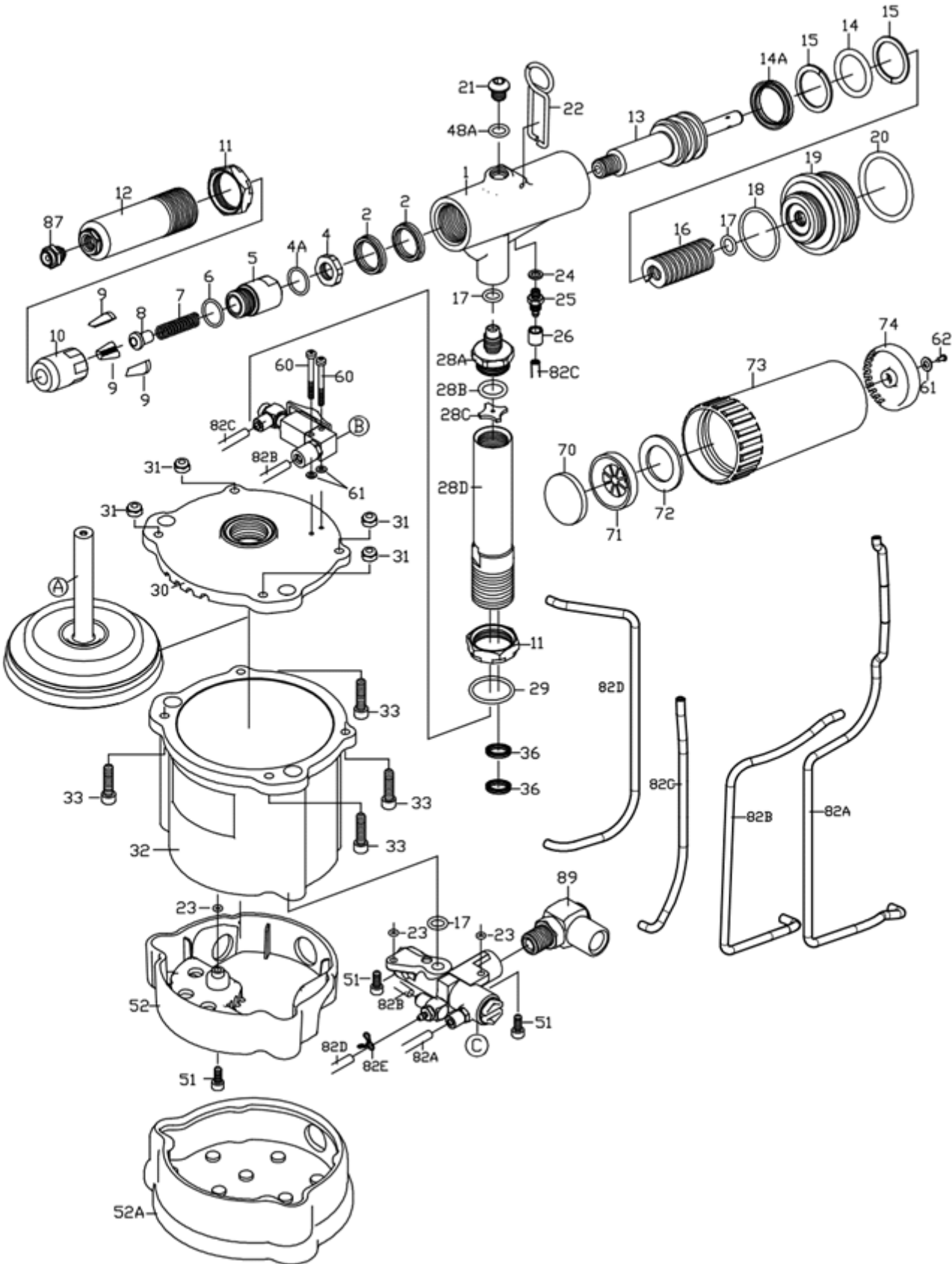
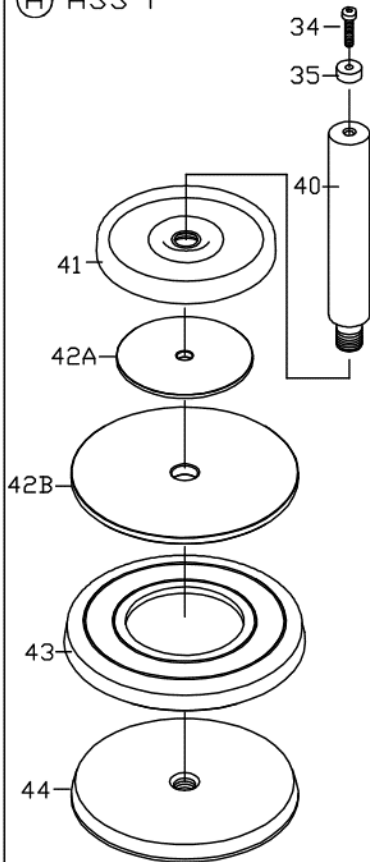


