

I - **ISTRUZIONI ORIGINALI**
RIVETTATRICE OLEOPNEUMATICA
PER INSERTI M3/M12
ISTRUZIONI D'USO - PARTI DI RICAMBIO



GB - **TRANSLATION OF ORIGINAL INSTRUCTIONS**
HYDROPNEUMATIC RIVETING TOOL
FOR INSERTS M3/M12
INSTRUCTIONS FOR USE - SPARE PARTS

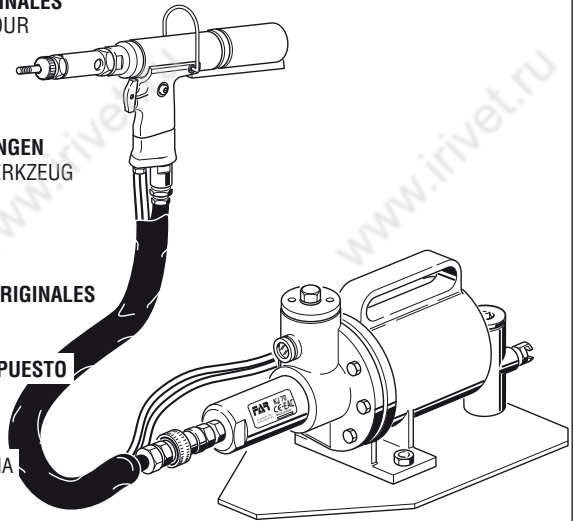
F - **TRADUCTION DES INSTRUCTIONS ORIGINALES**
OUTIL À RIVETER OLÉOPNEUMATIQUE POUR
ÉCROUS À SERTIR M3/M12
MODE D'EMPLOI - PIÈCES DÉTACHÉES

D - **ÜBERSETZUNG VON ORIGINALANLEITUNGEN**
PNEUMATISCH-HYDRAULISCHES NIETWERKZEUG
FÜR BLINDNIETMUTTERN M3/M12
BEDIENUNGSANLEITUNG - ERSATZTEILE

E - **TRADUCCION DE LAS ISTRUCCIONES ORIGINALES**
REMACHADORA OLEONEUMATICA
PARA INSERTOS M3/M12
ISTRUCCIONES DE USO - PIEZAS DE REPUESTO

PL - **TŁUMACZENIE ORYGINALNEJ INSTRUKCJI**
NITOWNICA PNEUMATYCZNO-HYDRAULICZNA
DO NITONAKRĘTEK M3-M12
INSTRUKCJA OBSŁUGI - CZĘŚCI ZAMIENNE

RUS - **ПЕРЕВОД ОРИГИНАЛЬНЫХ ИНСТРУКЦИЙ**
ГИДРОПНЕВМАТИЧЕСКИЙ ИНСТРУМЕНТ
ДЛЯ ВСТАВОК М3-М12
ИНСТРУКЦИИ ПО ЭКСПЛУАТАЦИИ - ЗАПАСНЫЕ ЧАСТИ
• ДАТА ПРОИЗВОДСТВА УКАЗАНА В «ТЕХНИЧЕСКОМ ПАСПОРТЕ»



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 "KJ 70 Rivettatrice oleopneumatica per inserti filettati M3-M12 con Booster di potenza separato dal corpo rivettatrice" numero di serie: vedi retro copertina, alla quale questa dichiarazione si riferisce è conforme ai requisiti essenziali di sicurezza previsti dal 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 responsibility that the riveting machine "KJ 70 Hydropneumatic tool for blind rivet nuts M3-M12 Tool body separated from the intensifier" serial number: see back cover, which is the object of this declaration complies with the basic safety requirements established in the law decree Leg. D. 17/2010 of 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 "KJ 70 Machine à sertir oleopneumatique pour inserts filetés M3-M12 Corps du pistolet séparé du booster" 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 "KJ 70 Hydraulisch-pneumatisches Nietwerkzeug für Blindnietmuttern M3-M12 Werkzeugkörper vom Verstärker getrennt" 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., domiciliata in Quarto Inferiore (BO) in via Giovanni XXIII n° 2,

