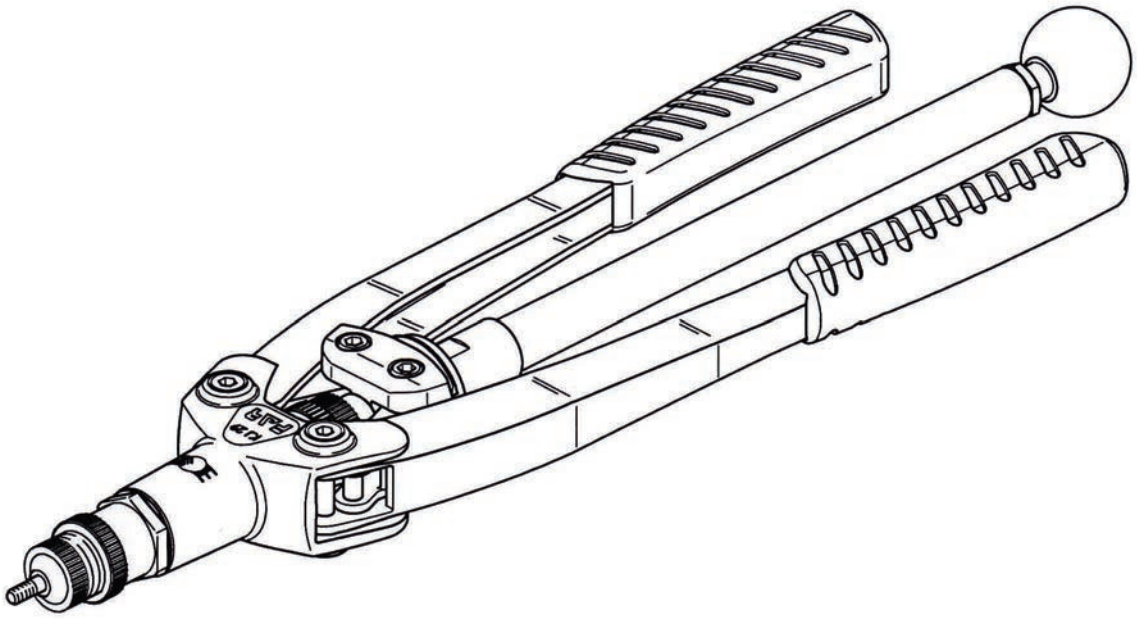
FAR
BOLOGNA
ITALY

KJ29

TRANSLATION OF ORIGINAL INSTRUCTIONS

HAND TOOL FOR THREADED INSERTS M3 - M10
OPERATING INSTRUCTIONS



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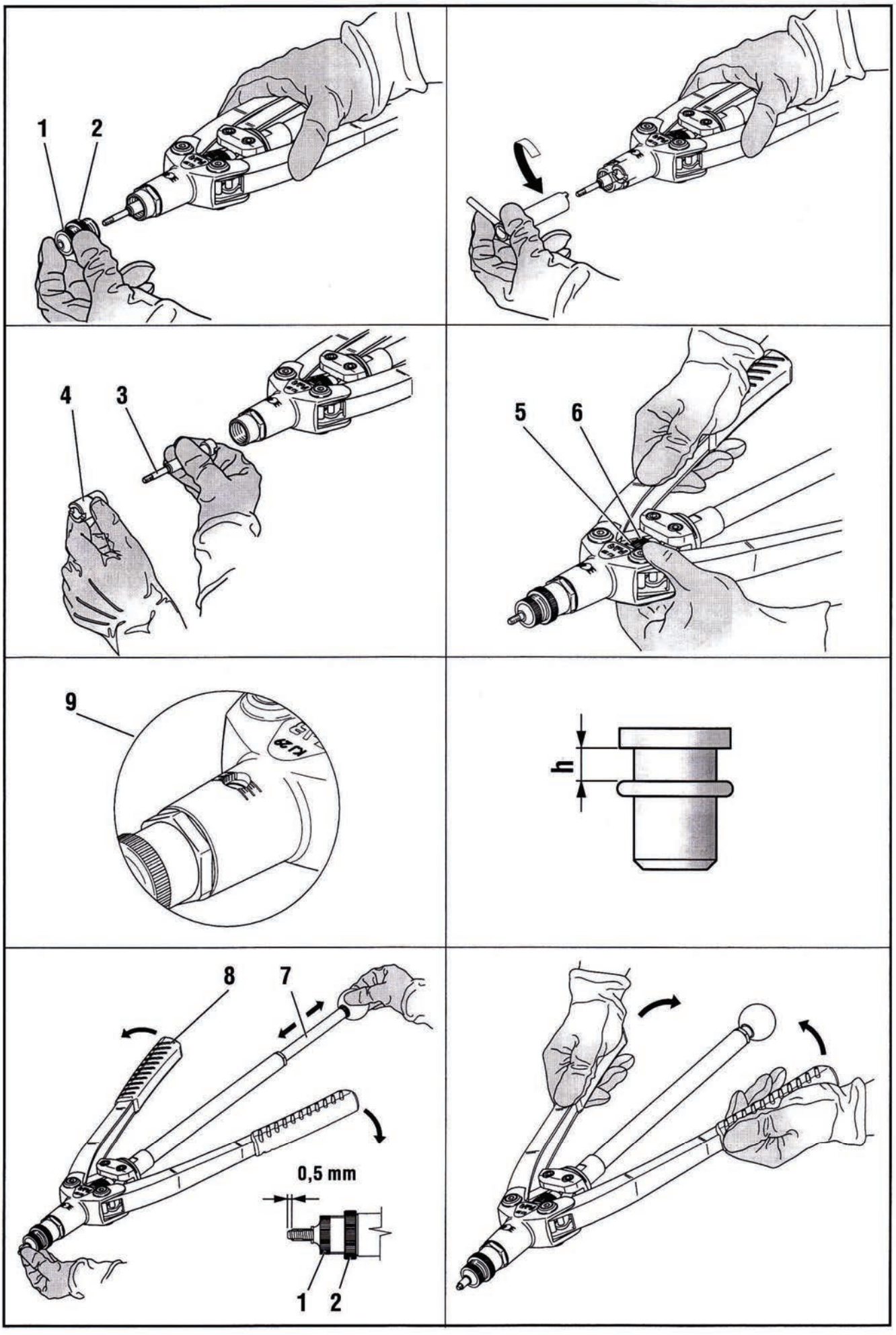
1
2
4
3
5
6
9
h
8
7
0,5 mm
1
2

HAND TOOL FOR THREADED INSERTS FROM M3 TO M10.

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 M5.

SIZE CHANGE:

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

By the supplied key, unlock the stay bolt (**3**) and the ring nut (**4**); take out those pieces from the tool, 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**) and (**4**) can be fitted with any insert size.

STROKE ADJUSTMENT:

Adjust stroke before operating the tool, with reference to the thickness of the material to clamp.

Stroke adjustment will be obtained by loosening the ring nut (**5**); screwing the adjusting screw (**6**) the stroke will increase while unscrewing it, the stroke will be reduced; stroke indicator will help during the adjustment (**9**).

By increasing the stroke, the insert deformation will be wider and therefore, the (**h**) distance 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 adjustment in accordance with the pressure that the insert exerts on 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:

Move the screwer (**7**) outward and open the levers (**8**), put the insert on the stay bolt moving inward the screwer (**7**). Put the insert in the hole of the material and pull the insert by the levers (**8**). After that move the levers outward in order to unscrew the stay bolt from the clamped insert.

