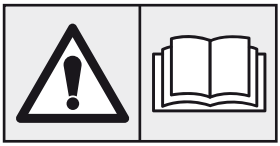
KJ 60



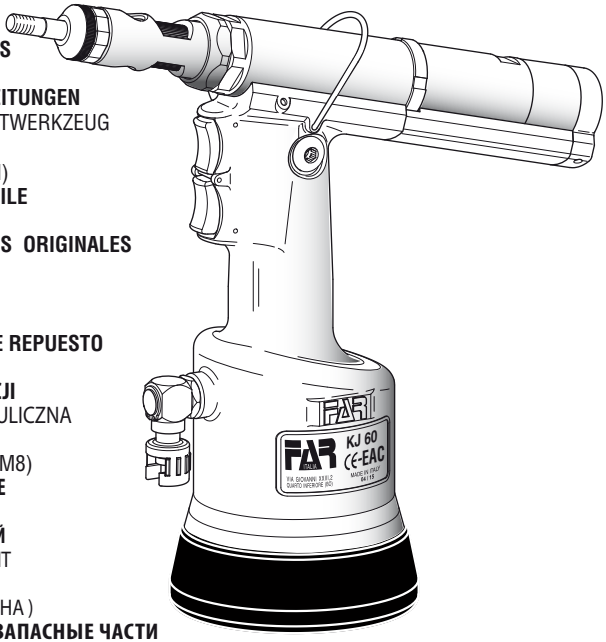
(I) - ISTRUZIONI ORIGINALI
RIVETTATRICE OLEOPNEUMATICA
PER INSERTI M3/M8*
(*ESCLUSO M8 INOX)
ISTRUZIONI D'USO - PARTI DI RICAMBIO

(GB) - TRANSLATION OF ORIGINAL INSTRUCTIONS
HYDROPNEUMATIC RIVETING TOOL
FOR INSERTS M3/M8*
(*INOX M8 EXCLUDED)
INSTRUCTIONS FOR USE - SPARE PARTS

(F) - TRADUCTION DES INSTRUCTIONS ORIGINALES
OUTIL À RIVETER OLÉOPNEUMATIQUE POUR
ÉCROUS À SERTIR M3/M8*
(*SAUF M8 INOX)
MODE D'EMPLOI - PIECES DETACHEES

(D) - ÜBERSETZUNG VON ORIGINALANLEITUNGEN
PNEUMATISCH-HYDRAULISCHES NIETWERKZEUG
FÜR BLINDNIETMUTTERN M3/M8*
(*EDELSTAHL M8 AUSGESCHLOSSEN)
BEDIENUNGSANLEITUNG - ERSATZTEILE

(E) - TRADUCCION DE LAS ISTRUCCIONES ORIGINALES
REMACHADORA OLEONEUMATICA
PARA TUERCAS M3/M8*
(*EXCEPTO M8 INOX)
INSTRUCCIONES DE USO - PIEZAS DE REPUESTO



(PL) - TŁUMACZENIE ORYGINALNEJ INSTRUKCJI
NITOWNICA PNEUMATYCZNO-HYDRAULICZNA
DO NITONAKRĘTEK M3-M8*
(*WYKLUCZONA STAL NIERDZEWNA M8)
INSTRUKCJA OBSŁUGI - CZĘŚCI ZAMIENNE

(RUS) - ПЕРЕВОД ОРИГИНАЛЬНЫХ ИНСТРУКЦИЙ
ГИДРОПНЕВМАТИЧЕСКИЙ ИНСТРУМЕНТ
ДЛЯ ВСТАВОК M3-M8*
(*НЕРЖАВЕЮЩАЯ СТАЛЬ M8 ИСКЛЮЧЕНА)
ИНСТРУКЦИИ ПО ЭКСПЛУАТАЦИИ - ЗАПАСНЫЕ ЧАСТИ
• ДАТА ПРОИЗВОДСТВА УКАЗАНА В «ТЕХНИЧЕСКОМ ПАСПОРТЕ»

(PT) - TRADUÇÃO DAS INSTRUÇÕES ORIGINAIS
REBITADORA OLEO-PNEUMÁTICA
PARA INSERTOS M3/M8*
(*EXCLUINDO M8 INOX)
INSTRUÇÕES DE USO - PEÇAS SOBRESSALENTES

CE - EAC

I

La sottoscritta Far S.r.l., con sede in Quarto Inferiore (BO) alla via Giovanni XXIII n° 2,

DICHIARA

sotto la propria esclusiva responsabilità che la rivettatrice Modello: KJ 60 - Rivettatrice oleopneumatica
Utilizzo: per inserti filettati M3÷M8 (escluso M8 Inox), numero di serie: vedi retro copertina, alla quale questa dichiarazione si riferisce è conforme ai requisiti essenziali di sicurezza previsti dal D. Lgs. 17/2010 di recepimento della Direttiva Macchine 2006/42/CE e successive modificazioni ed integrazioni, e CU TR 010/2011.
La persona autorizzata a costituire il fascicolo tecnico risponde al nome di Massimo Generali, presso la Far S.r.l.,
con sede in Quarto Inferiore (BO) alla via Giovanni XXIII n° 2.

GB

The undersigned Far S.r.l., having its office in Quarto Inferiore (BO), Via Giovanni XXIII No. 2, herewith

DECLARES

on its sole responsability that the riveting machine Type: KJ 60 - Hydropneumatic tool
Application: for blind rivet nuts M3÷M8 (Inox M8 excluded), serial number: see back cover, which is the object of this declaration complies with the basic safety requirements estabilished in the law decree Leg. D. 17/2010 of the Machinery Directive 2006/42/CE acknowledge and subsequent amendments and integrations and CU TR 010/2011. The person who is authorized to create the technical brochure is Massimo Generali, c/o Far S.r.l., head office in Quarto Inferiore (BO), via Giovanni XXIII n. 2.

