RIVET KING®

Instruction Manual
RK-280-NP Series

CONTENTS

SAFETY

- DO NOT USE OUTSIDE DEISNG INTENT OR WITH EQUIPMENT THAT IS NOT RECOMMENDED BY THE MANUFACTURER.
- ALWAYS DISCONNECT THE AIR SUPPLY BEFORE ATTEMPTING ANY MAINTENANCE OR ADJUSTMENT/FITTING OF NOSE EQUIPMENT
- DO NOT OPERATE A TOOL THAT IS DIRECTED TOWARDS ANY PERSON(S) OR WITH THE NOSE PIECES OFF THE TOOL
- ALL MODIFICATIONS CARRIED OUT ON THE TOOL WITHOUT EXPRESS WRITTEN CONSENT OF THE MANUFACTURER SHALL BE DONE SO AT THE CUSTOMERS' SOLE RESPONSIBILITY
- REFER TO THIS MANUAL BEFORE ATTEMPTING ANY MAINTENANCE OPERATION. DO NOT DISASSEMBLE THIS TOOL BEFORE RFERING TO THIS MANUAL.
- AVOID EXCESSIVE CONTACT WITH HYDRAULIC OIL, AS SOON AS POSSIBLE WASH HANDS THOROUGHLY
- DO NOT EXCEED 6 BAR / 90 PSI INLET PRESSURE, THE USE OF A PRESSURE REGULATOR IS HIGHLY RECOMMENDED
- INSPECT THE TOOL USING PREVENTITIVE MAINTENANCE TECHNIQUES AT REUGULARLY SCHEDULED INTERVALS. INSPECT FOR DAMAGE AND FUNCTION BY TRAINED COMPETANT PERSONEL. THE PLASTIC BODY MUST BE CHANGED WHERNEVER THERE IS EVIDANEC OF IMPACT DAMAGE, CHIPPING, OR CRACKING.
- WEAR SAFETY GLASSES AND ADOPT FIRM FOOTING DURING OPERATION.

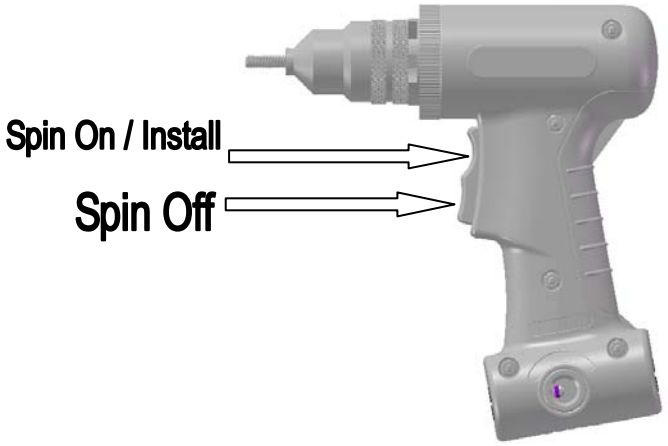
SPECIFICATIONS

The specifications and information contained in this manual are applicable only to the tool with which it was supplied. Industrial Rivet & Fastener Co reserve the right to make any changes without notice as part of Industrial Rivet & Fastener Co policy of continuous improvement.

SPECIFICATIONS FOR ZT-8000 RIVET TOOL					
Air Pressure	Min/Max	□	5.5 – 6 bar	□	80-90 psi
Free Air Volume Required	@5.5 bar/75psi	□	4.3 liters	□	

PREPARING THE TOOL FOR SERVICE

1. Inspect for damage
2. Connect the tool to the air supply
3. Insure the Rivet Nut you wish to install is within the capacity of the rivet tool
4. Choose and securely install the applicable nose piece for the rivet nuts you wish to apply.
5. Bring the tool and the rivet into the application hole. Insure the rivet head flat onto surface
6. Fully actuate the rocker trigger. The top button will spin the rivetnut onto the mandrel and install the rivetnut into the workpiece. The lower button will spin the rivetnut off the mandrel.



JAMMED GUN REMEDY

1. Disconnect tool from air supply
2. Remove Nose Piece
3. Replace Mandrel if Necessary
4. Reapply the nose case securely to the tool
5. Reattach air supply. Actuate tool without rivet. Check Function.
6. Once comfortable, Apply Rivets nuts.

AIR SUPPLY

- The rivet tool is powered by compressed air at an optimum pressure of 5.5-6.0bar(80-90 psi)
- The use of a pressure regulator filter/lubricator unit within 3 meters of the tool is highly recommended to extend the life of the tool.