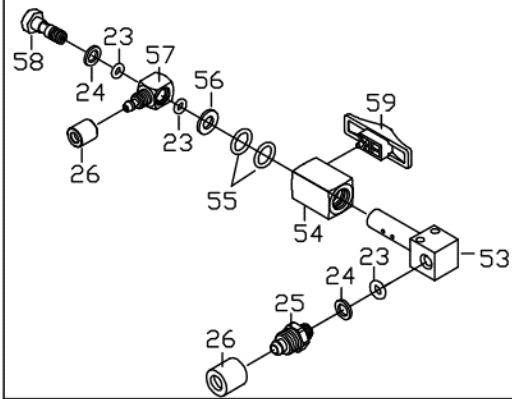
ZT2318D -8 5/16" (8mm) Air Hydraulic Riveter W/DIGITAL MODULE



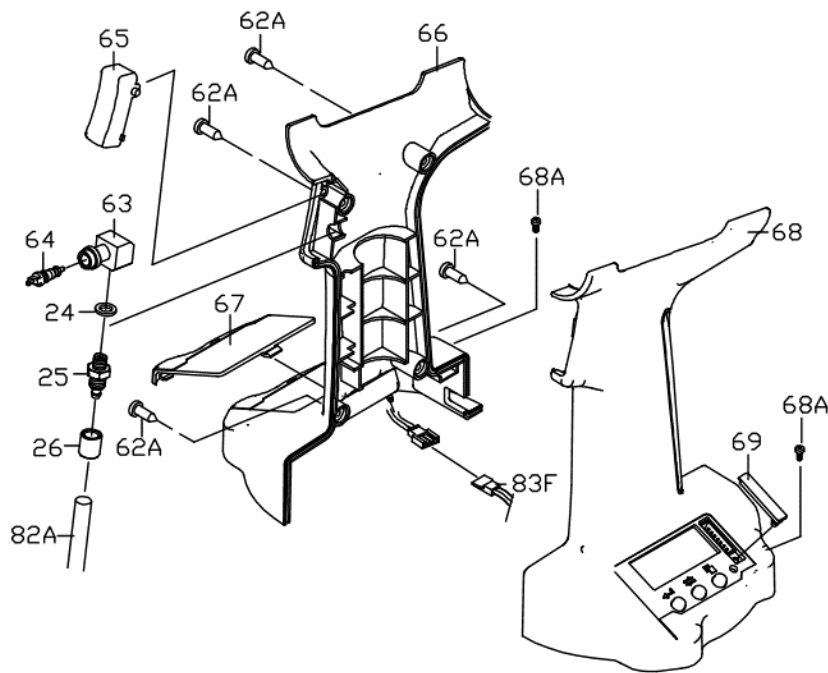
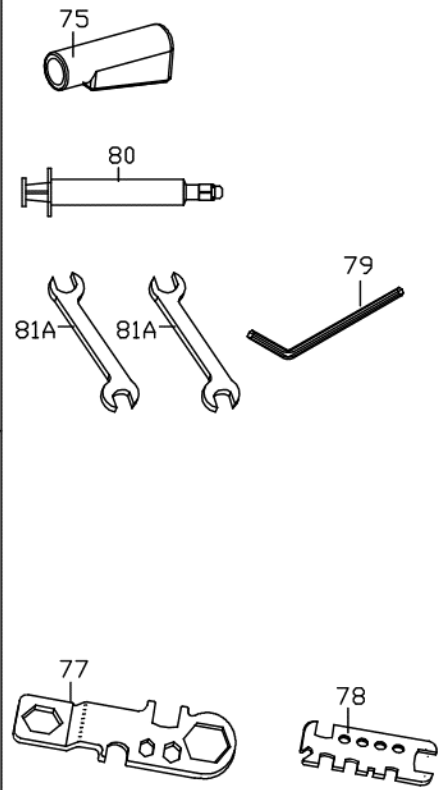
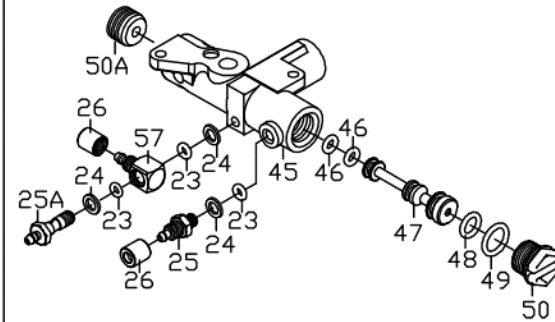
Ⓐ ASS'Y



