

## **DESCRIPTION:** FN FasMate Rebuild Instructions

Rebuild Kit Instructions for FN Style Connectors, body Size 6-7

These instructions are intended to be used with the Repair Tool Kit FN67RTK and a Repair Kit of replacement parts for your connector.

## **Special Notes on Disassembly and Reassembly:**

- **When compressing and decompressing the connector, be careful not to release the spring tension uncontrollably.**
- **When a connector has been disassembled, be sure to keep its collets together as a set!**

There are Two different operator styles available for the FN FasMate connectors.  
Thumb Valve and Pneumatic Pilot.



## **Disassembly:**

1. Actuate the connector with the thumb valve or the pneumatic pilot. Remove the main seal and save.

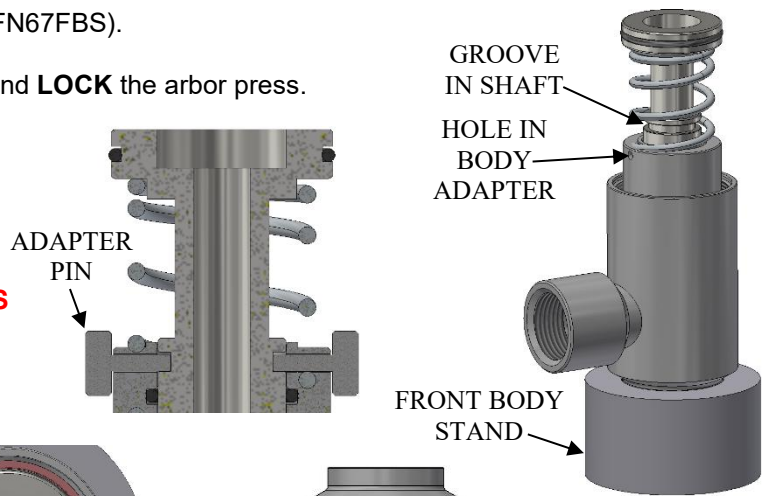


2. Un-thread the back body from connector.

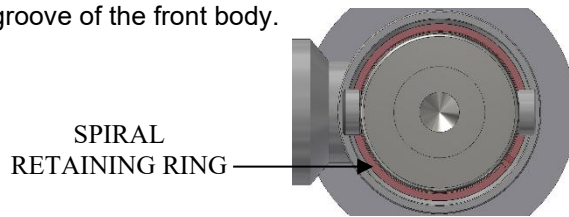


3. Load the connector into the Front Body Stand (FN67FBS).
4. Using an arbor press, fully compress the shaft and **LOCK** the arbor press.
5. Install the Adapter Pins (FN67AP) through the holes in the body adapter into the groove in the shaft to lock the shaft to the body adapter.

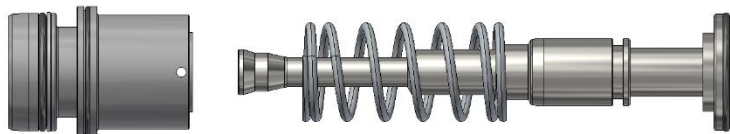
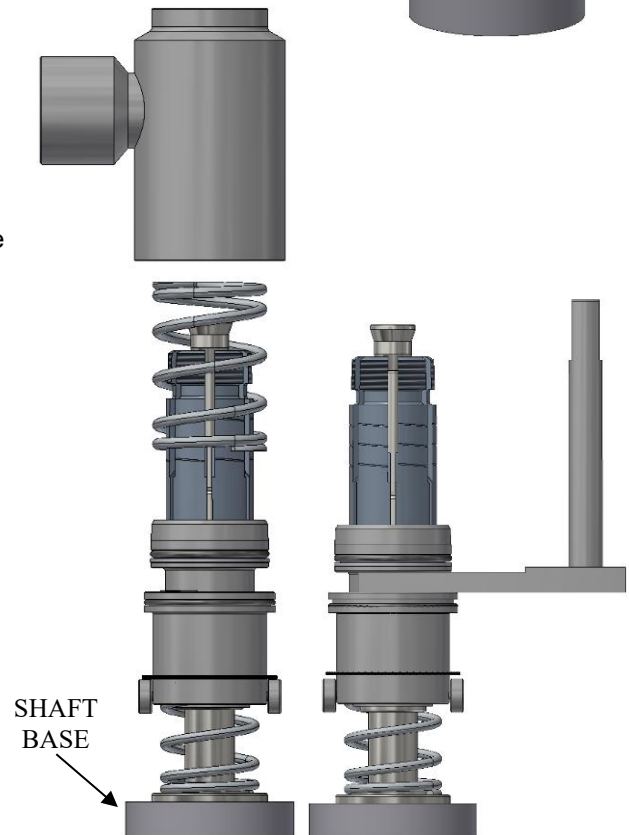
**MAKE SURE THE ADAPTER PINS ARE NOT REMOVED OR BUMPED OUT OF THE HOLES THROUGH THE NEXT SEVERAL STEPS!!!**



