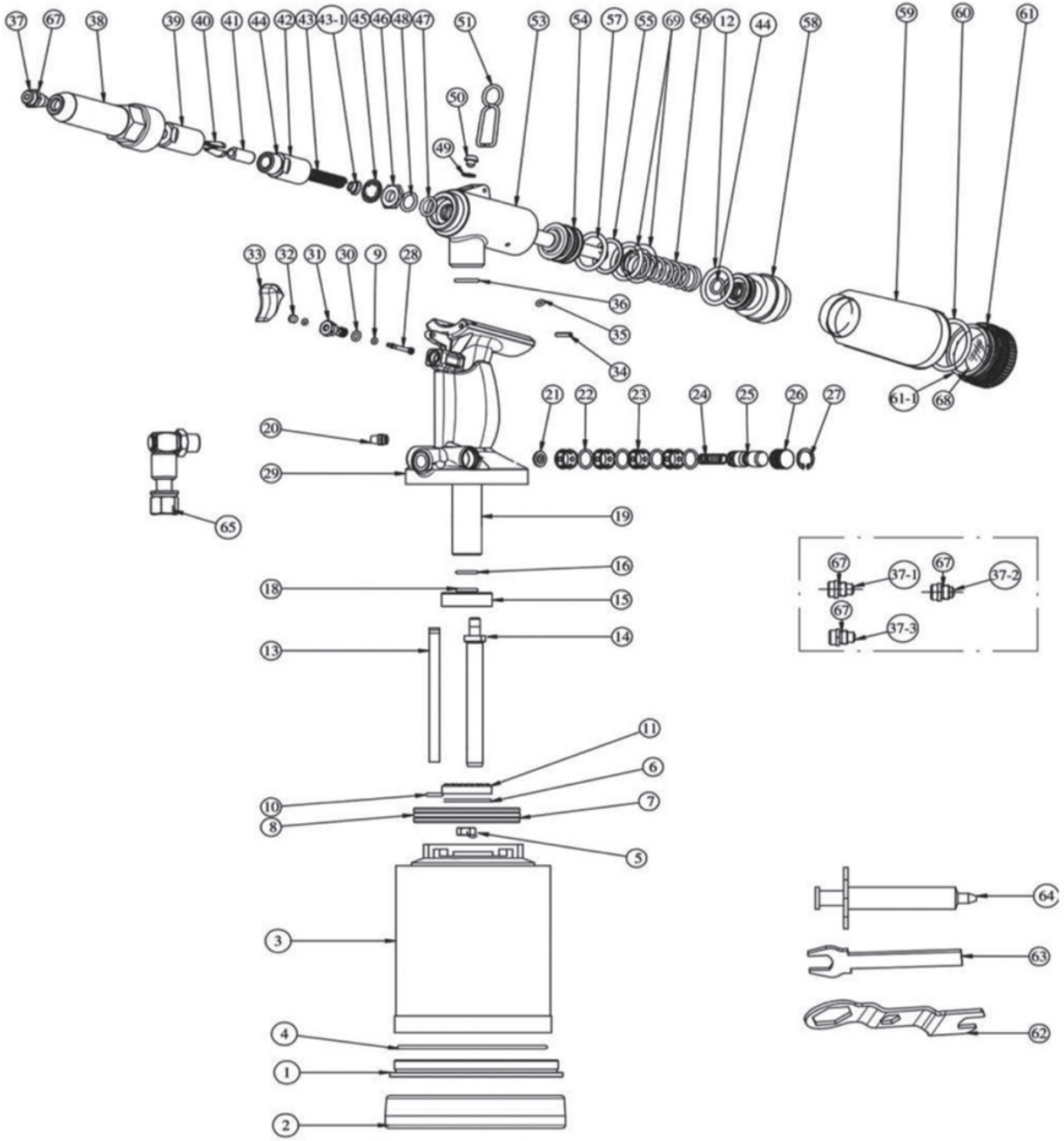
INSTRUCTIONS

AIR RIVETER item 1946C 7,8 (from sn 00900-01099)

