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Instruction and Parts Book for
**PNEUMATIC
COMPRESSION RIVETERS**

**Reman CP-351, Model "C"
AND "C" TYPE**



GENERAL INSTRUCTIONS

Air Supply

For satisfactory performance, 90 psi of clean, dry air is required AT THE TOOL with tool operating. Whip hose 5/16" I.D. may be used at the air inlet, but longer runs should be 3/8" hose size or larger, used with couplings of a minimum 9/32" I.D. The use of a C-104086 CHICAGO PNEUMATIC Air Line Separator and Filter and a C-104091 CHICAGO PNEUMATIC Air Line Pressure Regulator mounted as closely as possible to the tool is recommended.

Preparing for Operation

Daily before using and before putting tool into operation, disconnect air hose and pour about one ounce of recommended oil into tool air inlet. Blow out air line to clear it of accumulated dirt and moisture connect tool and operate to allow oil to be carried to the interior.

Lubrication

Daily before using and before putting tool into service, pour about one ounce of recommended oil into air inlet. In addition, use of a C-104101 CHICAGO PNEUMATIC Air Line Lubricator installed at the end of each air pipe leading to this pneumatic tool is recommended to assure a constant and adequate supply of lubricant to the motor.

At each inspection period, clean old grease from front end of tool and coat parts with recommended grease.

Recommended Lubricants

CHICAGO PNEUMATIC Airoilene Oil, which contains moisture absorbent, rust inhibiting additives and will not separate while the tool is idle, is recommended for use in the lubricator and may be purchased under the following symbols:

1 gal. can ----- P-089507
5 gal. can ----- P-089508

If recommended oil is not available, use a turbine or spindle grade oil with a viscosity of 100-150 SUS at 100°F which contains a rust inhibitor.

A good grade mineral oil grease such as Texaco Novatex #1 or equivalent is recommended for use in moving parts of front end units.

Cycle of Operation

The amount of pressure activating the piston (46) is controlled by the pressure regulator valve (51).

To increase pressure - turn pressure regulator knob (50) in a clockwise direction. Maximum pressure is produced when pressure regulator knob is turned all the way down.

To decrease pressure - turn pressure regulator knob in a counter-clockwise direction until desired pressure is reached.

When throttle lever (31) is depressed, compressed air forces the piston (46) forward and exerts pressure through the piston rod (47) to the wedge (58). In "C" Type Riveters the wedge forces the set holder lever (125) against the set holder (128). In Alligator Jaw Type Riveters the wedge forces the moving jaw (71) against the stationary jaw (70).

When the throttle lever is released, the air behind the piston escapes and compressed air enters behind the return piston (37) which moves back and returns the piston rod, piston and wedge to neutral position. The extent to which the return spring (83) draws back the set holder in the "C" Type Riveter or the moving jaw in the Alligator Jaw Type Riveter is controlled by turning the stroke adjusting thumb wheel (102).

To reduce return stroke - turn thumb wheel in a clockwise direction.
To increase return stroke - turn thumb wheel in a counter-clockwise direction.

If a greater return stroke is desired while positioning riveter or work piece, pull out escape button (108) which allows set holder ("C" Type) or moving jaw (Alligator Type) to return to its maximum open position.

Throttle Valve Adjustment

In case of loss of power caused by wear on the throttle valve stem (13), the throttle valve adjusting screw (32) may be moved down to compensate for the wear by loosening the adjusting screw nut (33), threading the adjusting screw down to the desired position and retightening nut.