DECLARA

bajo su exclusiva responsabilidad que la remachadora "KJ 70 Remachadora oleoneumática para remaches roscados M3-M12 Booster de potencia separado dal cuerpo de la remachadora" 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. Ley 17/2010 de recepción de la Directiva Maquinas 2006/42/CE y sucesivas modificaciones e integraciones y CU TR 010/2011. La persona autorizada a constituir el fascículo técnico es Massimo Generali, cerca FAR S.r.l., con sede a Quarto Inferiore (BO) – Via Giovanni XXIII n.2.

PL Niżej podpisana firma Far S.r.l., z siedzibą w Quarto Inferiore (BO), via Giovanni XXIII n. 2,

OŚWIADCZA

na własną i wyłączną odpowiedzialność, że nitownica, „KJ 70 Nitownica hydrauliczno-pneumatyczna do nitonakrętek gwintowanych M3-M12 z busterem mocy oddzielonym od korpusu nitownicy”, numer seryjny: patrz tylna okładka, do której odnosi się niniejsza deklaracja, jest zgodna z wymogami bezpieczeństwa przewidzianymi przez dekret legislacyjny 17/2010 implementujący Dyrektywę Maszynową 2006/42/WE wraz z późniejszymi zmianami i uzupełnieniami i CU TR 010/2011.

Osobą upoważnioną do utworzenia dokumentacji technicznej jest Massimo Generali z firmy Far S.r.l. mającej siedzibę w Quarto Inferiore (BO), via Giovanni XXIII nr. 2.


RUS Нижеподписавший представитель компании Far S.r.l., расположенной в Quarto Inferiore (провинция города Болонья) по адресу: улица Джованни XXIII, д.2

ЗАВЯЛЯЕТ

под свою исключительную ответственность, что заклепочник "KJ 70 Масляно-пневматический заклепочник для установки резьбовых заклепок M3-M12 с усилителем мощности, отделенным от корпуса заклепочника, 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 Quarto Inferiore (провинция города Болонья) по адресу: улица Джованни XXIII, д.2, является Джакомо Дженерали (Massimo Generali),

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 Zarządu)
(Председатель Административного Совета)

FAR

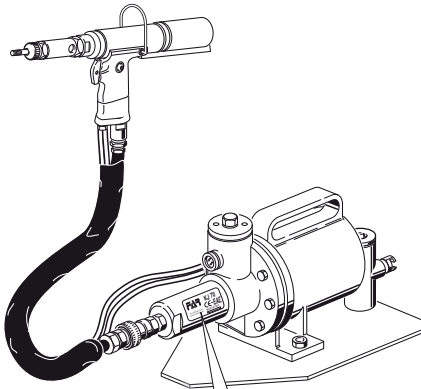
BOLOGNA
ITALY

KJ 70

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TOOL IDENTIFICATION

The riveting tool **KJ 70** 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.



Company name and address

Designation of the tool



Serial number

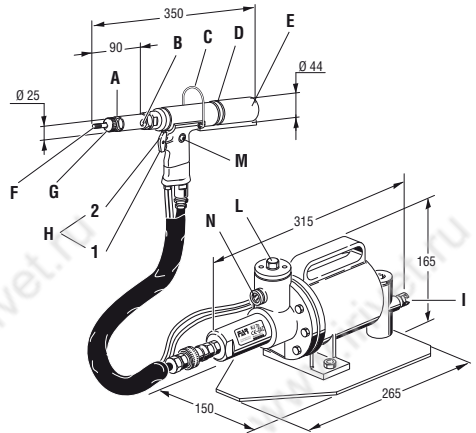
GENERAL NOTES AND USE

The tool can be employed only for blind rivet nuts with thread of **M3 ÷ M12** diameter.