Dirt and/or water in the air supply can seriously impact the performance and durability of the tool; damage to the tool caused by contaminated air supply is not covered under warranty

MAINTENANCE

In order to maintain the tool in a safe working order it is important to carry out regular maintenance as prescribed by the manufacturer. A thorough inspection replacement of all seals within the tool should be carried out after 500,000 placings or annually, whichever is the sooner. Item numbers in parentheses refer to assembly drawing part numbers

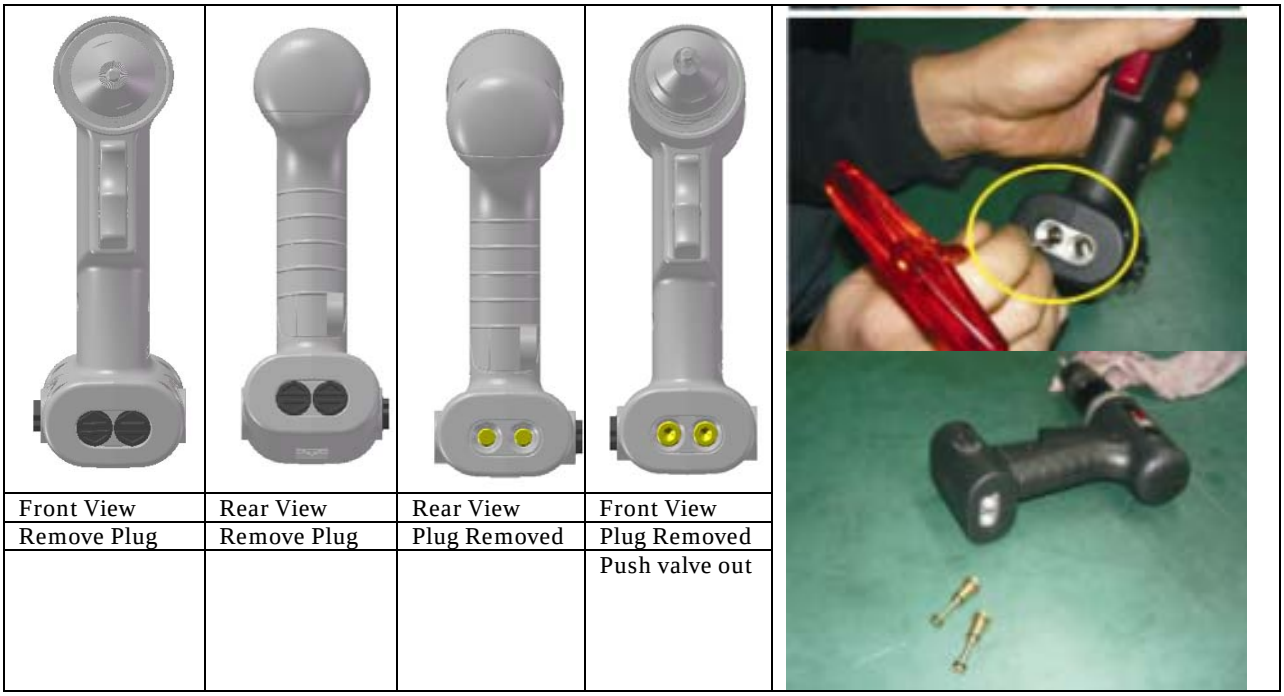
Daily Maintenance

- Check for air leaks. Any damaged hoses should be replaced
- Lubricate the tool by pouring a few drops of light lubricating oil into the air inlet on the tool
- If there is no pressure regulator, bleed the airline to clear it of accumulated dirt or water before connecting the air hose to the tool. If there is a filter, drain it.
- Check for proper nose piece/mandrel use depending on the size of the rivet nut.
- Remove the mandrel from the front nose assembly and inspect for cracks, wear or other damage. Replace if necessary.
- Check that front nose assembly is fully tightened onto body