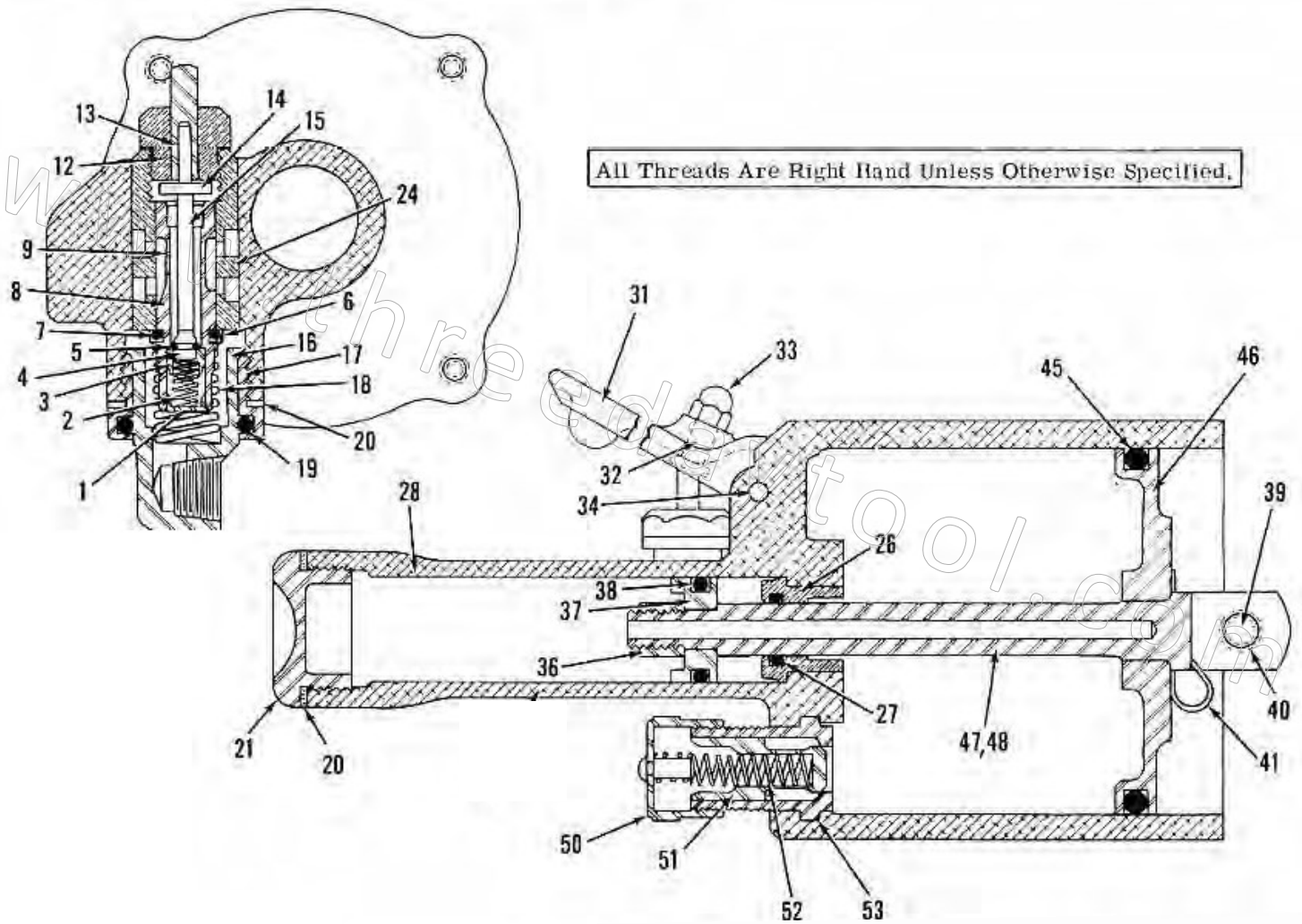
Maintenance

Do not penalize the operator by requiring him to use a tool which is not in first class condition. A regularly scheduled inspection and repair program will correct minor faults, avoid later, extensive repairs and maintain the tool at its highest efficiency.

1. Keep tool properly lubricated.
2. Provide 90 psi of clean, dry air AT THE TOOL.
3. Use hose and connections of proper size and in good condition.
4. Set up and maintain a repair and replacement program scheduled at regular intervals.

CP-351 COMPRESSION RIVETERS Model "C"