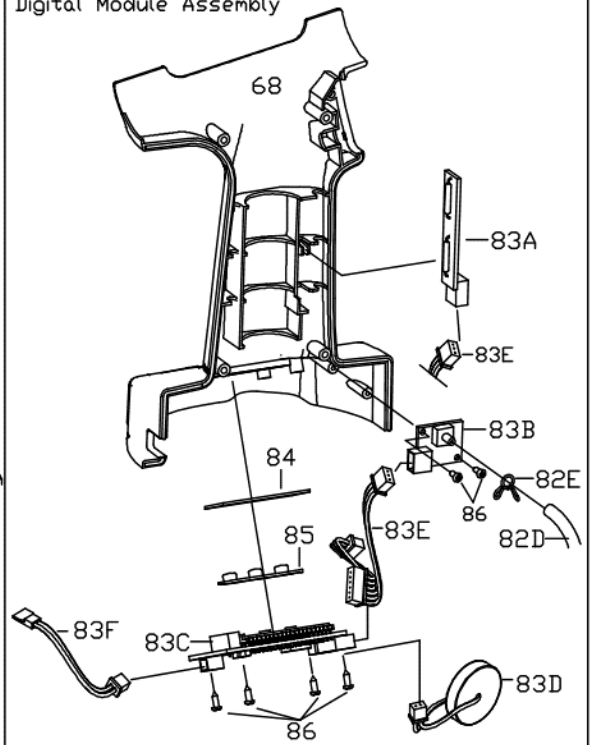
Ⓑ ASS'Y



Ⓒ ASS'Y



Digital Module Assembly



ZT2318D -8 5/16" (8mm) Air Hydraulic Riveter W/DIGITAL MODULE

TECHNICAL DATA	Traction Power	lbf(kgf)	:	5000(2300)
	Stroke Length	mm	:	18
	Net Weight	lbs(kgs)	:	5.6(2.5)
	Nosepieces Equipped	inch(mm)	:	5/16(7.8)
	Max. Capacity		:	Max. 5/16"(7.8mm) structural rivets in all materials

