

1. Safety instructions



The hydraulic tool kit is strictly approved only for the purposes intended by the manufacturer.



Ensure that the instruction manual is made available to operating personnel.



Protective gloves and a face mask must strictly be worn for all applications of the equipment, because metallic parts can break up and fly off with high energy if the tool is faulty or operated incorrectly.



Before starting work, check the preset air pressure! Incorrectly set air pressure could cause equipment damage or physical injury!

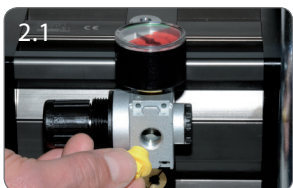


Always disconnect the riveting tool from pressure when leaving the work site!



The compressed air supply must be disconnected from the equipment before any adjustment or maintenance work is performed.

2. Startup



2.1

The pressure regulator is supplied with a closing cap fitted. Remove the closing cap.



2.2

2.2

Use a compressed air connection with R1/4" thread and seal. Screw this into the regulator.

3. Riveting Tool Preparation



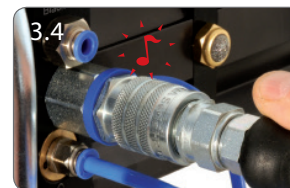
3.1



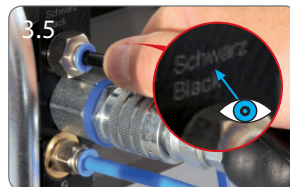
3.2



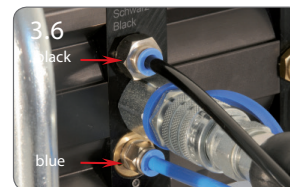
3.3



3.4



3.5



3.6

3.4

Connect the pneumatic hoses. Make sure that the black hose is attached to the marked coupling.



Before using the equipment, check the condition of the hydraulic actuator with add-on component and hoses. Risk of severe physical injury if the pump or the rivet clamp is damaged.



Check the hoses and couplings for damage.



In the event of any noticeable damage, the hydraulic components must be replaced. Damaged hoses or couplings could cause severe injury!



Incorrectly attached hoses could come loose and cause severe physical injury.

4. Connection of the Hydraulic Actuator



4.1

4.1

Connect compressed air to the pressure regulating valve and set the pressure.



4.2

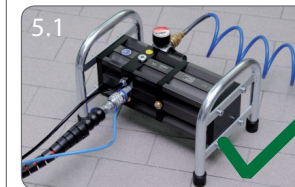
Never use pressure over the permitted value of 6 bar or 87 psi. This could cause damage to the equipment or even physical injury.



4.2

max. 6 bar/
87 psi

5. Safe Set-Up and Positioning



5.1



5.2
















Ensure that the high-pressure pump is always placed on a non-slip surface and that the hoses are routed in a way that prevents them from getting damaged or pinched off. The hoses must also be routed in a way that prevents people from tripping over them.



Make sure that the pump and hydraulic actuator are set up in a work area that is free from heat sources (max. 50°C / 120°F), corrosive liquids, greases and oils.



Before using the equipment, make sure that the pump is standing on a secure surface.

6. Riveting Tools		
Kit number	Item/Description	Item/Description
Kit: 45714	Setting head, 3 mm rivet	Closing head, 3 mm rivet
		
Kit: 45715	Setting head, 5 mm rivet	Closing head, 5 mm rivet
		
Kit: 45716	Setting head, flow form rivet Marked with 3 rings	Closing head, flow form rivet Marked with 3 rings
		
Kit: 45717	Punch and calibration mandrel Marked with 2 rings	Punch and calibration die Marked with 2 rings
		
Kit: 45718	Extraction mandrel Marked with 1 ring	Extraction die Marked with 1 ring
		
	Replacement elastomer rings 06-00000112	Set of fitting spanners, 3 mm rivet, BGR-TKR-00000239
		
Kit: 45719	Spacing adaptor composed of: 1 Bushing 2 Spacing bolt 3 Spacing sleeve	
		

7. Connecting the Tool to the Hydraulic Actuator

7.1



7.2



7.3



7.4



7.5



7.3/7.4/7.5

The two locking pins are inserted into the locking holes with the release button pressed. The tool must be pressed gently in the direction of the clamp while doing so. The pin must lock automatically once inserted and must not fall out of the locking hole by itself.



Warning!

The mounting adaptor on the hydraulic actuator must be clean and free from damage! The locking bolts must also be free from contamination and damage. The mounting hole in each tool must be free from contamination and damage!



Warning!

Damaged or defective locking pins must not be used!

8. Riveting Tool Kit RIVKIT UN 2.0 – Fitting and Intended Use

8.1



8.2



8.3



8.4



8.1/8.2


Screw the riveting tool needed for the working process into a holder in the rivet clamp as required. Hand-tighten the riveting head using the special spanners provided. Do not use force. Counterhold the nut using a screwdriver if necessary.

8.3/8.4

Screw the corresponding counterpart to the rivet insert into the opposite side of the rivet clamp (plunger rod) with the spacing bushing and bolt, and hand-tighten. Do not use force!



Each time rivet inserts are to be fitted, the bolt and die must be checked for a correct match first! Refer to the usage matrix in the RIVKIT UN 2.0 case for details.



Check that the riveting heads are firmly seated after each riveting operation. Rivet inserts that have come loose present a hazard and can lead to destruction of the equipment.