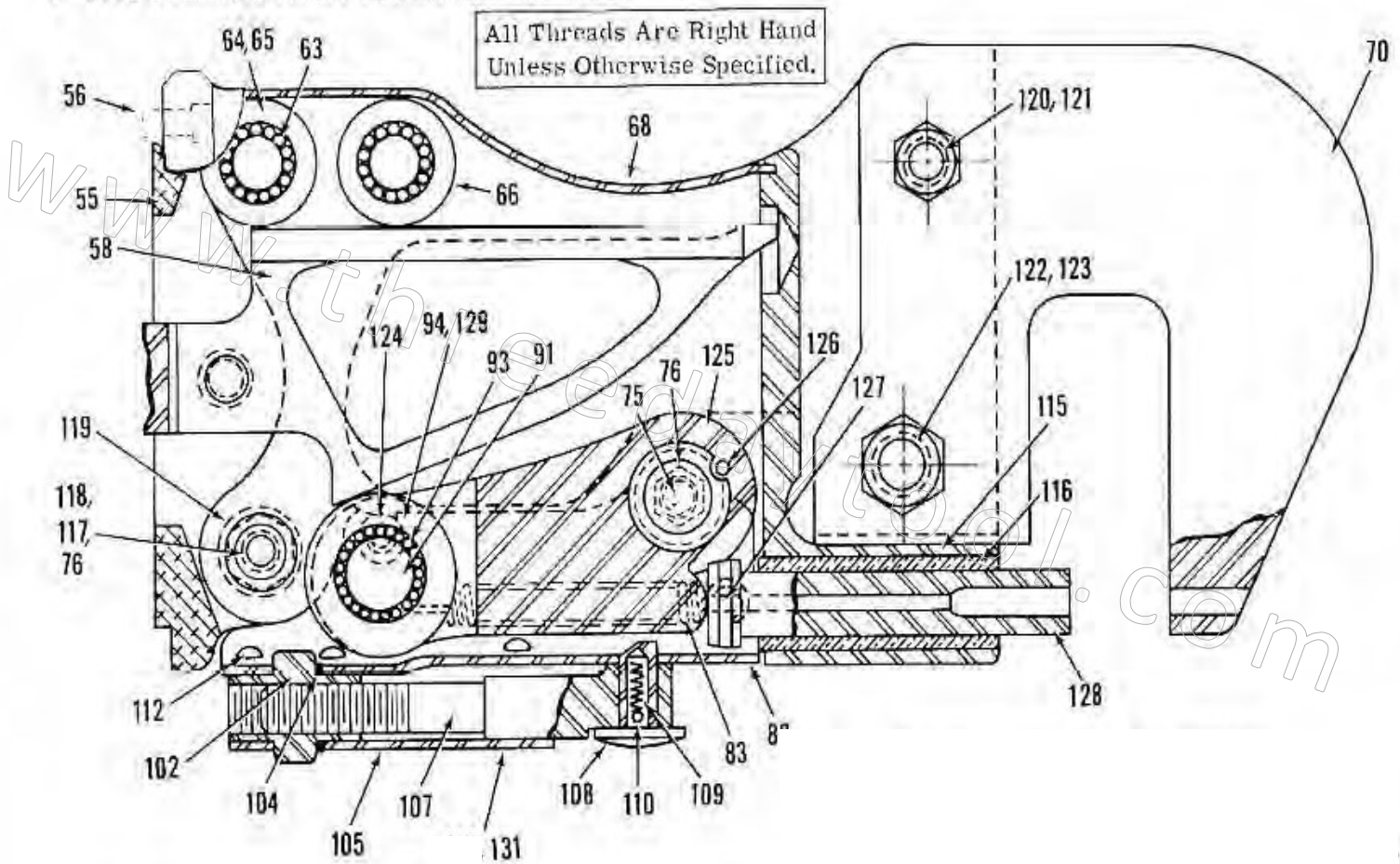
P-078074 POWER UNIT (Incl: ALL PARTS SHOWN BELOW)



| Item Number | Part Number | Description | No. Req'd | Item Number | Part Number | Description | No. Req'd |
|-------------|-------------|---|-----------|-------------|-------------|--|-----------|
| 1 | P-P073018 | Retainer Valve Spring | 1 | 27 | P-P083082 | O-Ring | 1 |
| 2 | P-P073017 | Spring Yoke | 1 | 28 | P-P078076 | Cylinder -Bare (Includes #24,26) | 1 |
| 3 | P-P089289 | Valve -Throttle (Inner) | 1 | 31 | P-P073052 | Lever- Throttle | 1 |
| 4 | P-P089290 | Holder O-Ring | 1 | 32 | P-P073115 | Screw -Adjusting | 1 |
| 5 | P-C087316 | O-ring | 1 | 33 | P-H072480 | Nut -Adjusting Screw | 1 |
| 6 | P-P089288 | O-Ring Retainer | 1 | 34 | P-P073085 | Pin -Lever | 1 |
| 7 | P-CA083354 | O-Ring | 1 | 36 | P-P070438 | Nut Piston Rod | 1 |
| 8 | P-P089287 | Valve -Throttle (Bare) | 1 | 37 | P-P089740 | Piston -Return | 1 |
| 9 | P-P087561 | Throttle Valve Complete (Includes #1-8) | 1 | 38 | P-C083177 | O-Ring | 1 |
| 12 | P-P073014 | Bushing Valve Stem | 1 | 39 | P-P073116 | Pin -Piston Rod | 1 |
| 13 | P-P073058 | Stem-Throttle Valve | 1 | 40 | P-P074672 | Ring - Retaining | 2 |
| 14 | P-P073060 | Block -Valve Stem | 1 | 41 | P-P074326 | Spring - Wedge | 1 |
| 15 | P-P073059 | Stem-Valve | 1 | 45 | P-P089292 | O- Ring | 1 |
| 16 | P-P089178 | Swivel-Air Inlet | 1 | 46 | P-P089737 | Piston | 1 |
| 17 | P-P073054 | Nut-Swivel Air Inlet | 1 | 47 | P-P073020 | Piston-Rod | 1 |
| 18 | P-P073057 | Spring -Throttle Valve | 1 | 48 | P-P077832 | Piston&Rod Complete (Includes #45-47) | 1 |
| 19 | P-A082759 | O-Ring | 1 | 50 | P-P078068 | Knob-Regulator | 1 |
| 20 | P-P073009 | Gasket | 2 | 51 | P-P073956 | Valve-Regulator | 1 |
| 21 | P-P073008 | Cap Return Cylinder | 1 | 52 | P-P073957 | Spring- Regulator | 1 |
| 24 | P-P073056 | Bushing -Throttle Valve | 1 | 53 | P-P078075 | Cylinder & Regulator Comp (Incl #28, 50, 51, 52) | 1 |
| 26 | P-P057199 | Bushing -Piston Rod (Includes #27) | 1 | | | | |

