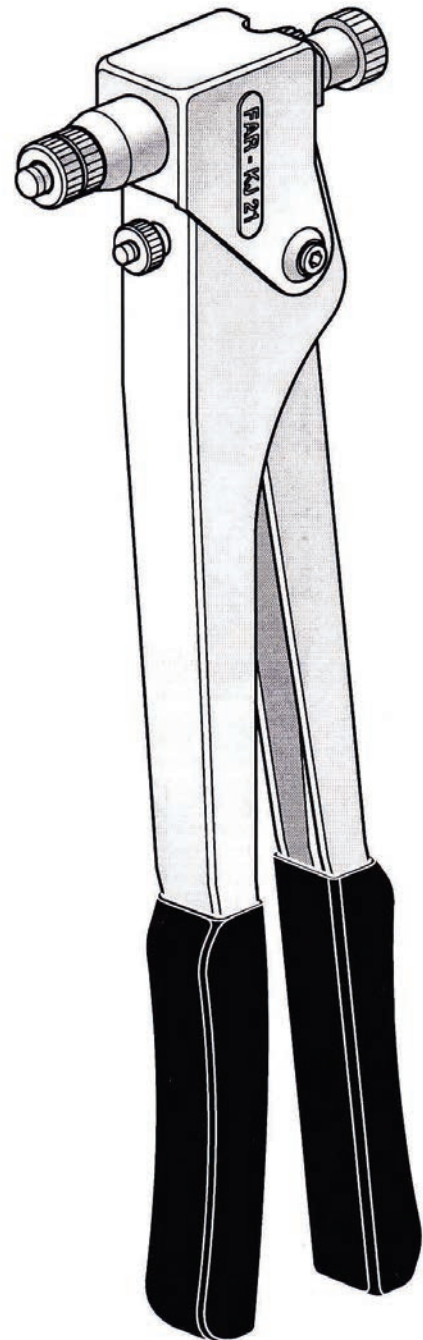
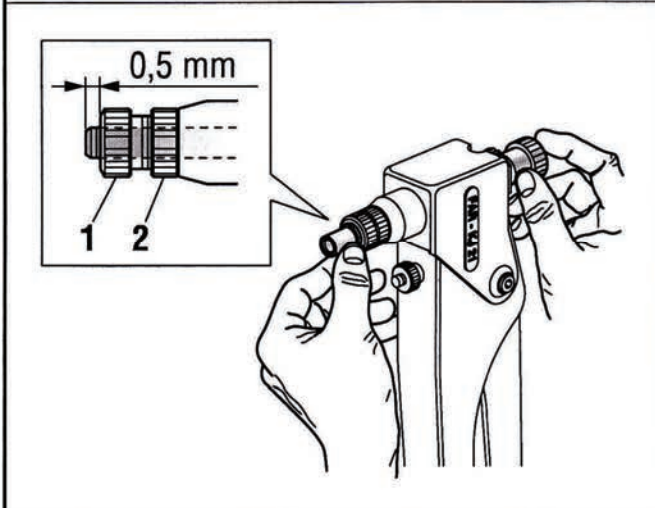
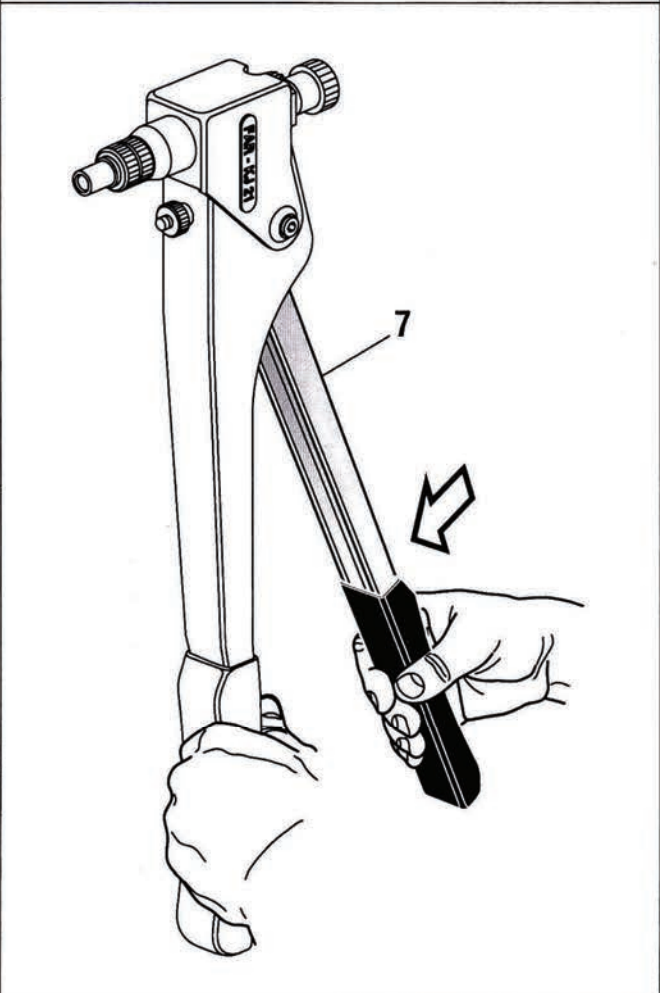
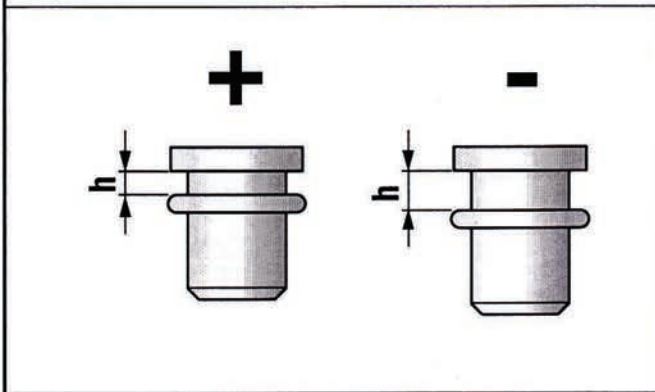
