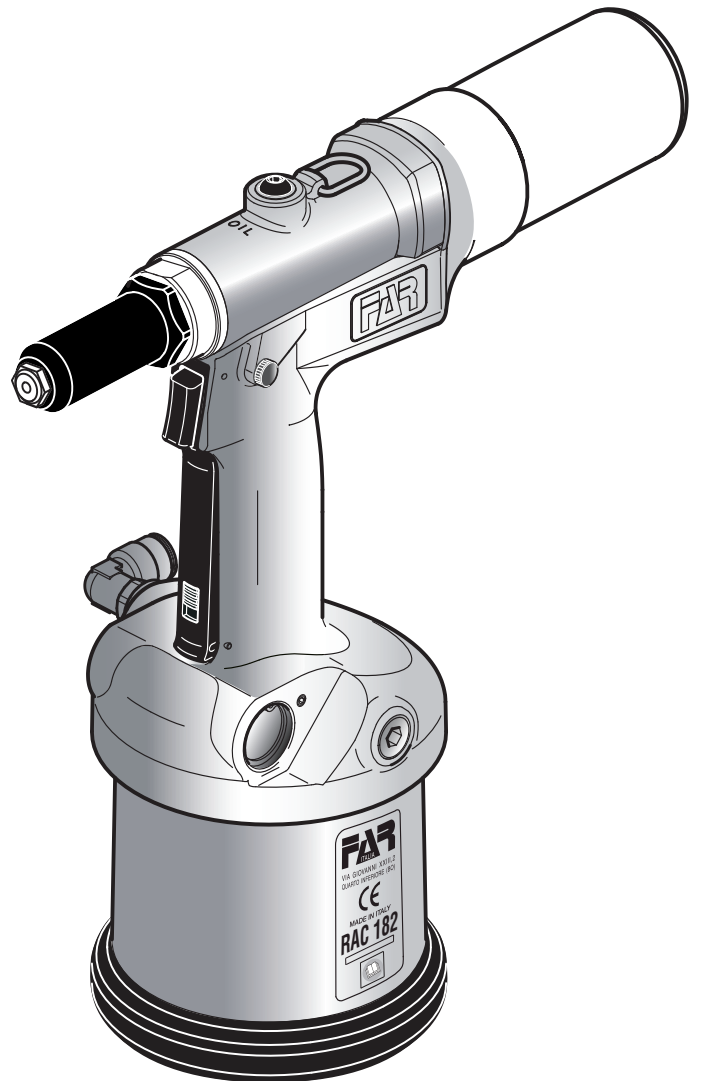
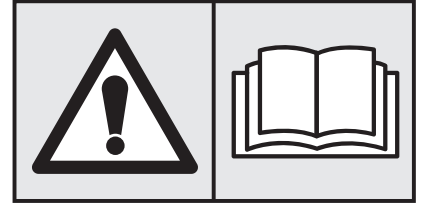


**GB** - TRANSLATION OF ORIGINAL INSTRUCTIONS  
HYDROPNEUMATIC RIVETING TOOL  
FOR RIVETS  $\varnothing 2,4 \div \varnothing 6^*$   
(\* $\varnothing 6$  ALU ONLY)  
INSTRUCTIONS FOR USE - SPARE PARTS



[www.air-allied.com.au](http://www.air-allied.com.au)



DATE 05-2021 REVISION-01

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## DECLARES

on its sole responsibility that the riveting machine Type: RAC 182 - Hydropneumatic tool

Application: for rivets diam. 2,4-6 (6 aluminium only), Serial number: see back cover which is the object of this declaration complies with the basic safety requirements established in the law decree Leg. D. 17/2010 of Machinery Directive 2006/42/CE acknowledge and subsequent amendments and integrations.

The person who is authorized to create the technical brochure is Massimo Generali, c/o Far S.r.l, head office Via Giovanni XXIII, 2 - Fraz. Quarto Inferiore - 40057 Granarolo Emilia Bologna - Italy

Quarto Inferiore, 01-05-2021



Far S.r.l. - Massimo Generali

(Presidente del Consiglio di Amministrazione) / (Chairman of the Board of Directors)  
(Président du Conseil d'Administration) / (Vorsitzender des Verwaltungsrates)  
(Presidente del Consejo de Administración) / (Prezes Zarzadu)  
(Председатель Административного Совета) / (Presidente do Conselho de Administração)



## GUARANTEE

FAR riveting tools are covered by a 12-month warranty. The tool warranty period starts on the date of delivery to the buyer, as specified in the relevant document. The warranty covers the user/buyer provided that the tool is purchased through an authorized dealer and only if it is used for the purposes for which it was conceived. The warranty shall not be valid if the tool is not used or maintained as specified in the instruction and maintenance handbook. In the event of defects or failures, FAR S.r.l. shall undertake solely to repair and/or replace the components it judges to be faulty.