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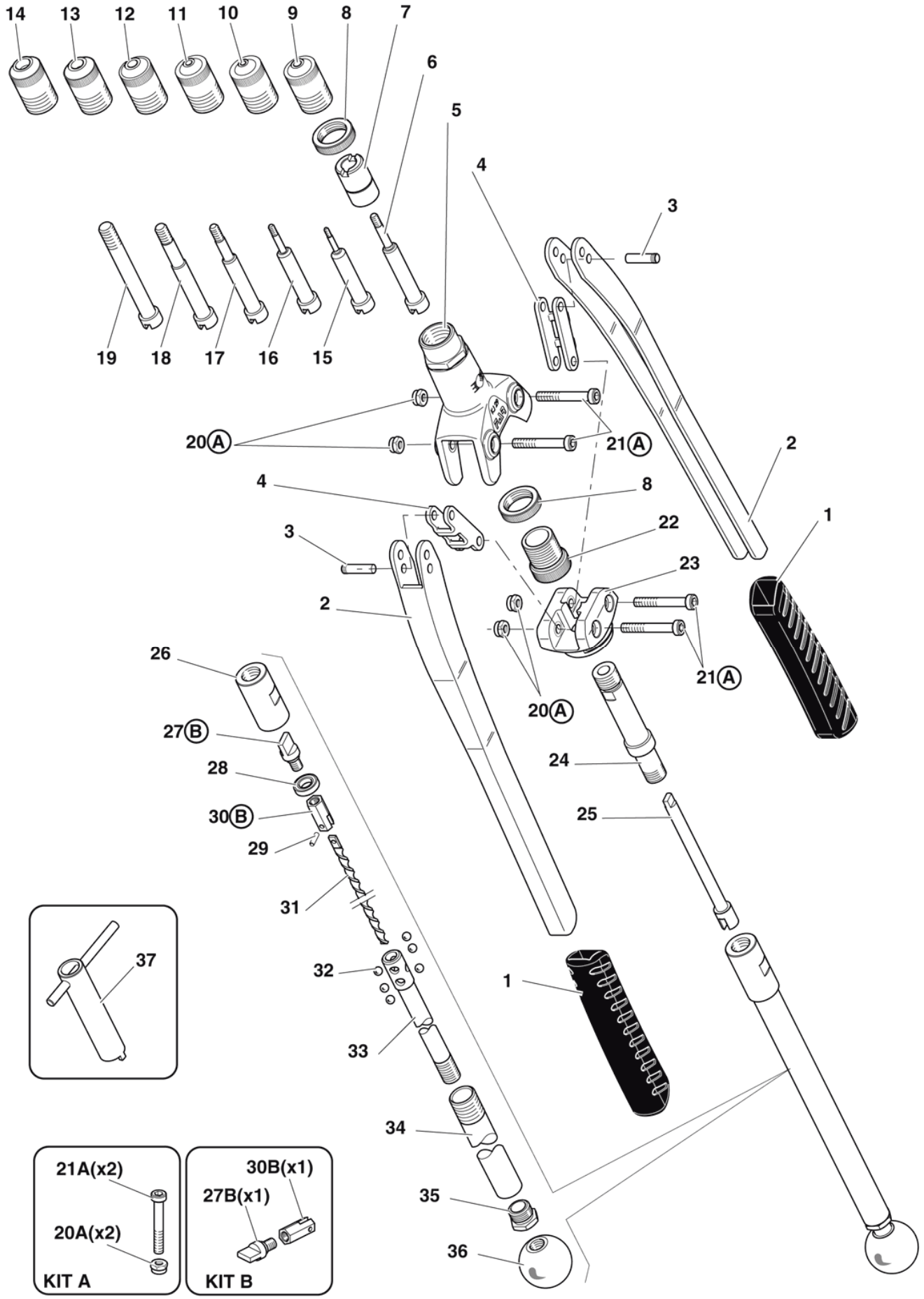
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20Ⓐ
26
27Ⓑ
28
30Ⓑ
29
31
24
25
37
32
1
33
34
35
36
21A(x2)
20A(x2)
KIT A
30B(x1)
27B(x1)
KIT B

Pos.	Code	Description	Qty
01	71345953	Handgrip	2
02	71345993	Lever	2
03	71345949	Roll pin	2
04	71345948	Connecting rod	2
05	72B00064	Outside body	1
06	720163	Tie rod M 5	1
07	710160	Ring nut	1
08	710159	Ring nut	2
09	710155	Head M 5	1
10	710153	Head M 3	1
11	710154	Head M 4	1
12	710156	Head M 6	1
13	710157	Head M 8	1
14	710158	Head M 10	1
15	720161	Tie rod M 3	1
16	720162	Tie rod M 4	1
17	720164	Tie rod M 6	1
18	710165	Tie rod M 8	1
19	710166	Tie rod M 10	1
20A	710623	Nut M 6 UNI 7473	4
21A	71345903	Screw TCCE M6	4
22	71345895	Regulation ring nut	1
23	72A00218	Connector	1
24	71345654	Sleeve	1
25	712285	Clutch	1
26	71345764	Screwer sleeve	1
27B	710639	Clutch	1
28	710647	Bearing 618/9	1
29	710649	Spring pin ø 3 x 10 UNI 6874	1
30B	710640	Nut	1
31	710704	Elicodal shaft	1
32	710646	Ball 7/32"	6
33	710642	Screwer sliding sleeve	1
34	710643	Outside body	1
35	710644	Ring nut	1
36	710648	Knob	1
37	712290	Wrench	1

KITA **74000069** **Screw M6 kit**

Code	Description	Qty
710623	Nut M6 UNI 7473	2
71345903	Screw TCCE M6	2

KITB **740639** **Clutch kit**

Code	Description	Qty
710639	Clutch	1
710640	Nut	1