

# Accessories Manual

Original Instruction



Hydro-Pneumatic  
Blind Rivet Nut Tool

ProSert<sup>®</sup> XTN20 Blind Rivet Nut Tool – 74202

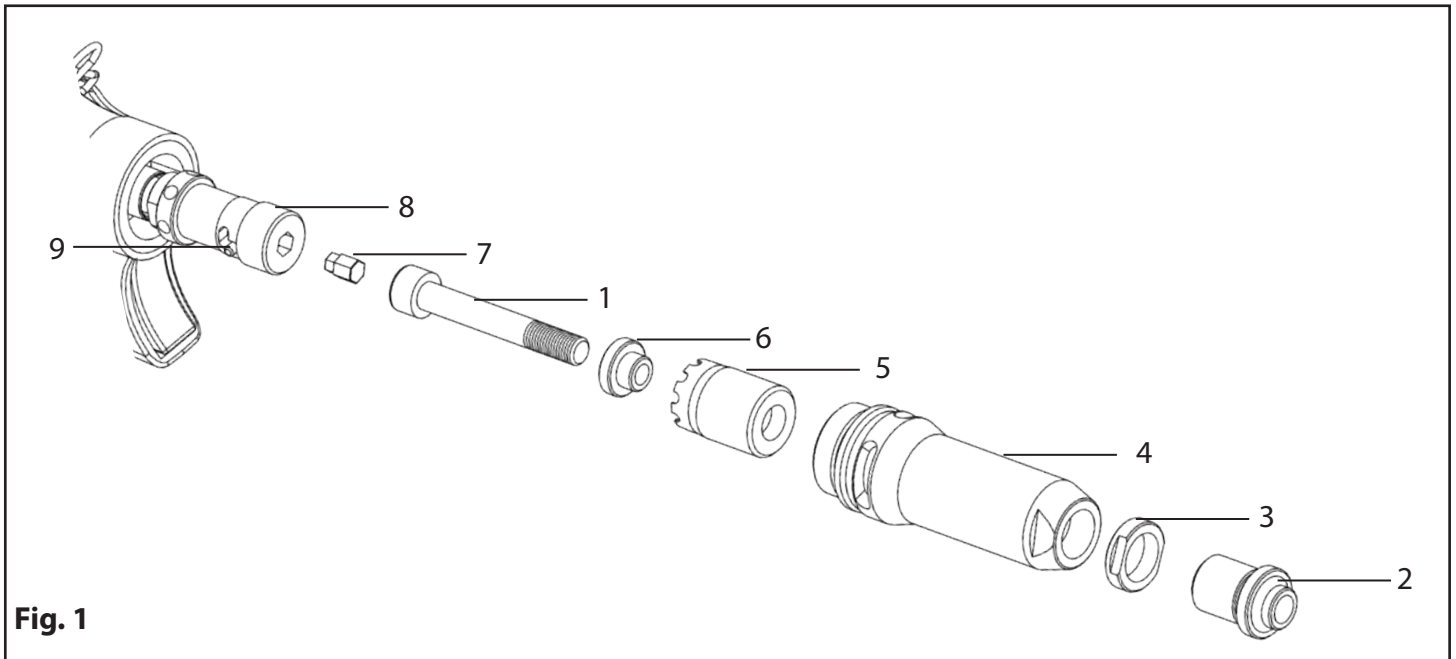
# Hydro-Pneumatic Power Tool

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## 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



