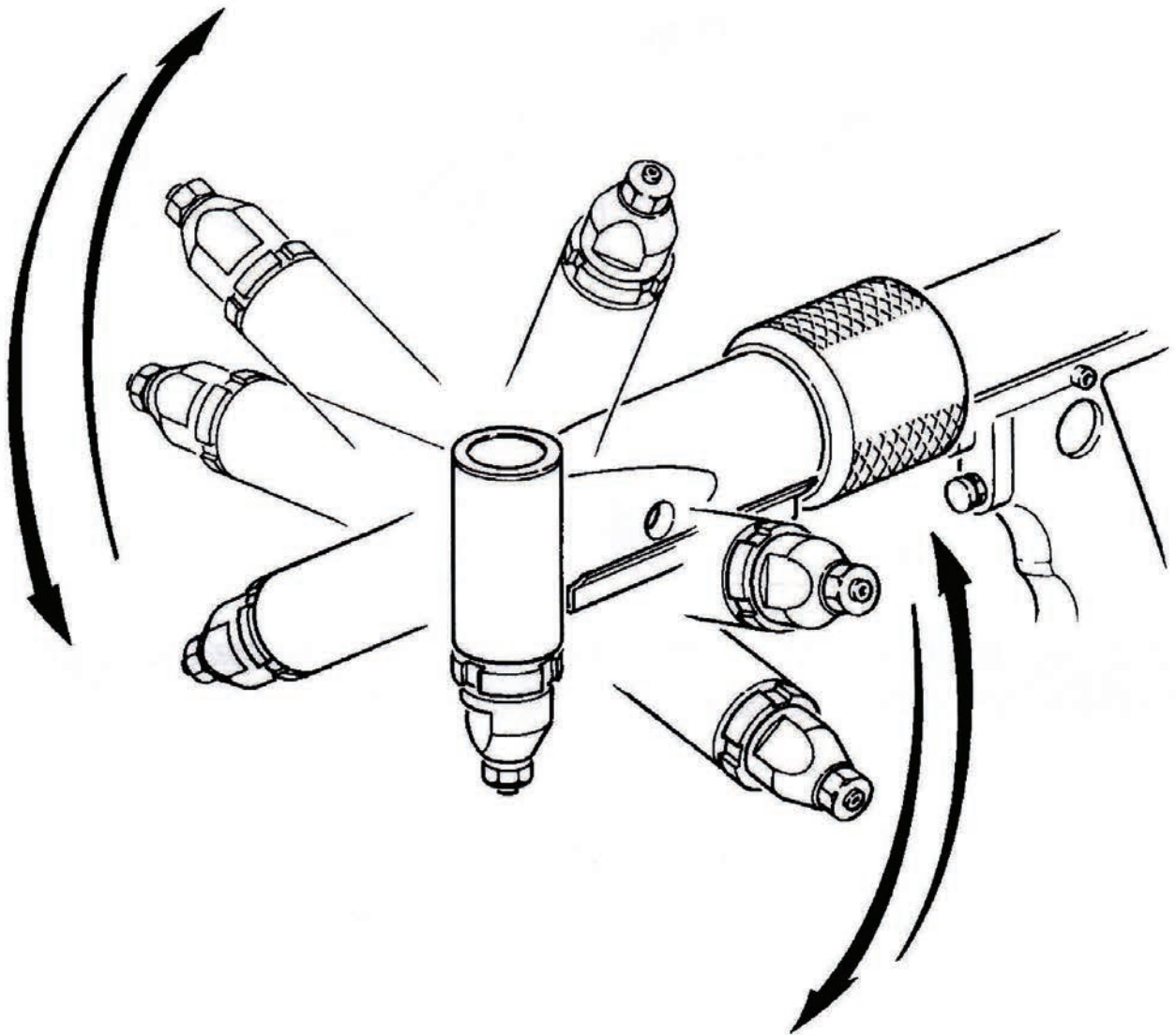


TRANSLATION OF ORIGINAL INSTRUCTIONS

ASSEMBLING INSTRUCTIONS FOR Ø 2.4 - Ø 4.8*



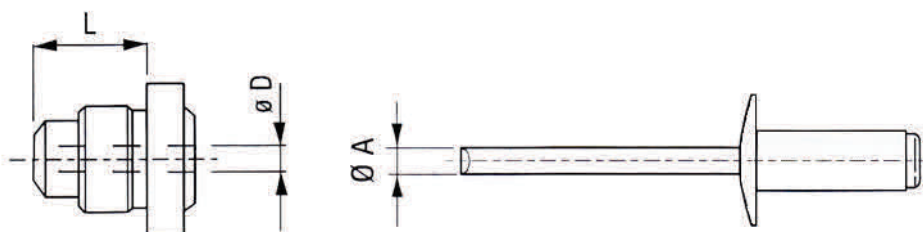
* Ø 4.8 STAINLESS STEEL EXCLUDED



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GENERAL NOTES AND USE

The tool must be used for rivets diam. 2.4 – 4.8 mm stainless steel excluded.