The **KJ 70** 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 technical solutions adopted reduce the dimensions and the weight of the tool 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) Ring nut clamping head
- B) Insertion Pin Hole Dechucking clutch
- C) Balancer connection
- D) Ring nut adjustment stroke
- E) Pneumatic motor
- F) Threaded tie rod
- G) Head
- H) Drive trigger: Pos. 1 Tiraction - Pos. 2 Unscrewing
- I) Compressed air connection
- L) Oil filler plug
- M) Service plug
- N) Oil level indicator



TECHNICAL DATA

- Working pressure **6 BAR**
- Min. int. diam. of the compressed air feeding hose **min. diam = 8 mm**
- Air consumption per cycle **10,4 NI**
- Max power **6 BAR -13656 N**

WEIGHT:

- Gun **2,050 Kg**
- Total **6,850 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 **78 dBA**
- Peak C-weighted instantaneous sound pressure **<130 dBC**
- A-weighted sound power **90 dBA**

AIR FEED

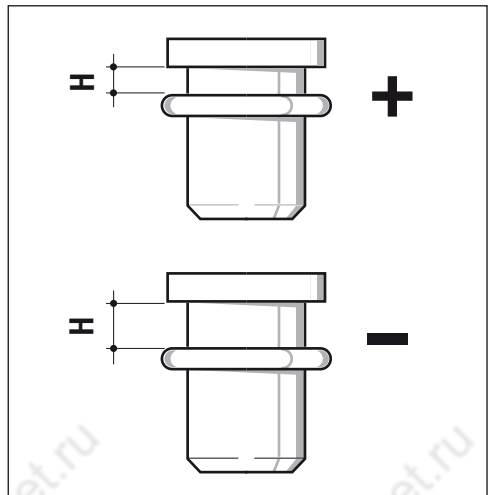
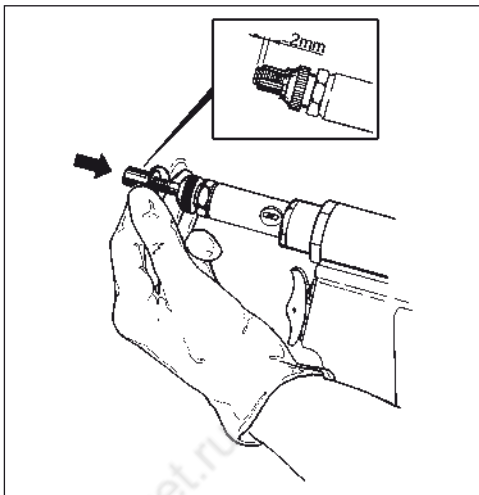
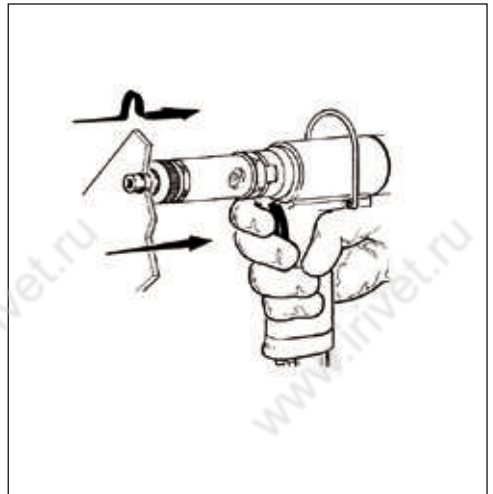
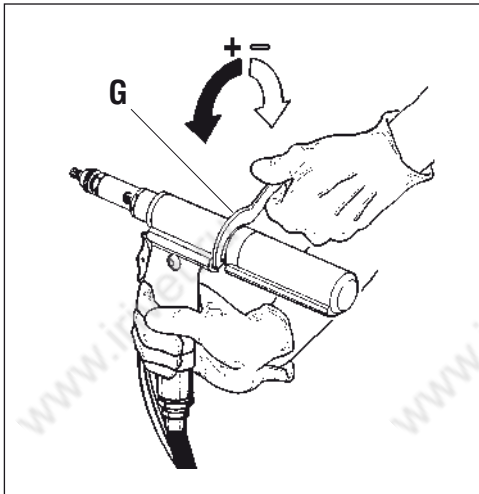
The air feed must be free from foreign bodies and humidity in order to protect the tool from premature wear and tear of the components in movement, therefore we suggest to use a lubricator group for compressed air.