**Fig. 1**

### 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**.

Thread Type	Thread Size	Assembly	1	2	6	7
<b>SQUARESERT® (GK08) + EUROSERT® (39002, 39006) + HEXSERT® (39101, 39102, 49141) + COUNTERSUNK NUTSERT® (FW96, GM17, GM57) + DK/DL SERIES + ALL LARGE FLANGE INSERTS (9698, FS58, FW78, GM68, 9408, 9418, 9498, 39301) POP® NUT (STANDARD, KNURLED, CLOSED END, HEXAGONAL, TETRA NUT)</b>						
<b>Standard Metric</b>	M3	07555-09883	07555-09003	07555-00903	07555-09103	07555-01003
	M4	07555-09884	07555-09004	07555-00904	07555-09104	07555-01004
	M5*	07555-09885	07555-09005	07555-00905	07555-09105	07555-01005
	M5**	07555-09185	07555-09005	07555-00915	07555-09105	07555-01005
	M6	07555-09886	07555-09006	07555-00906	07555-09106	07555-01006
	M8	07555-09888	07555-09008	07555-00908	07555-09108	07555-01008
	M10	07555-09880	07555-09010	07555-00910	-	07555-01010
<b>UNC</b>	4 UNC	07555-09854	07555-09054	07555-00854	07555-09154	07555-00754
	6 UNC	07555-09856	07555-09056	07555-00856	07555-09156	07555-00756
	8 UNC	07555-09858	07555-09058	07555-00858	07555-09158	07555-00758
	10 UNC	07555-09850	07555-09050	07555-00850	07555-09150	07555-00750
	1/4 UNC	07555-09848	07555-09048	07555-00848	07555-09148	07555-00748
	5/16 UNC	07555-09840	07555-09040	07555-00840	07555-09140	07555-00740
	3/8 UNC	07555-09842	07555-09042	07555-00842	-	07555-00742
<b>UNF</b>	10 UNF	07555-09870	07555-09070	07555-00850	07555-09150	07555-00750
	1/4 UNF	07555-09868	07555-09068	07555-00848	07555-09148	07555-00748
	5/16 UNF	07555-09860	07555-09060	07555-00840	07555-09140	07555-00740
	3/8 UNF	07555-09862	07555-09062	07555-00842	-	07555-00742
<b>BSW</b>	3/16 BSW	07555-09816	07555-09016	07555-00850	07555-09150	07555-00750
	1/4 BSW	07555-09818	07555-09018	07555-00848	07555-09148	07555-00748
	5/16 BSW	07555-09810	07555-09019	07555-00840	07555-09140	07555-00740

**THIN SHEET NUTSERT® (9468, FS38, 9658)**

<b>Standard Metric</b>	M3	07555-09983	07555-09003	07555-00993	07555-09103	07555-01003
	M4	07555-09984	07555-09004	07555-00994	07555-09104	07555-01004
	M5	07555-09985	07555-09005	07555-00995	07555-09105	07555-01005
	M6	07555-09986	07555-09006	07555-00996	07555-09106	07555-01006
	M8	07555-09988	07555-09008	07555-00998	07555-09108	07555-01008
	M10	07555-09980	07555-09010	07555-00999	-	07555-01010
<b>UNC</b>	4 UNC	07555-09954	07555-09054	07555-00954	07555-09154	07555-00754
	6 UNC	07555-09956	07555-09056	07555-00956	07555-09156	07555-00756
	8 UNC	07555-09958	07555-09058	07555-00958	07555-09158	07555-00758
	10 UNC	07555-09950	07555-09050	07555-00950	07555-09150	07555-00750
	1/4 UNC	07555-09948	07555-09048	07555-00948	07555-09148	07555-00748
	5/16 UNC	07555-09940	07555-09040	07555-00940	07555-09140	07555-00740
<b>UNF</b>	10 UNF	07555-09970	07555-09070	07555-00950	07555-09150	07555-00750
	1/4 UNF	07555-09968	07555-09068	07555-00948	07555-09148	07555-00748
	5/16 UNF	07555-09960	07555-09060	07555-00940	07555-09140	07555-00740
<b>BSW</b>	3/16 BSW	07555-09916	07555-09016	07555-00950	07555-09150	07555-00750
	1/4 BSW	07555-09918	07555-09018	07555-00948	07555-09148	07555-00748
<b>BA</b>	0BA	07555-09930	07555-09030	07555-00996	07555-09106	07555-01006
	2BA	07555-09932	07555-09032	07555-00950	07555-09150	07555-00750
	4BA	07555-09934	07555-09034	07555-00934	07555-09134	07555-00756

