USER MANUAL

PNEUMATIC RIVET NUTS SETTING TOOL

E-412NA

GAMME PREMIUM

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M3-M12

ALUMINIUM - STEEL - STAINLESS STEEL

(Anvil and mandrel for rivet nuts M3 and M12 not included)



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GENERAL SAFETY INSTRUCTIONS AND PRINCIPLES



READ THIS MANUAL CAREFULLY BEFORE USING THE TOOL !

It is IMPORTANT to follow the safety instructions for adequate protection against injuries.

- The tool must not be used for other purposes than those for which it was designed and in a different manner than that recommended by the manufacturer.
- Any alterations of the tool, its accessories or spare parts remain in sole responsibility of the customer.
- The tool must be kept in top condition and regularly tested for damage and proper operation.
- The tool must be repaired only by an authorized technician or by a person trained by the manufacturer or supplier. The tool must always be operated in accordance with respective sanitary and safety regulations.
- All queries regarding proper and safe operation of the tool should be addressed to your sales agent.
- Safety principles that must be adhered to in connection with operation of this tool must be known to all workers who operate the tool.
- When handling the tool take extra care to avoid unwanted activation and possible injury.
- The tool must be during any kind of maintenance or repair (does not apply to replacing nose-pieces and emptying the mandrel container) disconnected from the source of compressed air.
- Before operating the tool always take up firm posture and steady position.
- It is necessary to prevent break-away shanks endangering safe operation of the tool.
- Never aim with the tool at another person.
- Always check that the vent holes are not blocked or covered and that the supply hose are in good condition.
- Working pressure must not exceed 0.7 MPa.
- Oxygen or other flammable gasses from pressure cylinders must not serve as a driving agent.
- When operating the tool it is recommended to use safety glasses and utility gloves.
- If the continuous cycle of riveting exceeds 8 hours per day, it is recommended that the operators use ear protectors.
- When working with the tool the operator must not have loose parts of wear as e.g. a tie, long hair, jewellery etc. to avoid getting caught by the tool.
- Same safety instructions apply for persons standing close to the tool.
- Avoid unnecessary contact with the hydraulic fluid to prevent possible allergy reaction of the skin.
- The tool is equipped with permanent magnet, the magnetic pole may influence electronic and even some mechanic machines. So it is necessary to warn about the possibility of the influence on the operation of electronic implants (e.g. pacemakers, insulin pumps etc.) with potential fatal effect for the users of these implants. The magnetic pole may also damage information on magnetic appliances (audio and video cassettes, diskettes, credit cards etc.) and it can destroy the forever. While using (and storing) the tool, please, keep distance with these sensitive appliances, in this case 0.5 m is considered as the save distance.
- The tool is not designed for outdoor and explosive environment.
- After the service life, discard the tool according to the Disposal Act no. 185/01 Coll.

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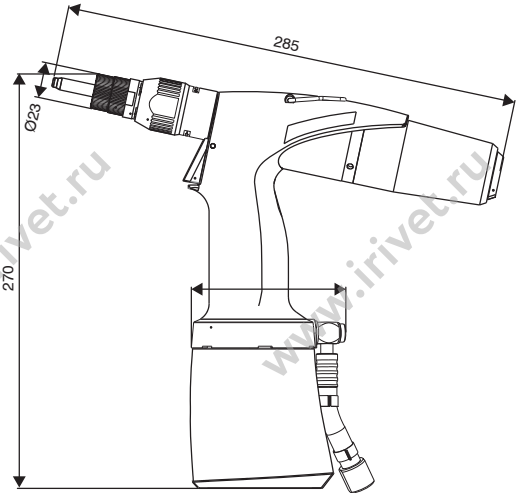
DESCRIPTION OF THE TOOL

1. BASIC CHARACTERISTICS

Lenght: 285 mm
Height: 270 mm
Width *(over the aircoupling)* : 99 mm
Weight: 1,65 kg
Stroke: 7 mm
Stroke force at 0.6 MPa: 18.5 kN
Air consumption: 1.5 L / stroke
Working pressure: 5 to 7 bars
Capacity:

RIVET NUTS	M3	M4	M5	M6	M8	M10	M12
ALUMINIUM	✓	✓	✓	✓	✓	✓	✓
STEEL	✓	✓	✓	✓	✓	✓	✓
STAINLESS STEEL	✓	✓	✓	✓	✓	✓	✓

✓ Intensive use ✓ Occasional use or small series



2. TOOL OPERATION

Description of the tool:

1 - Mandrel
2 - Anvil with counternut
3 - Quick interchangeable system
4 - Front nozzle
5 - Stroke set-up
6 - Revolvable air supply
7 - Unscrewing button

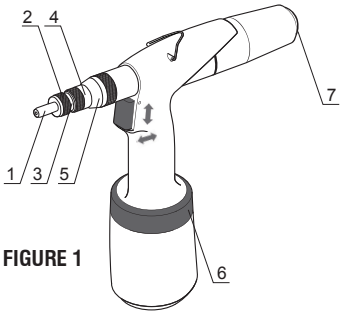


FIGURE 1

The manufacturer equipped the tool with a anvil and mandrel for rivet nuts M8. for riveting of rivets with a different dimension it is necessary to exchange the anvil and mandrel and change basic set up and regulation of the tool as following:

1. Loosen the counternut of the anvil
2. Screw out the anvil from the front nozzle
3. Screw out the mandrel from the sleeve
4. Choose appropriate anvil and mandrel, see the following chart:

Nuts	Anvils and mandrels	Spare part Nr.
M3	Mandrel for rivet nuts M3	E-TIGE-NA-03
	Anvil for mandrel M3	E-NEZ-NA-03
M4	Mandrel for rivet nuts M4	E-TIGE-NA-04
	Anvil for mandrel M4	E-NEZ-NA-04
M5	Mandrel for rivet nuts M5	E-TIGE-NA-05
	Nez pour tirant M5	E-NEZ-NA-05
M6	Mandrel for rivet nuts M6	E-TIGE-NA-06
	Anvil for mandrel M6	E-NEZ-NA-06

Nuts	Anvils and mandrels	Spare part Nr.
M8	Mandrel for rivet nuts M8	E-TIGE-NA-08
	Anvil for mandrel M8	E-NEZ-NA-08
M10	Mandrel for rivet nuts M10	E-TIGE-NA-10
	Anvil for mandrel M10	E-NEZ-NA-10
M12	Mandrel for rivet nuts M12	E-TIGE-NA-12
	Anvil for mandrel M12	E-NEZ-NA-12

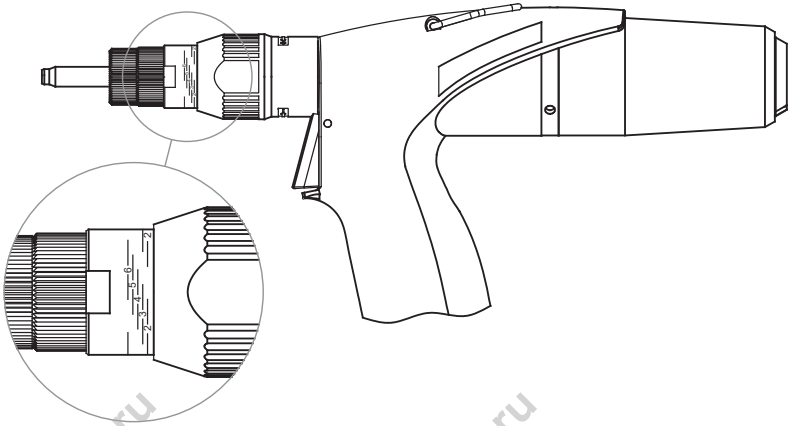
ANVIL/MANDREL M4 TO M10 INCLUDED
ANVIL/MANDREL M3 AND M12 TO ORDER

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5. Screw the mandrel on to the sleeve (to the backstop) and then turn it back, so that the flats of the hexagons of the screw-plug gauge and sleeve are matching.
6. Slide on the anvil to the hexagons of the mandrel and sleeve.
7. Screw on the anvil to the front nozzle.
8. Set-up the anvil:
   for rivet nuts - the rivet nut is screwed on the whole length of the thread on the mandrel and the front of the rivet nut leans on the anvil. Fasten the position of the anvil with a counternut.
   For rivet bolts - set-up the anvil so that there is a cca 1 mm space between the outer side of the rivet bolt and inner side of the anvil.
   Do it as following: screw on the anvil to the backstop to the mandrel and then screw it back one or two turns. Fasten the position of the anvil with a counternut.
9. Basic stroke set-up as following (does not apply for all types of rivet nuts):

RIVET NUTS	M3	M4	M5	M6	M8	M10	M12
BASIC STROKE (mm)	1.5	2	2.5	3	4	5	6

- to set-up the stroke turn the covering sleeve of the front nozzle, value of the stroke are indicated between the scale on the body of the front nozzle and the edge of the covering sleeve of the front nozzle, digits indicate the stroke into milimetres, see the following picture:



10. Adjust revolvable air supply into any required position and connect the tool to the source of the compressed air.
11. Put the rivet on the mandrel and push towards the anvil, this will screw on the rivet.
12. Put the screwed rivet into the prepared hole.
13. Press the trigger and the rivet will be riveted in.
14. Relieve the trigger, the mandrel will screw out from the rivet (if it is not fully screwed out, use the unscrewing button).
15. Check the fastened rivet:
    - if the rivet is not fully fastened it is necessary to increase the stroke.
    - if the rivet is too fastened, which results in deformation of the rivet and the mandrel is hard to unscrew out from the rivet, it is necessary to decrease the stroke.
16. Check the setting-up of the anvil according to the step **8**
17. The tool, which is set up a prepared this way is ready for riveting.

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TOOL MAINTENANCE

During maintenance the tool must be disconnected from the source of compressed air !!!