Code	L	Ø D	Ø A ÷
717008	7	2.25	1.7 ÷ 2.1
717009	9	2.7	2.15 ÷ 2.4
717010	9.5	3.1	2.6 ÷ 2.75
717011	11	3.4	2.9 ÷ 3.2

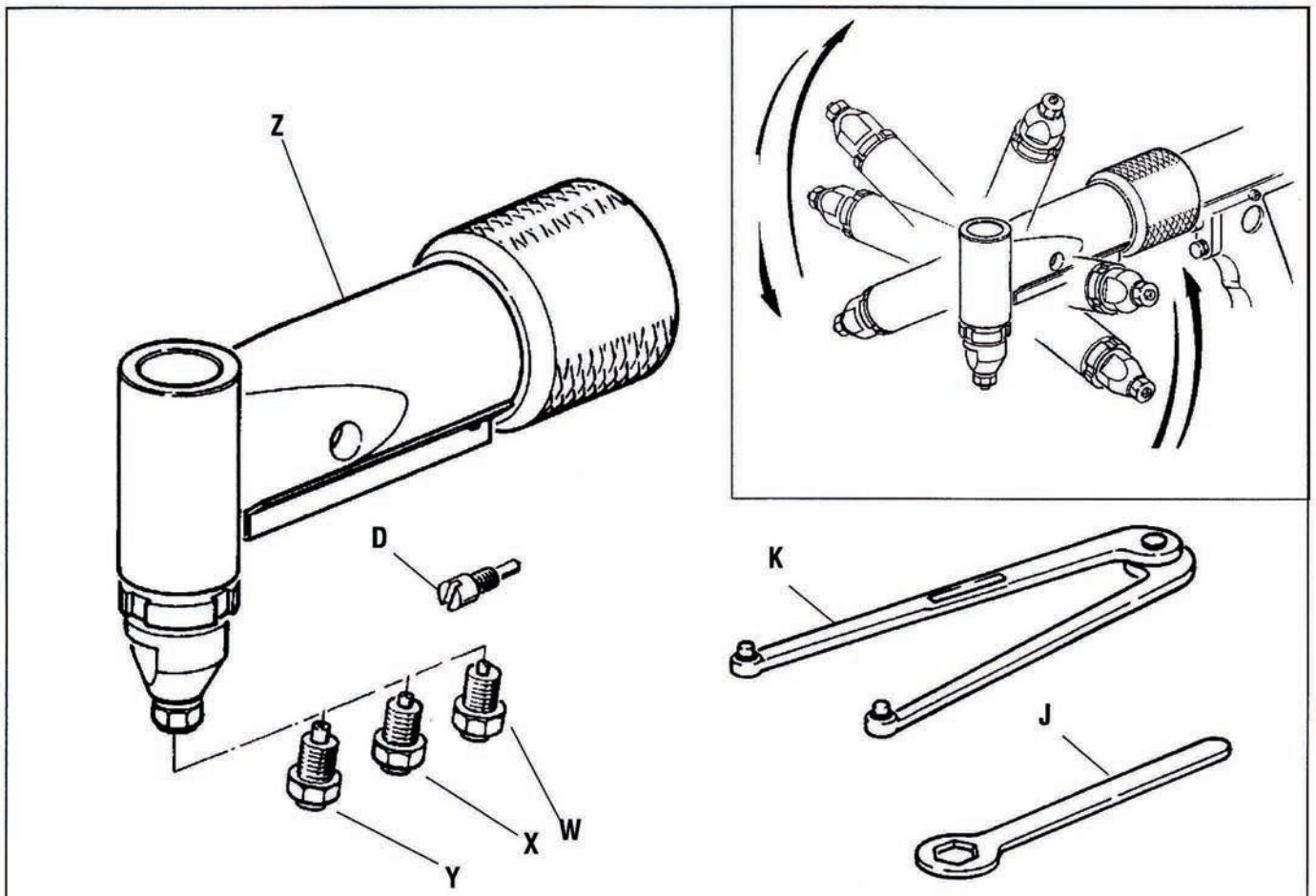
General Notes

FAR angle head can be rotated in any position, thus allowing you to operate easily and even in rather inaccessible positions.

Before mounting the angle head on your riveting tool, make sure the box contains the following components:

Ref.	Qty.	Description
Z	1	Angle Head complete with nozzle for rivets Ø 4.8 Cu/Steel
D	1	Knob for suction closing
Y	1	Nozzle for rivets Ø 4.8 Al
X	1	Nozzle for rivets Ø 4
W	1	Nozzle for rivets Ø 2.4 - 3.4
K	1	Face spanner
J	1	Key for nozzle

Should some components be missing, contact your supplier.