**HEXSERT® (9688)**

<b>Standard Metric</b>	M3	07555-09283	07555-09003	07555-08103	07555-09103	07555-01003
	M4	07555-09284	07555-09004	07555-08104	07555-09104	07555-01004
	M5	07555-09285	07555-09005	07555-08105	07555-09105	07555-01005
	M6	07555-09286	07555-09006	07555-08106	07555-09106	07555-01006
	M8	07555-09288	07555-09008	07555-00998	07555-09108	07555-01008

**2nd Grip M6 (09408)**

<b>Standard Metric</b>	M6	-	07559-12605	-	-	-
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\*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. \*\*\*For DK/DL series M8 large flange nose tip (2) is required 74209-12631

## Blind Stud Nose Equipment

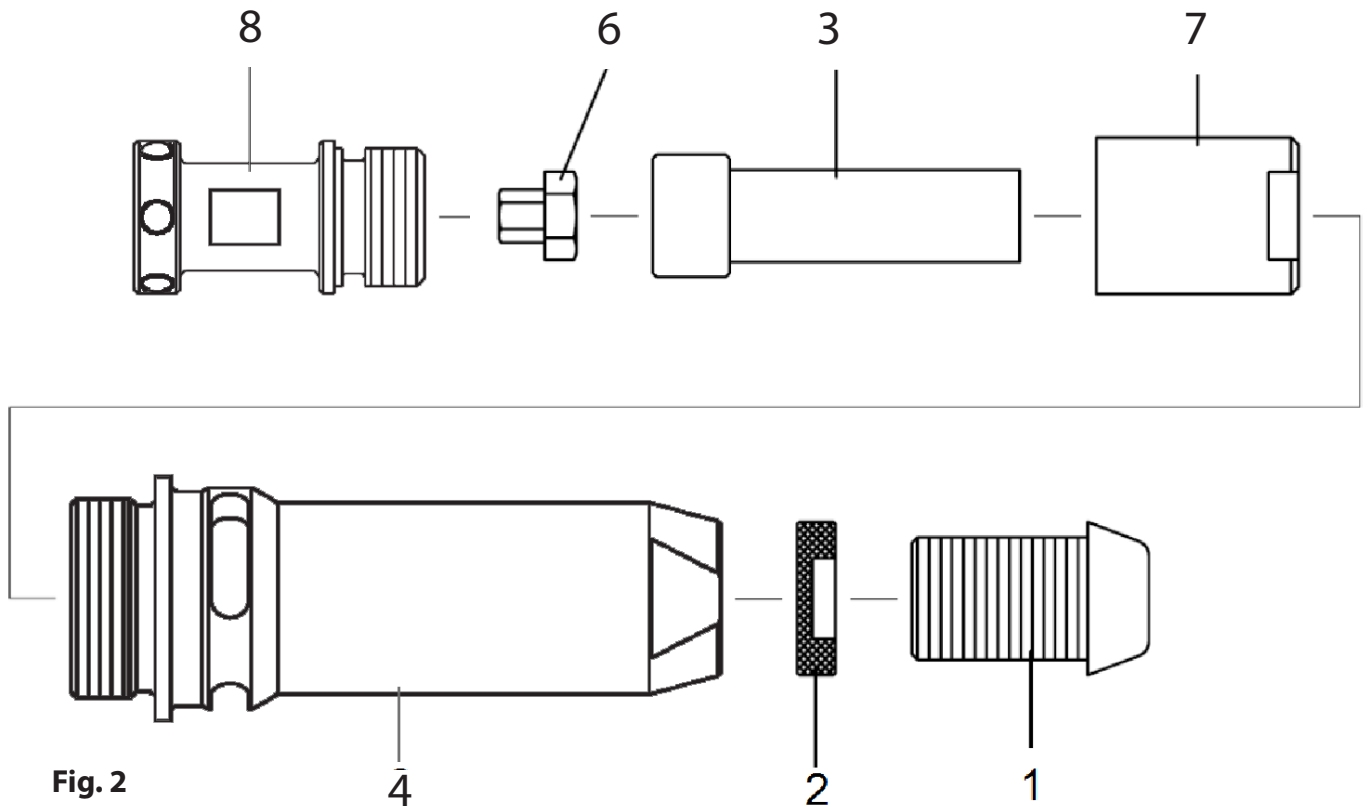


Fig. 2

	Assembly	<b>1</b>	<b>3</b>	<b>6</b>	<b>7</b>
M4	07559-03044	07559-03047	07559-03050	07555-01012	74200-12119*
M5	07559-03045	07559-03048	07559-03051	07555-01012	74200-12119*
M6	07559-03046	07559-03049	07559-03052	07555-01012	74200-12119*
M8	07559-03039	07559-03040	07559-03041	07555-01012	74200-12119*
M10	74200-12222**	74200-12220	74200-12221	-	-

\* 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.

