09886	07555-00906	07555-09006	07555-01006	07555-09106
M8	7420000088	07555-09888	07555-00908	07555-09008	07555-01008	07555-09108
M10	74200-00080	07555-09880	07555-00910	07555-09010	07555-01010	–
MI 2	7420000082	74200 09882 t	755500912	07555-09012	07555-01012	
UNC	7420000054	07555-09854	-4 07555-008 54	07555-09054	07555-00754	07555-09154
6 UNC	74200-00056	07555-09856	07555-00856	07555-09056	07555-00756	07555-09156
8 UNC	74200-00058	07555-09858	07555-00858	07555-09058	07555-00758	07555-09158
10 UNC	74200-00050	07555-09850	07555-00850	07555-09050	07555-00750	07555-09150
1/4 UNC	74200-00048	07555-09848	07555-00848	07555-09048	07555-00748	07555-09148
5/16 UNC	74203-00040	07555-09840	07555-00840	07555-09040	07555-00740	07555-09140
3/8 UNC	74203-0E042	07555-09842	07555-00842	07555-09042	07555-00742	–
10 UNF	7420040070	07555-09870	07555-00850	07555-09070	07555-00750	07555-09150
1/4 UNF	74200-00068	07555-09868	07555-00948	07555-09068	07555-00748	07555-09148
5/16 UNF	74200-00060	07555-09860	07555-00840	07555-09060	07555-00740	07555-09140
3/8 UNF	74200-00062	07555-09862	07555-00842	755509062	7555.00742	–
3/16 BSW	74200-00016	07555-09816	07555-00850	07555-09016	07555-00750	07555-09150
1/4 BSW	74200-00018	07555-09818	755500848	755509018	7555.03748	07555-09148
5/16 B5W	7420000010	07555-09810	07555-00840	07555-09019	07555-00740	07555-09140
THIN SHEET NUTSERT*19468, F538, 9658,9488)						
M3	74200-00183	07555-09983	755500993	07555-09003	07555-01003	07555-09103
M4	74200-00184	07555-09984	07555-0 0994	07555-09004	07555-01004	07555-09104
M5	74200-00185	07555-09985	755500995	07555-09005	07555-01005	07555-09105
MG	7420000186	755509986	07555-0 0996	07555-09006	07555-01006	07555-09106
M8	74200-00188	07555-09988	07555-00998	07555-09008	07555-01008	07555-09108
M10	7420000180	755509980	07555-00999	07555-09010	07555-01010	–
M12	74200-00182	74200-09982t	07555-00992	07555-09012	07555-01012	–

4 UNC	74200-00154	07555-09954	07555-00954	07555-09054	07555-00754	07555-09154
6 UNC	74200-00156	755509956	07555-00956	07555-09056	07555-00756	07555-09156
8 UNC	74200-00158	07555-0 99 5 8	755500958	07555-09058	07555-00758	07555-09158
10 UNC	74200-00150	755509950	07555-00950	07555-09050	07555-00750	07555-09150
1/4 UNC	74200-00148	07555-09948	07555-00948	07555-09048	07555-00748	07555-09148
5/16 UNC	74200-00140	07555-09940	07555-00940	07555-09040	07555-00740	07555-09140
10 UNF	74200-00170	07555-09970	07555-00950	07555-09070	07555-00750	07555-09150
1/4 UNF	74200-00168	755509968	07555-00948	07555-09068	755500748	07555-09148
5/16 UNF	74200-00160	07555-09960	07555-00940	07555-09060	07555-00740	07555-09140
3/1685W	74200-00116	755509916	07555-00950	07555-09016	07555-00750	755509150
1/4 135W	74200-00118	07555-09918	07555-00948	07555-09018	07555-00748	07555-09148
OBA	74200-00130	07555-09930	07555-00996	07555-09330	07555-01006	755509106
2BA	74200-00132	07555-09932	07555-00950	07555-09032	07555-00750	07555-09150
4 BA	74200-00134	07555-09934	07555-00934	07555-09034	07555-00756	07555-09134
SUPERSER V -OPEN AND CLOSED END IF 81						
M3	74200-00283	07555-09583	07555-07103	07555-09003	07555-01003	07555-09103
M4	7420000784	07555-09584	07555-07104	07555-09004	07555-01004	07555-09104
MS	74200-0028S	07555-09585	07555-07105	07555-09005	07555-01005	07555-09105
M6	74200-00286	07555-09586	07555-07106	07555-09006	07555-01006	07555-09106
M8	74200-00288	07555-09588	07555.07108	755509008	07555-01008	07555-09108
8 UNC	74200-00258	07555-09558	07555-07158	07555-09058	07555-00758	07555-09158
10 UNC	74200-00250	07555.09550	07555.07150	07555.09050	07555-00750	07555-09150
1/4 UNC	74200-00248	07555-09548	07555.07148	07555-09048	07555-00748	07555-09148
8 UNF	74200-00278	07555-09578	07555-07158	07555.09078	07555-00758	07555-09158
10 UNF	74200-00270	07555-09570	07555-07150	07555-09070	07555-00750	07555-09150
1/4 UNF	74200-00268	07555-09568	07555.07148	07555-09068	07555-00748	07555-09148
HEXSERT•(9688)						
M3	74200-00683	07555-09283	755508103	07555-09003	07555-01003	07555.09103
M4	74200-00684	07555-09284	07555-08104	07555-09004	07555-01004	07555-09104
MS	74200-00685	755509285	07555.08105	07555-09005	07555-01005	07555-09105
mo	74200-00686	07555-09286	07555-08106	07555-09006	07555-01009	07555-09109
M8	74200-00688	755509288	755500998	07555-09008	07555-01008	07555.09108