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 **M 10** 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. Plug in the notches of the regulation stroke ring nut the special key (issued). 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:

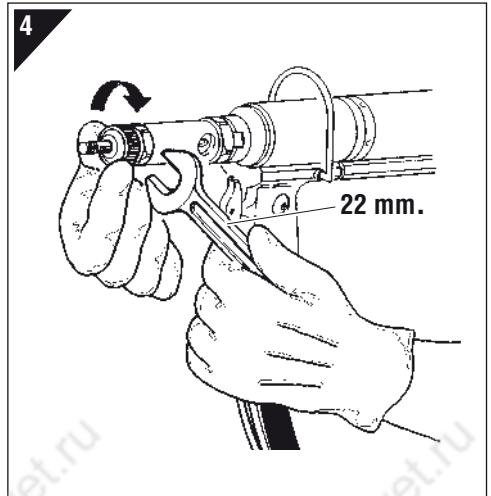
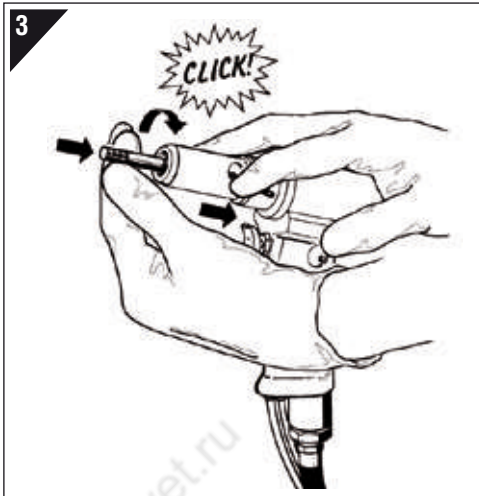
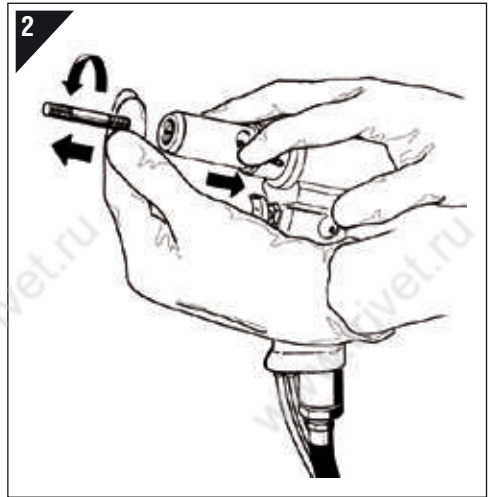
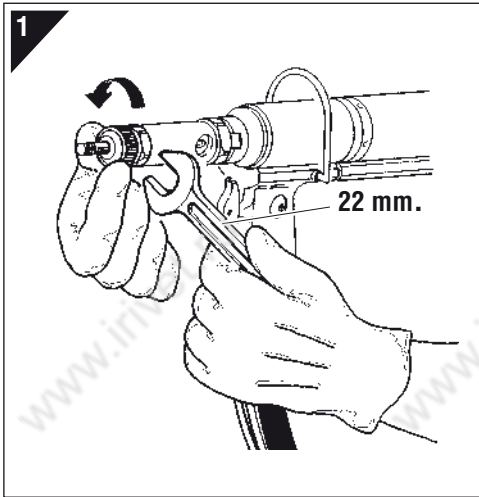
PICTURE 1. Loosen the ring nut by means of a 22-mm standard spanner and remove the riveting tool head.