6. Using a small flat screwdriver or sharp pick like tool, remove the spiral retaining ring in the groove of the front body.



7. Unlock the arbor press and remove the connector, making sure the Adapter Pins stay secure.
8. Flip the connector and load it into the Shaft Base (FN67SB). Remove the front body weldment and front spring.
9. Load the Fork Tool (FN67FS, FN67FP) into the arbor press.
10. Position the connector so that the fork fits between the piston and adapter.
11. Compress the connector until the Adapter Pins are loose. **LOCK** the arbor press then remove the Adapter Pins.
12. Unlock the arbor press and slowly decompress the connector until all spring force is released. Remove the collets and keep them together as a set.
13. Remove the piston and body adapter from the shaft as one piece. Some ball bearings may fall out in the process. Remove the Spring from the shaft.



14. Remove and discard all components being replaced with components from the Repair Kit for your connector.
15. Clean all parts prior to reassembly.

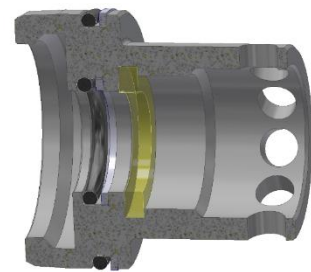
## **Reassembly:**

Use all the new seals, springs, balls, and backup rings provided. Lightly lubricate seals with petroleum jelly.

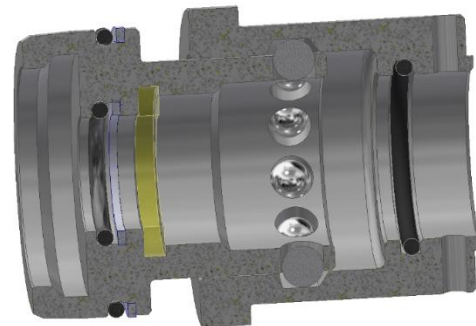
1. Install O-rings into the internal groove and the external groove in the Body Adapter.
2. Install O-ring into the groove on Shaft. Install the back spring onto the Shaft.



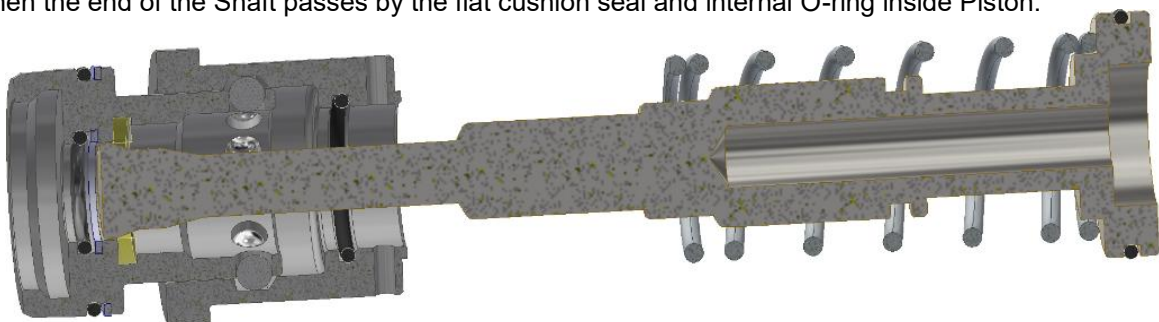
3. Install O-ring and backup ring into internal and external grooves of the Piston. Note the orientation of the O-rings and backup rings.
4. Install Flat Cushion Seal into internal groove in the Piston.
5. Lube all ball holes in the Piston with petroleum jelly. This will help retain the balls during the assembly process.