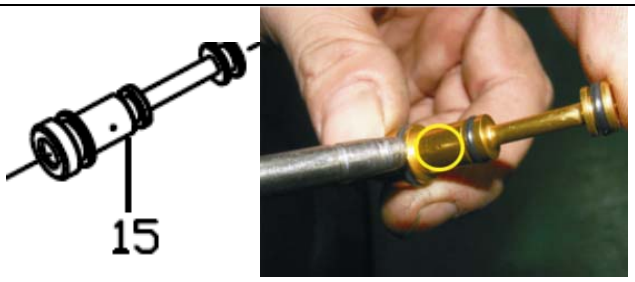
Weekly Maintenance

- Carry out procedures as per daily maintenance instructions above
- Clean and inspect the following using the below procedure..
    - Remove the 4 black screw plugs (2 in the front and 2 in the rear of the tool), exposing the brass pilot valve stem (see Fig 1).
    - With a blow gun, apply a stream of air to the threaded inlet to blow out any excess oil, dirt, or debris. (Fig 2a)
    - Wipe the brass pilot valve stem of excess oil, dirt or debris. Clean in spirits if necessary. Then, with a blow gun, apply a stream of air to the small hole in the center of the pilot valve stem, cleaning them of excess oil, dirt and debris.
    - Apply a generous coating of White Lithium Grease to the O-rings on the valve stem
    - Reassemble the valve stem and plugs insuring that the valve stem is placed in the tool correctly.

FIG. 1

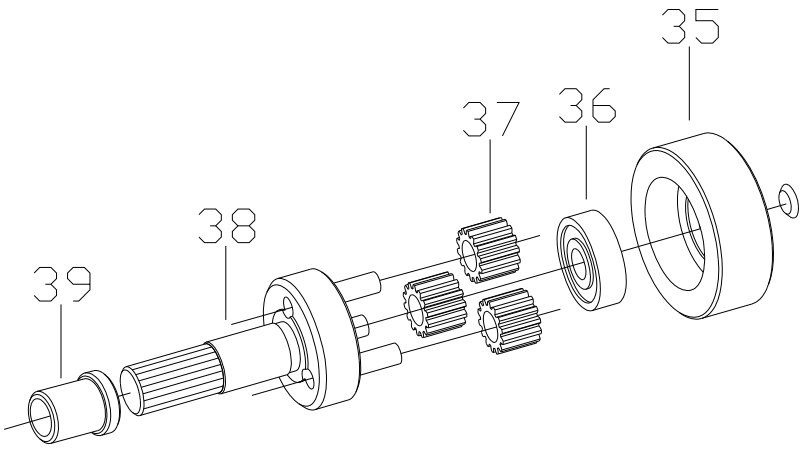


Front View	Rear View	Rear View	Front View	
Remove Plug	Remove Plug	Plug Removed	Plug Removed	
			Push valve out	