• Places all inserts listed in this section except M5 large flange Thin Sheet Nutsert®
•• Places M5 large flange Thin Sheet Nutsert® 09698-00516 ONLY
† These nose assemblies include an adaptor nut part number 74200-12119 to replace the one on the tool.

SERVICING THE TOOL

Regular servicing should be carried out and a comprehensive inspection performed annually or every 500,000 cycles, whichever is sooner.

CAUTION: Never use solvents or other harsh chemicals for cleaning the non-metallic parts of the tool. These chemicals may weaken the materials used in these parts.

CAUTION: Before maintenance, remove any dangerous substances that may have accumulated due to work processes.

CAUTION: The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.

CAUTION: The operator should not be involved in maintenance or repair of the tool unless properly trained.

CAUTION: The tool shall be examined regularly for damage and malfunction.

CAUTION: Read Safety Instructions on page 4 to 6.

6.1 DAILY SERVICING

- Daily, before use or when first putting the tool into service, pour a few drops of clean, light lubricating oil into the air inlet of the tool if no lubricator is fitted on air supply. If the tool is in continuous use, the air hose should be disconnected from the main air supply and the tool lubricated every two to three hours.
- Check for air leaks. If damaged, hoses and couplings should be replaced by new items.
- If there is no filter on the pressure regulator, bleed the air line to clear it of accumulated dirt or water before connecting air hose to tool.
- Check that the nose assembly is correct.
- Check the stroke of the tool is adequate to place selected insert. (See stroke adjustment page 9).
- Inspect the drive screw in the nose assembly for wear or damage. If any, renew.

6.2 WEEKLY SERVICING

* Check for oil leaks and air leaks on air supply hose and fittings.

6.3 SERVICE KIT

For all servicing we recommend the use of the service kit (part number 74200-99990) supplied in its own plastic case.

SERVICE KIT 74200-99990

SERVICE KIT 74200-99990					
Part Number	**Description**	**QTY**	**Part Number**	**Description**	**QTY**
07900-00618	PUSHER	1	07900-00393	14mm/15mm SPANNER	1
07900-00619	GUIDE BUSH	1	07900-00409	12mm/13mm SPANNER	1
07900-00478	0 3mm PIN PUNCH	1	07900-00626	11mm SPANNER	1
07900-00624	0 4mm PIN PUNCH	1	07900-00469	2.5mm ALLEN KEY	1
07900-00157	INTERNAL CIRCLIP PLIERS	1	07900-00351	3mm ALLEN KEY	1
07900-00161	EXTERNAL CIRCLIP PLIERS	1	07900-00224	4mm ALLEN KEY	1
07900-00625	SOFT MALLET	1	07900-00225	5mm ALLEN KEY	1
07900-00623	25mm SOCKET	1	07900-00620	12mm ALLEN KEY	1
07900-00006	SPATULA	1	07900-00456	T BAR	1
07900-00434	32mm SPANNER	1	07992-00075	MOLYKOTE 55M (100 gm TUBE)	1
07900-00621	28mm SPANNER	1	07900-00627	PLASTIC CASE	1
07900-00637	17mm SPANNER	1	07900-00632	17mm/19mm SPANNER	1
07900-00643	PUSHER KNOB	1			

6.4 MAINTENANCE

Every 500,000 cycles the tool should be completely dismantled and components replaced where worn, damaged or when recommended. All ‘O’ rings and seals should be replaced with new ones and lubricated with Molykote 55M grease before assembling.

WARNING: Read Safety Instructions on page 4 to 6.

WARNING: The employer is responsible for ensuring that tool maintenance instructions are given to the appropriate personnel.

WARNING: The operator should not be involved in maintenance or repair of the tool unless properly trained.

WARNING: The tool shall be examined regularly for damage and malfunction.

The airline must be disconnected before any servicing or dismantling is attempted unless specifically instructed otherwise.

It is recommended that any dismantling operation be carried out in clean conditions.

Before proceeding with dismantling, empty the oil from the tool. Remove oil plug **42,** oil seal washer **43,** bleed screw 48 and bleed screw washer **49** from the handle assembly and drain the oil into a suitable container.

