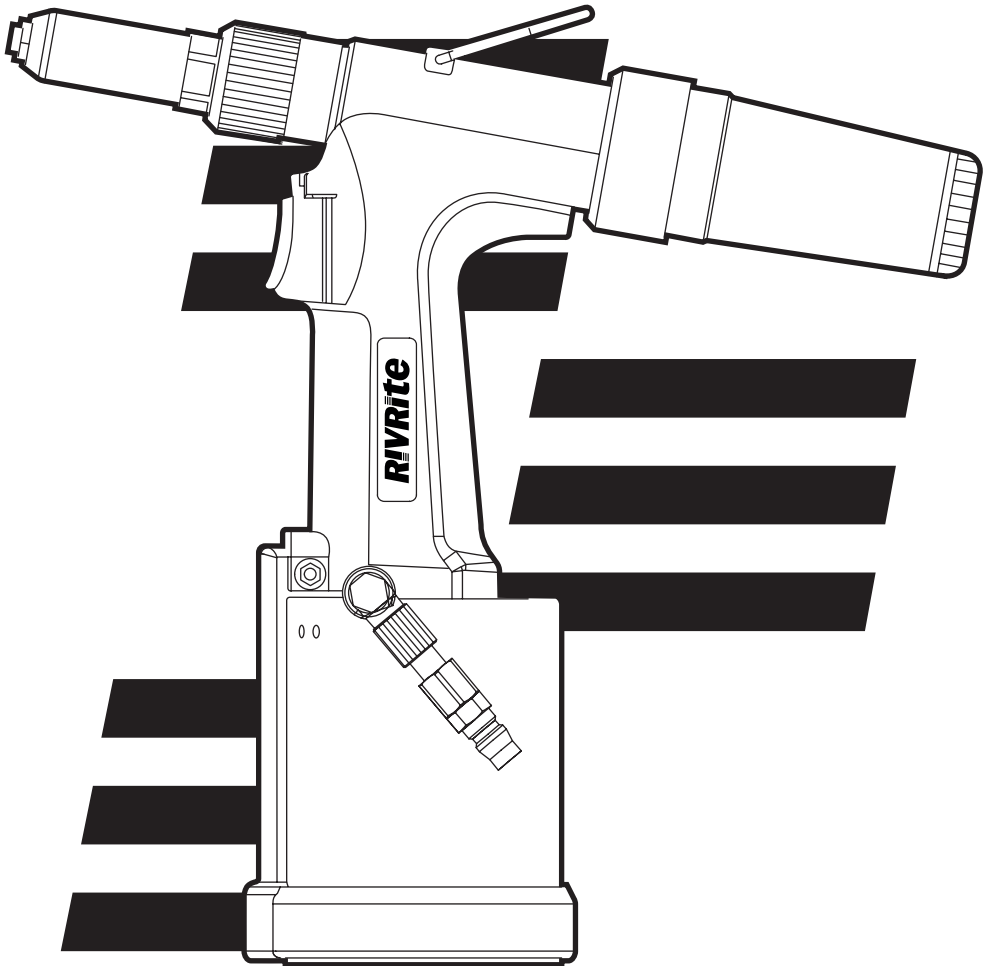


# RIVrite

RP2 Rivet Tool



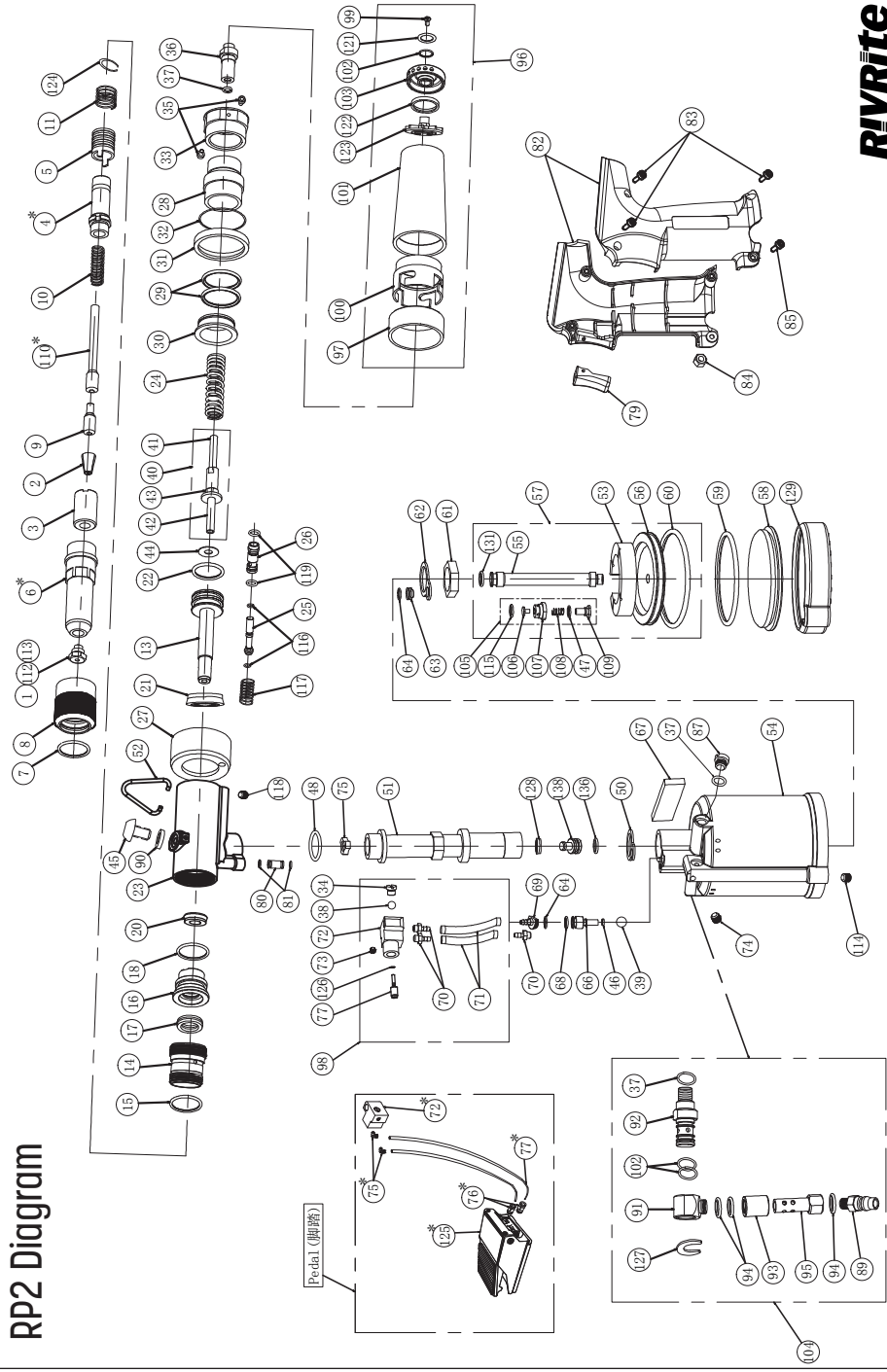
## Instruction Manual

## RP2 Parts List - With Mandrel Vacuum System

Item	Description	Part No	Item	Description	Part No	Item	Description	Part No	Item	Description	Part No
1	Nozzle 4.8	24M001A	28	End cap adapter	R4M028A	56	Piston plate	R4M056A	87	Screw	R4M087A
112	Nozzle 4.0	24M001B	29	O-Ring	B4M029A	57	"Air piston assembly"	Z4M057B	89	Joint Tail	C4R089B
113	Nozzle 3.2	24M001C	30	Slider	M4M030A	58	Cylinder bottom cover	R4M058A	90	Washer	B4R074A
2	Jaws	R4M002A	31	Sliding block	M4M031A	59	O-Ring	B4M059A	91	Conversion head	R4H188B
3	Jaw guide	R4M003A	32	O-Ring	B4M032A	60	O-Ring	B4M060A	92	Union joint	R4M092B
4	Pulling head	R4M004A	33	End cap	R4M033B	61	Sleeve lock nut	R4M061A	93	Switch the slider	R4H120D
5	Jaw guide lock	R4M005A	34	Screw	R4M034B	62	Washer	M4M062A	94	O-Ring	B4H121A
