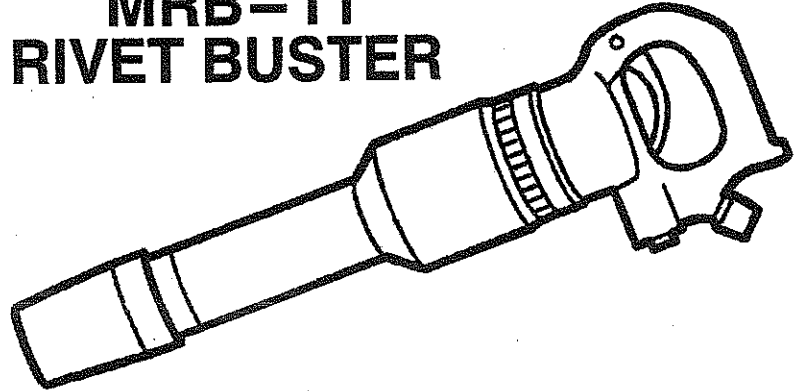


OPERATING INSTRUCTIONS AND PARTS LIST

MRB-8 MRB-11 RIVET BUSTER



GENERAL INFORMATION



OPERATOR IS REQUIRED TO READ
ENTIRE INSTRUCTION MANUAL

⚠ WARNING

Always turn off and disconnect air supply from tool before replacing steel or removing steel retainer.

- **COMPRESSED AIR SUPPLY (CFM [L/S]) REQUIRED**

Use an air compressor with sufficient CFM (L/S) (Cubic Feet per Minute [Liters per Second]) delivery to operate the tool(s) at a pressure of 90 to 100 PSI (Pounds per Square inch) (6.2 to 6.9 bar). RE: Chart for CFM (L/S) requirements.

- **AIR PRESSURE (PSI [BAR])**

Air pressure should be 90 to 100 PSI (6.2 to 6.9 bar) at the tool during operation. Higher pressure will increase kick back to operator, decrease performance, and may cause damage to tool. Lower pressure will reduce tool performance.

It is important to realize that long lead hoses, manifolds and worn hose connections will cause a pressure drop. Use couplings and fittings of maximum I.D. size for the hose being used. Reducers will restrict the air and result in less pressure at the tool.

- **AIR HOSE AND FITTINGS**

Inspect air hoses, fittings and gaskets for cuts and abrasions. Check that fittings, both in the tool and on the hose, are secure. Clear hoses of debris and excess water before attaching to tool. Use safety wire or chain to secure the couplings at the tool to prevent hose whipping should the hose become detached while pressurized. For hoses in excess of 1/2" (13mm) inside diameter install a proper flow limiting valve per government Health and Safety Requirements.

⚠ WARNING

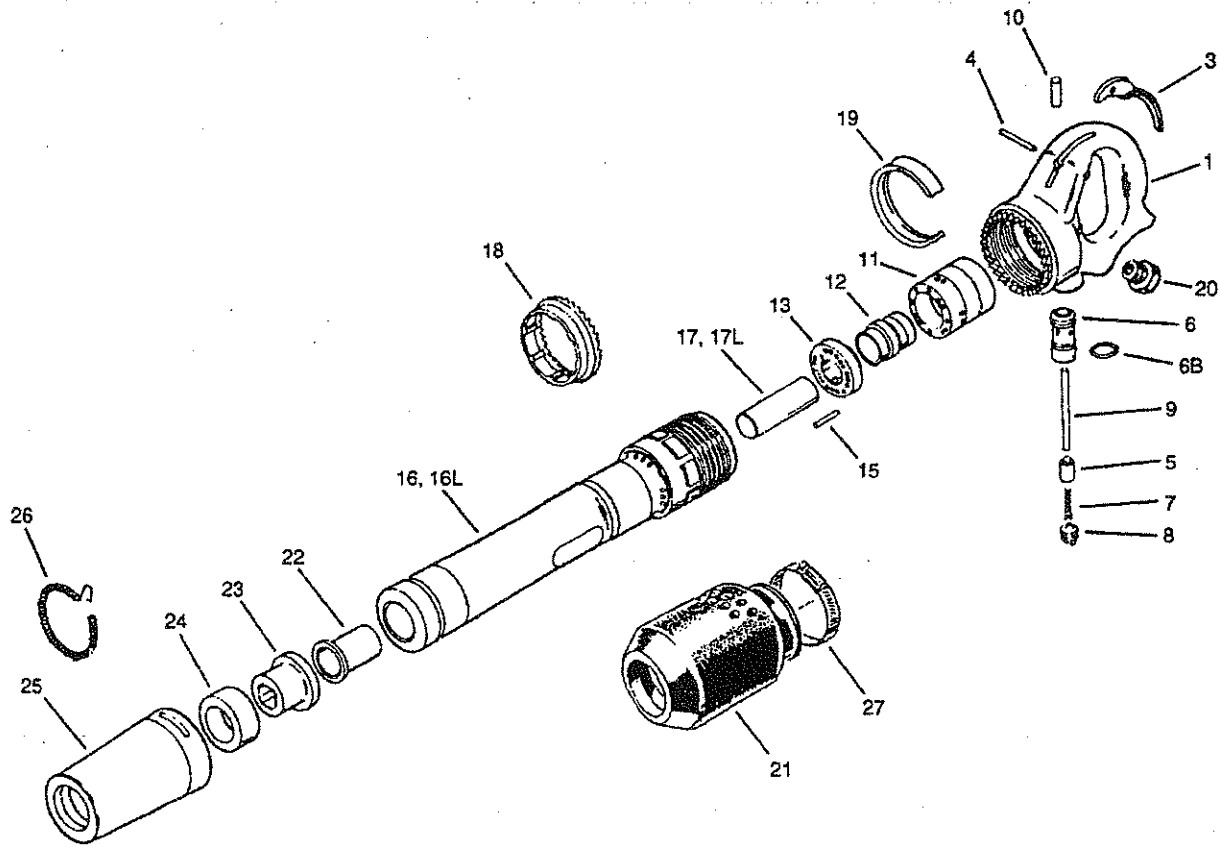
When blowing through a hose or air line, ensure that the open end is held securely. A free end will whip and may cause injury.

