

TAURUS® 1-4

DE Pneumatisch-hydraulisches Blindniet-Setzgerät
Betriebsanleitung mit Ersatzteilliste

GB Hydropneumatic blind rivet setting tool
Operating manual with spare parts list

FR Outil oléopneumatique pour pose de rivets aveugles
Mode d'emploi avec liste de pièces de rechange

ES Remachadora neumática
Manual de instrucciones con lista de repuestos

IT Rivettatrice pneumo-idraulica
Manuale per l'uso e la manutenzione ed elenco parti di ricambio

NL Pneumatisch-hydraulisch blindklinkpistool
Bedienings- en onderhoudshandleiding met onderdelenlijst

DK Pneumatisk hydraulisk blindniet-apparat
Betjeningsvejledning med reservedelsliste

SE Pneumatisk-hydraulisk blindnietpistol
Bruksanvisning med reservdelslista

NO Pneumatisk hydraulisk blindnietapparat
Bruksanvisning med reservedelliste

FI Pneumaattis-hydraulinen vetoniittityökalu
Käyttöohje ja varaosaluettelo

PT Rebiteadeira pneumática-hidráulica para rebites cegos
Instrução de serviço com lista de peças de reposição

CZ Pneumatiko-hydraulické nýtovací nářadí pro trhací nýty
Návod k obsluze se seznamem náhradních dílů

GR Πνευματική-υδραυλική συσκευή τοποθέτησης τυφλών πριτσινιών
Οδηγός χρήσης με λίστα ανταλλακτικών

HU Pneumatikus-hidraulikus szegecshúzó szerszám
Üzemeltetési utasítás, alkatrészlistával

PL Nitownica pneumatyczno-hydrauliczna do nitów jednostronnie zamykanych
Instrukcja obsługi wraz ze spisem czze, sci zamiennych

CN 气动液压式抽芯铆钉枪
操作说明书及备件目录

RU Пневмогидравлический заклепочник для установки вытяжных заклепок
Инструкция по эксплуатации и ведомость запчастей



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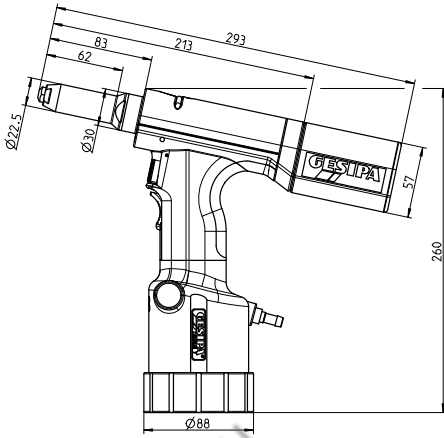
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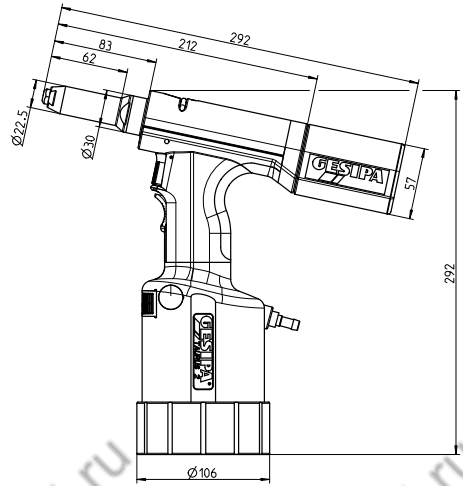


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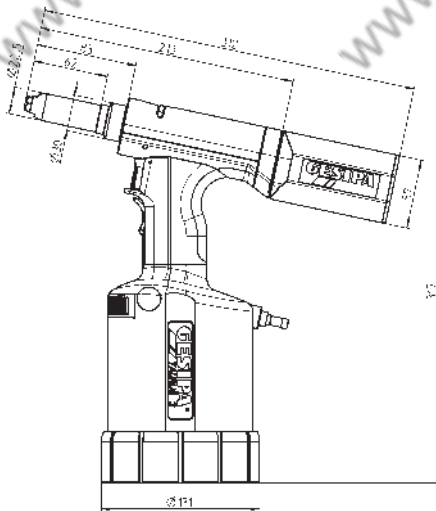
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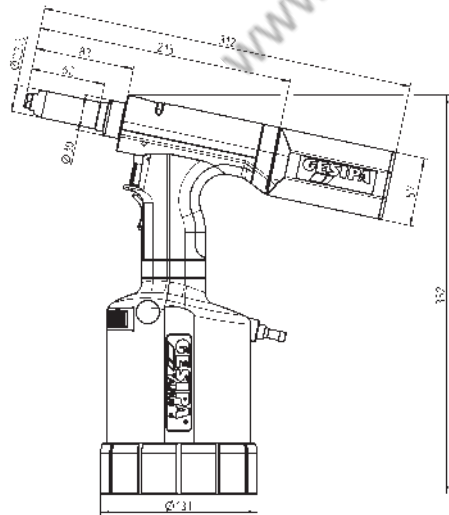
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TAURUS® 3