6. Insert Piston into the Body Adapter. Note the position of the holes in the Piston to the groove in the Body Adapter.
7. Through the Body Adapter, place a ball into each hole in the Piston, pushing each ball into the groove in the Body Adapter.

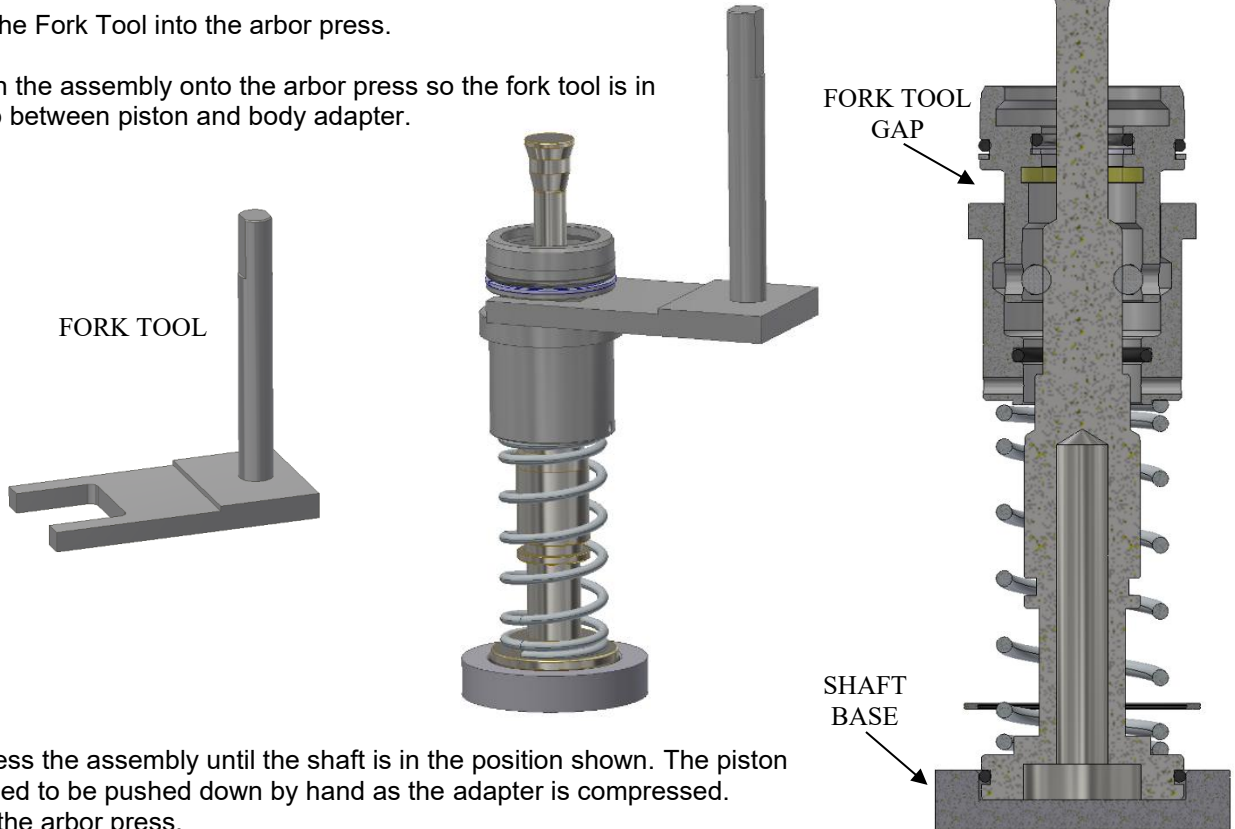


8. Insert the Shaft with Spring into the Piston and Body Adapter, keeping the balls in the groove. Resistance will be felt when the end of the Shaft passes by the flat cushion seal and internal O-ring inside Piston.