PARTS LIST

Index	Part #	Description	Index	Part #	Description
1.	202101R	Hydraulic Section	51.	HC00407010	Set Screw (3)
*2.	MS1217	Oil Seal (2)	52.	202402	Base
4.	202306	Nut	52A.	202404	Rubber Boot
4A.	VW1317	Wave Washer	53.	922701	Vacuum Valve
5.	202305	Jaw Housing Coupler (for Blind Rivet)	54.	922702	Sleeve
6.	OR1417	O-RING	55.	OR0811	O-RING (2)
7.	202308-B	Spring	56.	PW0510	Washer
8.	202302	Jaw Pusher	57.	612712	Swivel (2)
9.	202303	Jaw (3)	58.	612713	Socket
10.	202304	Jaw Hosing	59.	922703	Vacuum Switch
11.	819106	Lock Nut	60.	HC00305020	Set Screw (2)
12.	819105	Head(for Blind Rivet)	61.	PW0306	Washer (3)
13.	202311	Hydraulic Plunger	62.	ST0310	Screw
*14.	OR2835	O-RING	62A.	HC00305006	Set Screw (4)
*14A.	MS2835	Oil Seal	63.	107602	Valve Body
*15.	BR2835	Back-Up Ring (2)	64.	107601	Bleeding Valve
16.	202309	Return Spring	65.	107201R	Trigger
17.	OR0812	O-RING (2)	66.	202107RVE	Plastic Grip-Right
18.	OR3034	O-RING	67.	202107C	Battery Cap
19.	202102	Rear Gland	68.	202107LVE	Plastic Grip-Left
20.	OR3542	O-RING	68A.	HR002504506	Set Screw (2)
21.	HR00812508	Set Screw	69.	202E09	Dust Cover
22.	258801	Hanger	70.	919904	Silencer
23.	OR0306	O-RING (9)	71.	919903	Muffler Seat
24.	612714	Washer (7)	72.	919905	Silencer
25.	612717	Socket (4)	73.	919901	Mandrel Collector
25A.	612713A	Socket	74.	919906	Muffler Cap
26.	612711	Cap (6)	75.	612901	Deflector
27.	520106	Nut	77.	612904	Multi-Wrench (A)
28A.	5201082	Hydraulic Tube Connector-B	78.	918905	Multi-Wrench (B)
28B.	OR1417	O-RING	79.	314755	5mm Hex. Wrench
28C.	8211012	Hydraulic Tube Washer	80.	922901	Oiler
28D.	2311081	Hydraulic Tube Connector-A	81A.	144905	17x19 Wrench (2)
28E.	5201083	Washer	82A.	202704A	2.5x4 PU Hose(Black)
29.	OR2025	O-RING	82B.	202704B	2.5x4 PU Hose(Orange)
30.	202401RA	Upper Cover	82C.	202704C	2.5x4 PU Hose(Orange)
31.	NN005080B	Nut (4)	82D.	202704D	2.5x4 PU Hose(Black)
32.	202403RZ	Air Cylinder Body	82E.	258804	4mm Hose Loop (2)
33.	HC00508020	Set Screw (4)	83A.	202E01	Counter Sensor
34.	TC00508010S	Set Screw	83B.	202E02	Pressure Sensor
35.	258504	Magnet	83C.	202E03	Digital Display
*36.	MS1520	Oil Seal (2)	83D.	202E04	Lithium Battery
40.	231501	Back-Up Ring (2)	83E.	202E05	Signal Terminal
41.	202505	Plunger Rod	83F.	202E06B	Power Cable - Display Terminal
42A.	202504	Bumper Ring	84.	202E07	Display
42B.	202503	Front Head Disc A	85.	202E08R	Button
43.	920505	Front Head Disc B	86.	ST0206	Screw (6)
44.	202502	Packing Ring	87.	819709SUS	Nose Piece 5/16" (8mm)
45.	919211	Lower Plate	89.	92L2	Air Inlet Assembly
*46.	OR0408AS	Valve Case	90.	2318SK	Service Kit (opt.)
47.	919202A	O-RING (2)			(No.02.09.14.14A.15.36.46.48.48A.49)
*48.	OR0711	Valve Stem			
*48A.	OR0711A	O-RING			
*49.	OR1014	O-RING			
50.	107409	O-RING (2)			
50A.	922409	Inlet Plug			
		Socket Screw			

Maintenance Schedule

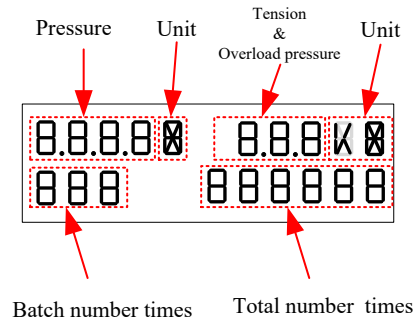
Frequency	Action
Daily after work or every 5,000 cycles	Lubricate tool through air inlet . Clean inside of Head
Jaws will not grip rivet stem or Every 20,000 cycles	Replace new Jaws
When oil leakage occurs or every 50,000 cycles	Replace O-Rings and Back-Up-Rings in Hydraulic Section and Hydraulic Tube .
every 100,000 cycles	Replace Packing Ring in Air Cylinder

