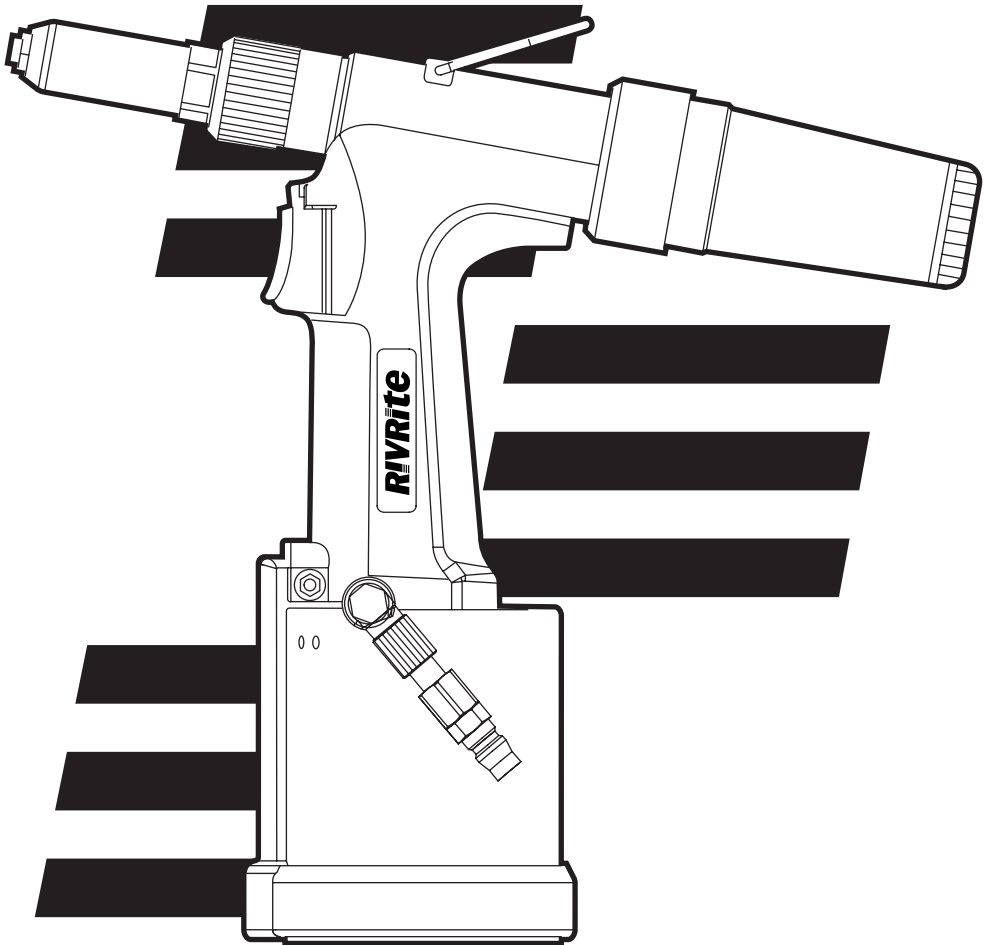


# RIVrite

RP1 Rivet Tool

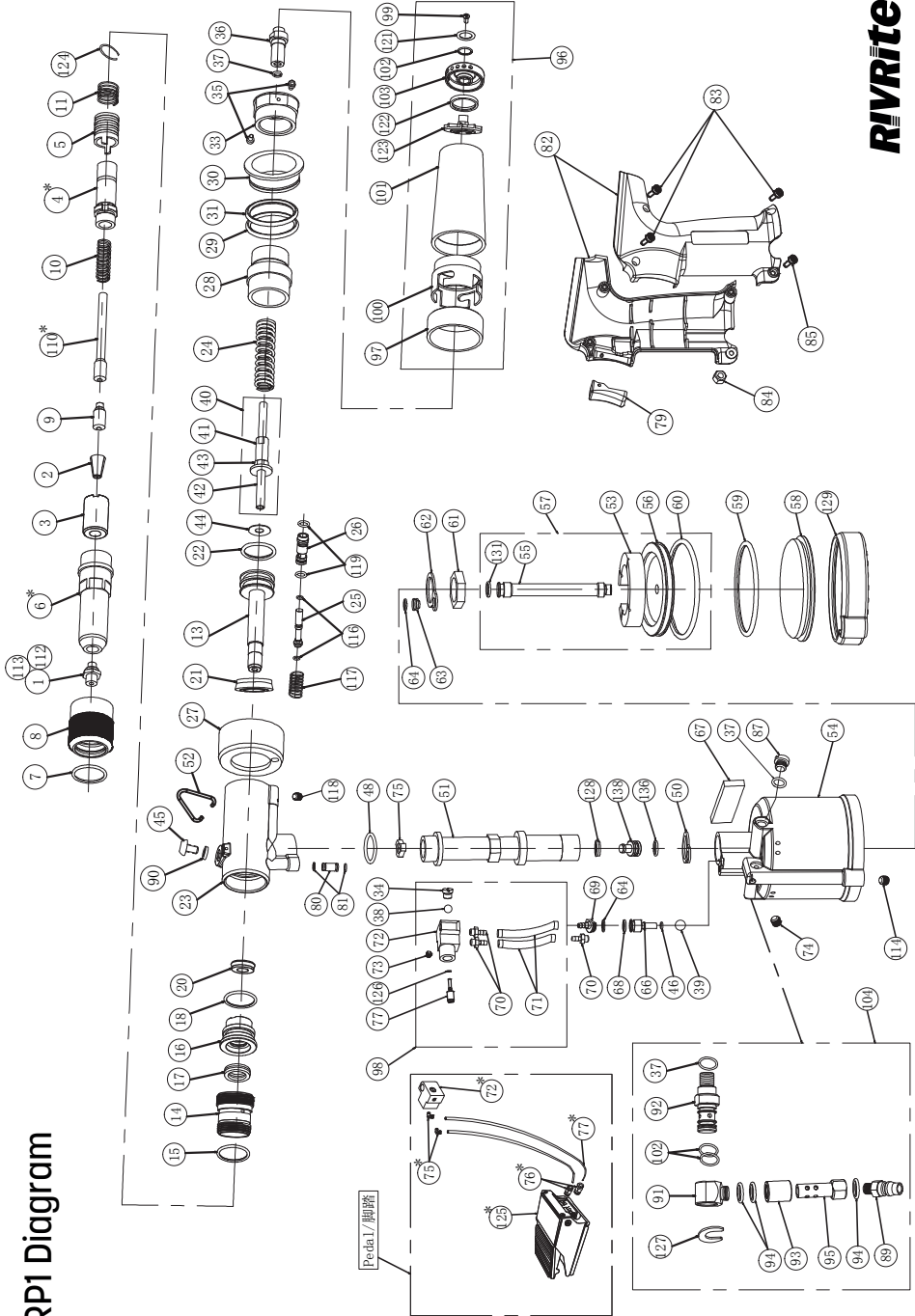


## Instruction Manual

## RP1 Parts List - With Mandrel Vacuum System

Item	Description	Part No	Item	Description	Part No	Item	Description	Part No	Item	Description	Part No			
1	Nozzle 2.4	R4S001A	27	MCS cap	R4S027A	56	Piston plate	R4S056A	85	Screw	R4S056A	124	Retaining ring	G4S124A
112	Nozzle 4.0	R4M001B	28	End cap adaptor	R4S028A	57	"Air piston assembly"	Z4S057B	87	Screw	R4M087A	126	O-Ring	B4M126B
113	Nozzle 3.2	R4M001C	29	O-Ring	B4M029A	58	Cylinder bottom cover	R4S058A	89	Joint Tool	G4S089B	127	Clamp spring	G4M127A
2	Jaws	R4S002B	30	Slider	M4S030A	59	O-Ring	B4S059A	90	Washer	B4R074A	128	Oil seal	B4M128A
3	Jaw guide	R4S003A	31	O-Ring	B4S029A	60	O-Ring	B4S060A	91	Conversion head	R4H188B	129	Rubber base	M4S129A
4	Pulling head	R4S004A	33	End cap	R4M033B	61	Sleeve lock nut	R4M061A	92	Union joint	R4M092B	131	Support ring	B4M131A
5	Jaw guide lock	R4S005A	34	Screw	R4M034B	62	Washer	M4M062A	93	"Switch the slider"	R4H120D	136	O-Ring	B4H086A