- **LUBRICATION**

Lubrication of the MRB-8 and MRB-11 Rivet Buster is required. A small amount of lightweight non-detergent oil may have to be added to the air supply and a drill rod coupling lubricant should be applied to the shank of the steel. A slight mist of oil should be present at the tool exhaust and on the shank of the steel. **Note: An in-line oiler is required on the MRB-8 and MRB-11.**

CROWDER SUPPLY

MRB-8 AND MRB-11 ILLUSTRATION



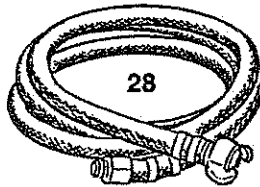
PARTS LIST

INDEX NO.	PART NUMBER	QTY. REQ.	DESCRIPTION	INDEX NO.	PART NUMBER	QTY. REQ.	DESCRIPTION
1	02250095-896	1	Handle w/Bushing. #10				DESCRIPTION
3	02250094-940	1	Throttle Lever,	21	02250094-915	1	Muffler
4	02250094-897	1	Throttle Lever Pin	22	250029-072		Upper Sleeve Bushing (11X)
5	02250094-898	1	Throttle Valve	23	250013-625	1	Lower Sleeve Bushing (11X)
6	02250094-899	1	Throttle Valve Bushing	24	250013-626		Bumper
6B	02250094-901	1	O-Ring	25	250035-776	1	Retainer
7	02250094-902	1	Throttle Valve Spring	26	250013-594	1	Retainer Lock Spring
8	02250094-903	1	Throttle Valve Plug	27	02250094-916		Muffler Clamp
9	02250094-904	1	Push Pin	28	Consult Factory	1	Hose, Whip
10	02250094-905	1	Push Pin Bushing				
11	02250094-906	1	Valve Box				
12	02250094-907	2	Valve				
13	02250094-908	1	Valve Cover Front				
15	02250094-909	1	Valve Dowel Pin	NS	02250094-938		Assemblies (Not Shown) Handle Assembly Complete includes Items # 1, 3, 4, 5, 6, 6B, 7, 8, 10, & 20
16	02250094-910	1	Barrel, (MRB-8)				
16L	02250094-911	1	Barrel, (MRB-11)	NS	02250094-939		Valve Assembly, includes Items # 11, 12, 13, & 15
17	02250144-351	1	Piston, 3" (MRB-8)				
17L	02250144-350	1	Piston, 4" (MRB-11)				
18	02250094-912	1	Handle Lock Ring				
19	02250094-913	1	Handle Lock Spring				
20	02250094-914	1	Handle Bushing				

* Recommended to purchase as assembly.

OPTIONAL ACCESSORIES

WHIP HOSE



ON-THE-JOB TROUBLESHOOTING (RIVET BUSTER)

⚠ WARNING

Never remove retainer or replace tool steel with air supply connected to the air tool.

PROBLEM	PROBABLE CAUSE	REMEDY
Tool Runs Sluggish	Low Air Pressure at Tool	Increase Pressure to 90–100 PSI (6.2 to 6.9 bar)
	Insufficient Air Flow (CFM [bar])	Check Hoses, etc. for Leaks
	Insufficient Lubrication	Add a Small Amount of Light-Weight Non-Detergent Oil into Hose.
Tool Runs Erratically	OSHA (Velocity Valve) Tripping	Inspect Valve for Proper Sizing
	Foreign Material in Tool Inlet	Remove Foreign Material
Tool Will Not Run (Air Blows thru Exhaust)	Automatic Valve Stuck	Inspect components and repair as needed.
Tool Continues to Run	Throttle Valve Stuck	Inspect components and repair as needed.
Excessive Kick-Back	Air Pressure Too High at Tool	Reduce Pressure to 90–100 PSI (6.2 to 6.9 bar)
	Dull Cutting Edge on Steel	Replace with Sharp Steel
Rapid Wearing of Retainer	Collar of Steel Striking Retainer	Exert sufficient down pressure to keep point against work surface.
Steel Will not Fit Bushing	Steel Shank Does Not Match Bushing	Use Steel with correct shank.
Steel Will not Fit Retainer	Steel Shank Does Not Match Bushing	Use Steel with correct shank.

If suggested remedies fail to correct problem, disassembly and inspection must be performed to determine cause.