6	Nose housing	R4M006A	35	Screw	C4M035A	63	"Reversing the cover"	R4M063B	95	Joint set	R4H122C
7	O-Ring	B4M007A	36	Ejector guide	R4M036C	64	O-Ring	B4M064A	96	"Collector assembly"	Z4M096A
8	Nose housing nut	R4M008A	37	O-Ring	B4M037A	66	Reversing piston	R4M066B	97	Front collector	R4M097B
9	Jaw pusher	R4M009A	38	Bell(Rubber)	B4M418B	67	Silencing Cotton	D4M067A	98	Switch assembly	Z4M072G
10	Jaw pusher spring	D4M010A	39	Bell(Rubber)	312079A	68	O-Ring	B4M068A	99	Screw	D4M030D
11	Spring	D4M011A	40	Ejector assembly	Z4M040A	69	Reversing switch	R4M069B	100	"Collector lock collar"	R4M008B
13	Hydraulic piston	R4M013B	41	Ejector rod A	R4M041A	70	Screw	R4M070A	101	"Collector assembly"	M4M010A
14	Housing adapter	R4M014B	42	Ejector rod B	R4M042A	71	"Answer the trachea"	D4M071A	102	O-Ring	B4M102B
15	O-Ring	B4M015A	43	Ejector rod C	R4M043A	72	Trigger	R4M072G	103	Collector end	M4M103B
