SRC-56P Instruction Manual

This instruction manual must be read with particular attention to the following safety direction, by any person installing, operating, or servicing this tool.

Never dismantle the tool without first having thoroughly studied the instructions given in this User Manual and applying them.

- **Always use the tool in accordance with the specified safety instructions. Direct any queries regarding optimal and safe operation or use of the tool to our company.**

- **The safety instructions must be made clear to all persons involved.**

- **Never connect the tool to any medium other than compressed air. Set the air pressure between 5 to 7bar.**

- **Do not use the tool other than placing break stem rivet.**

- **The tool must be maintained in a safe working condition at all times and examined at regular intervals for damage and function by trained competent personnel. Do not dismantle this tool without prior reference to the maintenance and service instructions.**

- **Always disconnect the airline from the tool inlet before attempting to maintenance and service.**

- **Do not operate the tool that is directed towards any person or the operator.**

- **When using the tool, the wearing of safety glasses is required both by the operator and others in the vicinity to protect against rivet stem ejection.**

- **Characteristic**

- Powerful durable, high speed production tool
- Longer stroke, could set up rivets with longer body in one time
- Minimized noise
- Machining part, imported seals, enhances tool life
- Ergonomic
- Light Weight, reduces operator fatigue

- **Technical Parameter：**

Capacity：Φ4.0- Φ 6.4 (5/32”~1/4”) for aluminum and steel blind rivets &
Φ4.0- Φ 4.8 (5/32”~3/16”) for stainless steel blind rivets
Stroke：20mm
Pull Force：10.0KN
Air Pressure：5-7bar
Weight：1.50kgs

- **Air Supply Requirement**

- All tools are operated with compressed air at the range of 3~7Kgf/cm2 (45~105psi).
- We recommended the use of pressure regulators and filtering systems on the main air supply. These should be fitted within 3 meters of the tool to ensure maximum tool life and minimum tool maintenance.
- Air supply hoses should have a minimum working pressure rating of 150% of the maximum pressure produced in the system or 10 bar, whichever is the highest.
- Air hoses should be oil resistant, have an brasion resistant exterior and should be armoured where operating conditions may result in hoses being damaged.
- All air hoses must have a minimum bore diameter of 6.4 millimeters or 1/4 inch.

- **Maintenance**

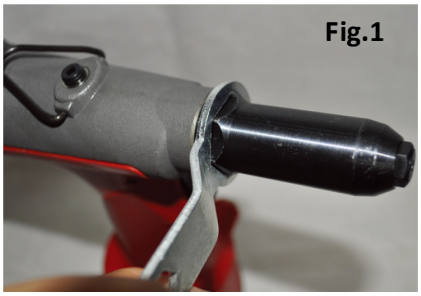
Cleaning

Attention: Disconnect the air supply during all operations.

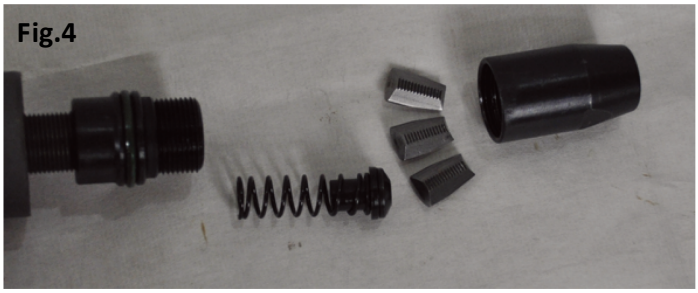
Every 10,000 cycles the jaws, jaw housing and upper housing should be cleaned.

1. Disconnect the air supply.

2. Unscrew nosepiece, outer cylinder, then jaw housing. (Fig.1, Fig.2)



3. Clean aluminum scraps in outer cylinder, jaw housing, jaws. (Fig.3, Fig.4)



- **Maintenance**

Adding Oil

Attention:

Keep the tool upright during all operations.

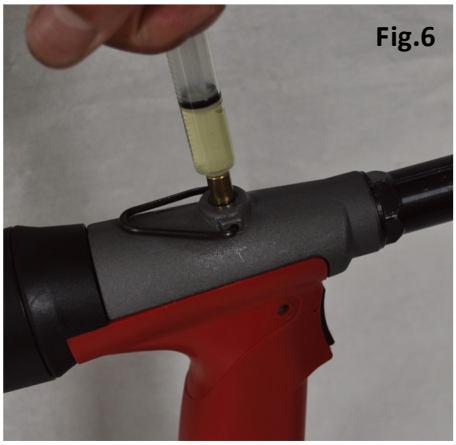
Connect the air supply, do not press the trigger.