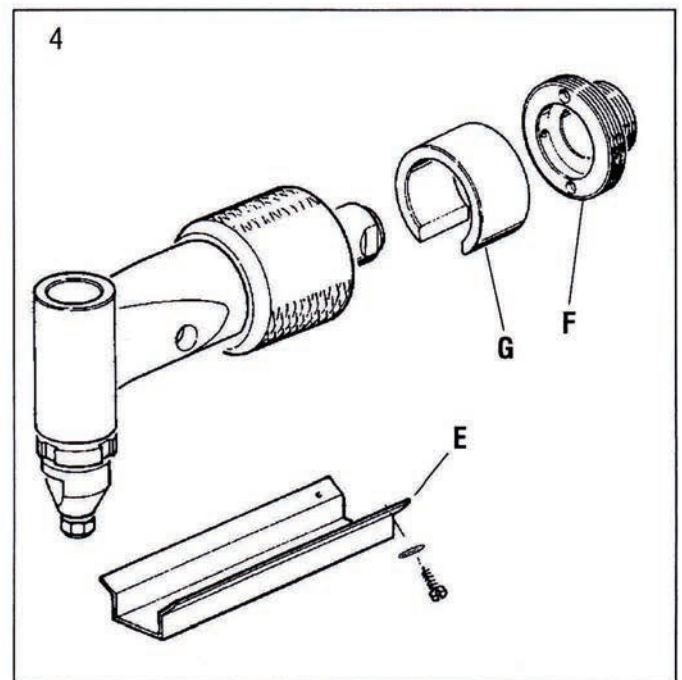
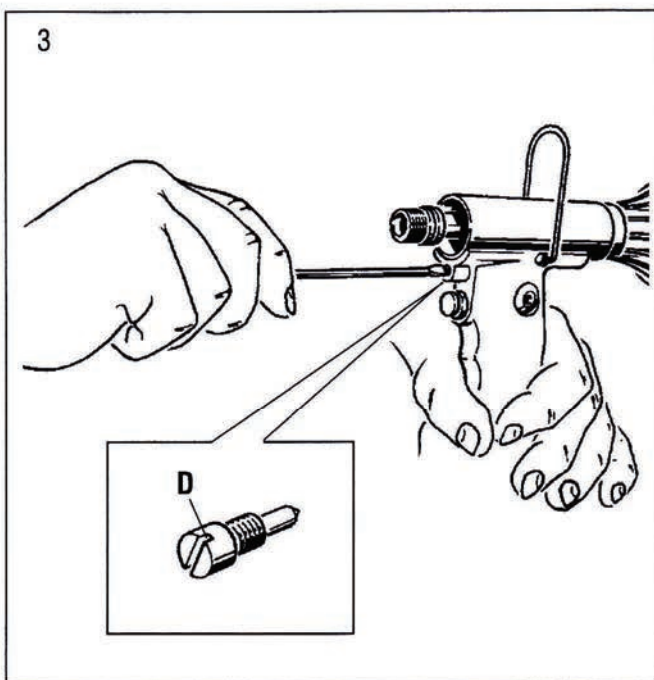
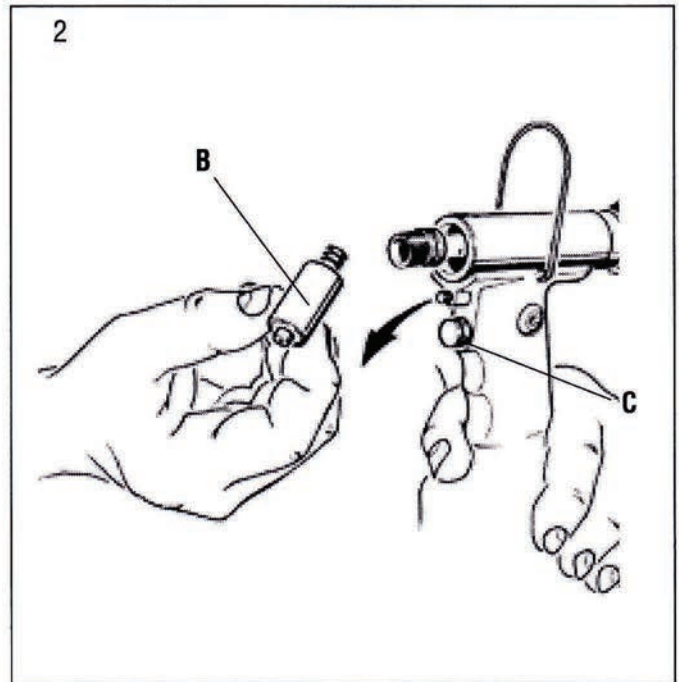
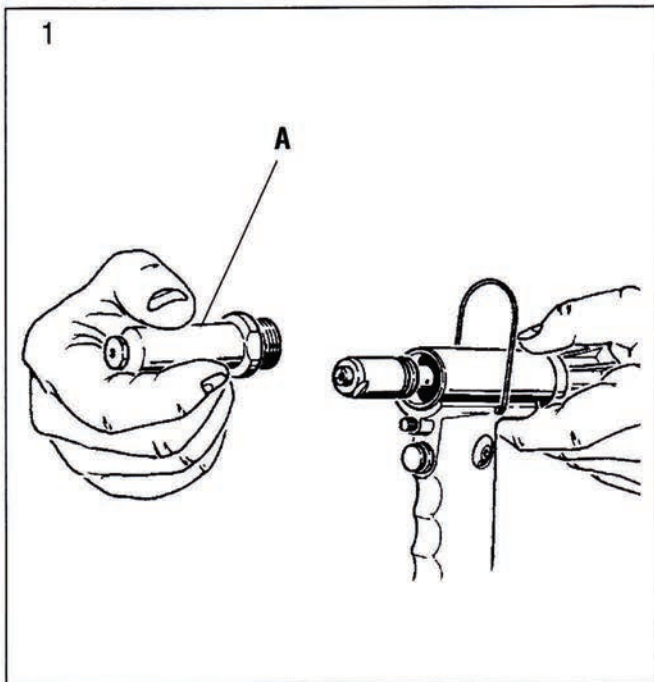


