NEO BOLT COLLAR CROPPER

STANLEY®
Engineered Fastening

Assembly Technologies
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1. SAFETY
- Before use, read and understand safety and operating instructions both the hydraulic equipment and the collar cropper tool.
- Always use eye protection when using this tool.
- Use of protective gloves is recommended.
- Avoid placing hands in potential pinch points, as tool will move while cutting.
- Verify that equipment is in good working condition and properly set up before using.

2. TECHNICAL SPECIFICATIONS

<table>
<thead>
<tr>
<th>Neobolt size</th>
<th>3/8”</th>
<th>12mm</th>
<th>12mm/ 1/2”</th>
<th>1/2”</th>
<th>5/8”</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cropper Assembly</td>
<td>65120-00061</td>
<td>65120-00060</td>
<td>65110-00059</td>
<td>65110-00054</td>
<td>65110-00055</td>
</tr>
<tr>
<td>Use with</td>
<td>Avdel AV5</td>
<td>Huck SF20</td>
<td>Avdel AV30</td>
<td>Avdel AV15</td>
<td>Avdel AV30</td>
</tr>
<tr>
<td>Hydraulic pressure (bar)</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Alum: 190</td>
<td>400</td>
<td>180</td>
<td>400</td>
<td>350</td>
<td></td>
</tr>
<tr>
<td>Seel: 490</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cropper Stroke (mm)</td>
<td>30</td>
<td>50</td>
<td>41</td>
<td>32</td>
<td>41</td>
</tr>
<tr>
<td>Cropper weight (kg)</td>
<td>0.48</td>
<td>0.86</td>
<td>2.4</td>
<td>1</td>
<td>1.5</td>
</tr>
<tr>
<td>Cropper Dia/Length (mm)</td>
<td>27 / 108</td>
<td>38 / 71</td>
<td>60 / 150</td>
<td>43 / 98</td>
<td>48 / 118</td>
</tr>
</tbody>
</table>

3. PACKAGE CONTENTS
One Neobolt collar cropper assembly.
Neobolt cropper components:

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
<th>3/8”</th>
<th>12mm</th>
<th>12mm/1/2”</th>
<th>1/2”</th>
<th>5/8”</th>
</tr>
</thead>
<tbody>
<tr>
<td>O-ring*</td>
<td>1</td>
<td>6510-00463</td>
<td>65110-00460</td>
<td>65110-00431</td>
<td>65110-00431</td>
<td>65110-00432</td>
</tr>
<tr>
<td>Jaw*</td>
<td>2</td>
<td>65110-00327</td>
<td>65110-00213</td>
<td>65110-00171</td>
<td>65110-00171</td>
<td>65110-00309</td>
</tr>
<tr>
<td>Cutter*</td>
<td>3</td>
<td>65110-00326</td>
<td>65110-00211</td>
<td>65110-00452</td>
<td>65110-00167</td>
<td>65110-00311</td>
</tr>
<tr>
<td>Jaw holder</td>
<td>4</td>
<td>65110-00328</td>
<td>65110-00212</td>
<td>65110-00451</td>
<td>65110-00172</td>
<td>65110-00310</td>
</tr>
<tr>
<td>Nut</td>
<td>5</td>
<td>65110-00329</td>
<td>-</td>
<td>65110-00454</td>
<td>65110-00291</td>
<td>65110-00313</td>
</tr>
<tr>
<td>Nose Hsg</td>
<td>6</td>
<td>65110-00330</td>
<td>-</td>
<td>65110-00453</td>
<td>65110-00173</td>
<td>65110-00312</td>
</tr>
</tbody>
</table>

* Typical wear items

4. CUTTER SETUP

Set pump to required pressure (See section 2 for required pressure)
Connect tool to hydraulic pump, use extension hose if required.
Mount cutter into hydraulic tool (See section 2 for tool selection)

- Remove o-ring from front of hydraulic tool.

- Thread cutter clockwise (hand tight – Do not use wrench) into tool rod, until it bottoms out.
• Thread retaining nut clockwise into tool body (hand tight – Do not use wrench), until it bottoms out.

• Cycle tool twice and retighten retaining nut if needed.
• Verify that pintail from Neobolt pin fits inside the jaws.

• Tool is now ready to use.

5. CUTTER USE
• Verify that pump pressure has been set to desired value
• Check tool to verify that jaws are intact and free of debris. Also check cutting surfaces for damage.
• Place tool against fastener to be cut. **Pin tail must be fully inserted into cutter.** Tool must be aligned with the fastener to be removed.

![OK](image1)

![INCORRECT](image2)

• Press trigger to start cutting. Release button once collar is fully cut.

![Diagram](image3)

• Remove tool from fastener.
• Separate collar from pin to remove fastener.

### 6. TOOL DISASSEMBLY

• Unthread nose housing from cutter.

![Diagram](image4)

• Push jaw holder into cutter and slide out of the cutter. Jaws should fall out of cutter.
7. TOOL ASSEMBLY

- Slide o-ring into jaw holder as shown.

- Apply light coat of moly-lithium grease to inside of cutter.

- Place jaws into jaw holder as shown, keeping them aligned with side grooves.

- Insert jaws and jaw holder into cutter, until jaws emerge out of the other side of cutter.
• Slide retaining nut into nose housing and thread nose housing (hand tight – Do not use wrench) into cutter.

8. TOOL MAINTENANCE

For optimal performance, it is critical that the tool is kept clean and in good working order. Cleaning frequency will depend on usage and operating conditions.

To clean tool:
• Disassemble tool.
• Clean components. Inspect for damage and replace any damaged components.
• Apply a light coat of moly-lithium grease to inside of cutter using a cotton swab.
• Reassemble tool.