CP-351 COMPRESSION RIVETERS Model "C"

"C" TYPE COMPLETE FRONT END UNITS -LESS YOKE



| <u>Item Number</u> | <u>Part Number</u> | <u>Description</u> | <u>No. Req'd</u> | <u>Item Number</u> | <u>Part Number</u> | <u>Description</u> | <u>No. Req'd</u> |
|--------------------|--------------------|--------------------------------------|------------------|--------------------|--------------------|--|------------------|
| 55 | P-P073002 | Adapter -Cylinder | 1 | 117 | P-P073026 | Bolt | 3 |
| 56 | P-P073025 | Screw- Allen Head | 4 | 118 | P-P073027 | Washer | 4 |
| 58 | P-P073006 | Wedge | 1 | 119 | P-P073029 | Spacer | 1 |
| 63 | P-P073031 | Bearing - Roller | 38 | 120A | P-P003092 | Yoke Bolt for 1A Frame | 1 |
| 64 | P-P073030 | Roller | 2 | 120B | P-P003083 | Yoke Bolt for 2A Frame | |
| 65 | P-P078605 | Roller Assy (Includes #63,64,66) | 2 | 121 | P-P003093 | Nut | 1 |
| 66 | P-P073032 | Guard Roller | 4 | 122A | P-P073047 | Yoke Bolt 1A Frame | 1 |
| 68 | P-P073033 | AIR VALVE RING | 1 | 122B | P-P073046 | Yoke Bolt 2A Frame | |
| 70 | P-P009530 | 990 1A C Yoke | 1 | 123A | P-P006315 | Yoke Nut 1A Frame | 1 |
| 75 | P-P073239 | Shaft Lever | 1 | 123B | P-P005997 | Yoke Nut 2A Frame | |
| 76 | P-P006087 | Nut -Shaft Lever | 4 | 124 | P-P073041 | Screw- Guard | 2 |
| 82 | P-P073240 | Guard -Spring Return | 1 | 125 | P-P073005 | Lever -Holder | 1 |
| 83 | P-P073238 | Return Spring | 2 | 126 | P-P073242 | Pin-Lock | 1 |
| 91 | P-P073045 | Shaft - Roller | 1 | 127 | P-P073961 | Spring Yoke | 1 |
| 93 | | See item # 129 | 28 | 128 | P-P073237 | Set Holder | 1 |
| 94 | | See item # 129 | 1 | 129 | P-P078606 | Lever-Roller Assembly (Includes #93,94) | 1 |
| 115A | P-P073004 | 1A Frame Yoke | 1 | 131 | P-P078124 | Stroke Adjusting Assembly (Incl # 82, 102,104,105,107,108,109,110,112) | 1 |
| 115B | P-P073003 | 2A Frame Yoke | 1 | | | | |
| 116 | P-P073036 | Bushing - Holder Set (For 1A Frame) | 1 | | 258-1710 | 1/8 Flush Squeezer set | 1 |
| 116B | P-P073035 | Bushing - Holder Set (For 2A Frame) | | | 258-1624 | 1/2 X 3/16 Brazier Cup Set | 1 |