Preliminary operations on the riveting tool

Remove the head carrying the nozzle (A) by means of a 27 mm spanner. In order to remove the cone holding the clamps (B), use a 16 mm and a 11 mm spanner. Now unscrew the knob for suction closing © and take it out. Then, replace it with the one supplied with the angle head (D). We recommend that you put all the parts removed from your riveting tool back in their right place in order to avoid losing them (fig. 1, 2, 3).

Preliminary operations on the angle head

Before fitting the angle head in the riveting tool, remove both the guard € and the bush (F), then slip off the spacer (G) (fig. 4).



Installing the angle head

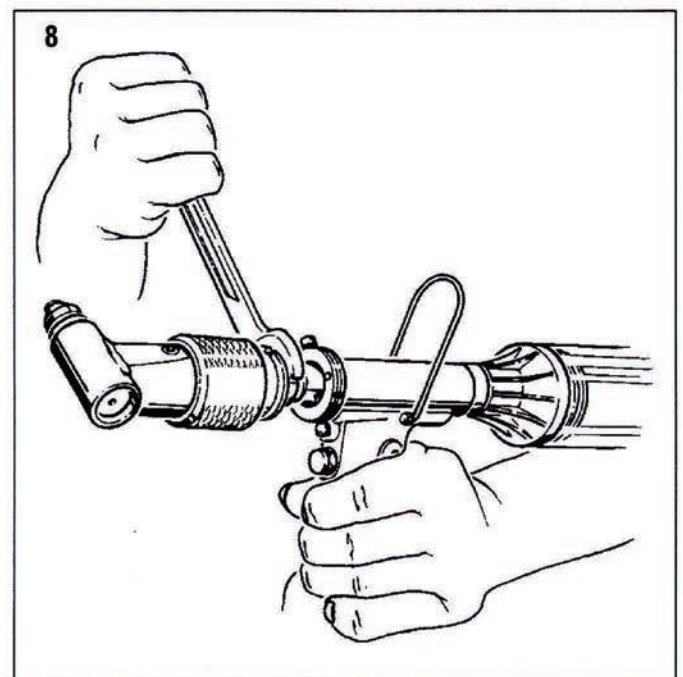
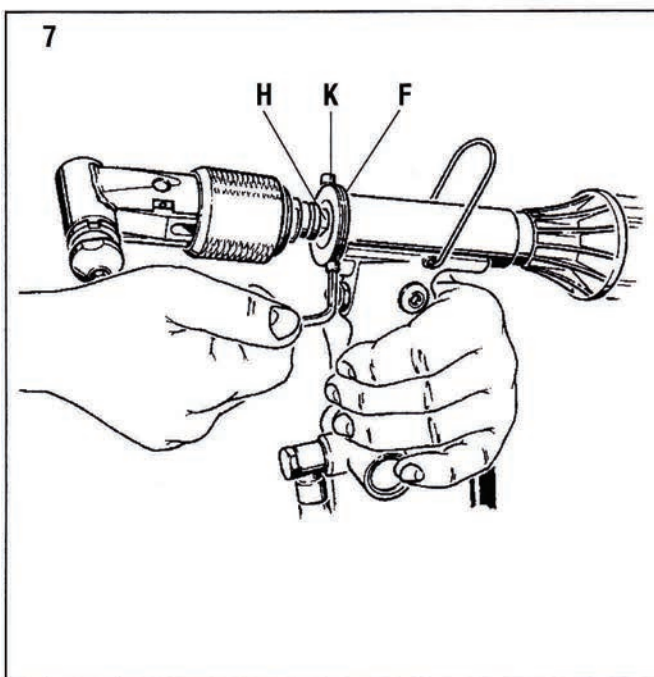
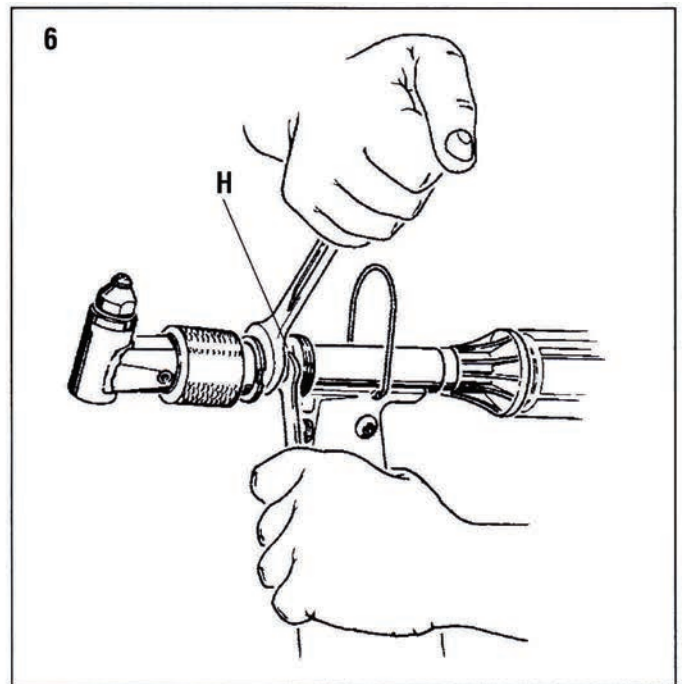
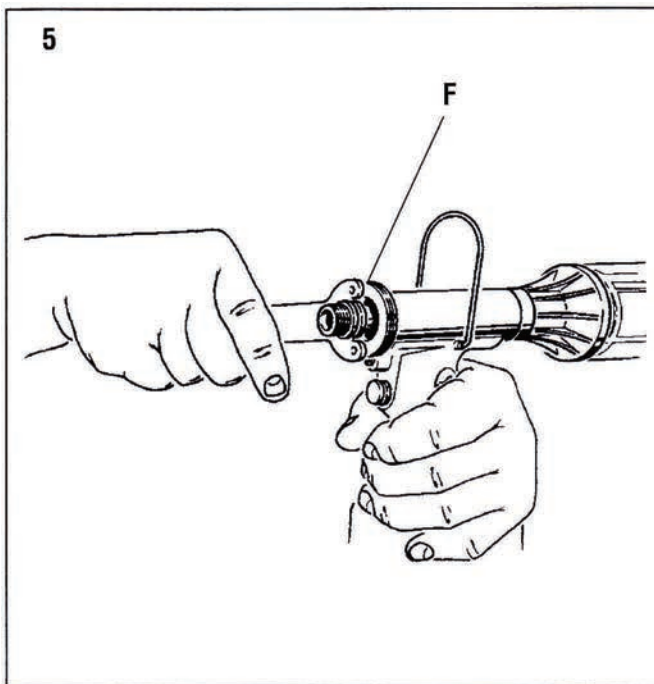
Fit the bush (F) in the riveting tool and secure it by means of a face spanner with teeth of Ø 4 mm, then screw the angle head to the thread of the head holding the cone (H).