6	Nose housing	R4S006A	35	Screw	G4M035A	63	"Reversing the cover"	R4M063B	94	O-Ring	B4H121A	138	Oil seal column	R4M138A
7	O-Ring	B4S007A	36	Ejector guide	R4S036B	64	O-Ring	B4M064A	95	Joint set	R4H122C	* Interchangeable Parts		
8	Nose housing nut	R4S008A	37	O-Ring	B4M037A	66	Reversing piston	R4M066B	96	"Collector Assembly"	Z4M096A	Item	Description	Part No
9	Jaw pusher	Z4S009A	38	Bell(Rubber)	B4M141B	67	Silencing Cotton	D4M067A	97	Front collector	R4M097B	4*	Pulling head	R4S004B
10	Jaw pusher spring	D4S010A	39	Bell(Rubber)	312079A	68	O-Ring	B4M068A	98	Switch assembly	Z4M072G	6*	Nose housing	R4S006B
11	Spring	D4S011A	40	Ejector assembly	Z4S040A	69	Reversing switch	R4M069B	99	Screw	D4M103D	72*	Conversion block	R4M072C
13	Hydraulic piston	R4S013B	41	Ejector rod A	R4S041A	70	Screw	R4M070A	100	"Collector lock collar"	R4M100B	75*	Screw	G4M070B
14	Housing adapter	R4S014A	42	Ejector rod B	R4S042A	71	"Answer the traced"	D4M071A	101	"Collector assembly"	M4M101A	76*	Screw	G4M070C
