

Lobster Tools® Service Bulletin

R1A2(A)

Applicable Serial Numbers: Ending in 0740-2339

Lobster Tools® Model R1A2(A) produced between November 2014 and October 2018, if the hydraulic oil is overfilled and not properly bled, it is possible for the Frame Cap “A” threads to fail and become detached.

Model: R1A2 (A)

Serial number (last 4 digits): 0740 – 2339



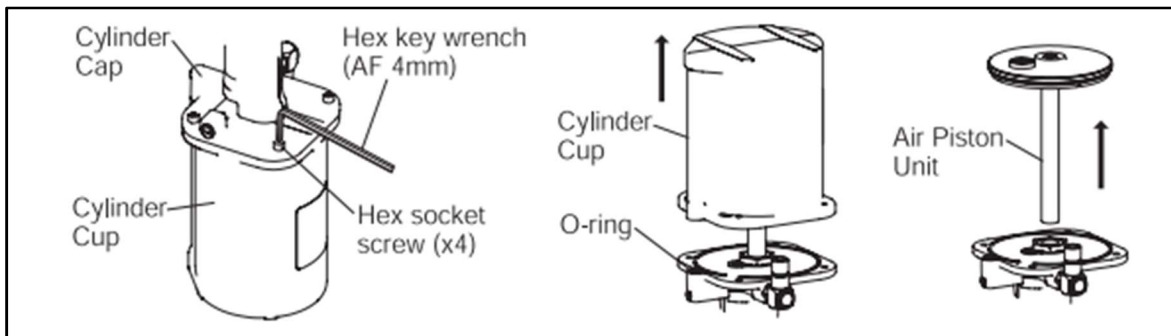
How does it happen?

The threads of Frame Cap “A” (#36) could possibly fail from pressure inside the hydraulic system when the tool is both overfilled and not properly bled, then energized.

How do I properly fill my Lobster Tools® R1A2 Riveter?

1. Remove the tool from the air supply.
2. Remove Frame Head (#2).
3. Remove all [4] Socket Head Cap Screws on Cylinder Top (#55).
4. Turn tool on its head so the Cylinder Cup (#79) is on top.
5. Remove Cylinder Cup, making sure not to lose the #66 O-Ring (63969).
6. Remove Air Piston Unit (63686).

From R1A2(A) Manual, page 12



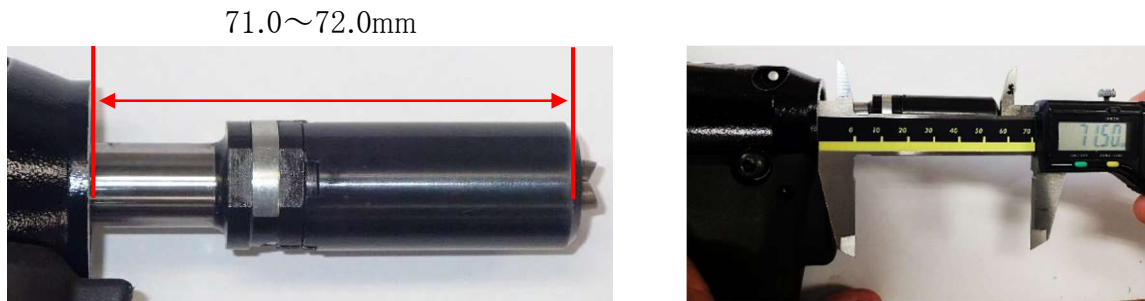
7. Fill the hydraulic fluid chamber with 46 Weight Hydraulic Fluid (10012).
8. Return the Air Piston Unit to the tool until you feel it “click” into its proper, seated position.
9. Press down on the Air Piston Unit several times, making sure the Jaw Case, #3 (63990), moves freely as you do.
10. Reassemble the tool with the screws and return to upright position.
11. **With the Frame Head still removed, lay the tool on its side with the Bleed Plug (#12) facing up so you can relieve the air in the hydraulic system.**

When filling in the oils.

- (a) Make sure Frame Head does not get loose. (ref. page 11-2)
- (b) Remove Frame Head when refilling oil. (ref. page 11-5)
- (c) After filling in the oil, put the Frame head on and turn bleed plug by turning around at least 7 times and make it loosen to take out extra oil and air.(ref. page 12-11)

*Also see page 11-12 of instruction manual.