16	Rod seal case	R4M016B	44	Combined washer	M4M044A	73	Stop Screw	C4M073A	104	Joint assembly	Z4M104D
17	Scraper	B4M017A	45	Screw	C4R045B	74	Stop Screw	C4M074A	105	"Frustrated assembly"	Z4M105A
18	O-Ring	B4M018A	46	O-Ring	B4M046A	75	Oil distributor	R6L058A	106	Valve head	R4M106A
20	Oil seal	B4M020B	47	O-Ring	B4M047A	77	"Switch valve core"	R4M077D	107	Valve bush	R4M107A
21	Oil seal	B4M018C	48	O-Ring	B4R048A	79	Trigger	M4M079C	108	Elastic ring	D4M108A
22	O-Ring	B4M018B	50	Gasket	M4M050A	80	"connecting pipe set"	R4M080A	109	Valve rod	R4M109A
23	Oil cylinder	M4M023C	51	Oil rod	R4M051D	81	O-Ring	B4M081A	114	Stop Screw	G4M114A
24	Return spring	D4L024B	52	Hook	M4R052B	82	Handle	M4M082E	115	O-Ring	B4M115A
25	MCS valve rod-1	R4H030B	53	Crash pad	M4M053B	83	Screw	C4M083A	116	O-Ring	B4H031A
26	MCS valve rod-2	R4H029A	54	Air cylinder	M4M054A	84	Nut	C4M084A	117	Elastic ring	D4H032A
27	MCS cap	M4M027A	55	Piston rod	R4M055B	85	Screw	C4M085A	118	Screw	G4H062A