F

La société Far S.r.l. soussignée avec siège à Quarto Inferiore (BO), Via Giovanni XXIII n° 2,

DECLARE

sous sa seule responsabilité que la riveteuse
Modèle: KJ 60 - Machine à sertir oléopneumatique
Utilisation: pour inserts filetés M3÷M8 (Sauf M8 Inox) , numéro de série: voir la dos couverture, à laquelle cette déclaration se rapporte est conforme aux conditions essentielles de sécurité requises par la loi 17/2010 d'acceptation de la Directive Machines 2006/42/CE et modifications et intégrations successives et CU TR 010/2011. La personne autorisée à constituer le dossier technique est Massimo Generali chez FAR S.r.l., avec siège à Quarto Inferiore (BO) – Via Giovanni XXIII. n.2.

D

Die Unterzeichnete, Fa. Far S.r.l., mit Sitz in Quarto Inferiore (BO), Via Giovanni XXIII Nr. 2,

ERKLÄRT

hiermit auf ihre alleinige Verantwortung, daß die Nietmaschine Typ: KJ 60 - Hydraulisch-pneumatisches Nietwerkzeug Anwendung: für Blindnietmuttern M3÷M8
(Edelstahl M8 ausgeschlossen),seriennummer: siehe Rückseite, auf das sich diese Erklärung bezieht, den wesentlichen Sicherheitsanforderungen des Gesetzesdekrets 17/2010 von Umsetzung der Maschinenrichtlinie 2006/42/CE und den nachfolgenden Änderungen und Anfügungen entspricht und CU TR 010/2011.
Der Berechtigte zur Bildung der technische Broschüre ist Massimo Generali, bei der Firma Far S.r.l.,
mit Sitz in Quarto Inferiore (BO), via Giovanni XXIII Nr. 2.

E

La firmataria Far S.r.l., domiciliada en Quarto Inferiore (BO) en via Giovanni XXIII n° 2,

DECLARA

bajo su exclusiva responsabilidad que la remachadora Modelo: KJ 60 - Remachadora oleoneumática
Empleo: para remaches roscados M3÷M8(Excepto M8 Inox), número de serie: ver la contratapa, a la cual la presente declaración se refiere corresponde a los requisitos esenciales de seguridad previstos por el D. Lay 17/2010 de recepción de la Directiva Maquinas 2006/42/CE y sucesivas modificaciones e integraciones y CU TR 010/2011.
La persona autirizada a constituir el fasciculo tecnico es Massimo Generali, cerca FAR S.r.l.,
con sede a Quarto Inferiore (BO) – Via Giovanni XXIII n.2.

PL

Firma FAR S.r.l z siedzibą w Quarto Inferiore (Włochy), Via Giovanni XXIII,2

DEKLARUJE

na własną i wyłączną odpowiedzialność, że nitownica Model: KJ 60 - Nitownica oleopneumatyczna
Zastosowanie: do nitonakrętek gwintowanych M3÷M8 (wykluczona stal nierdzewna M8), numer seryjny: patrz tylna okładka do której odnosi się niniejsza deklaracja, jest zgodna z wymogami bezpieczeństwa przewidzianymi przez D. Lgs. 17/2010 implementujący Dyrektywę Maszynową 2006/42/WE wraz z późniejszymi zmianami i uzupełnieniami i CU TR 010/2011.
Osoba upoważniona do utworzenia dokumentacji technicznej to Massimo Generali z firmy Far S.r.l.
mającej siedzibę w Quarto Inferiore (BO), via Giovanni XXIII nr 2

RUS

Нижеподписавшееся Far S.r.l., с местонахождением в Quarto Inferiore (BO) ул. Giovanni XXIII, 2,

ЗАЯВЛЯЕТ

под свою исключительную ответственность, что заклепочник модели:
KJ 60 - Масляно-пневматический заклепочный инструмент Использование: для резьбовых заклепок M3÷M8 (Нержавеющая сталь M8 исключена), серийный номер: см. на внутренней стороне обложки, к которому это заявление относится, соблюдает основные требования безопасности, предусмотренные Проектом закона 17.2010 по трансформации директивы по машинному оборудованию 2006/42/CE и последующими модификациями и дополнениями и ТР ТС 010/2011.
Лицом, уполномоченным оставлять техническую документацию компании Far S.r.l., расположенной в Куарто Инфериоре (провинция города Болонья) по адресу: улица Джованни XXIII, д.2, является Джакомо Дженерали (Massimo Generali),.

PT

A abaixo-assinada Far S.r.l., com sede em Quarto Inferior (BO) na via Giovanni XXIII n° 2,

DECLARA

sob sua exclusiva responsabilidade que a máquina de rebitar Modelo: KJ 60 - Máquina de rebitar óleo-pneumática Uso: para insertos roscados M3÷M8 (Excluindo M8 Inox), número de série: ver parte traseira da capa à qual esta declaração se refere, está em conformidade com os requisitos essenciais de segurança previstos pelo D.Leg. 17/2010 de recepção da Diretiva de Máquinas 2006/42/CE e posteriores modificações e integrações e CU TR 010/2011.
A pessoa autorizada a constituir o fascículo técnico é Massimo Generali, na Far S.r.l., com sede em Quarto Inferiore (BO) na via Giovanni XXIII n° 2.

Quarto Inferiore, 01-03-2019

.....