Pro Tip: Measure the distance from the end of the Jaw Case (not including the jaws) to the frame of the tool with calipers to ensure exact prime. The defined value for this distance: **71.5mm±0.5mm**



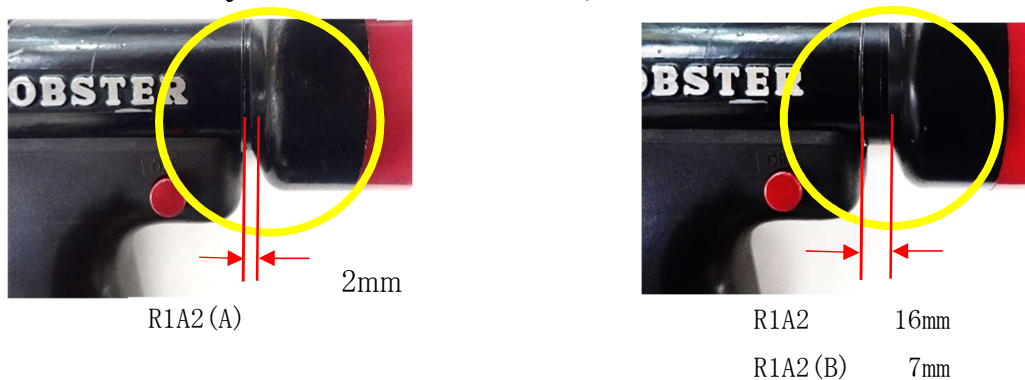
What else can I do to avoid this?

While the above instructions are best practice recommendation for all Lobster Tools ® Riveters and Rivet Nut Setters*, you can also contact us for a free upgrade kit from the original parts to new version.

- Oil Piston Backward Axis 'A' 64597 → Oil Piston Backward Axis 'B' 67376
- Inner shaft of Frame Cap 64596 → Inner shaft of Frame Cap 'A' 67375
- Frame Cap 'A' 64413 → Frame Cap 'B' 67377

*Distances vary. Check your specific manual.

How to identify R1A2(A) and R1A2, R1A2(B)



Not sure which version you own? Have a question?

Contact your Lobster Tools specialists for more information and support.

LOBTEX CO., LTD.

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4 Cleaning and Oil Supply of Air Cylinder section

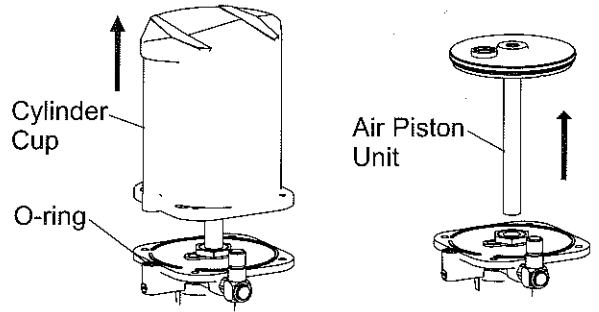
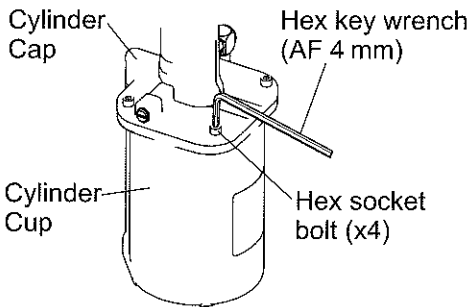
- Note**
- Accumulated dusts in the Air Cylinder section will adversely affect smoothness and durability.
 - If hydraulic oil becomes less causes insufficient stroke, supply hydraulic oil in the following procedure. If stroke becomes insufficient soon after supplying hydraulic oil, the cause may be abrasion of seal. In that case, please ask it for repair.

⚠ CAUTION

- **Before starting maintenance or disassembling the unit to replace parts, be sure to stop air supply.**
Performing maintenance or disassembly with air supplied may cause a part to jump out, oil to squirt out, or the unit to perform unexpected behavior, and may result in an accident or personal injury.
- **Avoid skin contact with substances such as hydraulic oil, lubricating oil and grease.**
Such substances may cause inflammation of the skin. If they come into contact with your skin, wash the affected area thoroughly.

DISASSEMBLY

- 1 Turn off air supply.
- 2 Remove the Frame Head using a wrench or spanner (AF22mm).
Make sure Jaw Case are not loosen.
- 3 Using a hex key wrench (AF 4 mm) remove the 4 hex socket bolts on the top surface of Cylinder Cap.
- 4 Turn the unit and keep it straight up as the Cylinder Cup comes to the top, and pull out the Cylinder Cup upward.
- 5 Pull out the Air Piston Unit upward.



- Note**
- Keep the Frame Head removed during work. Otherwise the position of Oil Piston becomes too low due to excess oil, then, the parts may break.
 - Tilting the main body may cause the hydraulic oil to spill out. Keep it standing up during work.

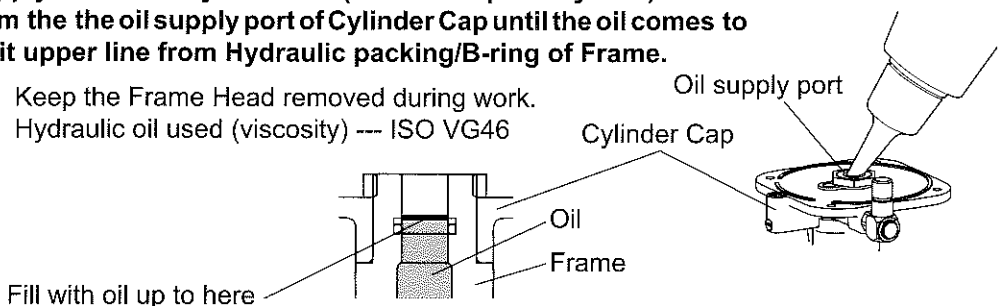
CLEANING

- 6 Clean each part using a waste cloth and brush.