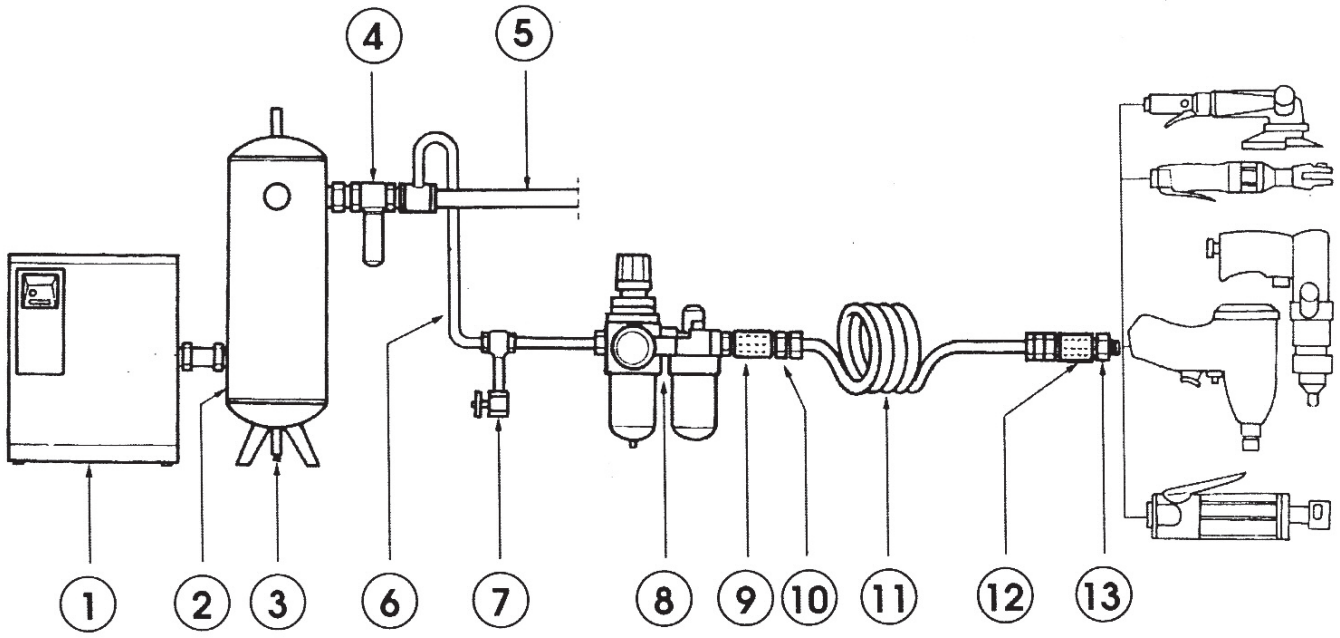
Part. No.	Code	Description
1	019460901	Cylinder Cap
2	019460902	Rubber Bottom
3	019460903	Air Cylinder Body
4	019460904	O-Ring
5	019460905	Crash Washer
6	019460906	Washer
7	019460907	Air Piston
8	019460908	O-Ring
9	019460809	O-Ring (2 pcs.)
10	019460810	O-Ring
11	019460805	Crash Washer
12	019460912	O-Ring
13	019460913	Tube
14	019460914	Rod
15	019460915	Stem Nut
16	019460816	Seal
17	019460917	O-ring
18	019460918	Wear Ring
19	019460919	Stem
20	019460820	Muffler
21	019460821	Pad
22	019460822	O-Ring (4 pcs.)
23	019460823	Cage (4 pcs.)
24	019460824	Spring
25	019460825	Valve
26	019460826	Valve Cap
27	019460827	Retaining Ring
28	019460828	Valve Piston
29	019460829	Handle Body
30	019460830	O-Ring
31	019460831	Trigger Insert
32	019460832	Trigger Head
33	019460833	Trigger
34	019460834	Spring Pin
35	019460835	O-Ring
36	019460836	O-Ring
37	019460937	Nosepiece 6,4 mm
37-1	019460970	Nosepiece 5,6 mm
37-2	019460971	Nosepiece 4,8 mm
37-3	019460972	Nosepiece 7,8 mm
38	019460938	Frame Head
39	019460939	Jaw Housing
40	019460940	Jaw (3 pcs.)
41	019460941	Jaw Pusher
42	019460942	Jaw Housing Coupler
43	019460943	Spring
43-1	019460944	Spring Collar
44I	019460974	O-ring
45	019460946	Case Washer
46	019460947	Case Lock Nut
47	019460948	Seal
48	019460848	O-Ring
49	019460849	Oil Seal Washer
50	019460951	Hexagon Socket Screw
51	019460851	Hook
52I	019460975	Rod rear axle
52-1I	019460976	O-ring
53	019460953	Oil Cylinder Body
54I	019460977	Piston rod
55	019460955	Back-up Ring
56	019460956	Spring
57	019460957	O-Ring
58I	019460978	Frame cap nut
59	019460959	Spent Mandrel Bottle
60	019460859	O-Ring
61	019460860	Cushion
61-1	019460861	Silencer
62	019460963	Spanner
63	019460964	Spanner Gauge
64	019460965	Oil Can
65	019460865	Shoutoff Valve
67	019460967	O-Ring (5 pcs.)
68	019460868	Protection Cap