Prior to dismantling the tool it is necessary to remove the nose assembly. For simple removal instructions see the nose assemblies section, pages **10-13**.

For total tool servicing we advise that you proceed with dismantling of sub-assemblies in the order shown below.

6.5 PNEUMATIC CYLINDER

- Remove rubber base 2.

- Place tool, base uppermost in vice fitted with soft jaws.
- Using a spanner*, unscrew end plug 3. Pneumatic piston 9 should move upward under spring 11 pressure (it may be necessary to exert hand pressure to pneumatic piston 9).
- Remove ‘O’ ring 4.
- Withdraw pneumatic piston 9.
- Remove lip seal 8 and ‘O’ ring 36.
- Hold piston rod 10 in soft vice jaws to avoid scratching rod diameter.
- Separate piston rod 10 from pneumatic piston 9 by unscrewing piston rod fastening bolt 5 using a spanner*.
- Inspect air tube 12 for damage or distortion. (Air tube is screwed internally into handle and set in position with Loctite® 222) If it is necessary to remove air tube, the base of the air tube will require warming to a temperature of 100 °C to soften the Loctite adhesive. The air tube 12 can then be unscrewed from the handle using an Allen key*.
- Check spring 11 is not distorted or damaged.
- Assembly is in reverse order to dismantling.

6.6 ROD GUIDE

- With tool in upside down position in vice, unscrew rod guide 15 using a spanner* and T-bar*.
- Withdraw rod guide 15.
- Unscrew locknut 13 using an Allen key*, remove seal 14 and ‘O’ ring 98.
- Remove ‘O’ ring 16.
- Assembly is in reverse order to dismantling.

6.7 TRIGGER

- With tool held in vice, remove pin 26 using a pin punch*.
- Remove trigger 25, pin 22, roller 23 and push wedge 24.
- Gently push on the head of trigger rod 20 and, remove together with ‘O’ rings 7 and 21, guide 19, lip seal 18 and plug 17.
- Assembly is in reverse order to dismantling. Ensure lip of lip seal 18 is towards head of tool.

  * Refers to items included in the 74200 service kit. For complete list see page 13.

  Item numbers in bold refer to the General Assembly drawing and parts list (pages 18-19).

6.8 SWIVEL AIR INLET (74200-12700)

Item numbers in bold refer to the General Assembly drawing and parts list (pages 18-19).

- Using an Allen key* remove screw 40 and washer 39.
- Remove swiveling inlet 38.
- Unscrew double male connector 41 from swiveling inlet 38 and remove nylon washer 33.
- Using a spanner*, remove drilled bolt 37.
- Remove two nylon washers 33 and air inlet block 35.
- Remove circlip 97 from double male connector 41 using circlip pliers and withdraw sintered filter 96.
- Assemble in reverse order of dismantling.
- Refers to items included in the 74200 service kit. For complete list see page 13.

6.9 DIFFERENTIAL VALVE

- Using special flat spanner* unscrew valve locking plug 27, withdraw and remove spring 104 and ‘O’ ring 29.
- Remove silencer 34 using a spanner* and remove nylon washer 33.
- Push valve piston 28 out from its housing together with ‘O’ rings 30, 31&32.
- Check spring 104 for distortion and renew if required.
- Assemble in reverse order of dismantling.

6.10 HEAD ASSEMBLY

- Remove nose equipment prior to commencing dismantling.
- Using spanners* remove spindle 44 and locknut 45.
- Remove return spring locknut 46 using a spanner*.
- Remove return spring 47, washer 99 and locking ring 90.
- Check return spring 47 for distortion and renew if required.
- Assemble in reverse order of dismantling.

6.11 REAR CASING

- Using an Allen key* remove screw 40 from stroke set finger 88 and lift off bridge washer 95.
- Disengage stroke set finger 88 by pushing it back against spring 89.
- Unscrew rear casing 86.
- Remove rear casing rubber band 87 if necessary.
- Extract circlip 84 using circlip pliers* and remove sintered silencer 85.
- Complete assembly in reverse order of dismantling. Locate pawl 102 in head before screwing on rear casing 86.

6.12 DISTRIBUTOR

* Using an Allen key* remove two screws 40.
* Withdraw distributor 83 together with air motor end plug 81 and ‘O’ rings 82&31 taking care not to drop ball 79 and push rod 78.
* Using an Allen key* remove four countersunk socket head screws 58 and withdraw stroke stop 57.
* Pull out two air supply tubes 59 and four ‘O’ rings 60.
* Assemble in reverse order of dismantling.

