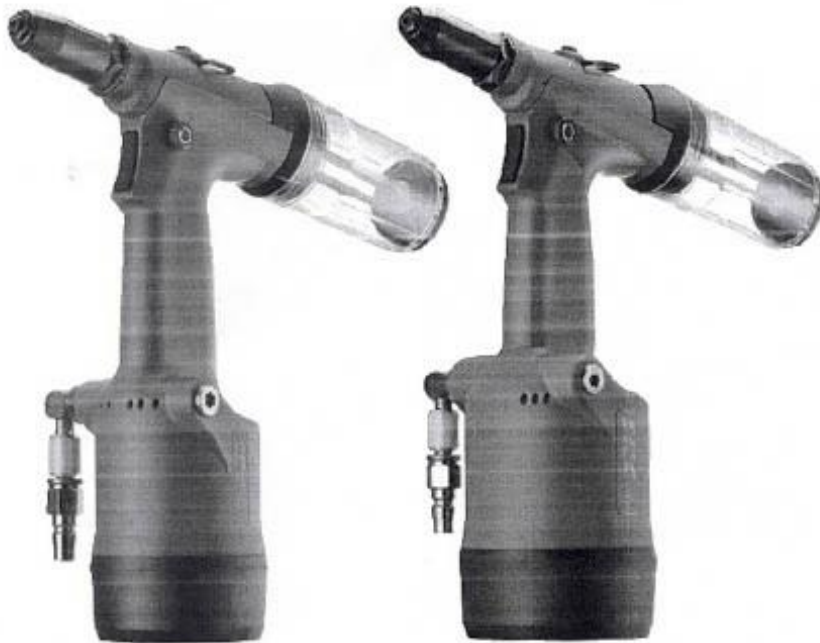




RIFSYS TECHNOLOGIES

A5/A6

Instruction Manual



Read All Safety Rules and Instructions Carefully

Save this manual for Future Reference

Never dismantle the tool without first having thoroughly studied the instructions given in this manual

- **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 3 to 7bar.**
- **Do not use the tool other than placing break stem blind 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 instruction.**
- **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.**

Note: maintenance and repair only by technical maintenance staff.

- **Characteristic**

- * Powerful and durable high speed production tool
- * Longer stroke, could set up rivets with longer body in one time
- * Machining parts and imported seals to enhance tool life
- * Ergonomic design
- * Light Weight, reduces operator fatigue
- * Adjustable vacuum airflow, minimizes air consumption

- **Technical Parameter:**

Model#	Capacity	Nosepiece included (mm)	Weight	Stroke	Air Pressure	Pull Force
SRC-A5	3.2mm*4.8mm (1/8"*3/16") aluminum and steel blind rivets & 3.2mm*4.0mm (1/8"*5/32") stainless steel blind rivets	Q13.2 Q14.0 Q14.8	1.2kgs	18mm	5-7bar 70-95psi	7KN
SRC-A6	4.0mm*6.4mm (5/32"*1/4") aluminum and steel blind rivets & 4.0mm*4.8mm (5/32"*3/16") stainless steel blind rivets	Q14.0 Q14.8 Q16.4	1.5kgs	20mm		10KN

- **Air Supply Requirement**

- All tools are operated with compressed air at the range of 3N7Kgf/cm² (45N105psi). 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 abrasion 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.

● PREPARATION

Determine the size rivet that you are going to use. The nosepiece screwed on rivet tool head is the nosepiece for the largest rivet size the tool can set.

Changing Nosepieces:

To change the nosepiece, remove it from rivet tool using wrench (not included). Select the nosepiece that corresponds to the rivet size you are using and screw nosepiece clockwise onto rivet tool head.

Setting Rivets:

- Attach air line to air supply.
- Turn on the ON/OFF valve on by pushing the deflector ring up. (Fig. 1)
- Insert the rivet mandrel into nosepiece.

The rivet will be held in place by the vacuum. If rivet falls out of the nosepiece, vacuum is not strong enough. To increase amount of suction, adjust vacuum adjusting button located on the side of the handle. (Fig.2)

- Push the trigger to set the rivet. Release the trigger once the rivet is set. The rivet stem is automatically transported to the nail container (part# 33) by the set suction.