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. Then 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

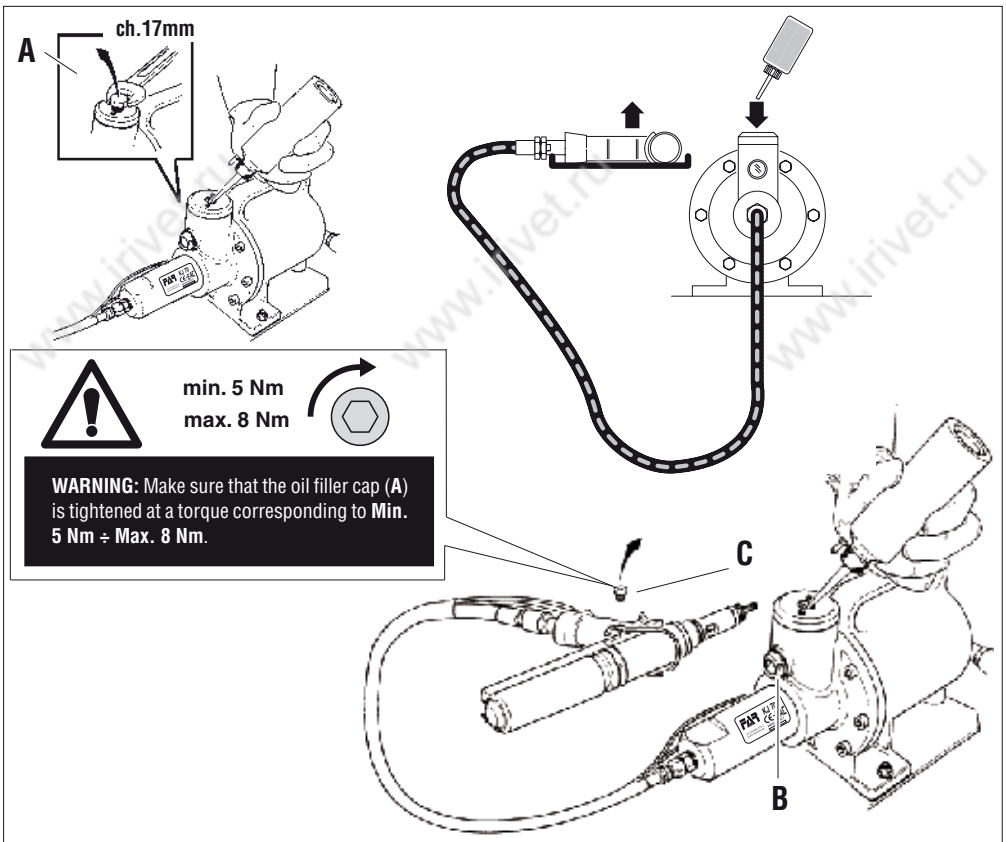
Verify periodically (15000 cycles), that the oil level does not go below 3/4 of the limit indicated by the proper indicator (B). Whether you need to top up the circuit, remove the plug (A) by means of a 17-mm wrench, then pour hydraulic oil, **HLP 32 CST**, until it reaches the border of the threaded hole.

WARNING! If you fail to perform this operation, you will note power loss that will lead to jeopardise the proper working of the tool. Therefore, you need to get rid of the air from the tool and restore the exact oil level in the oil-dynamic circuit.

Proceed as follows: put the riveting gun inside a container, in order to avoid loosing oil, and put the upper side of the booster on the same level of the gun/and lay the feed hoses as the picture shows. Remove the oil screw cap (A) and the service plug (C) by using a 17-mm wrench and a 5-mm allen wrench respectively. Pour oil **HLP 32 CST** until it flows from the hole, without plug (C), completely free from air bubbles. When the operation has been carried out, replace the plug (C) and make sure that oil has reached the border of the threaded hole. Screw the screw cap (A) and clean carefully the riveting tool from overflowed oil. It is very important to apply carefully to the instructions and use always gloves when you handle the tool. Overflowed oil, during the topping, must be collected in proper containers and delivered afterwards, to specialized waste oil gettingher company. Do not smash or cut the connecting hoses between gun and booster.



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.