6.13 HYDRAULIC PISTON & AIR MOTOR ASSEMBLY (74200-12610)

- Wrap adhesive tape around hydraulic piston 54 thread and move assembly backwards slowly and firmly. Using circlip pliers* remove circlip 52 and front seal 51.
- Remove ‘O’ rings 76 and 77.
- Using two spanners* separate the hydraulic piston 54 from air motor casing 75. Shim adjustment ring 55, movement pivot 56 and ‘O ring 101 will come out with hydraulic piston 54.
- Remove air motor assembly out of air motor casing 75, remove circlip 61 using circlip pliers*, then tap air motor casing 75 on bench to free components.

  * Refers to items included in the 74200 service kit. For complete list see page 13.

  Item numbers in bold refer to the General Assembly drawing and parts list (pages 18-19).

- Parts 62 to 74 can be pulled out as an assembly, taking care not to drop pin 74.
- Remove bearing 62, planet gear spindle 63, three planets 64, planet gear 65 and spacer 66.
- Using a soft mallet tap splined head of rotor 70.
- Bearing 67 and front end plate 68 will come out with stator 69 and five rotor blades 71. (rotor 70 remains in hand).
- Place rear end plate 72 in vice with soft jaws.
- Using a pin punch* tap centre of rotor 70 to remove bearing 73. (turn rotor 70 upside down and bearing 73 will come out).
- When assembling air motor, rear side of rotor 70 must just touch rear end plate 72 without any axial gap, (any existing gap will disappear when bearing 73 is fully located.
- When inserting air motor into air motor casing 75 carefully align parts so that pin 74 locates in centre hole between spin on/off ports of air motor casing 75 and rear end plate 72.
- When assembling hydraulic piston 54 onto air motor assembly, tighten parts by hand and blow air into one of the outer ports of air motor casing 75, checking to see air motor rotates freely.
- When assembling front seal 51 ensure larger diameter faces rear of tool.
- Complete assembly in reverse order to dismantling.

CAUTION: Check the tool against daily and weekly servicing.

CAUTION: Priming is ALWAYS necessary after the tool has been dismantled and prior to operating.

* Refers to items included in the 74200 service kit. For complete list see page 13.

Item numbers in bold refer to the General Assembly drawing and parts list (pages 18-19).

6.14 MOLYKOTE 55m SAFETY DATA

Grease can be ordered as a single item, the part number is shown in the service kit page 13.

FIRST AID

SKIN: Wipe off and wash with soap and water.

INGESTION: No adverse effects are normally expected. Treat symptomatically.

EYES: Irritant but not harmful. Irrigate with water and seek medical attention.

ENNVIRONMENT

Scrape up for incinerating or disposal on approved site.

FIRE

FLASH POINT: 101 °C

Not classified as flammable.

Suitable extinguishing media: Carbon dioxide, foam, dry powder or fine water spray.

HANDLING

Plastic or rubber gloves should be worn.