1946C 7,8

Until serial number 00900-01099



INSTALLATION SYSTEM



1 *AIR COMPRESSOR*

2 *AIR TANK*

3 *AUTOMATIC CONDENSATE DRAIN*

4 *MAIN FILTER*

5 *MAIN PIPEWORK*

6 *SUPPLY LINE*

7 *CONDENSATE DRAIN*

8 *FILTER-REGULATOR-LUBRICATOR 1/4”*

9 *COUPLER 1/4”*

10 *COUPLING 1/4”*

11 *HOSE 10 mm*

12 *COUPLER 1/4”*

13 *COUPLING 1/4”*

INSTRUCTIONS

AIR RIVETER
item 1946C 7,8

INSTRUCTION MANUAL FOR AIR RIVETERS

Tool distributed by:
BETA UTENSILI SPA

TO BE ABSOLUTELY DELIVERED TO THE USER

To reduce the risk of any, damage to people, before using or repairing the tool, doing any maintenance jobs or replacing any accessories,
READ ALL THE SECTIONS OF THE INSTRUCTION MANUAL CAREFULLY.

SAFETY INSTRUCTIONS FOR AIR RIVETERS
It is our aim to supply air tools which allow you to work efficiently and SAFELY.
It is however understood that YOU are the most important 'safety device' for any tool, as taking meticulous care is the best way of preventing injury.
Although we cannot enumerate all types of risks here, we tried to lay stress on some of the most significant ones.
Let us remind you that this tool must be used only by skilled workers and that the machine must never be forced; do not overload the tool.

RISKS DUE TO CONNECTION TO COMPRESSED AIR
Compressed air may harm people severely.
Do not direct air towards you or any other people.
The air coming out of the hoses may harm people severely; periodically check whether the hoses and/or fittings are loose and/or have been damaged.
Whipping hoses may cause severe damage.
Before handling the tool, close the main plant, release residual pressure and disconnect the tool only when it is not working.
Pressure must not exceed 6.2 bar, as measured at the air inlet while the tool is working, or the value shown on the tool plate.

RISKS OF VARIOUS KINDS
Stay at a safety distance from the rotating parts of the tool.
Do not wear any accessory round your neck, such as chains or necklaces. Do not wear any bracelets or loose clothes.
Avoid contact of accessories and tools with your hair.
Avoid contact with any accessories in motion, while the tool is being used or after it has been used.

Always wear work gloves to reduce the risk of cutting and burning yourself.

RISKS DUE TO SPLINTERS AND FRAGMENTS
Warning: small splinters and fragments may also harm your eyes and result in blindness.
Always wear eye protection while using the tool, doing any maintenance jobs and replacing any accessories or spare parts. This measure must also be taken by anyone who works nearby.

RISKS RELATED TO WORKING CONDITIONS
Mind too long hoses left at the work station; stumbling and falling is likely to result in severe injury.
High noise levels may result in permanent loss of hearing; **wear ear protection, as recommended by the employer and/or the regulations**.
Stay in a safe, well-balanced position.
Repetitive movements and awkward positions combined with vibrations may cause your hands and arms to be harmed; special precautions should be taken.
Do not breathe dust and waste; partially protect yourself with a filtering mask.
Both the workers and the maintainers must be physically fit for the size, weight and power of this tool.
This tool was not designed to be used in areas exposed to the risk of explosion and is not so insulated as to come into contact with power sources.

OTHER SAFETY REQUIREMENTS
This tool and its parts and accessories must not be modified and/or tampered with.
The building material of this tool may be subject to wear.
Working with compressed air tools may result in high vibrations; therefore, take any precautions needed.
Prevent your hands from being trapped between the tool and any object.

