ProSert™ XTN20 Blind Rivet Nut Tool – 74202

Hydro-Pneumatic Power Tool

Accessories Manual
Original Instruction
STANLEY Engineered Fastening policy is one of continuous product development and improvement and we reserve the right to change the specification of any product without prior notice.

Nose Assemblies

Nose equipment varies according to the blind rivet nut type being installed. Each nose assembly represents a unique set of components which can be ordered individually (see below). All nose assemblies also include a nose tip locknut 3 (part number 07555-00901). Component numbers refer to the illustration below. We recommend maintaining some stock of spares as items will need regular replacement if worn. Read the Servicing Manual for nose assembly instructions.

Nose Assembly Breakdown

Fitting Instructions

Item numbers in **bold** refer to nose assembly components in the exploded illustration.

**IMPORTANT** Air supply must be disconnected from the tool before working on the nose assembly.
• If still fitted, remove the Nose Casing 4 and the Chuck Nut 5.
• Insert Drive Shaft 7 into Mandrel Adaptor 8.
• Fit Mandrel 1 onto Drive Shaft 7.
• Insert Reducing Sleeve 6 (if specified) into the Chuck Nut 5.
• Screw the Chuck Nut 5 onto the Mandrel Adaptor 8 whilst pulling back the spring loaded Nose Rod 9. Tighten the Chuck Nut 5 clockwise.
• Screw on the Nose Casing 4 and Nose Tip 2 with the nose tip Lock Nut 3.
• The reverse operation is carried out for equipment removal.

With the tool still disconnected from the air supply
• Screw an blind rivet nut onto the Mandrel manually.
• Position Nose Tip 2 on the Nose Casing 4 and lock it with Lock Nut 3 so that the blind rivet nut lines up with the end of Mandrel 1.
• Lock the nose tip Lock Nut 3 by turning clockwise with a spanner*. Remove the blind rivet nut from Mandrel 1.
**Places all blind rivet nuts listed in this section except M5 large flange Thin Sheet Nutsert®**

**Places M5 large flange Thin Sheet Nutsert® 09698-00516 ONLY**

Please see the instruction Manual (7900-09300) for full details of the tool placing capability for the different Blind Rivet Nut types and sizes.
Blind Stud Nose Equipment

**Reducing Sleeve** (Fig. 2 Nr. 7) replaces Chuck Nut (Fig. 1 nr. 5) fitted to Base Tool.

**Nose Assembly** includes special Nose Casing 07555-00315. The standard Nose Casing fitted to the Base Tool is not used for this type of M10 Nose Assembly.

All Nose Assemblies also include a Nose Tip Nut 2 (part number 07555-00901)

**Fitting Instructions**

⚠️ **IMPORTANT** Air supply must be disconnected from the tool before working on the nose assembly.

* For disassembly please see [Fig. 1 Page 2](#). Item numbers in **bold** refer to components in that drawing

- Remove the Nose Casing 4 and the Chuck Nut 5 fitted to the base tool. Retain Nose Casing 4.

* For assembly please see [Fig.2 above](#). Item numbers in **bold** refer to components in this drawing.

- Fit Drive Nut 3 onto Drive Shaft 6 and insert into Reducing Sleeve 7.
- Screw Reducing Sleeve 7 onto Mandrel Adaptor 8.
- Screw on the Nose Casing 4 and Nose Tip 1 with the Nose Tip Lock Nut 2.
- The reverse operation is carried out for equipment removal.
Adaptor Kits for Japanese Market

This Mandrel Adaptor Kit is designed specifically to allow Nippon POP Rivet Mandrels to be used with this tool.

**Mandrel Adapter Kit**

<table>
<thead>
<tr>
<th>-</th>
<th>Assembly</th>
<th>4</th>
<th>15</th>
<th>16</th>
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<tbody>
<tr>
<td>Adapter kit</td>
<td>74202-02200</td>
<td>Nose Casing</td>
<td>Locking Ring</td>
<td>Mandrel Adapter</td>
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**POP NUT™ Blind Rivet Nut**

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<th>Thread Type</th>
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*The above table refers to Fig. 3.*

**Fitting Instructions**

*For disassembly please see Fig. 1 Page 2. Item numbers in bold refer to components in this drawing.*

⚠️ **IMPORTANT** Air supply must be disconnected from the tool before working on the nose assembly.

- Using a 19 mm Spanner unscrew Nose Casing 4.
- Retract the Nose Rod 9 and remove the Chuck Nut 5 by hand.
- Using a 14mm Spanner and the 4mm Push Pin, undo the Mandrel Adapter 8 from the Locking Nut and remove.
Now for assembly please see Fig. 3 Page 5. Item numbers in **bold** refer to components in this drawing

- Retain items nr. **17, 18** and **19** from the base tool.
- Using a 2mm Hexagonal Wrench undo the grub screw in the T Joint **17**, remove the Nose Rod and insert into the locking ring **15**. *(As show in the drawing that comes with the adaption kit).*
- Insert T Joint **17** followed by Nose Spring **18** into the new Mandrel Adaptor **16** supplied in the kit
- Tighten the new Mandrel Adaptor **16** up to the Lock Nut **19**

To insert a Drive Screw:

- Pull back the Locking Ring **15**, screw the Mandrel1 into the Mandrel Adaptor **16** and release the Locking Ring **15** so it is in the fully returned position.
- Screw on the new Nose Casing **4** supplied in the kit and position the Nose Tip **2** and Locking Nut **3** accordingly.
90 mm Nose Extension Kit

The Nose Extension Kit is designed increase the length of the Nose Assembly of the XTN20 Tool by 90 mm. and increases the access to an application which may be hindered by the tools main body or which may require additional length.

! IMPORTANT Air supply must be disconnected from the tool before working on the nose assembly.

For disassembly please see Fig. 1 Page 2. Item numbers in bold refer to components in that drawing

- Remove the Nose Casing 4 and Mandrel Adaptor 8 with the Chuck Nut 5 still attached.

Now for assembly please see Fig. 4 above. Item numbers in bold refer to components in this drawing

- Fit the Inner Extension 20 onto the tool and tighten against the locking nut 19.
- Re-attach the Mandrel Adaptor 8 to the Inner Extension 20.
- Slide the Outer Extension 21 over and screw this on to the tool.
- Attach desired size of Nose Equipment before screwing on the Nose Casing 4 and tighten.
- The reverse operation is carried out for equipment removal.

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### Nose Extension Kit

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<td>Outer extension</td>
<td>Inner extension</td>
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The below fitting instructions can be performed before or after attaching standard nose equipment supplied with the tool.

**Fitting Instructions**

**Fig. 4**
Find your closest STANLEY Engineered Fastening location on www.StanleyEngineeredFastening.com/contact
For an authorized distributor nearby please check www.StanleyEngineeredFastening.com/contact/distributors

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