STORAGE

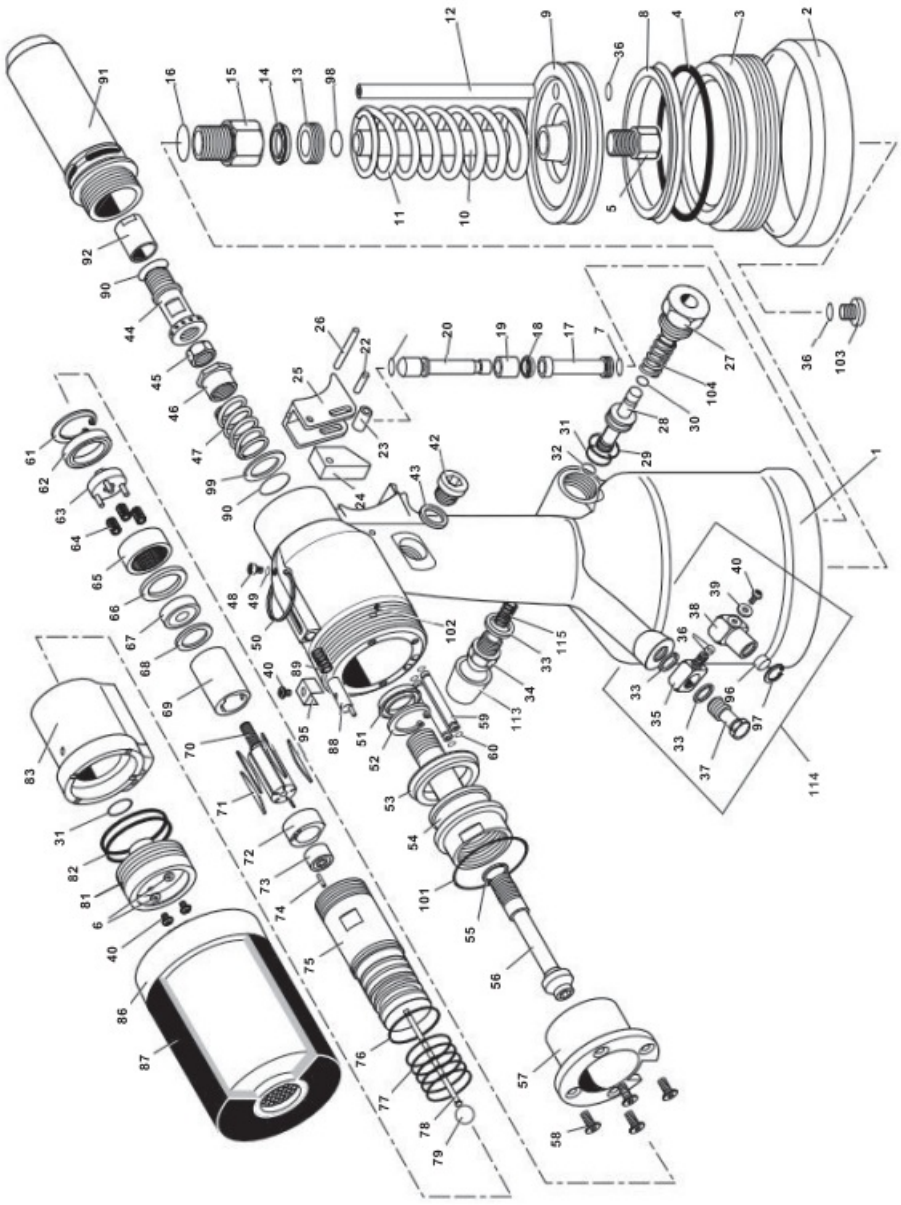
Away from heat and oxidizing agent

6.15 PROTECTING THE ENVIRONMENT

Assure conformity with applicable disposal regulations. Dispose all waste products at an approved waste facility or site so as not to expose personnel and the environment to hazards.

