

**Arconic
Fastening
Systems and Rings**

AIR FEED

Use only compressed air. Check airline for damage from humidity & contaminants. In order to protect the tool from premature wear, we recommend the use of an in line moisture filter and air regulator.

Air inlet thread connection size on the tool is 1/4" NPT.

**WARNING: ALWAYS WEAR SAFETY GLASSES
WHEN OPERATING AND PERFORMING MAINTENANCE ON TOOL**

WARNING:

Do not use air supply greater than recommended 85-95 PSI
or tool may be damaged or burst.

NORMAL OPERATION



1. Connect the air supply then switch ON/OFF valve to ON position.



2. To turn on and adjust the Vacuum system remove mandrel nail container and rotate bar counter-clockwise Adjust the amount of suction the vacuum system needs to hold the rivet in place and to eject spent mandrel into collection cup. Replace nail container.

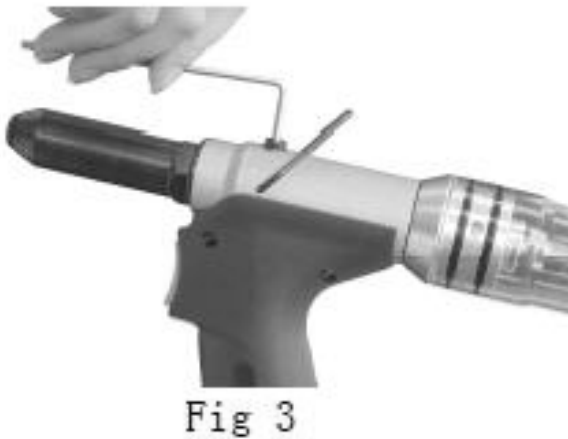
If you don't want to use vacuum system you can turn the vacuum system clockwise to shut it off. The tool will still be able to set rivets, but it must be tilted backwards to allow spent mandrel to fall into nail container.

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ADDITION OF HYDRAULIC FLUID

Tool is shipped with oil. If it becomes necessary to add oil, follow this procedure.
Please use the supplied priming pump as shown (fig. 4)

1. Disconnect air supply to tool and switch ON/OFF valve to OFF position.



2. Remove seal screw and seal (see Fig. 3)

3. Screw the priming pump of filled oil into the bleed screw hole. Actuate the priming pump by pressing down and releasing several times until resistance is felt. (Fig. 4)



4. Remove the priming pump and the excessive oil will flow out. Wipe away and clean out the excessive oil and replace the seal and screw.

IMPORTANT: Use only Anti-Foam Hydraulic Fluid

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CHANGING NOSEPIECES

1. After selecting the correct size nosepiece for the rivet being used Connect tool to air supply and pull trigger and hold trigger button.
2. Using wrench (supplied), unscrew nosepiece from frame head & replace with proper size nosepiece. Tighten down with wrench. **DO NOT OVERTIGHTEN.** Release trigger.

Your tool is now ready to work. Insert rivet mandrel into nosepiece. Insert rivet into predrilled hole in application and pull trigger button and hold until rivet sets then release the trigger. A second pull may be required.

CLEANING & CHANGING OF JAWS

With use, the jaws of the tool may become dirty or worn. This will cause slipping of the rivet mandrel & and improper setting of the rivet. To clean the jaws follow this procedure.

1. Disconnect air supply.
2. Use a suitable wrench, unscrew frame head and remove.
3. Using a pair of wrenches, disassemble front jaw case from rear jaw case.
DO NOT MOVE rear jaw case as this will affect tool operation.
4. To clean jaws, use a stiff dry wire brush.
5. If excessive wear is apparent, replace with new jaws.
6. Reassemble the jaw case assembly.