\* Interchangeable Parts

# RP2 Diagram

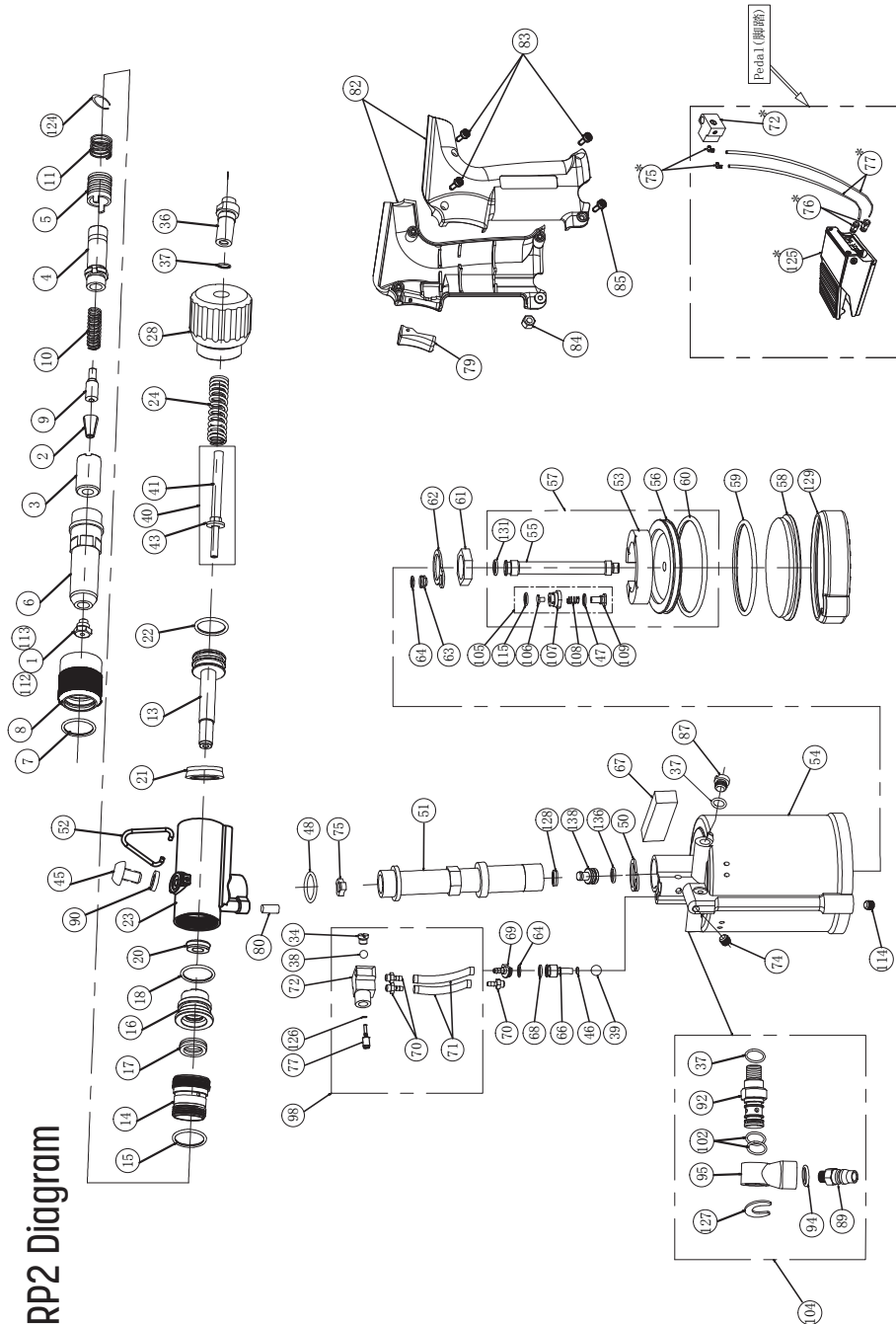


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## RP2 Parts List - Without Mandrel Vacuum System