Far S.r.l. - Massimo Generali

(Presidente del Consiglio di Amministrazione)
(Chairman of the Board of Directors)
(Président du Conseil d'Administration)
(Vorsitzender des Verwaltungsrates)
(Presidente del Consejo de Administración)
(Prezes Zarzadu)
(Председатель Административного Совета)
(Presidente do Conselho de Administração)

BOLOGNA
ITALY

KJ 60

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INSTRUCTIONS FOR USE

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GUARANTEE

FAR riveting tools are covered by a **12-month** warranty. The tool warranty period starts on the date of delivery to the buyer, as specified in the relevant document. The warranty covers the user/buyer provided that the tool is purchased through an authorized dealer and only if it is used for the purposes for which it was conceived. The warranty shall not be valid if the tool is not used or maintained as specified in the instruction and maintenance handbook. In the event of defects or failures, **FAR S.r.l.** shall undertake solely to repair and/or replace the components it judges to be faulty.

SAFETY MEASURES AND REQUIREMENTS

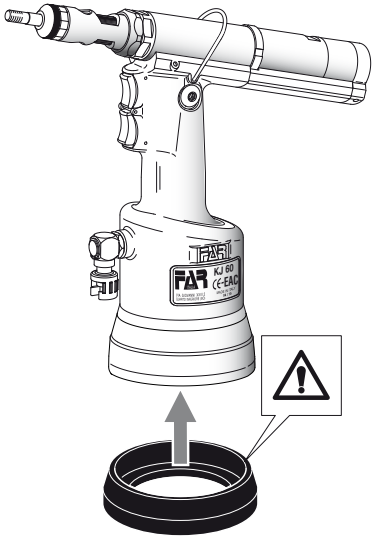
CAUTION!!!
All the operations must be done in conformity with the safety requirements, in order to avoid any consequence for your and other people security and to allow the best tool work way.

- Read the instructions carefully before using the tool.
- For all maintenance and/or repairs please contact **FAR s.r.l.** authorized service centers and use only **original spare parts**. **FAR s.r.l.** may not be held liable for damages from defective parts caused by failure to observe what above mentioned (**EEC directive 85/374**).

The list of the service centres is available on our website http://www.far.bo.it (Organization)

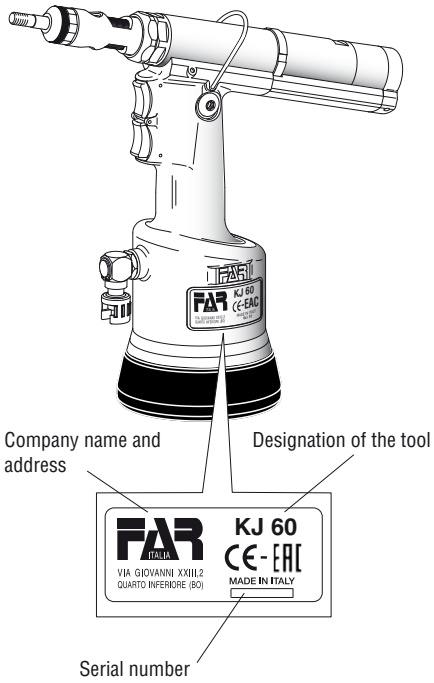
- The tool must be used only by expert workers.
- A protective visor and gloves must be put on when using the tool.
- Use equipment recommended in the maintenance chapter to do any maintenance and/or regulation of the tool.
- For topping up the oil, we suggest using only fluids in accordance with the features specified in this working book.
- If any drop of oil touches your skin, you must wash with water and alkaline soap.
- The tool can be carried and we suggest putting it into its box after using.
- The tool needs a thorough six-monthly overhaul.
- There are no special requirements for storage.
- Repairing and cleaning operations must be done when the tool is not fed.
- If it is possible, we suggest a safety balancer.
- If the A-weighted emission sound pressure level is more than 70 dB (A), you must use some hearing protections (anti-noise headset, etc.).
- The workbench and the work surface must be always clean and tidy. The untidy can cause damages to people.
- Do not allow unauthorized persons to use the working tools.
- Make you sure that the compressed air feeding hoses have the correct size to be used.
- Do not carry the connected tool by pulling the hose. The hole must be far from any heating sources or from cutting parts.
- Keep the tools in good conditions; do not remove either safety parts or silencers.
- After repairing and/or adjusting, make sure you have already removed the adjusting spanners.
- Before disconnecting the compressed air hose from the tool make sure that there is no pressure in the hose.
- These instructions must be carefully followed.
- Do not use the riveting tool in the case of visible damage.

WARNING!
Before using the tool, assemble the protection bottom supplied with the tool, as indicated in the picture below.
FAR has no responsibility for any damages on the tool, persons or things caused by lack of the protection bottom.



TOOL IDENTIFICATION

The riveting tool **KJ 60** is identified from a marking that shows company name and address of manufacturer, designation of the tool, CE. Always refer to the information on the riveting tool when requesting technical service.



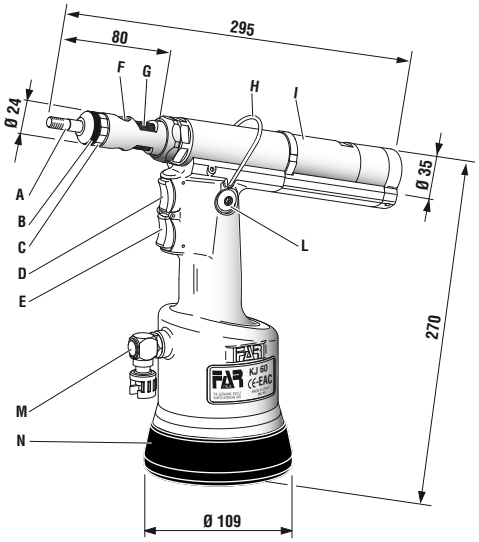
GENERAL NOTES AND USE

The tool can be employed only for blind rivet nuts with thread of **M3** ÷ **M8** diameter (**Inox M8 excluded**).