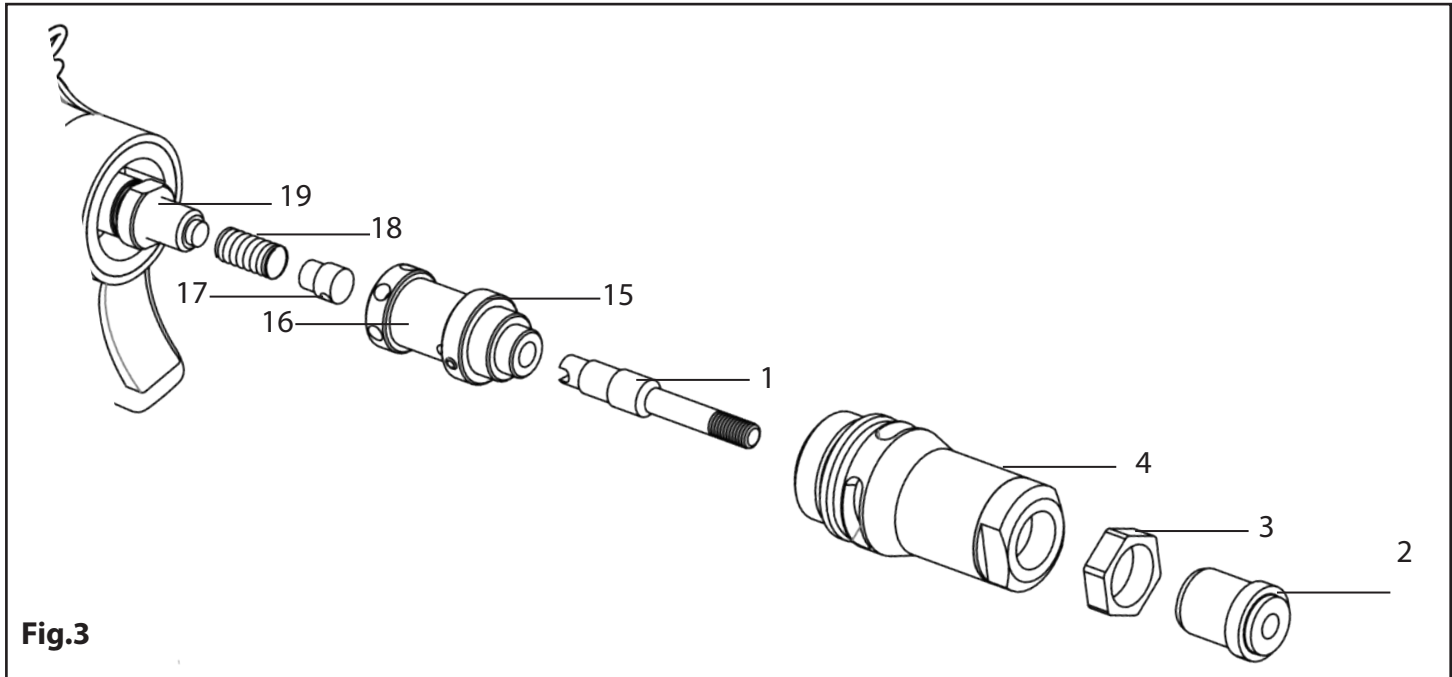


Fig.3

Mandrel Adapter Kit				
-	Assembly	4	15	16
Adapter kit	74202-02200	Nose Casing	Locking Ring	Mandrel Adapter
POP NUT® Blind Rivet Nut				
Thread Type	Thread Size	1	2	3
Metric	M3	PNT600-01-3	PNT600-02-3	PNT600-03
	M4	PNT600-01-4	PNT600-02-4	PNT600-03
	M5	PNT600-01-5P	PNT600-02-5	PNT600-03
	M6	PNT600-01-6P	PNT600-02-6	PNT600-03
	M8	PNT600-01-08	PNT600-02-8	PNT600-03
	M10	PNT600-01-10A	PNT600-02-10	PNT600-03