GENERAL ASSEMBLIES

7.1 GENERAL ASSEMBLY OF BASE TOOL 74200-12000



7.2 GENERAL ASSEMBLY PARTS LIST 74200-12000
Parts List for 74200-12000

74200-12000 PARTS LIST														
ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES	ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES	ITEM	PART N°	DESCRIPTION	QTY	REC. SPARES
01	74200-12001	HEAD & HANDLE	1	-	40	07001-00420	M4 BUTTON SOCKET HD SCREW	4	4	79	74200-12079	BALL (RUBBER)	1	1
02	74200-12002	RUBBER BASE	1	1						80	73200-02022	SAFETY LABEL	1	N/1
03	74200-12003	END PLUG (SCREWED)	1	-	42	07005-01274	OIL PLUG	1	1	81	74200-12081	AIR MOTOR END PLUG	1	-
04	74200-12004	'O' RING	1	1	43	74200-12043	OIL SEAL WASHER	1	1	82	74200-12082	'O' RING	2	2
05	74200-12005	PISTON ROD FASTENING BOLT	1	-	44	74200-12044	SPINDLE	1	1	83	74200-12083	DISTRIBUTOR	1	-
06	07002-00109	M4 SHAKEPROOF WASHER	2	-	45	07555-00803	LOCK NUT	1	1					
07	07003-00027	'O' RING	2	2	46	74200-12046	RETURN SPRING LOCKNUT	1	1	85	74200-12085	SINTERED SILENCER		
08	74200-12008	LIP SEAL (PNEUMATIC PISTON)	1	1	47	74200-12047	RETURN SPRING	1	1	86	74200-12800	REAR CASING ASSEMBLY	1	-
09	74200-12009	PNEUMATIC PISTON	1	-	48	07001-00329	M5 BLEED SCREW	1	1	87	74200-12087	REAR CASING RUBBER BAND	1	1
10	74200-12010	PISTON ROD (INTENSIFIER)	1	-	49	07003-00033	OIL SEAL BLEED WASHER	1	1	88	74200-12088	STROKE SET FINGER	1	1
11	07555-00205	SPRING	1	1	50	07265-03021	SUSPENSION RING	1	1	89	74200-12089	SPRING	1	1
12	74200-12012	AIR SUPPLY TUBE	1	1	51	07265-02004	FRONT SEAL	1	1	90	07003-00028	LOCKING RING	2	2
13	74200-12013	LOCK NUT	1	-	52	07004-00033	CIRCLIP	1	1	91	74200-12091	NOSE CASING	1	-
14	74200-12014	SEAL	1	1	53	74200-12053	SEAL	1	1	92	74200-12092	ADAPTOR NUT (UP TO M10)	1	1
15	74200-12015	ROD GUIDE	1	-	54	74200-12054	HYDRAULIC PISTON	1	-	93	74200-12093	COLOURED LABEL	1	N/1
16	07003-00100	'O' RING	1	1	55	74200-12055	SHIM ADJUSTMENT RING	1	1	94	07900-00354	TIE ON SAFETY LABEL	1	N/1
17	74200-12017	PLUG	1	-	56	74200-12056	MOVEMENT PIVOT	1	1	95	74200-12095	BRIDGE WASHER	1	1
18	74200-12018	LIP SEAL	1	1	57	74200-12057	STROKE STOP	1	-	96	74200-12096	SINTERED FILTERED	1	1
19	74200-12019	GUIDE	1	-	58	07001-00427	M5CSKSOCKETHEADSCREW	4	4	97	74200-12097	CIRCLIP	1	1
20	74200-12020	TRIGGER ROD	1	-	59	74200-12059	PNEU. MOTOR AIR SUPPLY TUBE	2	2	98	07003-00134	'O' RING	1	1
21	07003-00315	07003-00315 'O' RING	1	1	60	74200-12060	'O' RING	4	4	99	74200-12099	WASHER	1	1
22	74200-12022	PIN	1	1	61	74200-12061	CIRCLIP	1	1	100	07007-01526	'CE' LABEL (AVDEL ITALY)	1	N/1
23	74200-12023	ROLLER	1	1	62	74200-12062	BEARING	1	-	101	74200-12121	'O' RING	1	1
24	74200-12024	PUSH WEDGE	1	-	63	74200-12063	PLANET GEAR SPINDLE	1	-	102	74200-12122	PAWL (RUBBER)	1	1
25	74200-12025	TRIGGER	1	1	64	07555-09208	PLANET	3	-	103	74200-12103	PLUG	1	1
26	74200-12026	PIN	1	1	65	74200-12065	PLANET GEAR	1	-	104	74200-12104	SPRING	1	N/1
27	74200-12027	VALVE LOCKING PLUG	1	-	66	74200-12066	SPACER	1	-	105	07900-00614	TOOL MANUAL	2	N/1
28	74200-12028	VALVE PISTON	1	-	67	07555-09206	BEARING	1	-	106	07900-00632	17/19 MM THIN SPANNER	1	N/1
29	07003-00086	'O' RING	1	1	68	07555-09210	FRONT END PLATE	1	-	107	07900-00409	12/13 MM SPANNER	1	N/1
30	07003-00040	'O' RING	1	1	69	07555-09211	STATOR	1	-	108	07900-00224	4 MM ALLEN KEY	1	N/1
31	07003-00026	'O' RING	2	2	70	74200-12070	ROTOR	1	-	109	07900-00225	5 MM ALLEN KEY	1	N/1
32	07003-00046	'O' RING	1	1	71	07555-09213	ROTOR BLADE	5	5	110	07900-00624	4 MM Ø PIN PUNCH	1	N/1
33	74200-12033	1/8" NYLON WASHER	3	4	72	07555-09214	REAR END PLATE	1	-	111	07900-00637	SPECIAL 17 MM FLAT SPANNER	1	N/1
34	74200-12034	1/8" SILENCER	1	1	73	07555-09215	BEARING	1	-	112	07900-00469	2.5 MM ALLEN KEY		
35	74200-12035	AIR INLET BLOCK	1	-	74	07555-09216	PIN	1	1	113	74200-12300	DEFLECTOR ASSEMBLY	1	N/1
36	07003-00029	'O' RING	4	4	75	74200-12075	AIR MOTOR CASING	1	-	114	74200-12700	INLET ASSEMBLY	1	
37	74200-12037	DRILLED BOLT	1	-	76	07003-00305	'O' RING	1	1	115	07340-00401	SPRING	1	
38	74200-12038	SWIVELLING INLET	1	-	77	07003-00306	'O' RING	5	5					
39	74200-12039	WASHER	1	1	78	74200-12078	PUSH ROD 80 mm LONG	1	1					

PRIMING

Priming is ALWAYS necessary after the tool has been dismantled and prior to operating. It may also be necessary to restore the full stroke after considerable use, when the stroke may be reduced and fasteners are not fully placed by one operation of the trigger.

8.1 OIL DETAILS

The recommended oil for priming is Hyspin® VG32 available in 0.5l (part number 07992-00002) or one gallon containers (part number 07992-00006). Please see safety data below.

8.2 HYSPIN®VG 32 OIL SAFETY DATA FIRST AID

SKIN:

Wash thoroughly with soap and water as soon as possible. Casual contact requires no immediate attention. Short term contact requires no immediate attention.

INGESTION:

Seek medical attention immediately. DO NOT induce vomiting.

EYES:

Irrigate immediately with water for several minutes. Although NOT a primary irritant, minor irritation may occur following contact.

FIRE

Flash point 232°C. Not classified as flammable.

Suitable extinguishing media: CO2, dry powder, foam or water fog. DO NOT use water jets.

ENVIRONMENT

WASTE DISPOSAL: Through authorized contractor to a licensed site.May be incinerated. Used product may be sent for reclamation. SPILLAGE: Prevent entry into drains, sewers and water courses. Soak up with absorbent material.

HANDLING

Wear eye protection,impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area.

STORAGE

No special precautions.