There might be insufficient oil if you are not able to set the rivet in one hit. Without proper lubrication the tool will not work properly and parts will wear prematurely.

1. Unscrew the oil fill screw from the body using the hex key supplied with the tool.(Fig.5)

Fig.5

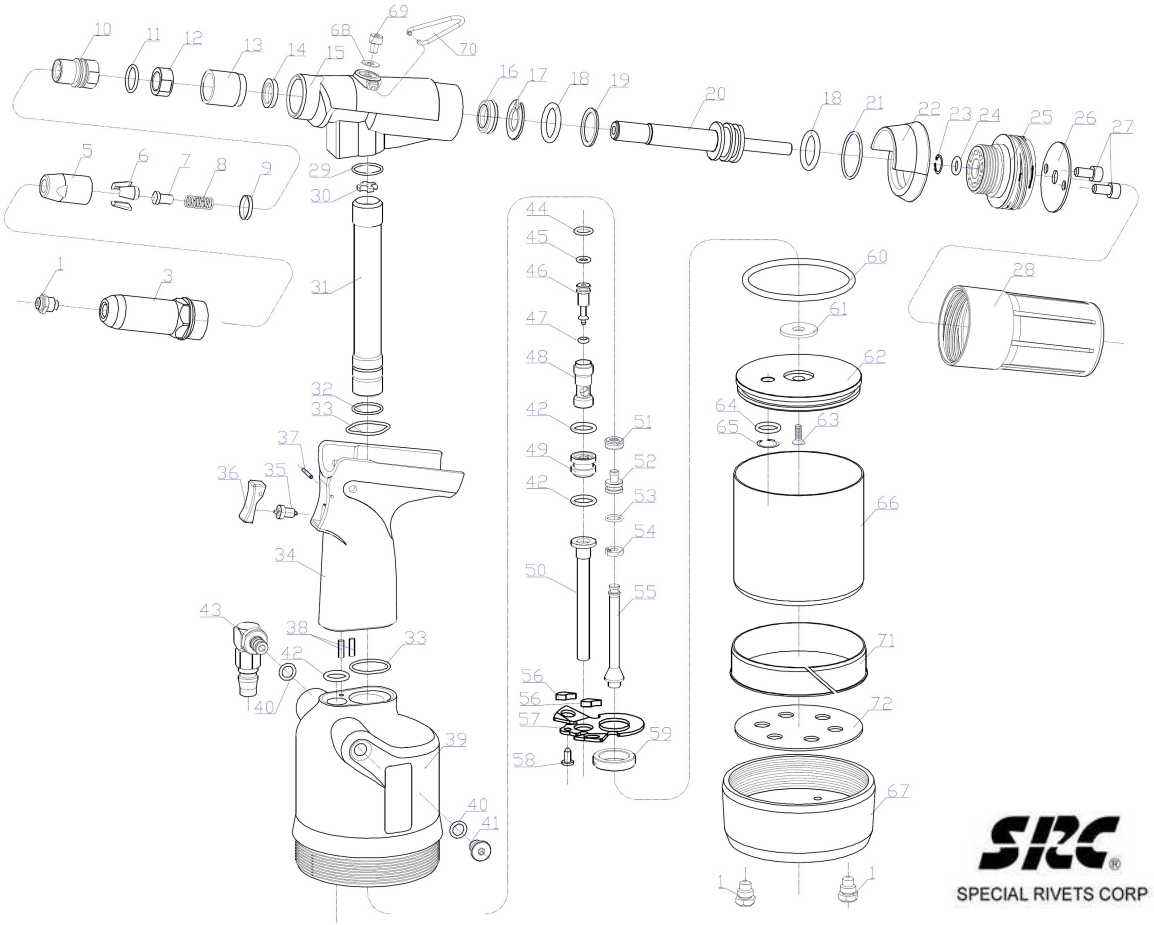
Fig.6



2. Fill the syringe (supplied with the tool) with hydraulic oil. Screw the filled syringe in the oil fill screw hole. Inject all of the oil in the syringe into the tool, adequate oil has been added if there is oil flowing back to the syringe when you loosen your hand, then keep pressing the syringe for two or three times, in order to prevent air go into the oil in the tool. (Fig.6)

3. Unscrew and remove the syringe from the body, then screw the oil fill screw into the hole using the hex key, wipe off any excess oil.