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 Mandrel**1** 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 to 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.

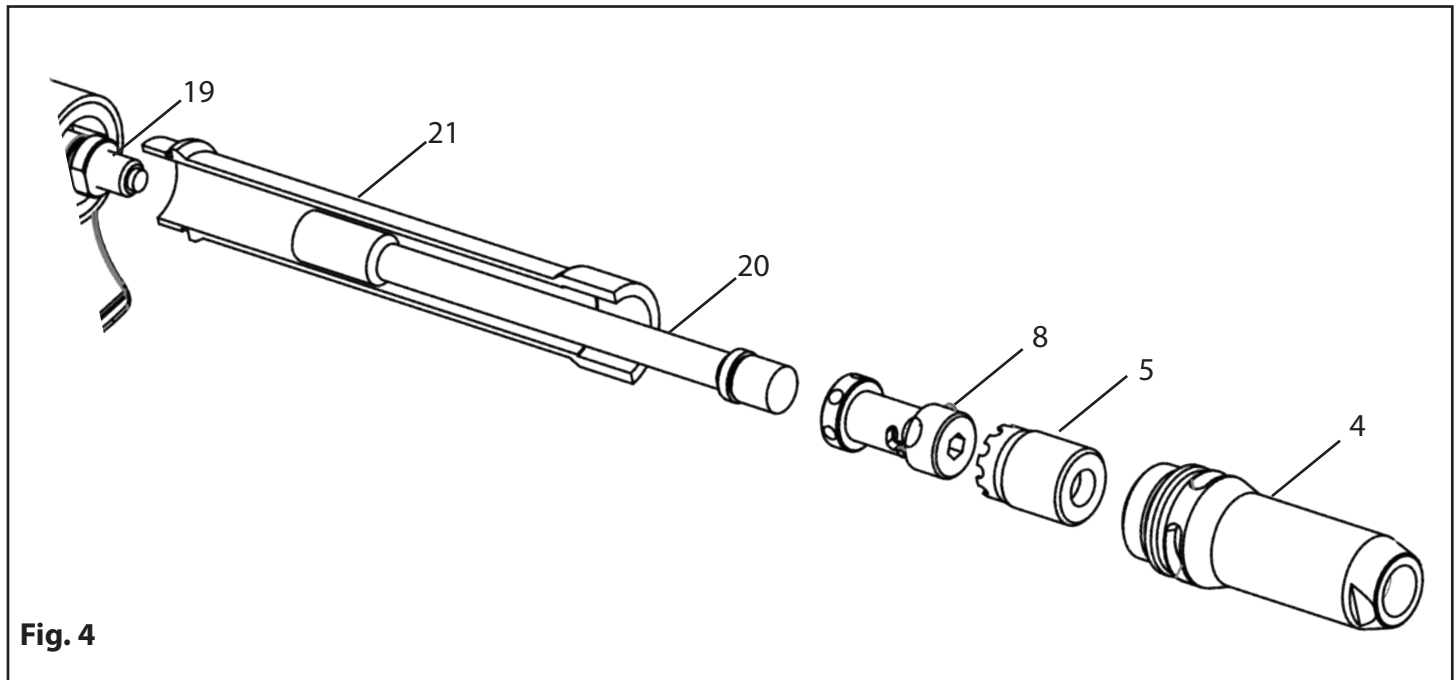


Fig. 4

Nose Extension Kit			
-	<b>Assembly</b>	<b>21</b>	<b>20</b>
<b>Adapter Kit</b>	<b>74202-02300</b>	<b>Outer extension</b>	<b>Inner extension</b>

The below fitting instructions can be performed before or after attaching standard nose equipment supplied with the tool.