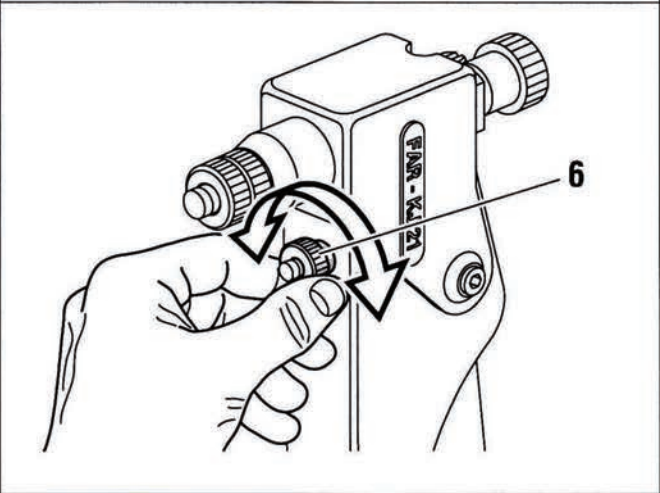
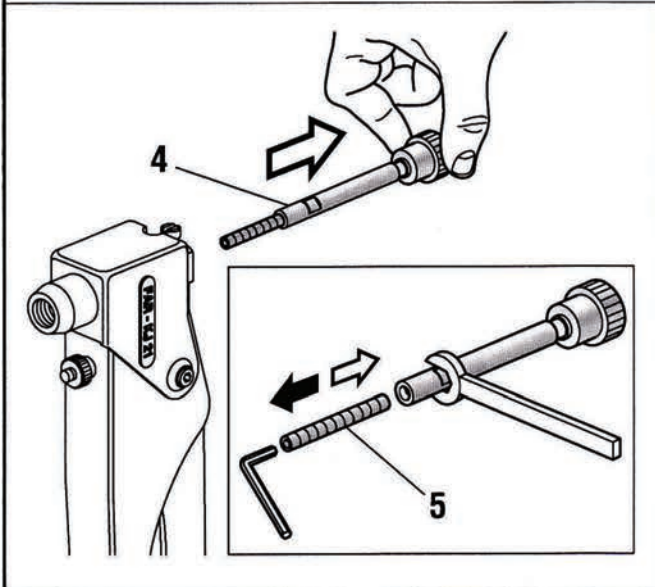
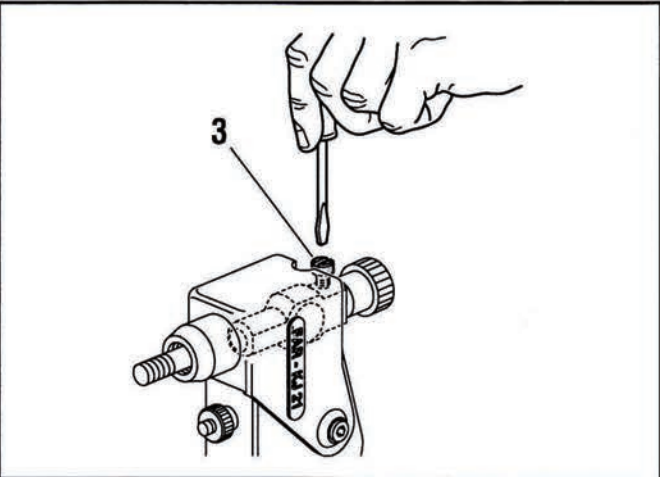
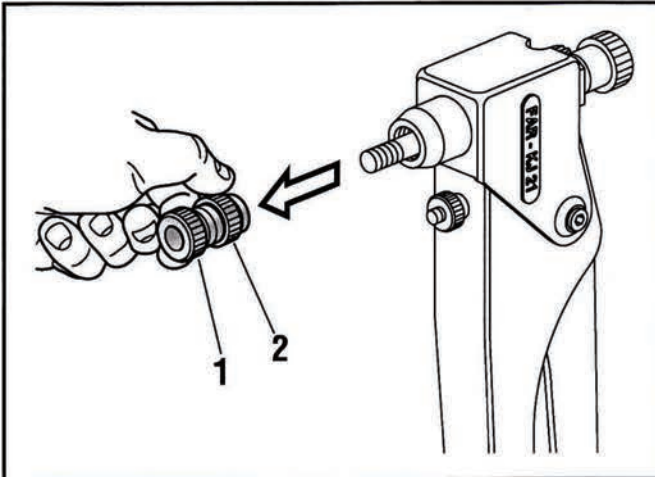