Prevent the head holding the cone from rotating by means of a 11 mm spanner and secure the angle head by a 21 mm spanner (fig. 5-6)

WARNING! Whether the bush (F) prevents the spanner from adhering to the head holding the cone (H), it means that your riveting tool was produced before the commercialisation of the angle head; therefore, proceed as follows:

Fit the two M5 x 20 screws (K) in their proper housings on the bush and tighten them so as to prevent the head holding the cone from rotating. Secure the angle head by means of a 21 mm spanner (fig. 7-8).

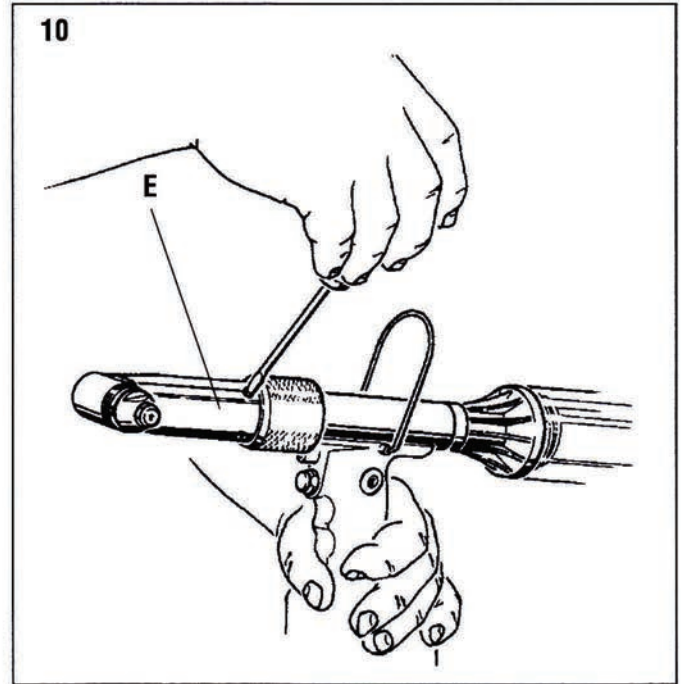
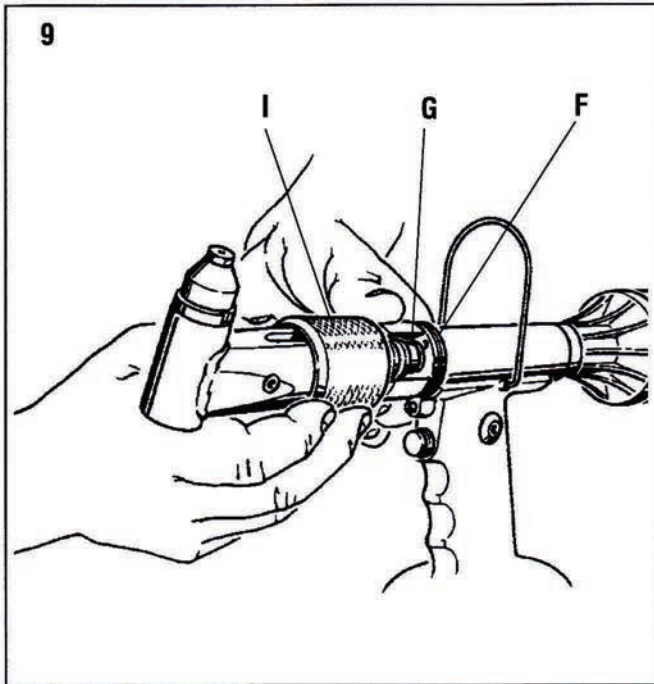
After carrying out this operation, take the two screws (K) out of the bush (F).



Installing the angle head (continued)

In order to conclude the installation of the angle head on the riveting tool, fit the spacer **(G)** and screw the ring nut **(I)** to the bush **(F)**.

Finally mount the guard **(E)** removed before (fig. 9-10).