TAURUS® 4



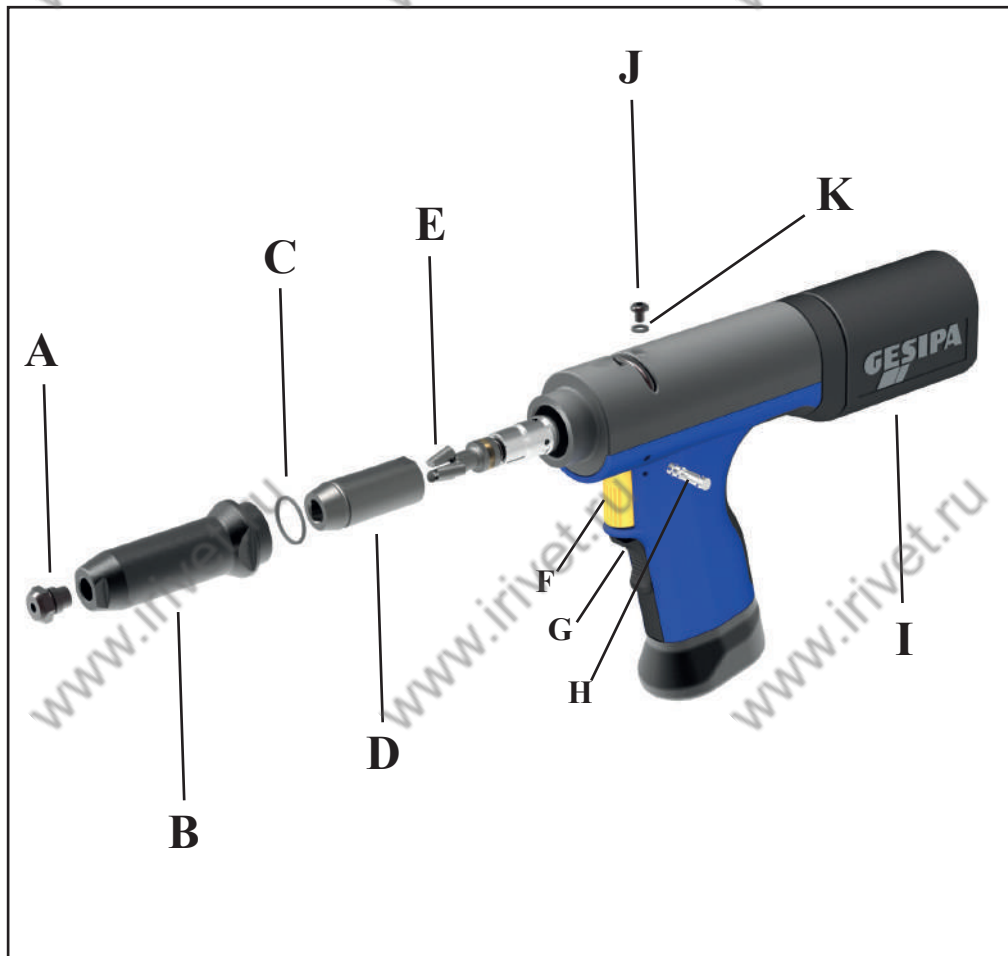


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1. Overview

A	Nosepiece
B	Steel head sleeve
C	O-ring
D	Chuck housing
E	Jaws
F	Trigger
G	Slide
H	Control slide valve
I	Spent mandrel container
J	Oil filler plug
K	Seal

2. Use for intended purpose

As described in these operating instructions, the blind rivet setting tool may only be used for the purpose of setting blind rivets. **Observe the safety information!**