TRANSLATION OF ORIGINAL INSTRUCTIONS

HAND TOOL FOR THREADED INSERTS M3 - M8
OPERATING INSTRUCTIONS



(*STAINLESS STEEL EXCLUDED)



HAND TOOL FOR THREADED INSERTS FROM M3 TO M8.

Before using it, make sure that the stay bolt and the head assembled on the tool are suitable for the thread of the insert to be used; otherwise, it will be necessary to change the stay bolt and the head size.

WARNING: The standard stay bolt and head supplied with the tool is usually M8.

SIZE CHANGE:

Unscrew the head (1) and the ring nut (2).

Loosen the screw (3) and take out the stay bolt (4); replace it by choosing the correct size from the kit.

Each tool is equipped with a stay bolt and a head for each size, the ring nut (2) can be fitted with any insert size. In case of stay bolts M3, M4, M5 and M6, it may be replaced the dowel (5) only, by pulling it out of the corresponding pin.

By means of an Allen key screw the new dowel in its seat and lock it using Loctite.

STROKE ADJUSTMENT:

By unscrewing the knob (6) the stroke will increase; by screwing the knob (6) the stroke will be reduced.

By increasing the stroke, the insert deformation will be greater and therefore, the (h) distance from the insert head and its deformation, will be reduced.

By reducing the stroke, the (h) distance will increase because of the smaller deformation.

When the preliminary adjustment has been made, the insert can be fixed on the material to clamp; complete the stroke in accordance with the pressure that the insert needs for the material.

In case of reduced stroke, the insert will not be properly locked, otherwise, in case of wider stroke, the thread will be deformed.

HEAD ADJUSTMENT:

After having set the stroke, it is necessary to adjust the head (1).

Put the threaded insert on the stay bolt; it is very important that the head of the insert is fully located.

The stay bolt must come out by 0.5 mm from the insert, if this doesn't happen, it is necessary to unlock the ring nut (2) and adjust the head position: by screwing it, the extension of the stay bolt will increase; by unscrewing it, the extension of the stay bolt will be reduced. After that you can lock again the ring nut (2).