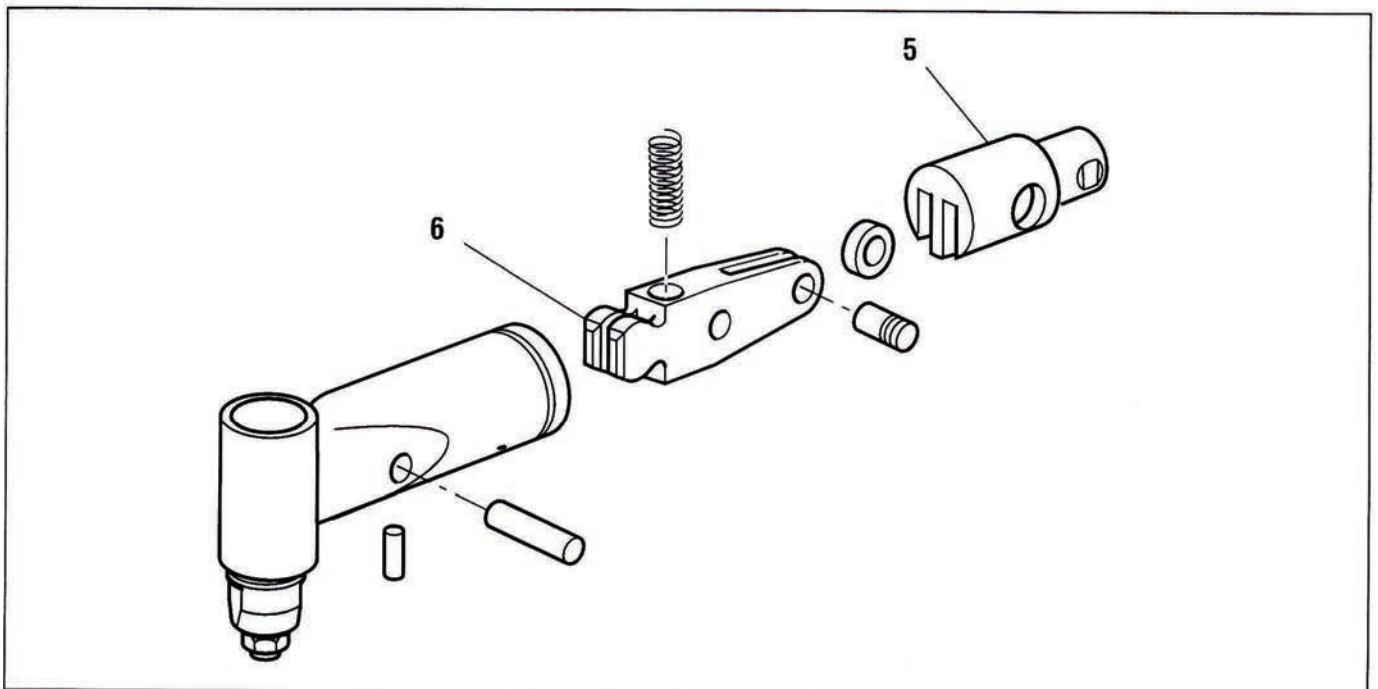
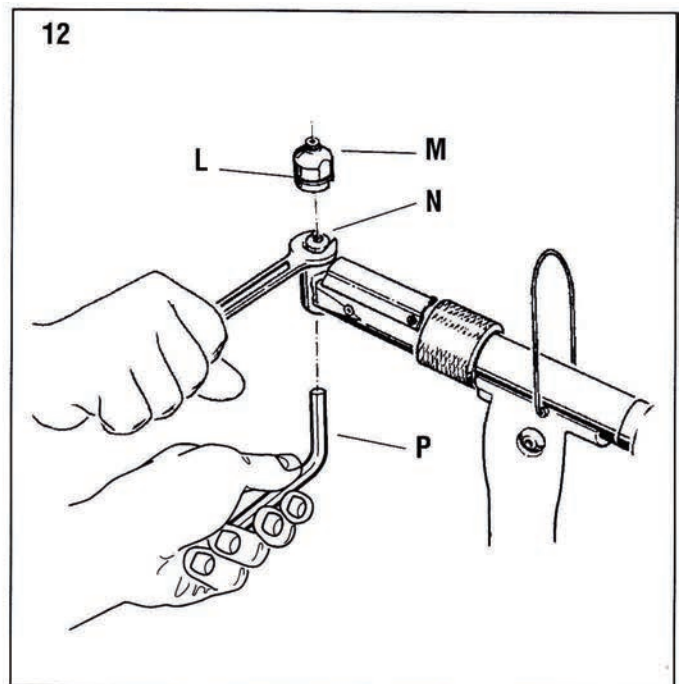
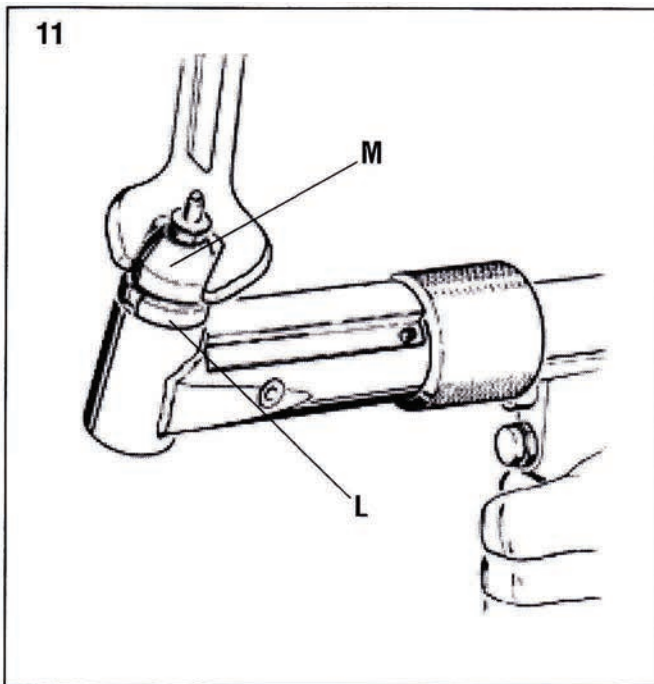
Setting up and maintenance

The angle head does not usually require any adjustment.

Should the fitting of the rivet into the nozzle turned out to be a different operation, thus preventing the rivet head from adhering to the nozzle, release the ring nut (L) and tighten the head carrying the nozzle (M) until the rivet fits perfectly (fig. 11).

The extended utilisation of the tool can cause the slipping of the clamps on the nail due to deposited impurities. It is necessary to lubricate the clamps after having cleaned them. Otherwise, if clamps are worn out and as a consequence their working is jeopardised, replace them. In order to perform this operation, release the ring nut (L) and dismount the head carrying the nozzle (M). Finally, remove the cone holding the clamps (N) by means of a 14 mm spanner and of the 4 mm key (P) provided with the angle head (fig. 12).

NOTE: The machine moving components (fig. 5-6) should be periodically lubricated with grease **DIN 51 502 KPFL 2N**.