15	O-Ring	B4S015A	43	Ejector rod C	R4M043A	72	Trigger	R4M072C	102	O-Ring	B4M102B	77*	"Answer the traced(1.5m)"	D4M071C
16	Rod seal case	R4S016B	44	Combined washer	M4M044A	73	Stop screw	G4M073A	103	Collector end	M4M103B	110*	Nail guide rod	Z4S110A
17	Scraper	B4S017A	45	Screw	G4R045C	74	Stop screw	G4M074A	104	Joint assembly	Z4M104D	125*	Pedal	G4M118A
18	O-Ring	B4S018A	46	O-Ring	B4M046A	75	Oil distributor	R4S058A	114	Stop Screw	C4M114A			
20	Oil seal	B4S020B	48	O-Ring	B4R048A	77	"Switch valve core"	R4M077D	116	O-Ring	B4H031A			
21	Oil seal	B4S018B	50	Gasket	M4M050A	79	Trigger	M4M079C	117	Elastic ring	D4H032A			
22	O-Ring	B4S022A	51	Oil rod	R4S051B	80	Connecting pipe set	R4M080A	118	Stop Screw	G4H062A			
23	Oil cylinder	M4S023C	52	Hook	M4S052A	81	O-Ring	B4M081A	119	O-Ring	B4H028A			
24	Return spring	D4S024A	53	Crash pad	M4M053B	82	Handle	M4S062A	121	Washer	G4M121A			
25	MCS valve rod-1	R4H030B	54	Air cylinder	M4S054A	83	Screw	G4M083A	122	Silencing cotton	D4M067B			
26	MCS valve rod-2	R4H029A	55	Piston Rod	R4S055B	84	Nut	G4M084A	123	"Pin absorbed terminal"	M4M103C			