FOR FURTHER INFORMATION ABOUT SAFETY REFER TO THE FOLLOWING:
The documents, information and instructions supplied with this tool;
The employer, trade associations and/or trade unions;
The EEC Council and/or local authorities
"Safety Requirements for Hand Held Non-Electric Tools", available at: European Committee for Standardization, Rue de Stassart 36, 1050 Brussels, Belgium.

REQUIREMENTS FOR PROPER AIR CONNECTION
Feed the tool with clean air, free from water or condensate, at a pressure of 6.0 bar, as measured at the air inlet, while the tool is working.
An excessively high pressure results in a shorter life for the mechanical parts and may cause people to be severely harmed.
Connect the tool to the feeding plant, using accessories of the same size as that shown in the enclosed drawing.
Do not fix any quick couplers directly into the air inlet.
Consult the instructions to connect the accessories properly.
Consult the specifications in this manual.

A. Preparing air riveter

Follow the steps below to install the required rivet nozzle:

– Loosen and remove the screw (part 37). To make it easier to replace the nozzle, unscrew the nozzle holder by 2 or 3 turns (part 38). Then fit the required nozzle (part 37 ~ 37-3) onto the nozzle holder.
– Loosen the nozzle holder (part 38) and remove it from the cylinder body (part 53).
– Loosen the clamps holding cone (part 39) from the cone holding head (part 42).
– Take out the clamp and the clamp opener (parts 40 and 41); then replace them with the relevant clamp and clamp opener.
– Then install the clamps holding cone and check adjustment, so that it can match the caliper wrench (part 63).
– Finally, assemble the nozzle holder and lock it with the relevant, previously loosened nut.

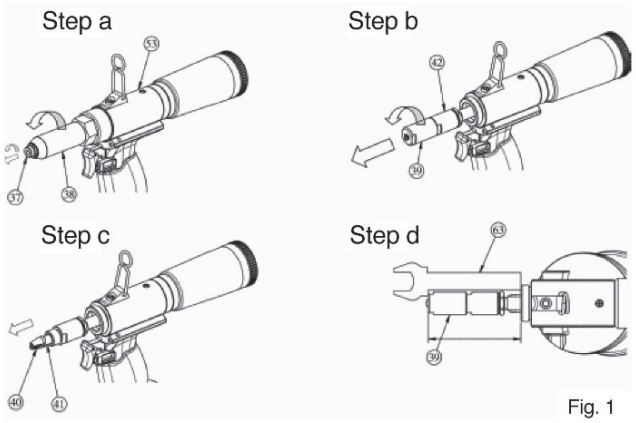


Fig. 1

B. Using air riveter

– Open the air inlet (part 65), to let air into the air riveter. While using the air riveter, the air inlet (part 65) must be open, to allow rivet suction.
– Turning the adjusting screw in part 58 allows suction adjustment. Turning the screw clockwise allows suction to be reduced.
– Use the nozzle with the relevant rivet; then press the trigger (part 33) to release the rivet rod into the rivet container (part 59).
– When the rivet container (part 59) is full, unscrew the adapter (part 61) and empty the rivet container.
– After cleaning it all, screw the adapter (part 61) into the rivet container (part 59). Then use the air riveter again, following the steps above.

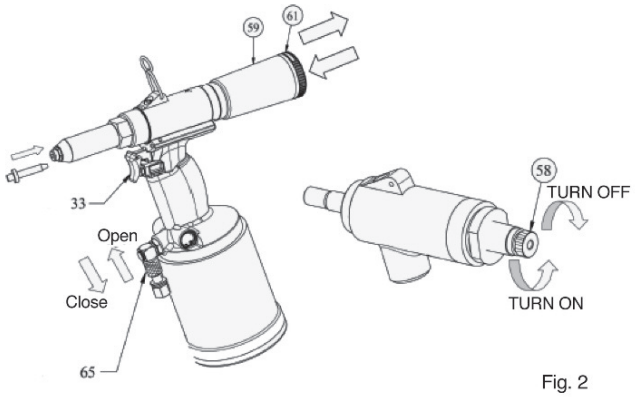


Fig. 2

Fixing problems

Stop using the tool immediately if any of the following problems should occur. Any repair or replacement must be performed by a trained person or an authorized service centre.

