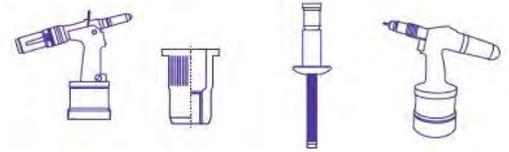


Basic Tips & Maintenance Guide for Blind Rivet Setting Air Tools



Regular inspection and maintenance will not only ensure consistent blind rivet setting performance but will also preserve the working life of your tool.

Below are a few tips on how to keep your tool working in optimum condition.

CLEAN THE JAWS

After 25 hours of use, it is recommended that you remove the nose assembly for cleaning, lubrication and replacement of any damaged or worn parts. If wear is visible on the gripping teeth of the jaws they should be replaced. The outer surface of the jaws, should be lubricated each time the jaws are cleaned or replaced. If you are setting rivets with stainless steel mandrels, jaw wear is more rapid due to the hardness of the stainless steel.

After extensive use, the tool may accumulate small metal chips from rivets within the nose assembly of the tool. These metal chips will lodge in the pulling grooves of the jaws and prevent these grooves from penetrating the surface of the mandrel. This will cause the jaws to slip on the mandrel and the rivet may not be set correctly.

OIL LEAKING FROM THE TOOL

Most commercial and industrial rivet setting tools are powered by compressed air and hydraulic oil. The compressed air pushes a piston and the rod of the piston is pushed into the hydraulic oil chamber. The oil is pushed into a hydraulic piston section and the piston pulls the setting jaws and sets the blind rivet.

Any loss of hydraulic oil will reduce the stroke and thus the efficiency of the tool, requiring more than one pull to set the rivet.

Hydraulic oil levels, seals and O-rings should be checked and replaced regularly.

MORE THAN ONE PULL REQUIRED TO SET THE RIVET

The reasons why the tool does not set the rivet in one pull are;

- Dirty or worn pulling jaws.
- Low air pressure.
- Low air volume.
- Loss of hydraulic oil.

REGULARLY SERVICE THE TOOL

When servicing the nose assembly, the setting tool should also be inspected. If your tool uses hydraulic oil pressure to pull the jaws tight and a compression spring to return the jaws to the open position in order to release the spent mandrel and accept a new rivet, the return spring should regularly be checked for length and condition. If the return spring is 5/16" shorter than a new compression spring it should be replaced. Once the tool has been inspected and serviced, ensure that all locking nuts are tight.

Dafra Fastening Systems - Rivets Rivnuts & Tooling

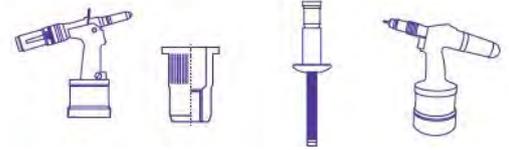
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2 OR 3 PIECE JAWS

Pulling jaws are constructed of either a set of 2 or 3 pieces. 2 piece jaws are usually used for tools setting 3/32" to 3/16" diameter blind rivets while 3 piece jaws are usually used in tools for setting 3/16" to 1/4" diameter rivets. Both 2 and 3 piece jaw sets should be inspected after every 25 hours of operation.

HOLD SETTING TOOL AT 90 DEGREES TO WORK PIECE

The tool should be held at 90-degrees to the work piece in order to ensure correct setting of the rivet. If the tool is held at an angle to the work piece, the tool will break the mandrel before the rivet is correctly set. It can also cause the tool to bend the rivet mandrel when setting the rivet and a bent mandrel can lodge itself inside the tool and not eject.

PUSH SETTING TOOL FORWARD WHEN SETTING BLIND RIVET

When setting a blind rivet, push the tool forward slightly towards your work piece to ensure the rivet is set correctly. Without this slight forward pressure, the flange of the set rivet may not sit flush against your work piece.

SPECIAL STRUCTURAL BLIND RIVET NOSE PIECE

Before starting work, the nose piece of your tool should be inspected to ensure that the correct nose piece is being used and that it is tight in the tool.

Be aware that there is one structural blind rivet that requires a special nose piece to set it. The nose piece has a small raised ring around the hold of the nose piece. This ring locks the mandrel into the blind rivet body when this structural blind rivet is set. If this ring is chipped or worn, the mandrel will not lock securely and the rivet will not be set correctly.

CLEAN AND LUBRICATED COMPRESSED AIR

An air filter and air lubricator should be installed in the compressed air line near the air/hydraulic tool body. Clean and lubricated compressed air extends the life of the tool. The amount of oil drops placed into the compressed air line should be as prescribed by the tool manufacturer.

AIR FITTINGS

Correct sized air fittings should be used in compressed air lines to operate air/hydraulic blind rivet setting tools. The setting tool will not have the correct volume of compressed air and will malfunction if the diameter of the air fittings used is smaller than specified by the tool manufacturer.

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