# RP1 Diagram

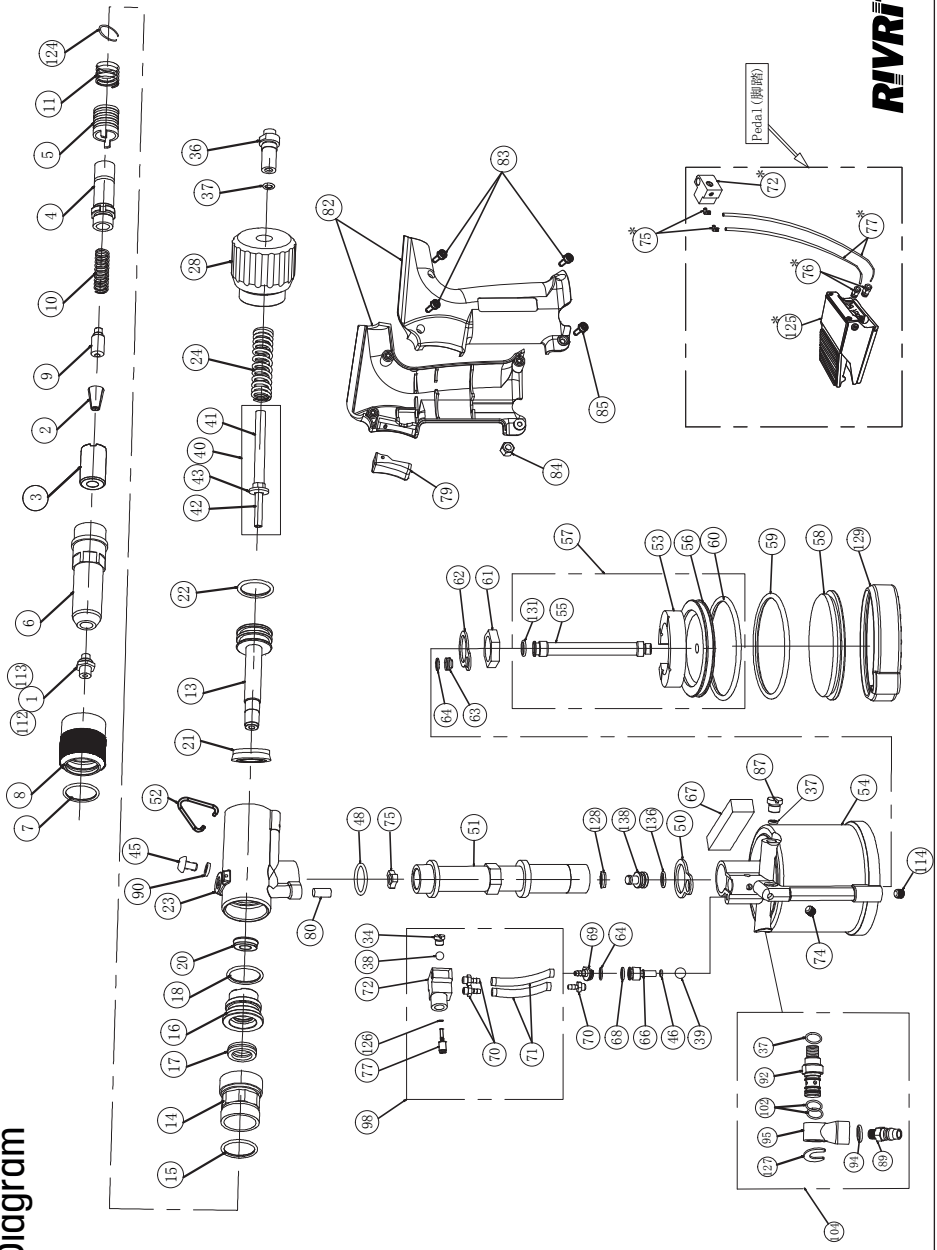


**Rivrite**

## RP1 Parts List - Without Mandrel Vacuum System

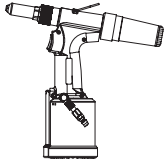
Item	Description	Part No	Item	Description	Part No	Item	Description	Part No	Item	Description	Part No	Item	Description	Part No
1	Nozzle 2.4	R4S001A	21	Oil seal	B4S018B	53	Crash pad	M4M053B	75	Oil Distributor	R4O056A	127	Clamp spring	G4M027A
112	Nozzle 4.0	R4M001B	22	O-Ring	B4S022A	54	Air Cylinder	M4S054A	77	"Switch valve core"	R4M077D	128	Oil seal	B4M028A
113	Nozzle 3.2	R4M001C	23	Oil Cylinder	M4S023D	55	Piston Rod	R4S055B	79	Trigger	M4M079C	129	Rubber base	M4S029A
2	Jaws	R4S002B	24	Return spring	D4S024A	56	Piston Plate	R4S056A	80	Connecting Pipe Set	R4M080B	131	Support ring	B4M031A
3	Jaw guide	R4S003A	28	End cap adapter	R4S028D	57	Air Piston assembly	Z4S057B	82	Handle	M4S082A	136	O-Ring	B4H086A
4	Pulling head	R4S004A	34	Screw	R4M034B	58	Cylinder bottom cover	R4S058A	83	Screw	G4M083A	138	Oil seal column	R4M038A
5	Jaw guide lock	R4S005A	36	Ejector guide	R4S036B	59	O-Ring	B4S059A	84	Nut	G4M084A	* Interchangeable Parts		
6	Nose housing	R4S006A	37	O-Ring	B4M037A	60	O-Ring	B4S006A	85	Screw	G4M085A	Description		
9	Jaw pusher	Z4S009A	40	Ejector assembly	Z4S040A	63	"Reversing the cover"	R4M063B	90	Washer	B48074A	72*	Conversion block	R4M072D
10	Jaw pusher spring	D4S010A	41	Ejector rod A	R4S041A	64	O-Ring	B4M064A	92	Union Joint	R4M092B	75*	Screw	G4M070B
11	Spring	D4S011A	42	Ejector rod B	R4S042A	66	Reversing piston	R4M066B	94	O-Ring	B4H021A	76*	Screw	G4M070C
13	Hydraulic piston	R4S013B	43	Ejector rod C	R4M043A	67	Silencing Cotton	D4M067A	95	Joint set	M48066B	77*	Answer the trachea(1.5m)	D4M071C
14	Housing adapter	R4S014A	45	Screw	G48045C	68	O-Ring	B4M068A	98	Switch assembly	Z4M072H	125*	Pedal	G4M018A
15	O-Ring	B4S015A	46	O-Ring	B4M046A	69	Reversing switch	R4M069B	102	O-Ring	B4M028B			
16	Rod seal case	R4S016B	48	O-Ring	B48048A	70	Screw	R4M070A	104	Joint assembly	Z4M04C			