Problem	Cause	Remedy
Rivet jammed	Wrong size of rivet	Different rivets require different nozzles, clamps and clamp openers. Read manual and check rivet size again (fig. 1).
	Filings jammed in part 39	Use adjustable wrench or wrench 63 to remove part 38; then use supplied wrench to remove spare part 39. Remove any deposits from parts. Lock parts 38 and 39 (fig. 1).
	Filings on part 37	This might occur when aluminium rivets are pulled. Use a sharp tool to remove filings from part 37.
No suction	Shut-off valve has not been opened	See fig. 2.
Air leaking	Damaged O-rings	Replace O-rings.
	Loose screws	Tighten screws.
Air riveter runs slow or suffers a loss of power	Air line is loose	Reinstall and tighten airline.
	Exhaust port (part 20) is blocked	Clean out exhaust port (part 20).
	Operating pressure is too low	Increase operating pressure to 5.9÷6.6 bar.

Tips

Clean parts 38~42 and oil every 500 uses.
Replace parts 40~43 every 2,000 uses (if stainless steel rivets with Ø 6.4 mm are pulled).
The rivet container (part 59) must be emptied when it reaches approximately 35 rivets.

LUBRICATION
For optimal use, connect the tool to a filter-lubricator unit provided with an air-oil microfog mixer (items 1919F...), set at two drops per minute, pouring special oil ISO 32 (item 1919L) in. The above-mentioned accessories will translate into a high-performing tool and wear-resistant mechanical parts.
Do not use kerosene or diesel oil.

MAINTENANCE
Should the riveter be used over long periods of time, impurities may form on the clamps, thus causing them to slip from the nail; clean the clamps with either petrol or some degreasers; then lubricate them.
To lubricate, use Mobilgrease XHP 222.
We recommend replacing any worn clamps.
Regularly check the oil level, as this riveter is an air tool; fill up whenever a shorter stroke is suddenly shown.
Take the following steps:
1) Disconnect the tool from the feeding plant.
2) Remove the nozzle holder (38).
3) Open the cylinder cover (1).
4) Remove the whole piston unit, using a plier and pulling without loosening the nut (5).
5) Pour Mobilgrease XHP 222 directly into the body (29), filling up under part 16.
6) After cleaning and greasing the piston stem and the rubber piston ring (7-8), put the piston unit back in.
7) Before retightening the nozzle holder, restore the clamps holding cone (39) and the cone holding head (42) the their original sizes, using the spanner (63) and the drawing enclosed with the exploded view. Then connect air and reighten the nozzle holder keeping the lever (33) pressed.

We recommend using the enclosed exploded view as a manula to disassemble and assemble the tool as well as to identify any spare parts.

WARRANTY
This tool is manufactured and tested with the greatest care, in accordance with current safety regulations, and is covered by a 24-month warranty.
We will repair any breakdowns caused by material or manufacturing defects by fixing the defective pieces or replacing them at our discretion. Should assistance be asked for during the warranty period, the expiry date of this warranty will remain unchanged.
This warranty will not cover any defects due to wear, misuse, or breakdowns caused by blows and/or falls. In addition, this warranty will no longer be valid if any changes are made, or if the tool is tampered with or sent to the customer service in pieces.
This warranty explicitly excludes any damage to people and/or things, whether direct or consequential.

DECLARATION OF CONFORMITY TO THE "MACHINE" DIRECTIVE

we
BETA UTENSILI SPA

hereby certify, assuming full responsability, that the product:

AIR RIVETER
item 1946C 7,8

complies with the following standards, according to the requirements set by the "Machine Directive":
2006/42/CE

Place and date of issue
SOVICO (MB) ITALY
January 2014

Name and title of the person in charge
ROBERTO CICERI
(President)

SPECIFICATIONS

TRACTION POWER	16900 N
STROKE LENGHT	22,5 mm
AIR INLET	1/4" taper GAS
WORKING PRESSURE	6,0 Bars
MAXIMUM WORKING PRESSURE	6,2 Bars
MINIMUM INTERNAL HOSE SIZE	10 mm
MAXIMUM AIR CONSUMPTION	4,9 l
WEIGHT	1,8 Kg
OVERALL LENGTH	305 mm
SOUND PRESSURE	78,5 dB (A) (pr EN 50144)
SOUND POWER	82,5 dB (A) (pr EN 50144)
MAXIMUM RIVET CAPACITY	7,8 STEINLESS STEEL