The **KJ 60** oil pneumatic system assures more power than the pneumatic system used for other models. That means a reduction in the problems due to the wear and tear of the components, therefore, there will be an increase in reliability. The technicai solutions adopted reduce the dimensions and the weight of the tooi which, for these reasons, make it very handy. The possibilities of leakage from the oil-dynamic system, are eliminated by some sealed gaskets, which solve this problem.

MAIN COMPONENTS

A) ..... Threaded tie rod
B) ..... Head
C) ..... Ring nut clamping head
D) ..... Tensile strength pushbutton
E) ..... Unscrewing pushbutton
F) ..... Insertion Pin Hole Dechucking clutch
G) ..... Regulation stroke ring nut
H) ..... Balancer connection
I) ..... Pneumatic motor
L) ..... Oil tank plug
M) ..... Compressed air connection
N) ..... Protection bottom



TECHNICAL DATA

- Working pressure ..... **6 BAR**
- Min. int. diam. of the compressed air feeding hose ..... **min. diam = 8 mm**
- Air consumption per cycle ..... **9 Nl**
- Max power ..... **6 BAR -13656 N**
- Weight ..... **2,200 Kg**
- Working temperature ..... **-5°/+50°C**
- Root mean square in total acceleration frequency (Ac) to which the arms are subjected. ..... **< 2.5 m/s²**
- A-weighted emission sound pressure level ..... **70 dBA**
- Peak C-weighted instantaneous sound pressure **<130 dBC**
- A-weighted sound power ..... **82 dBA**

AIR FEED

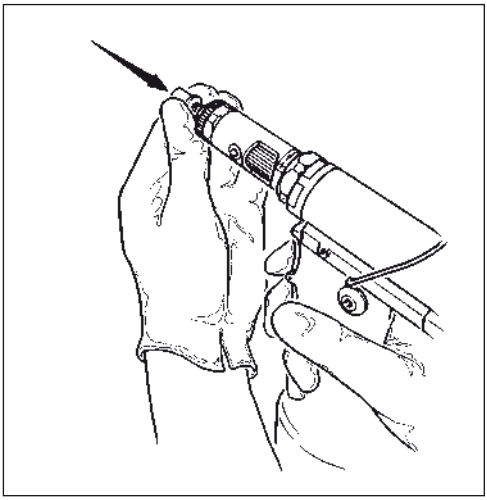
The air feed must be free from foreign bodies and humidity in order to protect the tool from premature wear and tear of the components in movement, therefore we suggest to use a lubrificator group for compressed air.

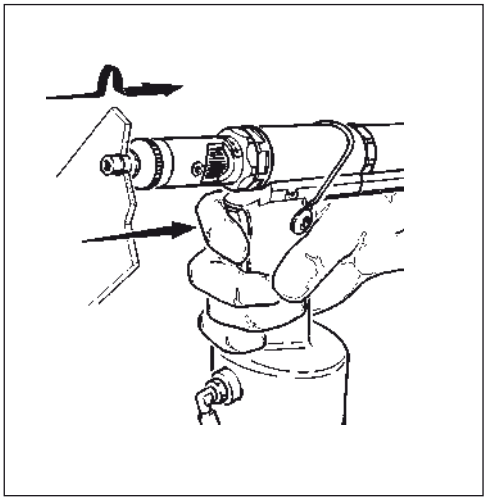
PLACING OF THE INSERT

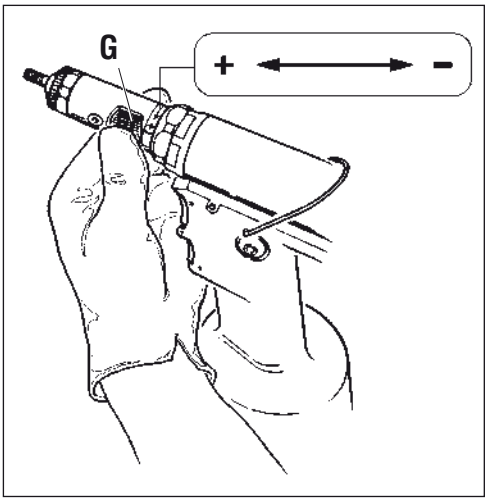
Make sure that the couple tie-rod/head mounted on your riveting tool is suitable for the insert to clamp; otherwise, change size accordingly. Usually the riveting tool is supplied with the couple tie-rod/head corresponding to a **M8** thread. Before using the riveting tool and after any change of size, perform the following operations according to the size and thickness of the part to clamp. Adjust the riveting tool stroke to the minimum by turning the ring nut "**G**" to "–" marked on the tool. Place the insert on the tie rod and push slightly on it so as to make it clamp automatically. Make sure the insert head touches the riveting tool head properly. Fasten the insert and in order to ensure a proper clamping of the material, adjust the riveting tool stroke by turning the ring nut "**G**" accordingly. By increasing stroke, i.e. by turning the ring nut "**G**" to "+", the distance "**h**" between head and insert deformation will decrease and clamping will result more effective.

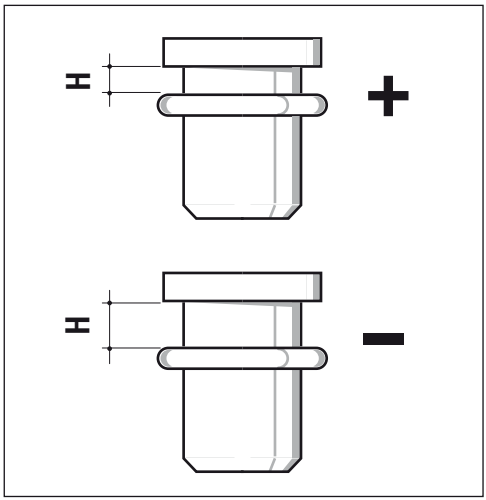
WARNING!!!