17	Scrapper	B4S017A	50	Gasket	M4M050A	71	Answer the trachea	D4M071A	114	Stop screw	G4M014A			
18	O-Ring	B4S018A	51	Oil rod	R4S051B	72	Switch block	R4M072H	124	Retaining ring	G4S024A			
20	Oil seal	B4S020B	52	Hook	M4S052A	74	Stop Screw	G4M074A	126	O-Ring	B4M026B			

# RP1 Diagram

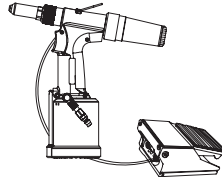


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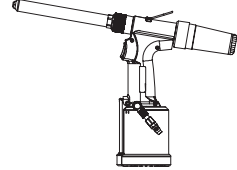
# Pneumatic Riveting Tool Instructions



Inspired air



Pedal



Extended



● Please read the operation instructions before using



● Please wear protective glasses when using the rivet tool

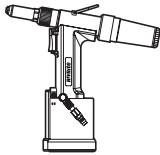
● The air supply pressure range is 5.5-6.5kgf/cm<sup>2</sup>

● Please clean the tools regularly

*If there is a fault, please do not try to open and repair the unit, contact the supplier*



● Do not disassemble tools with air supply



## Rivrite RP1:

Rivet size:  $\varnothing$  2.4mm-  $\varnothing$  4.0mm      Stroke range:18mm

Maximum pulling force:5270N      Gun head diameter:  $\varnothing$  17.3mm



Figure 1  
Flat Nozzle

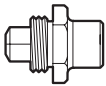


Figure 2  
Convex Nozzle



Figure 2  
Outside Lock  
Nozzle

1. The flat nose piece (Fig 1) is suitable for the larger riveting plane space, the larger rivet cap and shot rivet stem etc.



2. The convex nose piece (Fig 2) is ideal for small spaces. However, the length of the rivet stem is critical. If the rivet stem is too short, this can lead to the gun having difficulty gripping the rivet, and the rivet stem breaking improperly.

3. The outside lock nose piece (Fig 3) is suitable for Mono Lock type rivet, locking the retaining mandrel for greater strength and correct setting.

4. According to the needs of different positions and different rivets, different nozzle information is available upon request, flat nose piece (Fig 1) is standard in the product range.