3. Safety information

- The blind rivet setting tool is to be used solely for the purpose of setting blind rivets.
- Never overload the blind rivet setting tool; work within the specified working capacity.
- Do not use tool without material. The blind rivet could be flung from the blind rivet setting tool. Never turn the blind rivet setting tool towards yourself or towards other people.
- The spent mandrel container must remain mounted on the blind rivet setting tool during operation.
- The spent mandrel container must be emptied in good time; overfilling will cause the blind rivet setting tool to malfunction.
- Never use the blind rivet setting tool as a hammer.
- Regularly check the compressed air lines to ensure they are fitted correctly and airtight.
- The blind rivet setting tool should always be disconnected from the compressed air system when carrying out maintenance work and when the tool is not in use.
- Always wear protective goggles when working with the blind rivet setting tool. Personal protective equipment such as protective clothing, gloves, safety helmet, non-slip footwear, ear protection and fall arresting device is recommended.
- Do not exceed the permitted working pressure.
- When putting down the blind rivet setting tool, make sure that it cannot fall.
- Repairs must be carried out only by skilled personnel. In case of doubt, always send in the complete (not disassembled) blind rivet setting tool to the supplier or to GESIPA®.
- Dispose of the used hydraulic oil in accordance with valid environmental protection regulations.

4. Working range

Tool type	TAURUS® 1	TAURUS® 2	TAURUS® 3	TAURUS® 4
Standard blind rivet Ø (mm)	2.4 - 3.2	up to 5	up to 6.4	up to 6.4
	All materials			
	up to 4 Al/steel	up to 6 Al/steel	-	up to 8 Al
Max. mandrel Ø (mm)	2.5	3.2	4.5	4.5

5. Technical data

Tool type	TAURUS® 1	TAURUS® 2	TAURUS® 3	TAURUS® 4
Weight (kg)	1.3	1.6	1.9	2.0
Operating pressure (bar)	5-7	5-7	5-7	5-7
Stroke (mm)	15	18	25	19
Hose connection Ø (1/4") (mm)	6	6	6	6
Volume of spent mandrel container	approx. 100 to 200 depending on size			
Air consumption (sl/rivet)	approx. 1.0	approx. 2.3	approx. 4.8	approx. 4.8
Setting force at 6 bar (N)	5,500	11,000	18,000	23,000
Hydraulic oil, Renolin Eterna 32 (ml)	approx. 30	approx. 30	approx. 30	approx. 30
Noise emission Lpa Measurement uncertainty k = 3 dB (dB)	77	78	79	79
Vibration (m/s ²) Measurement uncertainty k = 1.5 m/s ²	< 2.5	< 2.5	< 2.5	< 2.5
Compressed air quality according to ISO 8573- 1	Class 1.4.2	Class 1.4.2	Class 1.4.2	Class 1.4.2
Integrated spent mandrel evacuation	✓	✓	✓	✓
Integrated blind rivet intake	✓	✓	✓	✓

6. Equipment/accessories

Tool type	TAURUS® 1	TAURUS® 2	TAURUS® 3/4
Nosepiece in working position	17/22	17/32	17/45
Nosepiece in tool base	17/20 17/18	17/24 17/29 17/27	17/40 17/36
1 wrench WAF 12/14 (144 6044)	✓	✓	✓
1 wrench WAF 14/17 (144 6043)	✓	✓	✓
1 bottle of hydraulic oil 100 ml (144 5294)	✓	✓	✓
1 oil refill can (162 5612)	✓	✓	✓

7. Nosepiece assignment

Rivet Ø (mm)	Rivet material	Nosepiece	Part No.
2.4	Al/steel, Al/stainless steel	17/18	143 4976
3.0	Steel/steel; stainless steel, Al/steel, Al/stainless steel	17/20	143 4994
3.2	CAP® Al, CAP® Cu, PG Al/steel, PG Cu/stainless steel, PG Al/stainless steel	17/20	143 4994
3.2	Al/steel, steel/steel, stainless steel	17/22	143 5018
4	Al/steel, Al/stainless steel, CAP® Al/steel, CAP® Al/stainless steel	17/24	143 4955
4	Steel/steel, PG Al/steel, PG Al/stainless steel	17/27	143 4973
4	PG steel/steel, stainless steel, PG stainless steel, G-Bulb stainless steel, G-Bulb Al/steel	17/29	143 4974
4.8 and 5	Al, CAP® Al, CAP® Cu, PG Al	17/29	143 4974
4.8 and 5	Steel, Al/Al	17/32	143 4975
4.8 and 5	Stainless steel, Stinox, PG steel, PG stainless steel, G-Bulb	17/36	143 4977
6	Al	17/36	143 4977
6	Steel	17/40	143 4999
6.4	Al	17/40	143 4999
6.4	Steel, PG steel, Al/Al, stainless steel, G-Bulb	17/45	143 4860
8	Al	17/45	143 4860