NO.	SRC PART#	DESCRIPTION	Requiry QTY (pcs)	NO.	SRC PART#	DESCRIPTION	Requiry QTY (pcs)	NO.	SRC PART#	DESCRIPTION	Requiry QTY (pcs)
1	SRC-56P-1	NOSEPIECE 4.0MM	1	27	SRC-56P-27	BOLT	2	53	SRC-56P-53	O RING	1
1	SRC-56P-1	NOSEPIECE 4.8MM	1	28	SRC-56P-28	STEM COLLECTOR	1	54	SRC-56P-54	PISTON RING	1
1	SRC-56P-1	NOSEPIECE 6.4MM	1	29	SRC-56P-29	O RING	1	55	SRC-56P-55	PISTON ROD	1
3	SRC-56P-3	OUTER SLEEVING	1	30	SRC-56P-30	STAR WASHER	1	56	SRC-56P-56	SILENCER	2
5	SRC-56P-5	JAW CASE	1	31	SRC-56P-31	OIL TUBE	1	57	SRC-56P-57	CLAMP PLATE	1
6	SRC-56P-6	JAWS (3pcs=1set)	3	32	SRC-56P-32	O RING	1	58	SRC-56P-58	TAPPING SCREW	1
7	SRC-56P-7	JAW SPREADER	1	33	SRC-56P-33	O RING	2	59	SRC-56P-59	SET NUT	1
8	SRC-56P-8	SPRING	1	34	SRC-56P-34	HANDLE	1	60	SRC-56P-60	O RING	1
9	SRC-56P-9	LOCK RING	1	35	SRC-56P-35	TRIGGER VALVE	1	61	SRC-56P-61	WASHER	1
10	SRC-56P-10	JAW SPREADER HOUSING	1	36	SRC-56P-36	TRIGGER	1	62	SRC-56P-62	CYLINDER PISTON	1
11	SRC-56P-11	O RING	1	37	SRC-56P-37	TRIGGER PIN	1	63	SRC-56P-63	BOLT	1
12	SRC-56P-12	SET NUT	1	38	SRC-56P-38	SPRING PIN	2	64	SRC-56P-64	O RING	1
13	SRC-56P-13	PLASTIC SEAL SLEEVING	1	39	SRC-56P-39	PLASTIC CYLINDER	1	65	SRC-56P-65	CIRCLIP	1
14	SRC-56P-14	SEALING RING	1	40	SRC-56P-40	O RING	2	66	SRC-56P-66	AIR CYLINDER	1
15	SRC-56P-15	HEAD ASSEMBLY	1	41	SRC-56P-41	SCREW	1	67	SRC-56P-67	BASE COVER	1
16	SRC-56P-16	LIP SEAL	1	42	SRC-56P-42	O RING	3	68	SRC-56P-68	WASHER	1
17	SRC-56P-17	SEAL RETAINER	1	43	SRC-56P-43	AIR INLET ASSEMBLY	1	69	SRC-56P-69	OIL SCREW	1
18	SRC-56P-18	O RING	2	44	SRC-56P-44	O RING	1	70	SRC-56P-70	HOOK	1
19	SRC-56P-19	PLASTIC RING	1	45	SRC-56P-45	O RING	1	71	SRC-56P-71	GAP RING	1
20	SRC-56P-20	HEAD PISTON	1	46	SRC-56P-46	VALVE CORE	1	72	SRC-56P-72	CRASH PAD	1
21	SRC-56P-21	O RING	1	47	SRC-56P-47	O RING	1				
22	SRC-56P-22	STEM COLLECTOR ADAPTOR	1	48	SRC-56P-48	VALVE BODY	1				
23	SRC-56P-23	CIRCLIP	1	49	SRC-56P-49	VALVE BASE	1				
24	SRC-56P-24	O RING	1	50	SRC-56P-50	TRANSFER TUBE	1				
25	SRC-56P-25	END CAP	1	51	SRC-56P-51	LIP SEAL	1				
26	SRC-56P-26	STEEL PLATE COVER	1	52	SRC-56P-52	AIR TUBE PISTON	1				



SPECIAL RIVETS CORP