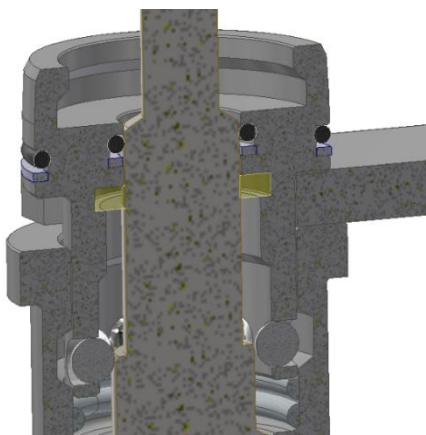


9. Insert the Shaft until the spring contacts the Adapter.
10. Place the retaining ring over the bottom end of the shaft, it can be around the spring.

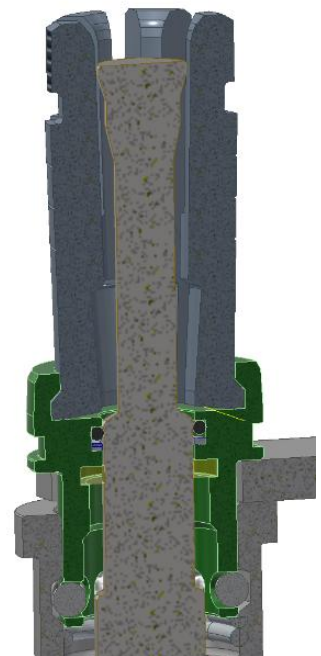
11. Stand this assembly up to a vertical position and place it onto the Support Base. The spiral retaining ring can rest on the face of support base.
12. Install the Fork Tool into the arbor press.
13. Position the assembly onto the arbor press so the fork tool is in the gap between piston and body adapter.



14. Compress the assembly until the shaft is in the position shown. The piston may need to be pushed down by hand as the adapter is compressed. **LOCK** the arbor press.



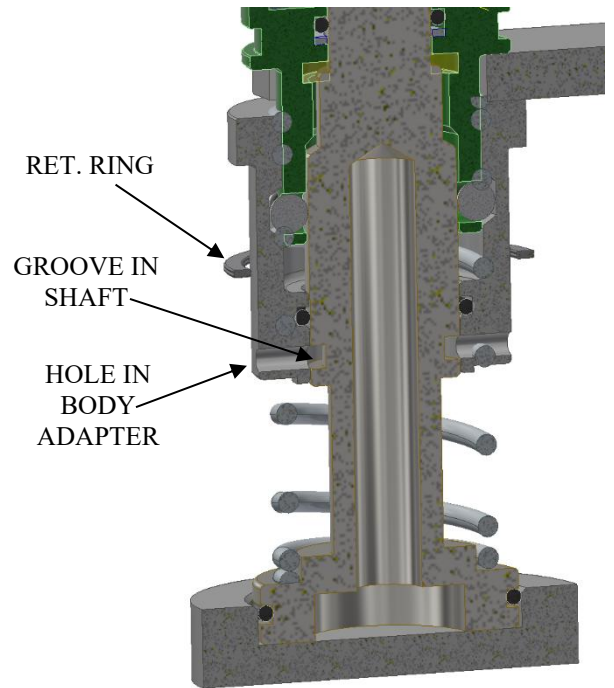
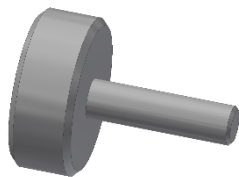
15. Load the collets into the piston groove. The collets are in the correct order when the spiral grooves from each collet to the next are all lined up.
16. Unlock arbor press and compress the assembly so the shaft comes up through collets. **MAKE SURE THE COLLETS STAY IN PISTON GROOVE.**