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

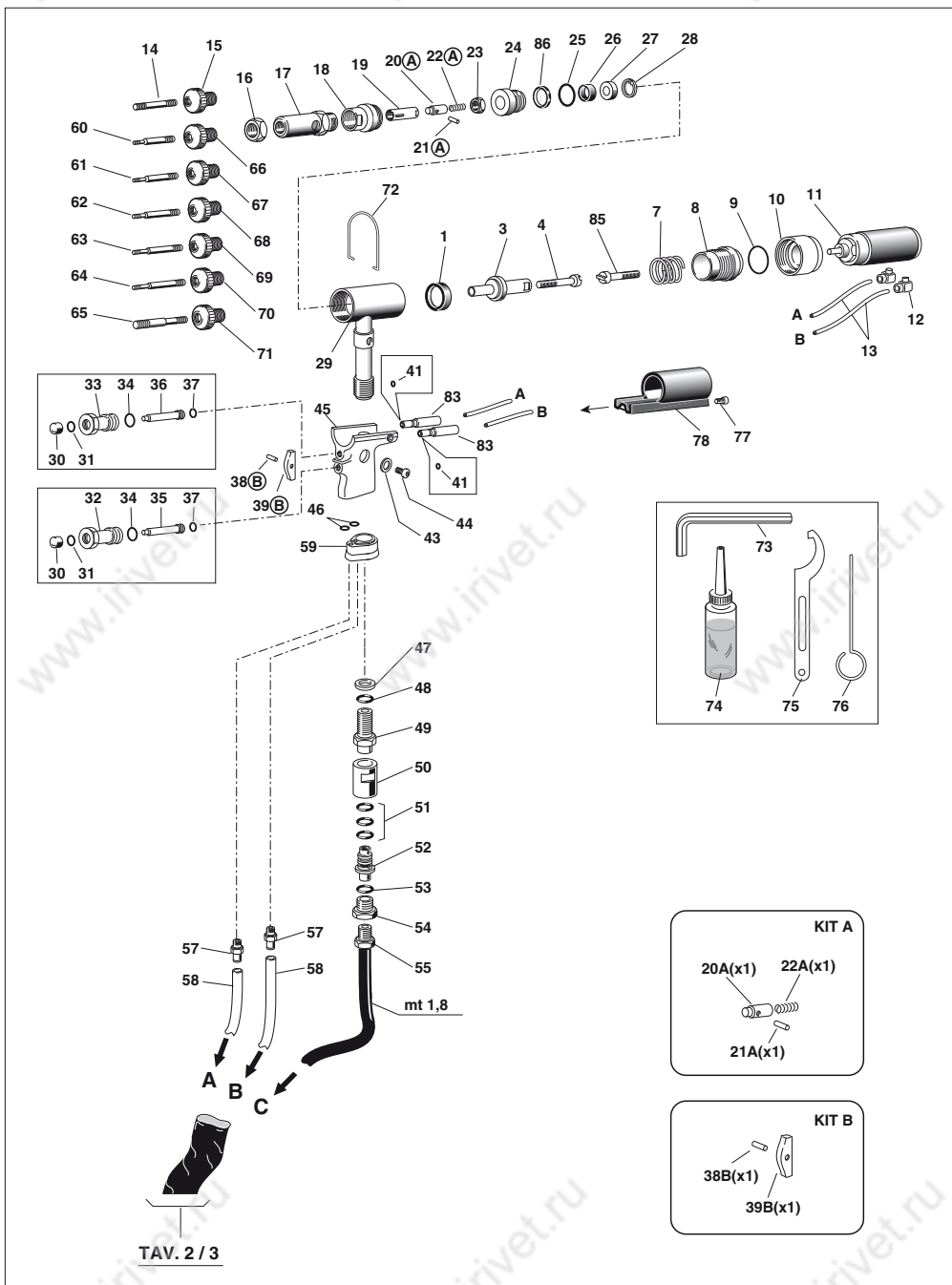
Tab. 2/3

No.	CODE	Q.ty	DESCRIPTION	KIT
01	711824	1	Connector NV 1/4" NPT-M	
02	711823	1	Connector NV 1/4" NPT-F	
03	711825	1	Connector NPT 1300	
04	711662	1	Oil level HFE.9	
05	710375	2	Gasket OR 2-131	
06	711660	1	Cap	
07	711663	1	Cap 2611-1/4"	
08	710211	6	Screw TCCE M6 x 14 UNI 5931	
09	711656	1	Cylinder head	
10	711664	1	Gasket OR 2-237	
11	711658	1	Booster sleeve	
13	711053	1	Stop ring	
14	711066	1	Ring Sealing RSS 12-20	
15	711050	1	Sleeving gasket	
16C	710572	1	Gasket OR 2-120	C
17C	711661	1	Gasket OR 2-135	C
18C	711065	1	Ring Sealing WRI 12	C
19	711827	1	Gasket TTS-12-19-5.7 / L	
20	711657	1	Rod guide	
21	710931	1	Gasket OR 614	
22D	710829	1	Shock absorber	D
23	711659	1	Rod	
24D	710923	1	Gasket OR 012	D