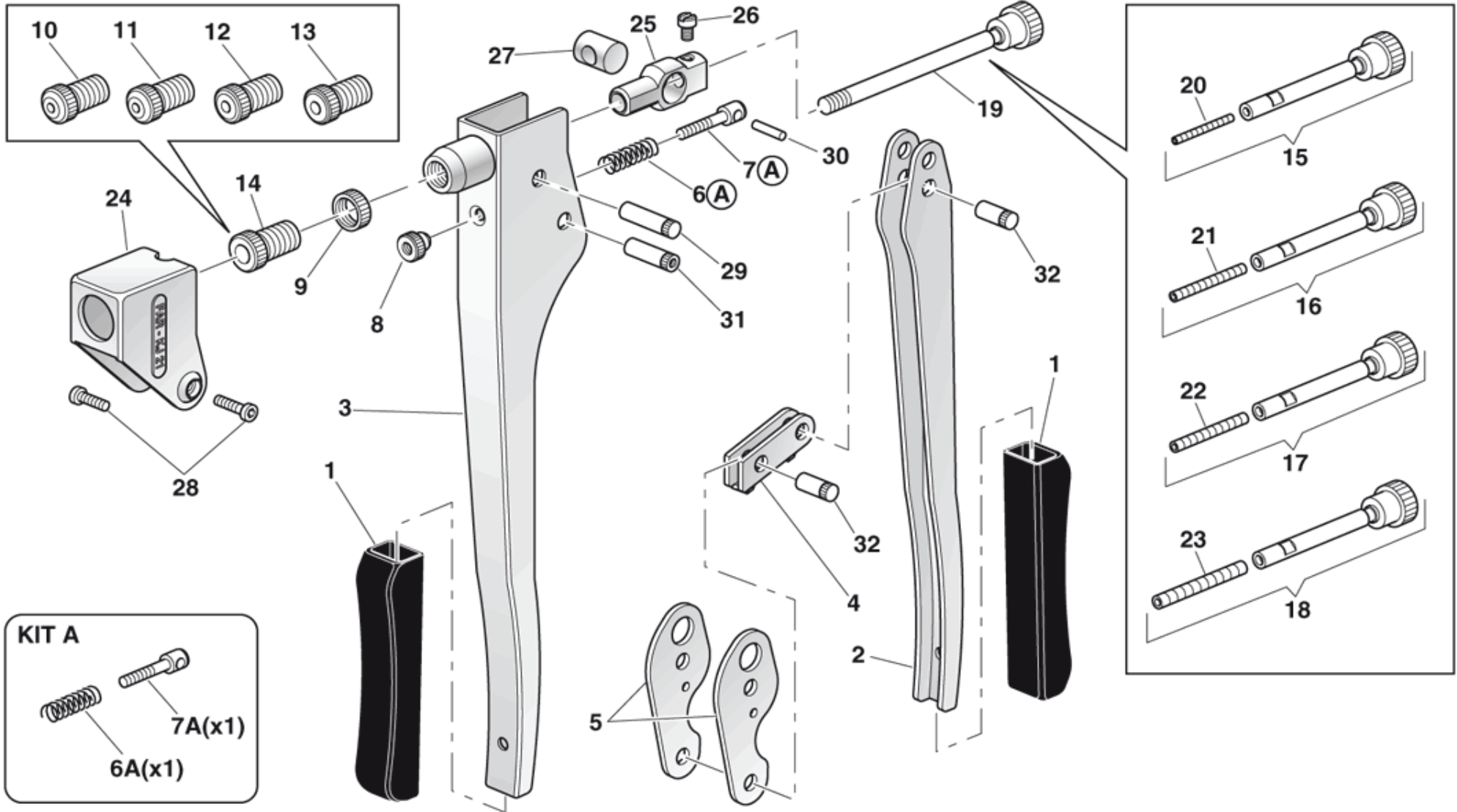
Every time the insert size is changed this adjustment is always necessary.

INSERT OPERATION:

Screw the insert on the stay bolt; position it in the hole of the material and pull the insert by the levers (7). After that, unscrew the stay bolt: now the tool is ready for a new insert.



KJ21



Pos.	Code	Description	Qty
01	712907	Handle	2
02	712301	Secondary lever	1
03	712300	Principal lever	1
04	712304	Connecting rod	1
05	712310	Lever	2
06A	713068	Spring for lever return	1
07A	712302	Threaded pin	1
08	710149	Knob	1
09	711772	Ring nut	1
10	713085	Head M 3	1
11	713086	Head M 4	1
12	713087	Head M 5	1
13	713088	Head M 6	1
14	713089	Head M 8	1
15	723062	Tie rod M 3	1
16	723063	Tie rod M 4	1
17	723064	Tie rod M 5	1
18	723065	Tie rod M 6	1
19	723066	Tie rod M 8	1
20	713080	Screw STCE M3 x 30 UNI 5923	1
21	713081	Screw STCE M4 x 35 UNI 5923	1
22	711625	Screw STCE M5 x 35 UNI 5923	1
23	713083	Screw STCE M6 x 40 UNI 5923	1
24	713070	Protecting cap	1
25	712305	Inside body	1
26	710137	Screw TCCI M5 x 5,3	1
27	712303	Roll pin	1
28	713084	Screw TBCE M4 x 8 ISO 7380	2
29	713079	Long pin	1
30	713095	Spring pin \varnothing 4 x 18 UNI 6873	1
31	713067	Threaded long pin	1
32	713061	Short pin	2

KITA

742302

Pin kit

Code	Description	Qty
713068	Spring for lever return	1
712302	Threaded pin	1