FILLING OIL

- 7 Supply LOBSTER hydraulic oil (B10012: separately sold) from the the oil supply port of Cylinder Cap until the oil comes to a bit upper line from Hydraulic packing/B-ring of Frame.

- Note**
- Keep the Frame Head removed during work.
 - Hydraulic oil used (viscosity) --- ISO VG46

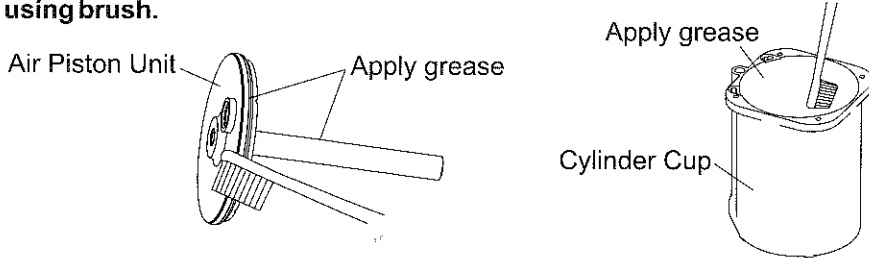




⚠ CAUTION

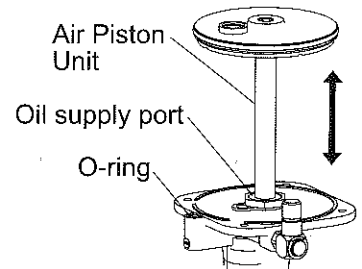
- **Avoid skin contact with substances such as hydraulic oil, lubricating oil and grease.** Such substances may cause inflammation of the skin. If they come into contact with your skin, wash the affected area thoroughly.
- **Maintain the tool with due care.** Refer to the Instruction Manual for details on replacing parts and attachments, otherwise injury may occur.

8) Apply grease to the O-Ring and rod of Air Piston Unit and to the inside of Cylinder Cup using brush.

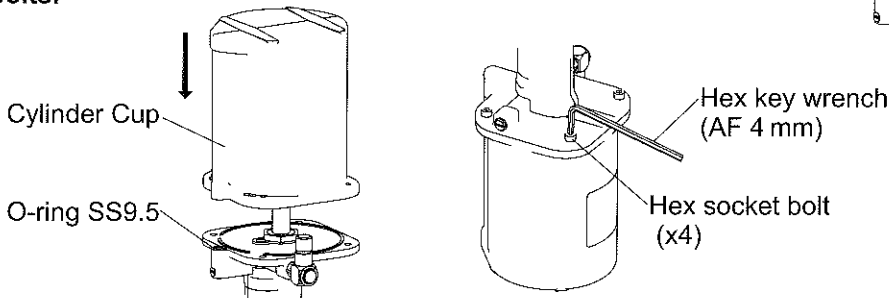


- Note**
- Before assembling, be sure to apply lubricant such as grease to each sliding section.
 - Recommended grease is Grease grade 1~2.

9) Push and insert the Air Piston Unit into the oil supply port and manually perform a piston motion for several times. Wipe off hydraulic oil spilling out of the oil supply port.

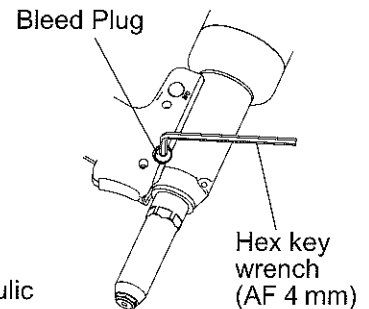


10) Attach the Cylinder Cup on the Air Piston Unit, and keeping pressing it down tighten the 4 hex socket bolts.



- Note**
- Assemble in reverse order of disassembly.
 - Make sure the O-ring SS9.5 is surely set in the counterbore.

11) After assembled Frame Head with Frame, turn the unit as the Bleed Plug (hex socket bolt) comes to the upper side. Then, loosen it using a hex key wrench (AF 4 mm) in order to let excessive hydraulic oil and air (bubble) out. After making sure that hydraulic oil no longer comes out, tighten the Bleed Plug again.



- Note**
- Note that hydraulic oil may squirt out when you loosen the Bleed Plug.
 - The work should be done by necessity after feeding hydraulic oil. Otherwise there may be detrimental to the tool in loading rivet or breakage of Frame.

12) Wipe off hydraulic oil adhering to the main body or spilling out before use.

- Note**
- During disassembly/assembly, be careful to prevent cutting dusts of metal and other objects from getting into the hydraulic oil and Air Cylinder.

13. Use caliper to check the length of Oil piston to see the length are appropriate.