A wrong adjustment of the riveting tool stroke may cause a faulty clamping of inserts and may brake the tie rod!









CHANGE OF SIZE

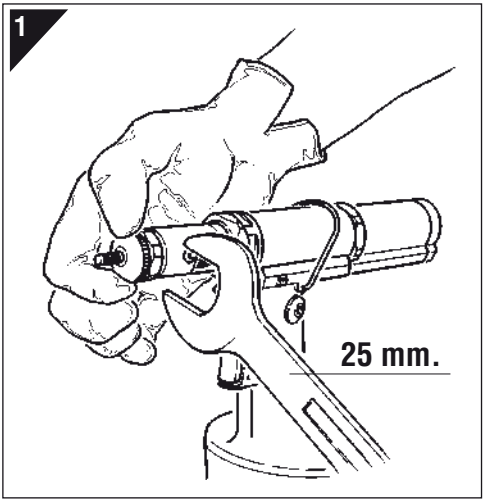
Depending on insert thread, it is necessary to replace the couple “tie-rod/head” as follows:

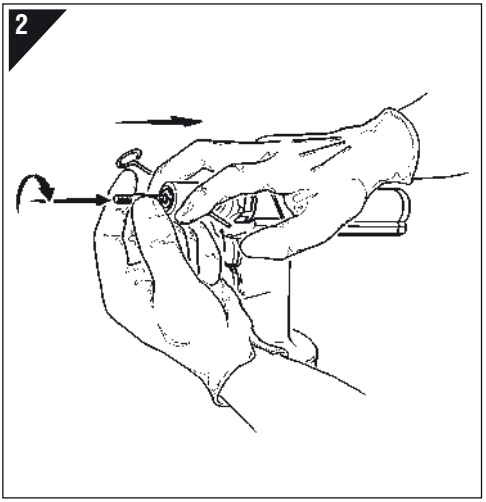
PICTURE 1. Loosen the ring nut by means of a 25-mm standard spanner and remove the riveting tool head.

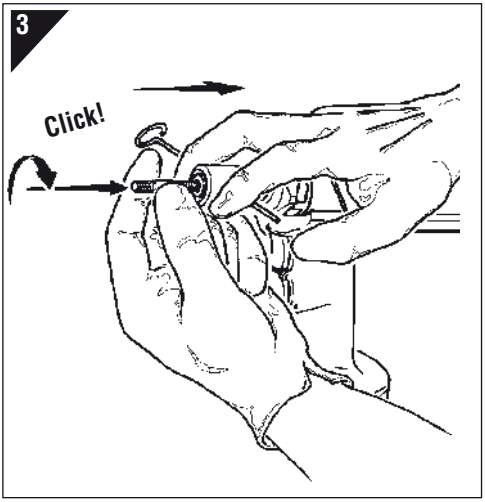
PICTURE 2. Make the pin supplied pass through the pertinent service hole located on the cone carrying head and apply a light pressure on the head inwards, in order to dechuck the tie rod clutch., at the same time, unscrew the tie rod and extract it.

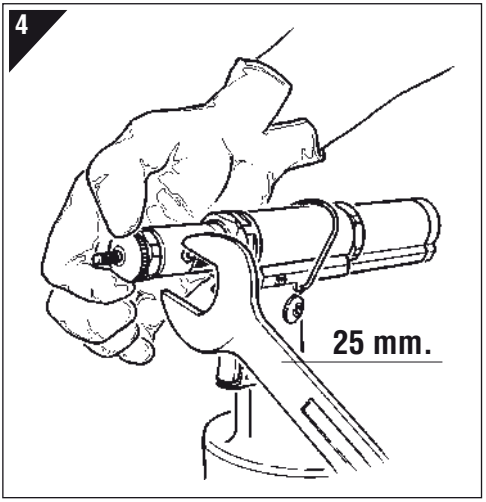
PICTURE 3-4. Keep the clutch dechucked and screw the tie rod size desired. When the replacement of the tie rod has been performed, swing it until you hear a click. Them assembly the proper head and lock it with the corresponding ring nut loosen before. Each time you carry out any change of size, repeat the adjustment operations as specified in the previous pages.

WARNING! Desconnect air feed when performing those operations.