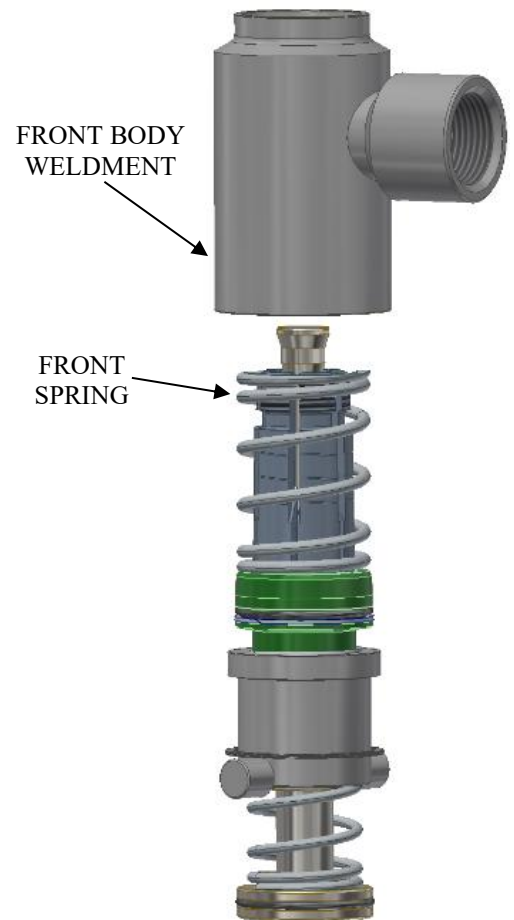
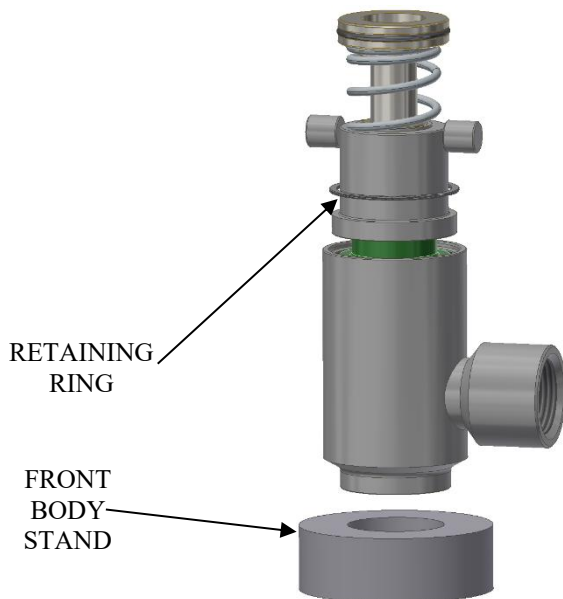
17. Locate the 2 holes in the body adapter and compress the assembly until they are lined up with the groove in the shaft. **LOCK** the arbor press.
18. Hold the spiral retaining ring above the holes in the body adapter. On body size 6 connectors, the spiral retaining ring needs to stay above the Adapter Pins.
19. Insert the Adapter Pins through each hole of the body adapter and into the groove in the shaft.