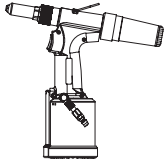
Item	Description	Part No	Item	Description	Part No	Item	Description	Part No	Item	Description	Part No			
1	Nozzle 4.8	24M001A	22	O-Ring	B4M018B	55	Piston rod	R4M055B	80	Connecting pipe set	R4M080B	124	Retaining ring	G4M124A
112	Nozzle 4.0	24M001B	23	Oil cylinder	M4M023D	56	Piston plate	R4M056A	82	Handle	M4M082E	126	O-Ring	B4M126B
113	Nozzle 3.2	24M001C	24	Return spring	D4L024B	57	Air piston assembly	Z4M057B	83	Screw	C4M083A	127	Clamp spring	G4M127A
2	Jaws	R4M002A	28	End cap adapter	R4M028D	58	Cylinder bottom cover	R4M058A	84	Nut	G4M084A	128	Oil seal	B4M128A
3	Jaw guide	R4M003A	34	Screw	R4M034B	59	O-Ring	B4M059A	85	Screw	C4M085A	129	Rubber base	M4M129A
4	Pulling head	R4M004A	36	Ejector guide	R4S036B	60	O-Ring	B4M060A	87	Screw	R4M087A	131	Support ring	B4M131A
5	Jaw guide lock	R4M005A	37	O-Ring	B4M037A	61	Sleeve lock nut	R4M061A	89	Joint tail	C4S089B	136	O-Ring	B4H086A
6	Nose housing	R4M006A	38	Bell(Rubber)	B4M141B	62	Washer	M4M052A	90	Washer	B4S074A	138	Oil seal column	R4M138A
7	O-Ring	B4M007A	39	Bell(Rubber)	312079A	63	Reversing the cover	R4M063B	92	Union joint	R4M092B	* Interchangeable Parts		
8	Nose housing nut	R4M008A	40	Ejector assembly	Z4M040B	64	O-Ring	B4M064A	94	O-Ring	B4H121A	* Interchangeable Parts		
9	Jaw pusher	R4M009A	41	Ejector rod A	R4M041C	66	Reversing piston	R4M066B	95	Joint set	M4S066B	72*	Conversion block	R4M072D
10	Jaw pusher spring	D4M010A	43	Ejector rod C	R4M043A	67	Silencing cotton	D4M067A	98	Switch assembly	Z4M072H	75*	Screw	G4M070B
11	Spring	D4M011A	45	Screw	G4S045B	68	O-Ring	B4M068A	102	O-Ring	B4M102B	76*	Screw	G4M070C
13	Hydraulic piston	R4M013B	46	O-Ring	B4M046A	69	Reversing switch	R4M069B	104	Joint assembly	Z4M104C	77*	Answer the trachea(1.5m)	D4M071C
14	Housing adapter	R4M014B	47	O-Ring	B4M047A	70	Screw	R4M070A	105	Frustrated assembly	Z4M105A	125*	Pedal	G4M118A
15	O-Ring	B4M015A	48	O-Ring	B4S048A	71	Answer the trachea	D4M071A	106	Valve head	R4M106A	* Interchangeable Parts		
16	Rod seal case	R4M016B	50	Gasket	M4M050A	72	Trigger	R4M072H	107	Valve bush	R4M107A	* Interchangeable Parts		
17	Scraper	B4M017A	51	Oil rod	R4M051D	74	Stop screw	G4M074A	108	Elastic ring	D4M108A	* Interchangeable Parts		
18	O-Ring	B4M018A	52	Hook	M4S052B	75	Oil Distributor	R4L058A	109	Valve rod	R4M109A	* Interchangeable Parts		
20	Oil seal	B4M020B	53	Crash pad	M4M053B	77	"Switch valve core"	R4M077D	114	Stop screw	G4M114A	* Interchangeable Parts		
21	Oil seal	B4M018C	54	Air cylinder	M4M054A	79	Trigger	M4M079C	115	O-Ring	B4M115A	* Interchangeable Parts		

# RP2 Diagram

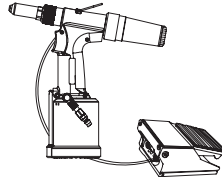


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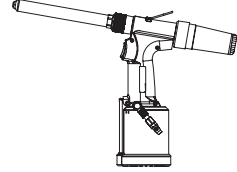
# Pneumatic Riveting Tool Instructions



Inspired air



Pedal



Extended



- Please read the operation instructions before using



- Please wear protective glasses when using the rivet tool

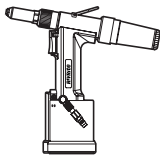
- The air supply pressure range is 5.5-6.5kgf/cm<sup>2</sup>

- 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 RP2:

Rivet size:  $\varnothing$  3.2mm-  $\varnothing$  4.8mm      Stroke range:18mm

Maximum pulling force:9230N      Gun head diameter:  $\varnothing$  20.5mm



Figure 1  
Flat Nozzle

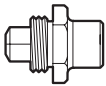


Figure 2  
Convex Nozzle



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 stroke. Please re prime and fill 46# 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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