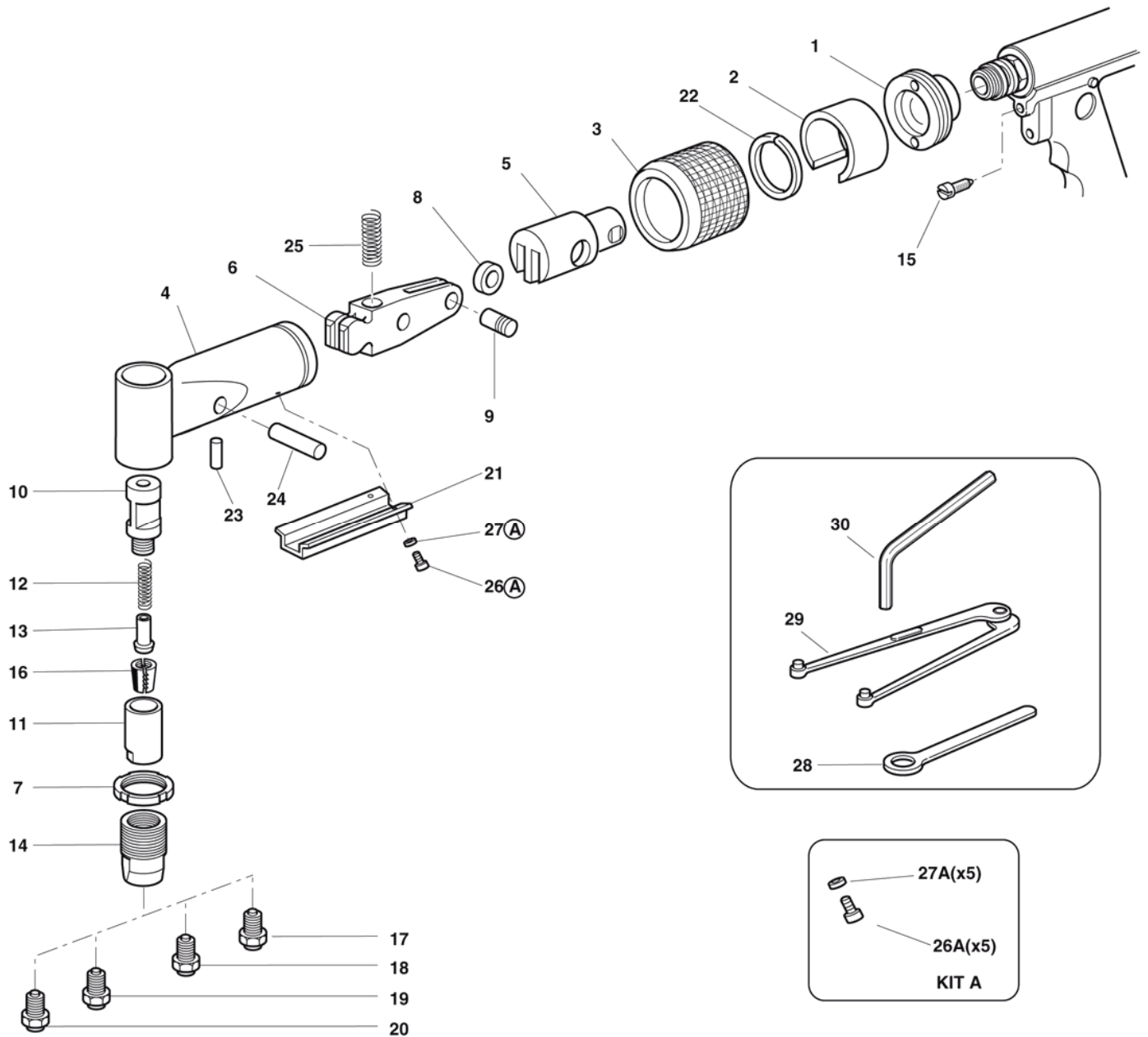


705023



Angle Head

NOTE: It can only be assembled on the RAC180, RAC181 & RAC182



Pos.	Code	Description	Qty
01	711739	Bush	1
02	711740	Spacer	1
03	711741	Ring nut	1
04	712267	Body	1
05	711743	Cam	1
06	711744	Fork	1
07	711745	Ring nut	1
08	711746	Pin	1
09	711747	Roll pin	1
10	711748	Shaft	1
11	711749	Clamps holding cone	1
12	711750	Clamps return spring	1
13	711751	Clamps opener	1
14	711752	Sleeve carrying nozzle	1
15	710842	Suction regulation knob	1
16	711778	Clamps	2
17	717008	Nozzle for rivet \varnothing 2,4 ÷ 3,4	1
18	717009	Nozzle for rivet \varnothing 4	1
19	717010	Nozzle for rivet \varnothing 4,8 All.	1
20	717011	Nozzle for rivet \varnothing 4,8 Cu / Steel	1
21	711758	Guard	1
22	711754	Snap ring WR 35	1
23	710383	Spring pin \varnothing 3 x 20 UNI 6874	1
24	711756	Roll pin	1
25	711757	Spring CF 10 x 25	1
26A	711759	Screw TCCI M3 x 4 UNI 6107	2
27A	711839	Washer \varnothing 3,2 UNI 1751	2
28	711832	Wrench 10 mm	1
29	711849	Face wrench	1
30	712225	Wrench 4 mm	1

KITA	741759	Screw M3 kit	
	Code	Description	Qty
	711759	Screw TCCI M3 x 4 UNI 6107	5
	711839	Washer \varnothing 3.2 UNI 1751	5