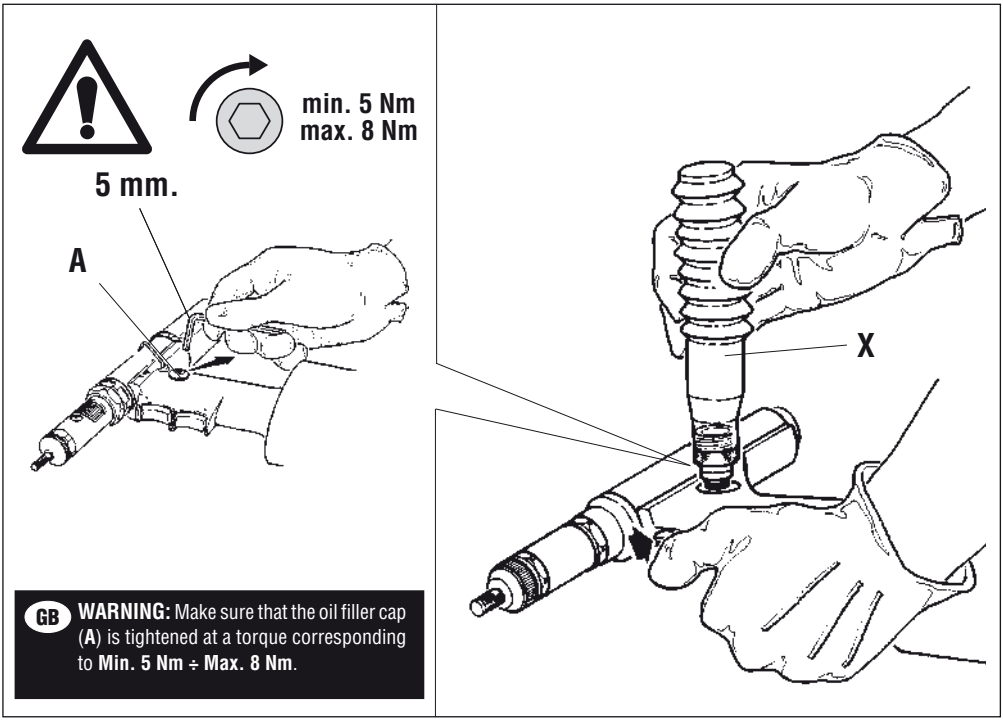


TOPPING UP THE OIL-DYNAMIC CIRCUIT

You need to top up the oil-dynamic circuit after a long period of work (15000 cycles), when you note a power loss. Put the riveting tool (**dwell and not fed**) in a horizontal position and remove the plug (**A**), by means of a 5 mm Allen wrench (equipped with the riveting tool); during this operation, check the oil level in order to avoid any overflowing. Then, slowly pour the oil **HLP 32 cSt** into the bellows container (**X**) which shall be screwed to its seat on the plug (**A**). While keeping the riveting tool in a horizontal position and starting air feeding, push the tensile strength button and make the riveting tool carry out some cycles until air bubbles inside the container (**X**) stop coming out. This condition indicates that the topping up of the oil has fully been achieved. At this point **stop the air feeding** and, while keeping the riveting tool in a horizontal position, unscrew and close up the container (**X**) and the plug (**A**).

WARNING: it is very important to follow the about mentioned instructions and use gloves. If you need to empty fully the hydraulic circuit, you must put the oil in a suitable container and contact a Company that is authorized to discharge any waste

WARNING! Before disconnecting the compressed air hose, make sure that it is not under pressure!
We recommend to use oil **HLP 32 cSt** or similars.



GB **WARNING:** Make sure that the oil filler cap (**A**) is tightened at a torque corresponding to **Min. 5 Nm ÷ Max. 8 Nm**.

DISPOSAL OF THE RIVETING TOOL

Follow the prescriptions of the national laws for disposing of the riveting tool.
After disconnecting the tool from the pneumatic system, disassemble and split all the components according to the material: steel, aluminium, plastic material, etc.
Then proceed to scrap the materials in accordance with current laws.

SPARE PARTS

No.	CODE	Q.ty	DESCRIPTION	KIT
01	721779	1	Riveting tool body	
02	712269	1	Body cover	
03	711684	1	Cylinder bottom plate	
04	721685	1	Pneumatic piston	
05	711780	1	Connector	
06	721689	1	Hydraulic cylinder	
07	711781	1	Rod	
08	711691	1	Silencer	
09	711692	1	Screw TE M7 x 18	
10	711782	1	Shock absorber	
11	711694	1	Lower valve	
12	711695	1	Threaded sleeve	
13	721698	1	Valve body	
14	711700	1	Upper valve	
15	711701	1	Upper valve body	
16A	711702	1	Plate	A
17	711703	2	Valve body	
18	711704	2	Valve piston	
19	710839	1	Oil tank plug	
20D	711705	2	Push-button	D
21B	711713	1	Spacer	B
22	710854	1	Balancer hook	
23	721387	1	Oil container	
24	711783	1	Motor cover	
25	72A00126	1	Pneumatic Motor F002	
26	711785	1	Motor protection sector	
27	711786	1	Ring nut	
28	711787	1	Stop ring	
29	712670	1	Clutch	
30	711790	1	Spring	
31	711791	1	Spring	
32E	711792	1	Ball bushing	E
33	712270	1	Rod	
34	711794	1	Hydraulic piston	
35	711795	1	Front connector	
36	711796	1	Shaft	
37	711797	1	Milled sleeve	
38	711798	1	Stroke adjusting ring nut	
39	711799	1	Stroke-adjusting knob	
40C	711800	1	Spring	C
41	711801	1	Sleeve carrying tie rod	
42C	711802	1	Tie rod clutch	C
43	711803	1	Ring nut	
44	711804	1	Ring nut	
45	711805	1	Head M 3	
46	711806	1	Head M 4	
47	711807	1	Head M 5	
48	711808	1	Head M 6	
49	711809	1	Head M 8	
50	711810	1	Tie rod M 3	
51	711811	1	Tie rod M 4	
52	711812	1	Tie rod M 5	
53	711813	1	Tie rod M 6	
54	711814	1	Tie rod M 8	
55	710876	1	Tie rod release pin	
56	710906	1	Washer 400-020-4490	
59D	711726	3	Dowel pin ø 2 x 20 UNI 1707	D
60C	710537	1	Spring pin ø 4 x 12 UNI 6873	C
61	711815	2	Ball ø 3,5	
62	710911	4	Ball ø 4	
63E	711816	3	Ball ø 2,5	E
64	711817	1	Seeger ring 18 UNI 7437	
65B	710902	1	Seeger ring 16 UNI 7435	B
66	711818	1	Seeger ring SW 11	
67	711821	1	Seeger ring JV 20	
68	711721	1	Gasket B-110078-B / NEO	
69	711722	1	Gasket B-094063-B / NEI	
70	711819	1	Gasket B-070039 / 1	
71	711820	1	Gasket TS-10-18-5,8 / L	
72A	711727	1	Screw TSCE M4 x 8 UNI 5933	A
73	712037	2	Inox filter ø 6 x 4	
74	711092	1	Wrench 5 mm	
75	711728	2	Gasket OR 2-016	
76	711730	1	Gasket OR 2-119	
77	710367	1	Gasket OR 2-008	
78	710376	2	Gasket OR 2-009	
79	710918	2	Gasket OR 2-005	
80	710919	2	Gasket OR 2-004	
81	710003	2	Gasket OR 5-052	
82	710342	2	Gasket OR 2-017	
83	710594	1	Gasket OR 2-012	
84	711061	1	Gasket OR 5-614	
85	711731	1	Gasket OR 2-018	
86	711732	1	Gasket OR 2-118	
87	710258	3	Gasket OR 5-612	
88	711734	1	Gasket OR 2-232	
89	711735	1	Gasket OR 2-040	
90	711834	2	Silencer	
91	711917	1	Ring Parbak 8-119	
92B	711933	1	Seeger ring JV 24	B
95	712159	1	Protection bottom	
96	722047	1	Safety valve assembly	
97	712153	1	Spring	
98	712132	1	Rotating connector	
99E	713341	1	Gasket OR 1 x 4	E