FIG. 2a	FIG 2b
	

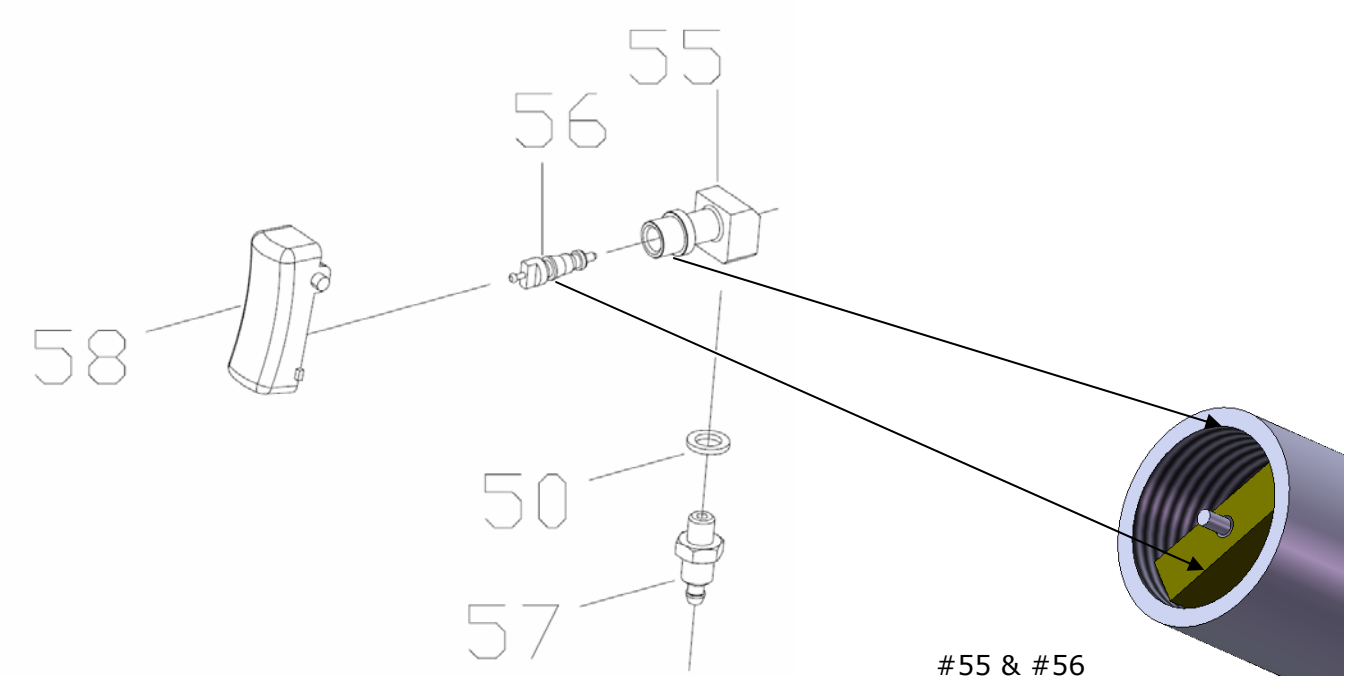
Monthly Maintenance

- Carry out procedures as per daily & monthly maintenance instructions above
- Grease the engine/gear reducer with a red synthetic grease



Trigger Service

- Inspect trigger pin valve by insuring **56** has not come loose. The proper depth should be just under the valve stem.
- If adjustment is necessarym using a fork wrench or tire valve tool, screw the trigger pin **56** into the valve stem. A very small amount of loctite243 is ok around the threaded portion only.
- If the trigger still fails, remove the trigger pin assembly from the valve stem and inspect the seal around the trigger pin for damage. If damaged, purchase a replacement part. Re-assemble according to the previous step.



#55 & #56

SCHEMATIC

Please see the attached document for the parts drawing & parts list.

PARTS LIST

Please see the attached document for the parts drawing & parts list.

Oil Details

The recommended oil for priming is Hyspin VG32 available in 0.51 or one gallon containers, or, you can use 30W hydraulic oil. Please see safety data below.

Hyspin VG 32 Oil Safety Data

First Aid
SKIN:
Wash thoroughly with soap and water as soon as possible. Casual or short term contact requires no immediate attention.
INGESTION:
Seek medical attention immediately. DO NOT induce vomiting.
EYES:
Irrigate immediately with water for several minutes. Although NOT a primary irritant, minor irritation may occur following contact.

Fire
Flash point 232°C. Not classified as flammable.
Suitable extinguishing media: CO_2, dry powder, foam or water fog. DO NOT use water jets.

Environment
WASTE DISPOSAL: Through authorized contractor to a licensed site. May be incinerated. Used product may be sent for reclamation.
SPILLAGE: Prevent entry into drains, sewers, and water courses. Soak up with absorbent material.

Handling
Wear eye protection, impervious gloves (e.g. of PVC) and a plastic apron. Use in well ventilated area.

Storage
No special precautions.

TROUBLESHOOTING

Item numbers in parentheses refer to assembly drawing part numbers on page 9.

Problem	Possible Cause	Remedy
Threads will not engage the rivet nut	▪ Wrong Mandrel Size ▪ Worn or Broken Mandrel ▪ RivetNut Thread Failure	▪ Measure rivetnut thread & pitch and select appropriate mandrel ▪ Replace Mandrel ▪ Contact Rivetnut manufacture and inform them of thread pitch failure
Tool will not pull down rivetnut	▪ Check Rivetnut with capacity of tool	▪ This tool is capable of installing thin wall rivetnuts only. ▪ The tool capacity is listed on the parts list.
Trigger Failure	▪ Pilot Valve Stem frozen or clogged ▪ Loose rectangle nut in trigger stem.	▪ Perform Weekly Maintenance ▪ Tighten rectangle nut (See trigger failure) ▪ Replace if neccessary
Cannot release rivetnut	▪ Threads of rivetnut stripped ▪ Pressure to High	▪ Reduce Air pressure 80-90 psi max.
Slow cycle	▪ Lack of lubrication ▪ Low air pressure ▪ Build up of dirt inside tool	▪ Lubricate tool at air inlet point ▪ Adjust air pressure to within specification
Tool fails to operate	▪ No air pressure ▪ Damaged trigger valve	▪ Connect and adjust to within specification ▪ Replace ▪ Tighten

A comprehensive tool service and repair program, for details contact your local area sales representative or call:

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