25	711678	1	Pneumatic piston	
26D	710912	1	Nut M 10 x 6	D
27	711679	1	Gasket OR 2-339	
28	711655	1	Cylinder	
29E	711829	2	Screw TSCE M6 x 20 UNI 5933	E
30	711828	1	Foot	
31E	710623	2	Nut M 6 UNI 7473	E
32	710173	1	Milled nut connector 1/4"	
33	712061	1	Washer	
34F	710840	1	Valve spacer	F
35F	710921	3	Gasket OR 2-115	F
36F	710823	3	Cage	F
37F	711158	1	Spring	F
38	710841	1	Valve	
39	710916	1	Gasket OR 2-015	
40	710528	1	Gasket OR 008	
41	710822	1	Valve piston	
42	710258	1	Gasket OR 5-612	
43	710905	1	Seeger ring 11 UNI 7437	
44	710922	2	Gasket OR 018	
45	712268	1	Spring guide plug	
46	711665	1	Valve cap	
47	711085	1	Silencer SPL 3/8"	
48	711068	2	Connector 6520 - ø 5 - 1/8"	
49	711826	1	Connector 2020 - 1/4"	
50	711121	1	Reduction 2521-1/4"-3/8"	
51	712160	1	Sheath	
52	712050	1	Screw STCE M8 x 8 UNI 5923	