**MAKE SURE THE ADAPTER PINS ARE NOT REMOVED OR BUMPED OUT OF THE HOLES THROUGH THE NEXT SEVERAL STEPS!!!**

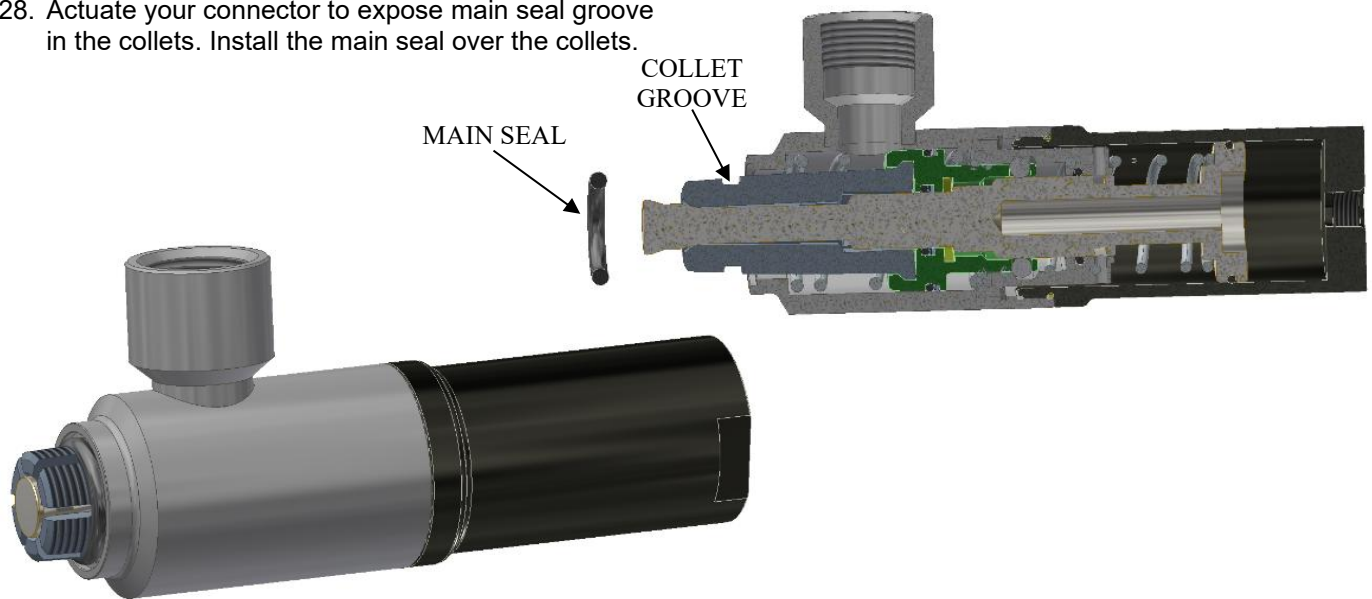
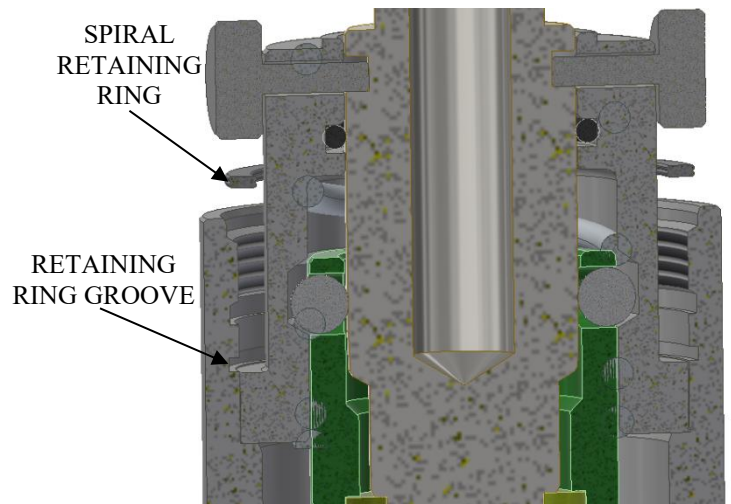
ADAPTER  
PIN



20. Unlock the arbor press and slide the assembly out of the fork tool. Remove the assembly from the Support Base.
21. Install the front spring over the collets. Install the front body weldment over the front spring/collet end of the assembly until it rests on the front spring.
22. While making sure to keep the Adapter Pins secure, flip this assembly and place it onto the Front Body Stand. Place the assembly onto the arbor press.



23. Use the arbor press to compress the assembly until the body adapter is fully inserted into the front body weldment. **LOCK** the arbor press.
24. Using a small flat screwdriver or sharp pick like tool, install the spiral retaining ring into the groove in front body.
25. Unlock the arbor press and remove Adapter Pins. Slowly raise arbor press until the assembly gets to its fully retracted position.
26. Remove the assembly from arbor press.
27. Now that connector sub-assembly is complete, thread the back body you have back onto the connector. (Valve or Pneumatic)
28. Actuate your connector to expose main seal groove in the collets. Install the main seal over the collets.



29. Actuate the connector several times to ensure proper function and movement of the collets.

## **FasTest, Inc. Product Warranty**

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