KIT	It indicates that the part is sold in kits consisting of different parts in different quantities.

SPARE PARTS

KIT			
N°	**COD.**	**Qt.**	**DESCRIZIONE**
KITA	**741702**		**Plate kit**
16A	711702	2	Plate
72A	711727	2	Screw TSCE M4 x 8 UNI 5933
KITB	**741713**		**Spacer Kit**
21B	711713	1	Spacer
65B	710902	1	Seeger ring 16 UNI 7435
92B	711933	1	Seeger ring JV 24
KITC	**741802**		**Tie rod clutch kit**
40C	711800	1	Spring
42C	711802	1	Tie rod clutch
60C	710537	1	Spring pin ø 4 x 12 UNI 6873
KITD	**741705**		**Push-button Kit**
20D	711705	2	Push-button
59D	711726	3	Dowel pin ø 2 x 20 UNI 1707
KITE	**741792**		**Ball bushing kit**
32E	711792	1	Ball bushing
63E	711816	3	Ball ø 2,5
99E	713341	1	Gasket OR 1 x 4
KITF	**74000043**		**Tie rod container kit**

KIT	It indicates that the part is sold in kits consisting of different parts in different quantities.

F002				
N°	**COD.**	**Qt.**	**DESCRIZIONE**	**KIT**
01	**71345169**	**1**	Connector	
02	**71C00764**	**1**	Bearing 61801	
03	**71345646**	**1**	Gear cage	
04	**71345644**	**3**	Planetary gear	
05	**71345643**	**1**	Crown gear	
06	**71345642**	**1**	Washer	
07	**71C00763**	**1**	Bearing AY7-ZZ	
08	**71345640**	**1**	Connector	
09	**71C00761**	**2**	Spring pin ø 1,5 x 10 UNI 6875	
10	**71345639**	**5**	Vane	
11	**71345638**	**1**	Rotor	
12	**71345637**	**1**	Outside body	
13	**71345641**	**1**	Back cap	
14	**713037**	**1**	Pin ø 2 x 9,8	
15	**71C00762**	**1**	Bearing 695-ZZ	
16	**710376**	**2**	Gasket OR 2-009	
17	**71C00529**	**1**	Gasket XR 008 PP180 B	
18	**720025**	**1**	Motor driving rod	
19	**711869**	**1**	Spring	
20	**711865**	**1**	Cap	
21H	**71345175**	**1**	Left spear valve	H
22H	**71345174**	**1**	Right spear valve	H
A	**72A00126**		Pneumatic Motor F002	

KIT			
KITG	**74000051**		**Body motor kit**
KITH	**74000074**		**Spear valve group**
21H	71345175	1	Left spear valve
22H	71345174	1	Right spear valve

KIT	It indicates that the part is sold in kits consisting of different parts in different quantities.