5. The orifice of the nose piece. The correct gap between the nose piece and rivet stem is 0.2-0.5mm. (Consult the table below and your supplier for any special requirements)

# Rivet Selection

Rivet size		Ø 2.4mm	Ø 3.2mm	Ø 4.0mm	Ø 4.8mm	Ø 6.4mm	Ø 6.4mm structural
The orifice of the nozzle		Ø 1.7 <sup>+0.1</sup> <sub>0</sub> mm	Ø 2.2 <sup>+0.1</sup> <sub>0</sub> mm	Ø 2.7 <sup>+0.1</sup> <sub>0</sub> mm	Ø 3.3 <sup>+0.1</sup> <sub>0</sub> mm	Ø 4.3 <sup>+0.1</sup> <sub>0</sub> mm	Ø 4.5 <sup>+0.1</sup> <sub>0</sub> mm

# Repair and Maintenance

After every 5,000 rivets, thoroughly clean the build up of aluminium and iron dust from the gripper and paw in the top tube. This will prevent the rod sticking, stem slip and help to maintain one-time snap of the rivets. Regular cleaning will enhance the life of the tool.

- 1 Shut off air supply (Caution: please shut off the air supply when replacing jaws, jaw pusher and jaw pusher spring) to avoid damage to other components of the tool.
- 2 Disassembly the gun head(6#) by hand. There is no requirement for any tools.
- 3 Pull the lock (5#) and screw off the jaw guide (3#). There is no requirement for any tools.
- 4 Disassemble the jaws, jaw pusher and jaw pusher spring and clean them thoroughly. Please replace them if needed.
- 5 Assemble the parts by the reverse procedure of unassembling. Turning on of the air supply, and holding the trigger is allowed when installing the gun head. This makes it easier to screw back on.

# Replacing the Oil

The hydraulic oil will deteriorate or reduce after the riveter is used for a certain time. The stroke travel of the tool may reduce. This may cause the rivet to not set on the first stoke. Please re prime and fill 45# with hydraulic oil, using the priming syringe provided.

Method.

1. Disassemble the gun head (6#), using an allen key slowly loosen 45# oil screw and let the excess oil or air bubbles spills, and check the O-rings (90#) is damaged or not, please replace it if visual damaged can be determined.
2. Connect the air supply, let the oil filling hole on the top of the tool aim into a disposal oil tank (Do not aim at people or other items), then press the trigger (79#) to discharge waste oil. Repeat this process until the waste oil discharge has discharged completely.
3. Please fill the oil cylinder (23#) with hydraulic oil, using the re priming syringe provided. Please note that washer (90#) should be taken off the sealing screw (46#) and placed on the threaded are of the syringe. Slowly tighten the threaded part of the syringe into the oil cylinder (23#). Once in place, slowly start to apply pressure to the syringe to expel new oil into the cylinder. Repeat this process several times to fill the adequate amount of oil into the oil cylinder. Once resistance is felt in the syringe, this indicates the tool has a sufficient amount of oil place within it. Remove the washer (90#) from the syringe and replace back on to the sealing screw (46#). Screw the sealing screw (46#) back into the cylinder head (23#) and tighten accordingly.

# Trouble Shooting

Symptom	Possible cause	Remedy
Difficult setting the rivet	Jaw damaged	Change jaws
	Pressure insufficient	Adjust the air pressure to the specified range
	There is the oil shortage in riveter or there is the air bubbles in the oil	Re prime the tool with hydraulic oil
Jaws slipping and rivet stem	Jaws damaged	Change jaws
	Jaws dirty	Clean the jaws and fill the lube oil
	Jaw pusher spring failure	Change jaw pusher spring
	The nose piece is not correct	Use the proper nose piece
Rivet stuck in the tool	Jaws dirty	Clean the jaws
	Jaw pusher spring worn	Replace the jaw pusher spring
	Spent rivet mandrel stuck in the tool	Check oil level of tool
	Spent rivet mandrels stuck in the tool	Empty the collector bottle and clear guide tube of any jammed mandrels
Riveter no action	No pressure or pressure insufficient	Adjust the air pressure to the specified range
	No action when the trigger is pressed	Contact authorised RivRite repair centre

# **RIVRite**

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CA**