8.3 PRIMING PROCEDURCE

CAUTION: Ensure that the oil is perfectly clean and free from air bubbles.

CAUTION: The tool must remain on its side throughout the priming sequence.

CAUTION: All operations should be carried out on a clean bench, with clean hands, in a clean area.

CAUTION: Care MUST be taken, at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

- Place tool on its side, oil plug 42 side up.
- Pull back stroke set finger 88 and unscrew rear casing 86 by a maximum of 5 turns from the fully 'IN' position.
- With an Allen key, unscrew oil plug 42 and remove with oil seal washer 43.
- Fill tool with priming oil rocking gently to expel air.
- Replace oil seal washer 43 and oil plug 42 and tighten.
- You must now bleed the tool. This operation is to ensure air bubbles are eliminated from the oil circuit.
- Ensuring oil bleed screw 48 is fully tightened unscrew by ONE TURN only, using an Allen key. Connect the tool to the air supply and depress the trigger.
- Wait until oil appears all around oil bleed screw 48 then re-tighten. Wipe excess oil away.
- Release the trigger.
- Using an Allen Key open oil plug 42.
- Top-up with priming oil to reset level. Replace oil seal washer 43 and oil plug 42 and fully tighten.
- It is necessary to fit the appropriate nose equipment and adjust the tool stroke prior to operating the tool.
  Item numbers in bold refer to general assembly drawings and parts list (pages 18-19).

FAULT DIAGNOSIS

SYMPTOM	POSSIBLE CAUSE	REMEDY	PAGE REF.
Pneumatic motor runs slowly	Air leak from motor	Check for worn seals. Replace	15
	Low air pressure	Increase	12 II
	Air way blockage	Clear restriction in air supply	
	Worn drive screw	Replace	10 II
	Vanes jamming	lubricate tool through air inlet	
Insert does not deform properly			
	Stroke incorrectly set	Adjust	12
	Air pressure outside the tolerance	Adjust	12
	Low oil level	Prime tool	21
	Insert out of grip	Check grip range of Insert	
Drive screw turns independent of motor			
	Worn or damaged drives haft	Replace	II
	Worn or damaged drive screw	Replace	10
	Adaptor nut loose	Tighten	10111

	Locking ring 90 missing	Fit new locking ring	17
Insert will not place onto drive screw			
	Incorrect Insert thread size	Change to correct insert	“91111
	Incorrect drive screw fitted	Change to correct drive screw	
	Worn or damaged drive screw	Replace	-.
	Nose equipment incorrectly asse mblec	Disconnect air supply. re-fit nose eq uipment carefully	10-11
Tool is jammed on placed insert			
	Excessive stroke/ Defective inser t/ Oar or defective drive screw	DO NOT DEPRESS TRIGGER. Unlock. Stroke locking device and b ring rear casing forward to zero stro ke • position. Depress trigger. Tool sho uld spin off. Reset stroke. If not. dis connect air to tool. nsert a 4mm 0 pi n through nose casing slots into spi ndle 44. Turn until drive screw leave s. Insert. Use new insert AND Drive screw.	
Drive screw breaks	Stroke of tool excessive	Re-set stroke	
	Side load on drive screw	Hold tool square to application whe n placing Insert	
Tool does not spin on	Screw adaptor nut loose	Tighten	
	No air supply	Connect	12 -a
	Insufficient gap between locknut 45 and spindle 44	Adjust to 1 .5mm gap to 2mm gap	17
	Push rod 78 too short	Replace	18 Al
	Air motor jammed	Lubricate tool at air inlet. If insufficie nt Dismantle and clean air motor th oroughly	
Trigger inoperative	Static friction Low air pressure Valve piston remains stuck	Depress trigger a few times Increas e air pressure Depress trigger several times. Lubri cate tool through air inlet. If unsuccessful, dismantle, clean and lubricate trigger elements	
Drive screw does not ret urn and/or keeps spinnin g off	Lip seal 18 is defective	Replace	17

Tool does not spin off	Adaptornut 92 loose No air supply Rear casing unscrewed by more than 5 turns 'O'ring 82 leaking air Distributor stuck Air motor jammed	Tighten Connect Set tool stroke 5 turns Replace Lubricate Lubricate tool at air inlet. If insufficient dismantle and clean air motor thoroughly	18

Item numbers in bold refer to general assembly drawings and parts list (pages 18-19).
Other symptoms or failures should be reported to your local Stanley Engineered Fastening authorised distributor or repair centre.

EC DECLARATION OF CONFORMITY

We, Stanley Engineered Fastening, Stanley House, Works Road, Letchworth Garden City, Hertfordshire, SG6 1JY UNITED KINGDOM, declare under our sole responsibility that the product:
Description: 74200 Hydro-Pneumatic Tool for Blind Rivet Nuts Model: 74200 to which this declaration relates is in conformity with the following harmonized standards:

ISO 12100:2010	EN ISO 3744:2010
EN ISO 11202:2010	EN ISO 11148-1:2011
EN ISO 4413:2010	BS EN 28662-1:1993
EN ISO 4414:2010	EN ISO 20643:2008+A1:2012
EN ISO 28927-5:2009+A1:2015	ES100118-rev 17:2017

Technical documentation is compiled in accordance with Annex VII, in accordance with the following Directive:
Machinery Directive (2006/42/EC)
The undersigned makes this declaration on behalf of STANLEY Engineered Fastening.