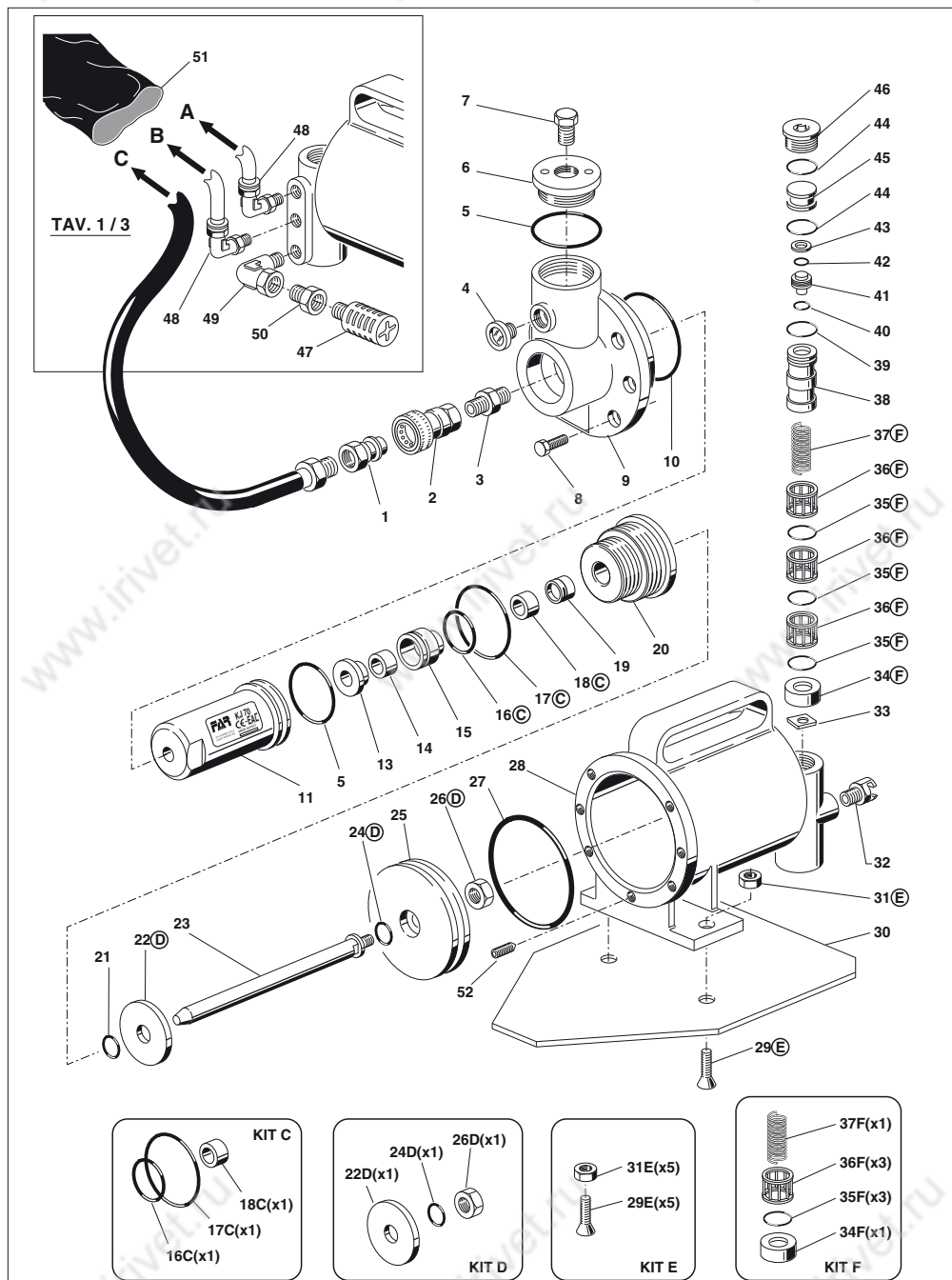
Tab. 2/3

KIT				
No.	CODE	Q.ty	DESCRIPTION	
KITC	741065		Gaskets kit	
16C	710572	1	Gasket OR 2-120	
17C	711661	1	Gasket OR 2-135	
18C	711065	1	Ring Sealing WRI 12	
KITD	740829		Dampener kit	
22D	710829	1	Shock absorber	
24D	710923	1	Gasket OR 012	
26D	710912	1	Nut M 10 x 6	
KITE	741829		Screw M 6 kit	
29E	711829	5	Screw TSCE M6 x 20 UNI 5933	
31E	710623	5	Nut M 6 UNI 7473	
KITF	740840		Valve spacer kit	
34F	710840	1	Valve spacer	
35F	710921	3	Gasket OR 2-115	
36F	710823	3	Cage	
37F	711158	1	Spring	
KIT		It indicates that the part is sold in kits consisting of different parts in different quantities.		
Tab. 3/3				
No.	CODE	Q.ty	DESCRIPTION	
01	711218	1	Rod	
02	711529	1	Ring nut	
03	712124	1	Gear cage	
04	710949	1	Nut	
05	710947	1	Bearing 608-2Z	
06	712123	3	Planetary gear	
07	711477	1	Crown gear	
08	711530	1	Spacer	
09	711531	1	Outside body	
10	710037	1	Bearing 609-2Z	
11	711524	1	Front cap	
12	711474	6	Vane	
13	712125	1	Rotor	
14	711476	1	Stator	
15	711525	1	Back cap	
16	710071	1	Bearing 625-2Z	
17	710944	1	Roll pin	
18	721496	2	Connector	
19	711532	1	Screw STCE M5 x 5 UNI 5923	
20	710772	1	Gasket OR 2-007	
21	711235	1	Ball ø 7	
22	711473	1	Spring	
23	711498	1	Cap	
24	711485	1	Baffle	
A	712122		Pneumatic Motor SP-326	

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