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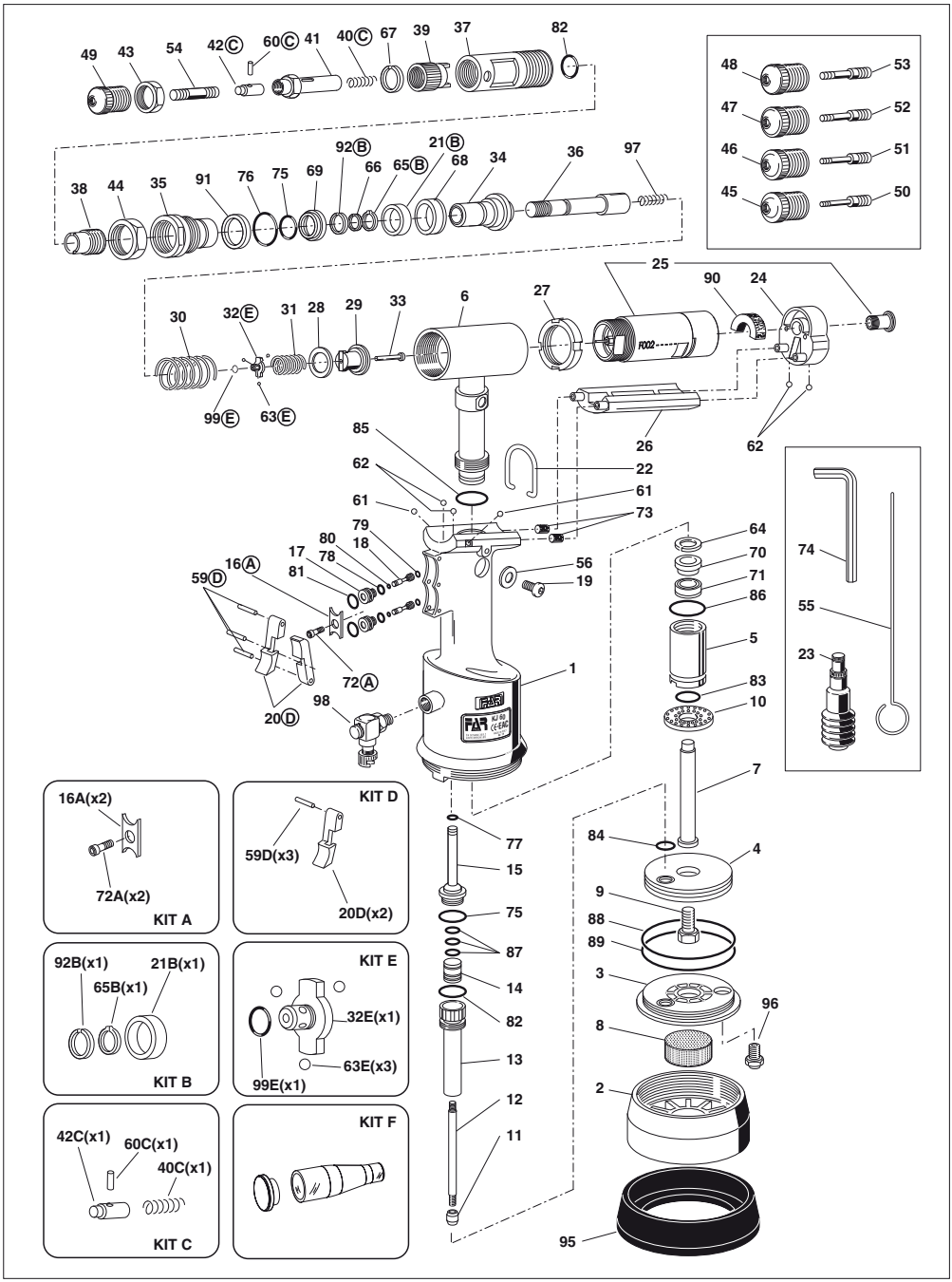
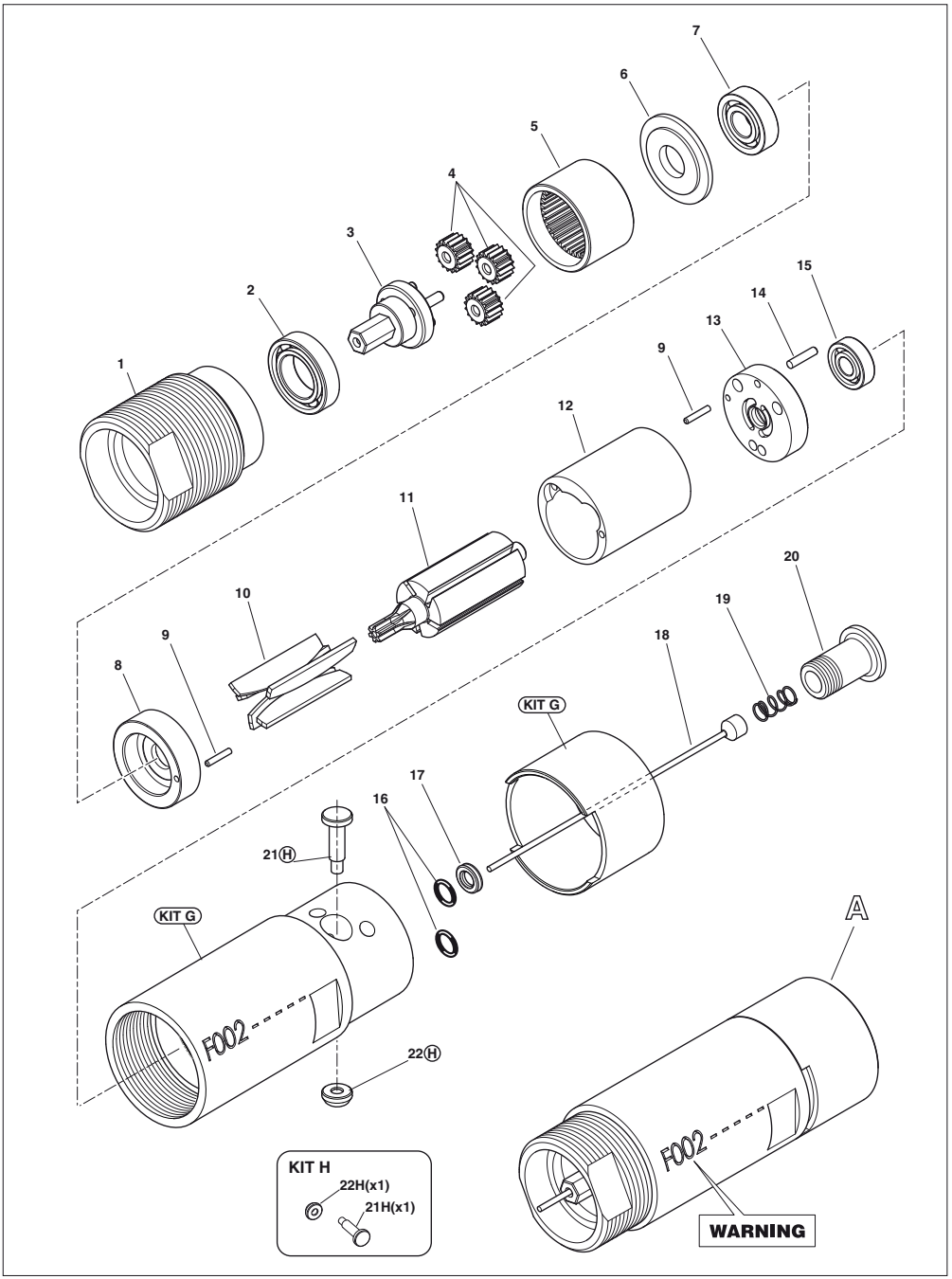
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