A. K. Seewraj
Director of Engineering, UK
Avdel UK Limited, Stanley House, Works Road, Letchworth Garden City, Hertfordshire,
SG6 1JY UNITED KINGDOM
Place of issue:
Letchworth Garden City, UK
Date of issue:
01-01-2021
The undersigned is responsible for compilation of the technical file for products sold in the European Union and makes this declaration on behalf of Stanley Engineered Fastening.
Matthias Appel
Team Leader Technical Documentation
Stanley Engineered Fastening, Tucker GmbH, Max-Eyth-Str.1, 35394 Gießen, Germany

CE **This machinery is in conformity with Machinery Directive 2006/42/EC**

UK DECLARATION OF CONFORMITY

We, Stanley Engineered Fastening, Stanley House, Works Road, Letchworth Garden City, Hertfordshire, SG6 1JY UNITED KINGDOM, declare under our sole responsibility that the product:
Description: 74200 Hydro-Pneumatic Tool for Blind Rivet Nuts Model: 74200 to which this declaration relates is in conformity with the following designated standards:

ISO 12100:2010	EN ISO 3744:2010
EN ISO 11202:2010	EN ISO 11148-1:2011
EN ISO 4413:2010	BS EN 28662-1:1993
EN ISO 4414:2010	EN ISO 20643:2008+A1:2012
EN ISO 28927-5:2009+A1:2015	ES100118-rev 17:2017

Technical documentation is compiled in accordance with the Supply of Machinery (Safety) Regulations 2008, S.I. 2008/1597 (as amended).
The undersigned makes this declaration on behalf of STANLEY Engineered Fastening

Director of Engineering, UK
Avdel UK Limited, Stanley House, Works Road, Letchworth Garden City, Hertfordshire, SG6 1JY UNITED KINGDOM
Place of issue: Letchworth Garden City, UK
Date of issue: 01-01-2021

UK CA This machinery is in conformity with Supply of Machinery (Safety) Regulations 2008, S.I. 2008/1597 (as amended)

PROTECT YOUR INVESTMENT!

Stanley® Engineered Fastening BLIND RIVET TOOL WARRANTY
STANLEY® Engineered Fastening warrants that all power tools have been carefully manufactured and that they will be free from defect in material and workmanship under normal use and service for a period of one (1) year. This warranty applies to the first time purchaser of the tool for original use only.
Exclusions: Normal wear and tear.
Periodic maintenance, repair and replacement parts due to normal wear and tear are excluded from coverage.
Abuse & Misuse.
Defect or damage that results from improper operation, storage, misuse or abuse, accident or neglect, such as physical damage are excluded from coverage.
Unauthorized Service or Modification.
Defects or damages resulting from service, testing adjustment, installation, maintenance, alteration or modification in any way by anyone other than STANLEY® Engineered Fastening, or its authorized service centres, are excluded from coverage. All other warranties, whether expressed or implied, including any warranties of merchantability or fitness for purpose are hereby excluded. Should this tool fail to meet the warranty, promptly return the tool to our factory authorized service centre location nearest you. For a list of STANLEY® Engineered Fastening Authorized Service Centres in the US or Canada, contact us at our toll free number (877)364 2781.
Outside the US and Canada, visit our website **www.StanleyEngineeredFastening.com** to find your nearest

STANLEY Engineered Fastening location.
STANLEY Engineered Fastening will then replace, free of charge, any part or parts found by us to be defective due to faulty material or workmanship, and return the tool prepaid. This represents our sole obligation under this warranty. In no event shall STANLEY Engineered Fastening be liable for any consequential or special damages arising out of the purchase or use of this tool.
Register Your Blind Rivet Tool online.
To register your warranty online, visit us at https://www.stanleyengineeredfastening.com/support/warranty-registration-form
Thank you for choosing a STANLEY® Engineered Fastening's Stanley Assembly Technologies Brand tool.

Documents / Resources

	STANLEY 74200 Threaded Insert Tool [pdf] Instruction Manual 74200 Threaded Insert Tool, 74200, Threaded Insert Tool, Insert Tool

References

- STANLEY® Engineered Fastening | Precision Fastening and Assembly Solutions
- Contact Us | STANLEY® Engineered Fastening
- Find A Fastener Distributor | STANLEY® Engineered Fastening
- Warranty Registration Form for POP® Avdel® STANLEY Asssemblie Technologies Tools | STANLEY® Engineered Fastening