1. DAILY MAINTENANCE

Daily, before starting work, apply several drops of lubricating oil (we recommend hydraulic oil grade HLP ISO VG 32) into the air inlet of the tool, on condition there is no lubricating device connected in the air distribution. If the tool is in continuous operation, it is necessary to disconnect the air hose from the main air supply and lubricate the tool every 2 or 3 hours.

Check the tool for air leakage, if necessary replace damaged hoses and clasps.

If the pressure regulator is not equipped with a filter, blow through the air hose before its connection to the tool in order to get rid of impurities and water. If the pressure regulator has a filter, dry it out.

Check whether the fixed nose-piece corresponds to the BR diameter and that all screw threads and joints are tightened properly.

Check whether the air outlets are really empty.

2. WEEKLY MAINTENANCE

Cleaning of the tool and replacement of worn or non-functional parts.
Unscrew the anvil and mandrel according to the chapter «2. TOOL OPERATION» p.3 from **1** to **3** and clean them thoroughly.
Visually check - especially the mandrel, anvil and front nozzle - if worn or damaged, replace them.
Dismounted parts should be reinstalled according to the chapter «2. TOOL OPERATION» p.4 from **5** to **7** including setting up according to the point **8**.

3. GENERAL MAINTENANCE

General maintenance should be performed after about 500 000 strokes or once every three years. The tool must be completelly disassembled and all seals and worn parts must be replaced. This repair may be carried out by an authorized technician only or a person trained by the manufacturer or supplier.

SPARE PARTS

1. ORDERING

Order the spare parts exlusively from the manufacturer or from your sales agents.
The order must contain:
a) tool serial number
b) number of ordered part
c) number of pieces
d) name of your company and precise address
e) your tax identification number and identification number

2. LIST OF QUICKLY EXPENDABLE PARTS

- All types and dimensions of mandrels and anvils «2. TOOL OPERATION» p.3
- Front nozzle complete S-1400600

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STORAGE

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The pneumatic-hydraulic tool embedded in a shipping container must be stored in environment with relative humidity to 70% and temperature ranging from +5°C to +40°C, without aggressive evaporation of salts, acids and caustics.

OPERATIONS AND WARRANTY CONDITIONS

1. OPERATION CONDITIONS

For reliable function of the tool we recommend to use treated compressed air. Treated compressed air means compressed atmospheric air bare of solid particles and water, reduced to required pressure and lubricated with anti-corrosive oil. Immediately before the tool there must be a regulation valve set to maximum outlet pressure of 0.7 MPa, air filter and lubrication in the circuit of compressed air. Equivalent sound-pressure level of noise A, $L_{pAeq,T}$ does not exceed 74.7 dB(A), still it is recommended to use ear protectors during continuous and long-term operation.
Aggregated weighted vibration acceleration level $L_{avw,T}$=116.1dB re 10^{-6}m.s^{-2}. The cumulative weighted effective value of the vibration acceleration $a_{vw,T}$=0.635m.s^{-2}.
The trigger enables safe control of the tool with a force max. 10N < 50N without releasing the grip-handle according to the health regulation.

2. WARRANTY CONDITIONS

For reliable and safe function of the tool it is necessary to adhere to instructions and principles stated above.

For the warranty period the customer must not perform any alterations other than those permitted by the manufacturer, see paragraph «1. BASIC CHARACTERISTICS» p.3, «1. DAILY MAINTENANCE» p.5, «2. WEEKLY MAINTENANCE» p.5. Other non-detachable parts are secured with paint. In case of neglecting this protection the manufacturer shall not admit possible warranty repairs. To admit warranty repair the customer must submit proof of purchase. The warranty period is 12 months from the day of purchase if the purchase contract does not state otherwise.

Warranty is valid provided that the following:

- «GENERAL SAFETY INSTRUCTIONS AND PRINCIPLES» p.2
- «2. TOOL OPERATION» p.3
- «1. DAILY MAINTENANCE» p.5
- «2. WEEKLY MAINTENANCE» p.5
- «STORAGE» p.6
- «OPERATIONS AND WARRANTY CONDITIONS» p.6

Warranty does not apply to quickly expendable parts (see paragraph «2. LIST OF QUICKLY EXPENDABLE PARTS» p.5).

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CONDIZIONI DI GARANZIA

CLIENTE: .....
TIMBRO E FIRMA

FORNITORE: .....
TIMBRO E FIRMA

NUMERO DI SERIE DELL'UTENSILE:.....

Il periodo di garanzia di 12 mesi è valido dalla data d'acquisto se i seguenti punti verranno osservati:

- **«ISTRUZIONI GENERALI DI SICUREZZA» p.12**
- **«2. FUNZIONAMENTO» p.13**
- **«1. MANUTENZIONE GIORNALIERA» p.15**
- **«2. MANUTENZIONE SETTIMANALE» p.15**
- **«STOCCAGGIO» p.16**
- **«CONDIZIONI DI FUNZIONAMENTO» p.16**

La garanzia non è valida per le parti di usura «2. LISTA DELLE PARTI DI RICAMBIO PIÙ COMUNI» p.15.

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