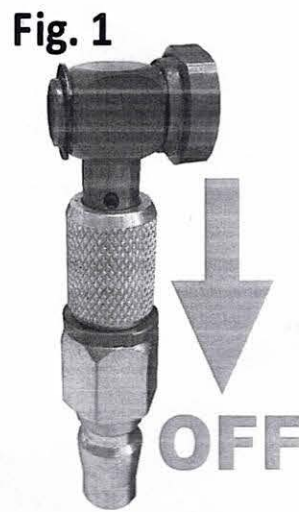
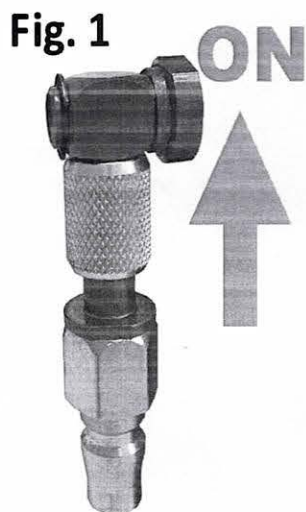


Fig. 2

Vacuum Adjusting Button



● Maintenance

Cleaning

Attention: Disconnect the air supply during all operations.

Every 5,000 cycles the jaws of the tool should be cleaned and oiled.

- 1) Unscrew the nose casing (part #3)
- 2) Use two wrenches (not included) to remove jaw housing (part #5)
- 3) Clean jaws (part #6), jaw housing (part #5), jaw spreader (part #7), spring (part #8) and thread area of the pulling head with a wire brush.
- 4) Lubricate the jaws, apply one drop of machine oil on outside of jaws (not serrated side). (Fig. 4)
- 5) Return jaws into jaw housing ensuring proper placement of jaws.

Fig. 3

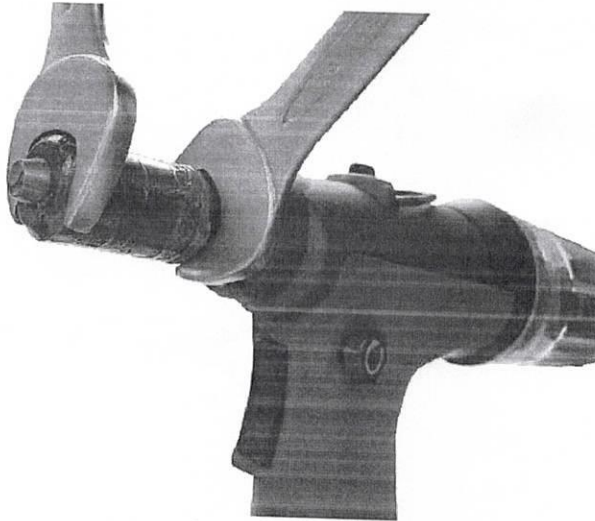


Fig. 4



● Maintenance

Adding Oil

Attention:

Keep the tool upright during all operations. Connect the tool to the air supply and turn on the ON/OFF valve to "on" position. (Fig. 1)

*** Note: Don't push the trigger.

When the travel decreases or a blind rivet is not completely pulled or after approximately 100,000 cycles, please check and fill up hydraulic oil level.

- 1) Unscrew the oil screw (part# 80) and remove the washer (part# 79) from the head assembly using the allen wrench included. (Fig. 5)
- 2) Fill the syringe (included) with hydraulic oil, screw the filled syringe in the oil fill screw hole. (Fig. 6)
- 3) Inject all of the oil in the syringe into the tool, adequate oil has been added if there is oil flow back to the syringe when you loosen your hand, then keep pressing the syringe for two or three times, in order to make sure there is no air go into the oil in the tool.
- 4) Unscrew and remove the syringe from the head assembly, put the washer back and screw the oil screw tightly.
- 5) Wipe off any excess oil around the filler hole.
- 6) Screw the oil screw into the hole using the allen wrench.

Fig. 5

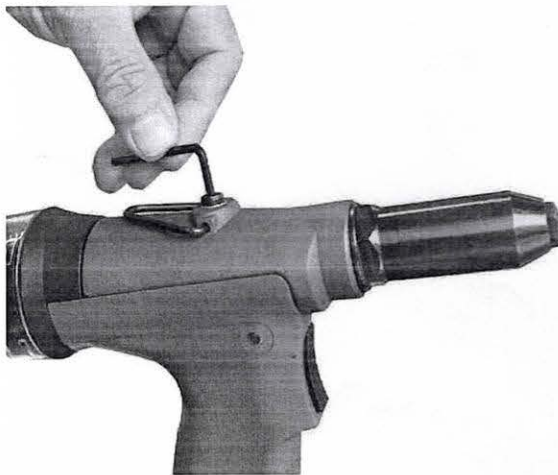
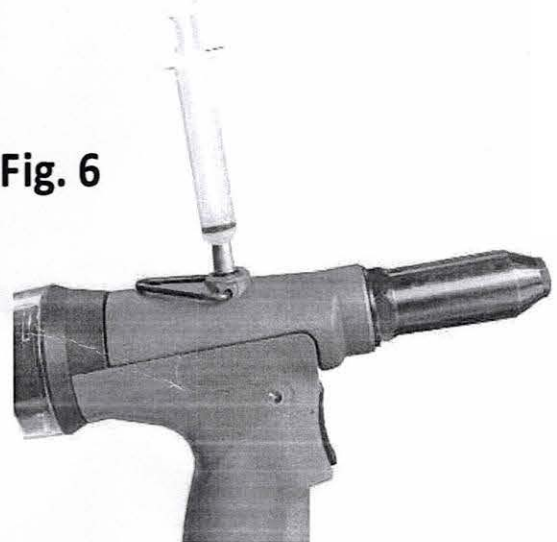