### Fitting Instructions

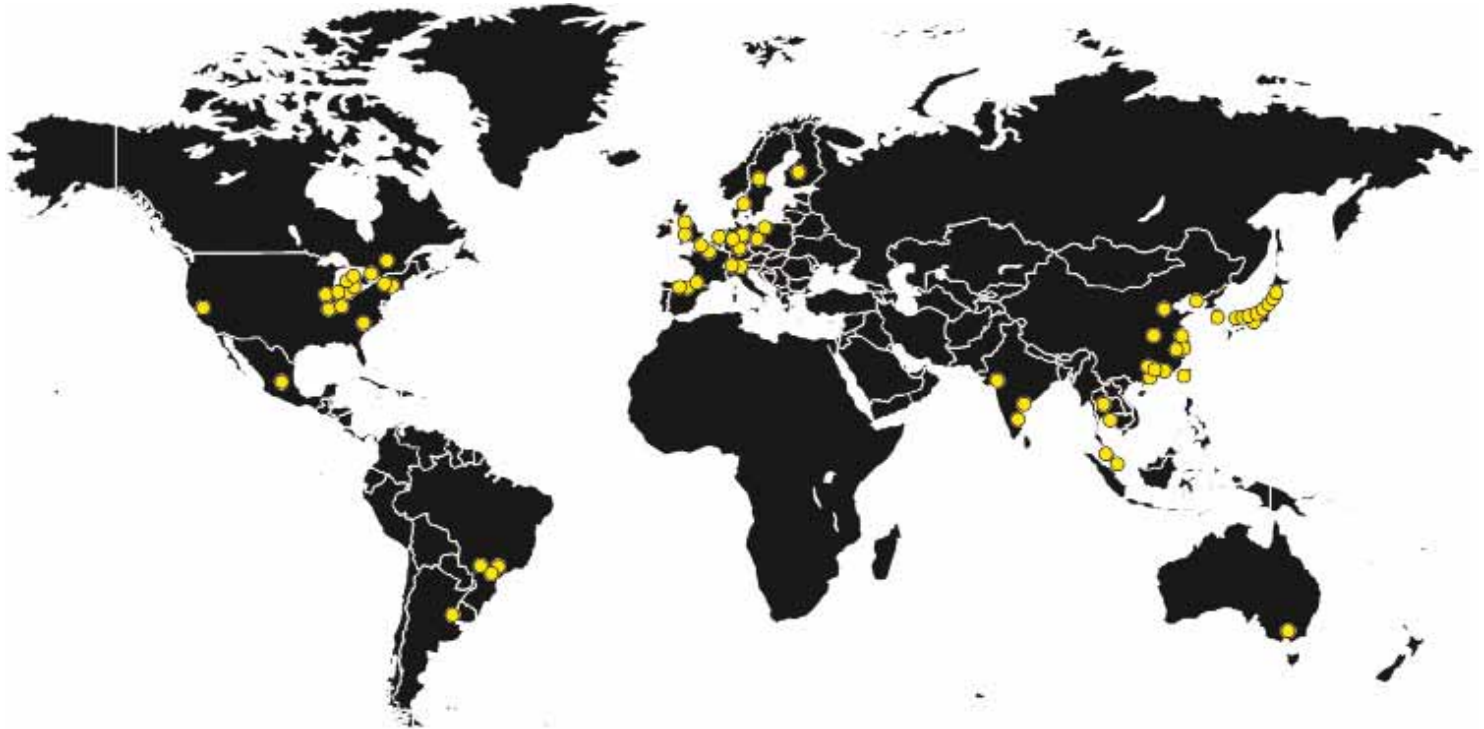
**▲ IMPORTANT** Air supply must be disconnected from the tool before working on the nose assembly.

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

- Remove the Nose Casing **4** and 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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