BULB-TITE® Ø (mm)	Rivet material	Nosepiece	Part No.
4	Al/Al	17/26 BT*	143 4985
5.2	Al/Al	17/32 BT*	143 4986
6.3	Al/Al, steel/steel, Monel/stainless steel	17/42 BT*	143 4988
7.7	Al/Al	17/48 BT*	143 4989

MEGA-GRIP® Ø (mm)	Rivet material	Nosepiece	Part No.
4.8	Al/Al, steel/steel, stainless steel	17/31 MG*	143 4993
6.4	Al/Al, steel/steel, stainless steel	17/41 MG*	143 4865

* available as optional accessory.

Extended version of nosepiece and other special versions are available on request.

8. Start-up

Before starting the blind rivet setting tool, read and observe the operating instructions and safety information and keep in a safe place. Have technical personnel connect the compressed air supply to the blind rivet setting tool.

8.1 To attach spent mandrel container

Fully screw on spent mandrel container (I) by turning clockwise.

8.2 Selecting and changing the nosepiece

Caution! Always fit the nosepiece corresponding to the size of the blind rivet (select from table in Section 7).

To change the nosepiece

- Disconnect the blind rivet setting tool from the compressed air supply.
- Unscrew nosepiece (A) from steel head sleeve (B).
- Screw in selected nosepiece (A) and tighten.

8.3 To set a blind rivet

- Connect the blind rivet setting tool to the compressed air supply.
- Insert the blind rivet in the nosepiece (A) and using the tool fit as far as it will go in the hole in the material to be joined.
- Press trigger (F) until the mandrel breaks off.
- Release trigger (F).
- The spent mandrel is automatically conveyed into the spent mandrel container (I) (see Section 8.5).

8.4 To suck in and hold a blind rivet

This function is used to hold the blind rivet in the nosepiece for riveting vertically downward.

- Using a pin (e.g. rivet mandrel), push the slide valve (H) in the tool head as far as it will go to the left or right.
- After the blind rivet setting tool has grabbed the rivet, push up the slide (G) so that it locks in. To switch off the suction, push down the slide (G).
- The complete suction function of the blind rivet setting tool is deactivated by pushing back the slide valve (H).

8.5 To empty the spent mandrel container

- The spent mandrel container (I) must be emptied in good time; overfilling will cause the blind rivet setting tool to malfunction.
- Unscrew the spent mandrel container (I) by turning anticlockwise, collect spent mandrels in suitable container.
- Screw on spent mandrel container (I).

9. Maintenance and care

The complete grip mechanism must be maintained regularly.

9.1 To oil jaws

- Disconnect the blind rivet setting tool from the compressed air supply.
- Unscrew steel head sleeve (B).
- Dip the complete jaw mechanism up to the O-ring (C) into an oil batch or wet jaws (E) with oil and allow to drip off.
- Reassemble in reverse order.

9.2 To change jaws

- Disconnect the blind rivet setting tool from the compressed air supply.
- Unscrew steel head sleeve (B).
- Unscrew jaw housing (D).
- Remove jaws (E).
- Clean jaw housing (D) and grease sliding surfaces.
- Fit new jaws (E) from the front (they are held by the grease).
- Reassemble in reverse order, ensuring that all parts are fixed tight.

9.3 To top up hydraulic oil

Follow correct sequence!



Wear safety goggles!



Danger of oil escaping at high pressure.

- Store the riveting tool in a dry place.
- If necessary, worn nosepieces (A) must be replaced as per section 8.2.
- After prolonged use, it may be necessary to refill or replace hydraulic oil. Follow the steps below to refill or replace hydraulic oil.