Fig. 6



NO.	PART#	DESCRIPTION	Require QTY (pcs)	NO.	PART#	DESCRIPTION	Require QTY (pcs)	NO.	PART#	DESCRIPTION	Require QTY (pcs)
1	NA-1	NOSEPIECE	1	29	NA-29	O RING	1	57	NA-57	VALVE BODY	1
2	NA-2	O RING	1	30	NA-30	O RING	1	58	NA-58	O RING	3
3	NA-3	NOSE CASING	1	31	NA-31	SAFETY DEVICE	1	59	NA-59	VALVE SEAT	1
4	NA-4	O RING	1	32	NA-32	RETAINER	1	60	NA-60	TRANSFER TUBE	1
5	NA-5	JAW HOUSING	1	33	NA-33	NAIL CONTAINER	1	61	NA-61	LIP SEAL	1
6	NA-6	JAW'S (3 pcs=1 set)	3	34	NA-34	SILENCER	1	62	NA-62	OIL TUBE PISTON	1
7	NA-7	JAW SPREADER	1	35	NA-35	SILENCER COVER	1	63	NA-63	O RING	1
8	NA-8	SPRING	1	36	NA-36	WASHER	1	64	NA-64	PISTON RING	1
9	NA-9	LOCK RING	1	37	NA-37	SCREW	1	65	NA-65	PISTON ROD	1
10	NA-10	JAW SPREADER HOUSING	1	38	NA-38	O RING	2	66	NA-66	CLAMP PLATE	1
11	NA-11	POLYURETHANE RING	1	39	NA-39	VACCUUM VALVE	1	67	NA-67	SET NUT	1
12	NA-12	VACUUM SLEEVE	1	40	NA-40	O RING	1	68	NA-68	SILENCER	2
13	NA-13	POLYURETHANE RING	1	41	NA-41	STAR WASHER	1	69	NA-69	TAPPING SCREW	1
14	NA-14	SET NUT	1	42	NA-42	OIL TUBE	1	70	NA-70	O RING	1
15	NA-15	O RING	1	43	NA-43	O RING	1	71	NA-71	WASHER	1
16	NA-16	SEAL HOUSING	1	44	NA-44	O RING	2	72	NA-72	PISTON	1
17	NA-17	SEALING RING	1	45	NA-45	HANDLE	1	73	NA-73	BOLT	1
18	NA-18	HEAD ASSEMBLY	1	46	NA-46	TRIGGER VALVE	1	74	NA-74	O RING	1
19	NA-19	LIP SEAL	1	47	NA-47	TRIGGER	1	75	NA-75	RETAINING RING	1
20	NA-20	SEAL RETAINER	1	48	NA-48	TRIGGER PIN	1	76	NA-76	ALUMINUM AIR CYLINDER	1
21	NA-21	O RING	2	49	NA-49	SPRING PIN	2	77	NA-77	BASE COVER	1
22	NA-22	PLASTIC RING	1	50	NA-50	PLASTIC CYLINDER	1	78	NA-78	ON/OFF ASSEMBLY	1
23	NA-23	HEAD PISTON	1	51	NA-51	O RING	2	79	NA-79	WASHER	1
24	NA-24	STEM COLLECTOR ADAPTOR	1	52	NA-52	SCREW	1	80	NA-80	OIL SCREW	1
25	NA-25	O RING	1	53	NA-53	O RING	1	81	NA-81	HOOK	1
26	NA-26	END CAP	1	54	NA-54	O RING	1	82	NA-82	ADJUSTING BUTTON	1
27	NA-27	O RING	1	55	NA-55	VALVE CORE	1	83	NA-83	GAP RING	1
28	NA-28	RETAINING RING	1	56	NA-56	O RING	1	84	NA-84	CRASH PAD	1