Troubleshooting

Symptom	Diagnosis	Remedy
Rivet cannot be set by a single pull	- Low working air pressure - Tool requires re-priming - Worn Jaws or dirt in Jaws - Broken Jaws	- Check air pressure at the tool. - Priming the tool correctly according to the instruction - Replace the Jaws
The tool can't do suction	The Suction Switch didn't open	Turn on the Suction Switch .
Jaws will not grip rivet mandrel	- Worn Jaws or build up of dirt on Jaws Jaw Housing loose - Weakened Jaw Pusher Spring	- Clean before replace new Jaws - Tighten Jaw Housing, Jaw Housing Coupler and Nut - Replace new Jaw Pusher Spring
Broken rivet mandrel can't be released by Jaws	- Dirty Jaws and Jaw Housing - Weakened Jaw Pusher Spring - Hydraulic oil over primed.	- Clean and re-lubricate - Replace Jaw Pusher Spring - Remove Plug Screw and O-Ring, let it spill till stop by itself
Broken rivet mandrel jammed inside the Head	- Damaged Jaws - Damaged or dirty Jaw Pusher	- Replace Jaws - Replace or clean Jaw Pusher
The suction force is not strong enough to suck broken mandrel	- Low air pressure - Air leakage inside Suction Switch	- Check and regulate proper air pressure - Check if exhaust air is stuck at rear end of Collector - Check and replace O-Rings
Digital monitor no display or show "Low"	Low battery power.	Replace new battery
Digital monitor show "Er1".	Inlet pressure is higher than 7.5kg/cm ² .	Adjust the inlet pressure to the pressure below 7.5kg/cm ² .
Digital monitor show "Er2".	- Oil leaking causes insufficient hydraulic oil - Improper assembly of the tool	- Check the cause of leakage and replace seals if necessary - Re-prime hydraulic oil.

Digital Module Operation

1. Digital monitor



2. Button explanation

There are three button on the plastic grip-left.

: **Module button**. The button is used to choose unit or 0~9 number.

: **Shift button**. The button is used to select the mode.

: **Enter button**. The button is used to confirm setting.

3. Turn on & turn off the monitor

Turn on : Push button or the tool is working.

Turn off : No actuating the tool within 30 seconds, the monitor will be shut down automatically

4. Unit Selection

a. Push button 3 seconds. Enter mould function, the monitor begins to flash.



b. Push button. Pressure and **pulling force** display begins to flash.

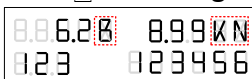
c. Push button. Enter **Unit** choose mode, Air Pressure and **pulling force** unit display begins to flash.



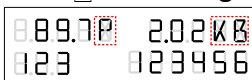
d. Push button. Change unit.



Push button again. Change unit.



Push button again. Change unit.



e. Push button. Finish **Unit** setting. The monitor stop flashing.

Table 1 below is **Unit** selection of **Air Pressure** and **Pulling Force**.

Table 1. Unit displays

	Air Pressure unit	display	Pulling Force unit	display
ISO	Kg/Cm^2	K	KgF	K
ISO	MPa	M	NF	N
Newton	Bar	B	NF	N
ISS	Psi	P	LbF	B

5. Setting batch number

- a. Push  **button** 3 seconds. Enter module function, the monitor begins to flash.



8.8 6.3k 9.1.1.1k
1.2.3 1.2.3.4.5.6

- b. Push  **button**. The batch number display begins to flash.



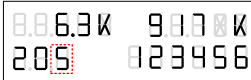
8.8 6.3k 9.1.1.1k
1.2.3 1.2.3.4.5.6

- c. Push  **button**. Enter batch number times function. The first number display begins to flash.



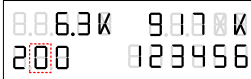
8.8 6.3k 9.1.1.1k
2.0.0 1.2.3.4.5.6

- d. Push  **button**. Change number 0~9.



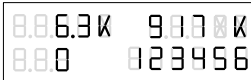
8.8 6.3k 9.1.1.1k
2.0.5 1.2.3.4.5.6

- e. Push  **button**. Change numbers'.



8.8 6.3k 9.1.1.1k
2.0.0 1.2.3.4.5.6

- f. Push  **button**. Finish batch number setting. The monitor is stop flashing. Batch number display will show "0".

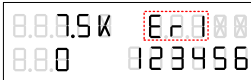


8.8 6.3k 9.1.1.1k
8.8.0 1.2.3.4.5.6

- g. Push  **button** twice, the batch number display will show "0"

6. Error message :

- a. If working air pressure is over 7.5 kg/ cm²(107psi), the monitor will display "Er1".



8.8 7.5k 8.8.0
8.8.0 1.2.3.4.5.6

- b. Insufficient hydraulic oil inside Hydraulic Section, the monitor will display "Er2".



8.8 7.5k 8.8.0
8.8.0 1.2.3.4.5.6

- c. If battery is low power, the monitor will display "Low".



8.8 Low 8.8.0
8.8.0 1.2.3.4.5.6