Top up hydraulic oil	Replace hydraulic oil
Connect riveting tool to compressed air network (it will move to starting position)	Disconnect riveting tool from the compressed air network.
Disconnect riveting tool from compressed air network	Unscrew steel head sleeve (B)
Unscrew steel head sleeve (B)	Unscrew oil filler plug (J) and gasket (K) with TORX® screwdriver T20.
Unscrew oil filler plug (J) and gasket (K) with TORX® screwdriver T20.	Screw on the oil top-up tank provided with cover.
Screw on the oil top-up tank with cover supplied and fill to approx. 50% with hydraulic oil	Connect the riveting tool to the compressed air network and press the trigger. Important! The old hydraulic oil will be squeezed out. Keep the cover tightly closed!
Carefully move the piston unit by hand back and forth several times up to the stop, until the hydraulic oil comes out bubble-free; push the piston unit completely back and leave at the rear (hydraulic oil level in oil top-up tank will drop). Important! Ensure that no air is drawn in!	Disconnect riveting tool from the compressed air network.
Unscrew the oil top-up tank from the riveting tool.	Tip out the old hydraulic oil using the riveting tool, and fill the oil refill container with fresh hydraulic oil up to the upper mark.
Screw in oil filler plug (J) with gasket (K) with TORX® screwdriver T20.	Carefully move the piston unit by hand back and forth several times up to the stop, until the hydraulic oil comes out bubble-free; push the piston unit completely back and leave at the rear (hydraulic oil level in oil top-up tank will drop). Important! Ensure that no air is drawn in!
Connect the riveting tool to the compressed air network via a pressure regulator and reset the pressure regulator to 0 bar. Important! Do not release the trigger.	Unscrew the oil top-up tank from the riveting tool.
Unscrew oil filler plug (J) and gasket (K) with TORX® screwdriver T20.	Screw in oil filler plug (J) with gasket (K) with TORX® screwdriver T20.
Screw on the oil top-up tank provided with cover.	Connect the riveting tool to the compressed air network via a pressure regulator and reset the pressure regulator to 0 bar. Important! Do not release the trigger.
Gradually increase the air pressure to mains pressure at the regulator; any excess hydraulic oil is squeezed out.	Unscrew oil filler plug (J) and gasket (K) with TORX® screwdriver T20.

Unscrew oil top-up tank from the riveting tool and wipe up any escaped hydraulic oil with a cloth.	Screw on the oil top-up tank provided with cover.
Screw in oil filler plug (J) with gasket (K) with TORX® screwdriver T20.	Gradually increase the air pressure to mains pressure at the regulator; any excess hydraulic oil will be squeezed out.
Carefully unscrew oil filler plug (J) by approx. 2 turns; the piston unit will slowly move into the forward end position. Collect any leaking oil with a cloth.	Unscrew oil top-up tank from the riveting tool and wipe up any escaped hydraulic oil with a cloth.
Screw on steel head sleeve (B)	Screw in oil filler plug (J) with gasket (K) with TORX® screwdriver T20.
	Carefully unscrew oil filler plug (J) by approx. 2 turns; the piston unit will slowly move into the forward end position. Collect any leaking oil with a cloth.
	Screw on steel head sleeve (B)

Regular maintenance will extend the service life of your high-quality GESIPA® tools and they should be serviced at least every 2 years by an authorised workshop or by GESIPA® Service. We recommend servicing tools that are subject to intensive use ahead of schedule.

9.4 Storage

The blind rivet setting tool should be stored in a dry place where there is no danger of frost.

10. Repairs

Repairs under warranty are carried out by the manufacturer. Repairs outside the warranty period should only be carried out by **skilled technical personnel**. Failure to observe the assembly and setting procedures and operation by non-skilled personnel may result in serious damage to the blind rivet setting tool. In case of doubt, always send the blind rivet setting tool back to the supplier or to GESIPA®.

11. Troubleshooting

11.1 Blind rivet is not set

Cause	Corrective measures
Jaws (E) dirty	Clean and oil sliding surfaces (Point 9.1)
Jaws (E) worn	Replace (Point 9.2)
Insufficient working pressure	See working pressure (Point 5)
Tool stroke too low	Top up with hydraulic oil (Point 9.3)

11.2 Spent mandrel is not evacuated

Cause	Corrective measures
Spent mandrel container (I) full	Empty (Point 8.5)
Wrong nosepiece (A) used	Replace according to table (Point 7)
Nosepiece (A) worn	Replace
Spent mandrel jammed in jaws (E)	Clean jaws (E) and jaw housing (D) and oil sliding surfaces; replace if worn (Point 9.2)

12. Warranty

The applicable terms and conditions of guarantee shall apply and can be viewed under following link: www.gesipa.com/agb

13. CE Declaration of conformity

We hereby declare that the design and construction of the tool named below, as well as the version that we have put on the market, complies with applicable fundamental health and safety requirements stipulated in EU directives. Tool modifications made without our authorisation shall render this declaration void. The safety information in the product documentation provided must be observed. This document must be retained.

TAURUS® 1-4

- 2006/42/EG
- DIN EN ISO 12100:2011
- DIN EN ISO 11148-1:2012
- DIN EN 82079-1:2013



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