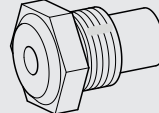
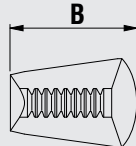
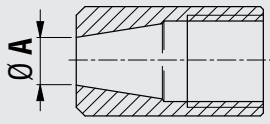
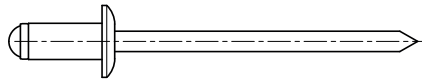
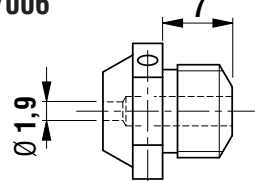
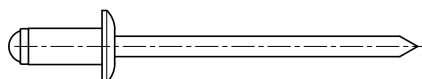
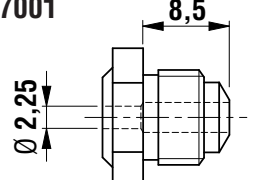
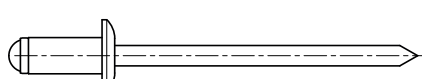
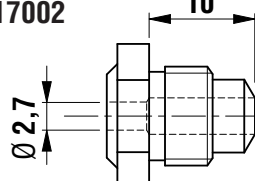

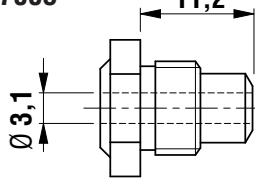
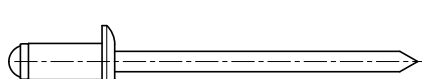
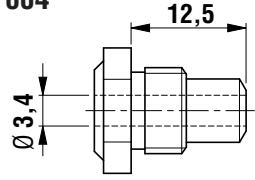
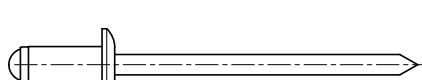
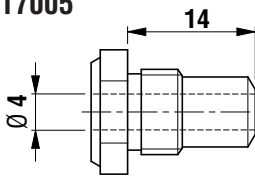
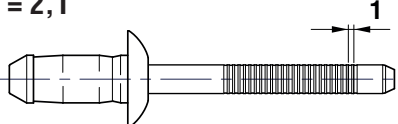
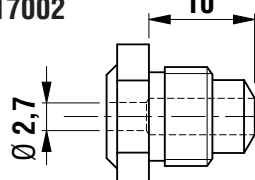
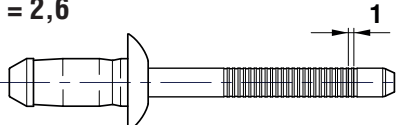
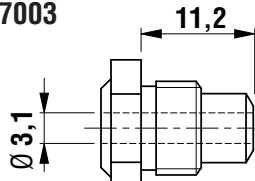


## GENERAL NOTES AND USE

The tool must be used for rivets diam. 2,4 - 6 mm.

Diam 6 mm only in aluminium.

The RAC 182 oil pneumatic system assures more power than the pneumatic system used for other models. That means a reduction in the problems due to the wear and tear of the components, therefore, there will be an increase in reliability. The technical solutions adopted reduce the dimensions and the weight of the tool which, for these reasons, make it very hardy. The possibilities of leakage from the oil-dynamic system are eliminated by some sealed gaskets, which solve this problem.

			
<p>Ø C = 1,43</p> 	<p>717006</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>Ø C = 1,7 ÷ 2,1</p> 	<p>717001</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>Ø C = 2,15 ÷ 2,4</p> 	<p>717002</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>Ø C = 2,6</p> 	<p>717003</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>Ø C = 2,9 ÷ 3</p> 	<p>717004</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>Ø C = 3,5</p> 	<p>717005</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>TAMP Acc. Ø 3,2 Ø C = 2,1</p> 	<p>717002</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>
<p>TAMP Acc. Ø 4 Ø C = 2,6</p> 	<p>717003</p> 	<p>B = 13</p> <p>71345507</p>	<p>Ø A = 8,3</p> <p>710859</p>

<p><b>TAMP Acc. Ø 4,8</b> <b>Ø C = 2,9</b></p>	<p><b>717004</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>MULTIFAR Inox. Ø 3,2</b> <b>Ø C = 2,15</b></p>	<p><b>717002</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>MULTIFAR Inox. Ø 4</b> <b>Ø C = 2,6</b></p>	<p><b>717003</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>MULTIFAR Inox. Ø 4,8</b> <b>Ø C = 3,2</b></p>	<p><b>717004</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>Ø C = 1,80 ÷ 2,15</b></p>	<p><b>717001</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>Ø C = 2,6</b></p>	<p><b>717003</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>Ø C = 3,2</b></p>	<p><b>717004</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>
<p><b>Ø C = 3,4</b></p>	<p><b>717005</b></p>	<p><b>B = 13</b></p> <p><b>71345507</b></p>	<p><b>Ø A = 8,3</b></p> <p><b>710859</b></p>



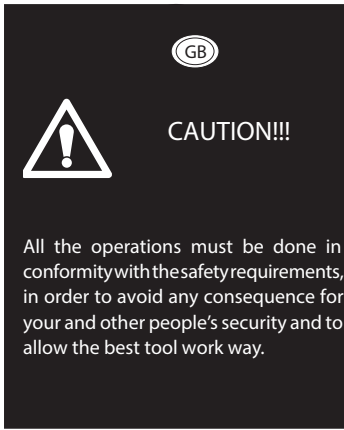
#### SAFETY MEASURES AND REQUIREMENTS

- Read the instructions carefully before using the tool.
- For all maintenance and/or repairs please contact FAR s.r.l. authorized service centers and use only original spare parts. FAR s.r.l. may not be held liable for damages from defective parts caused by failure to observe what above mentioned (EEC directive 85/374).

The list of the service centres is available on our website  
<http://www.far.bo.it> ( Organization )

- The tool must be used only by expert workers.
- A protective visor and gloves must be put on when using the tool.
- Use equipment recommended in the maintenance chapter to do any maintenance and/or regulation of the tool.
- For topping up the oil, we suggest using only fluids in accordance with the features specified in this working book.
- If any drop of oil touches your skin, you must wash with water and alkaline soap.
- The tool can be carried and we suggest putting it into its box after using.
- The tool needs a thorough six-monthly overhaul.
- There are no special requirements for storage.
- Repairing and cleaning operations must be done when the tool is not fed.
- If it is possible, we suggest a safety balancer.

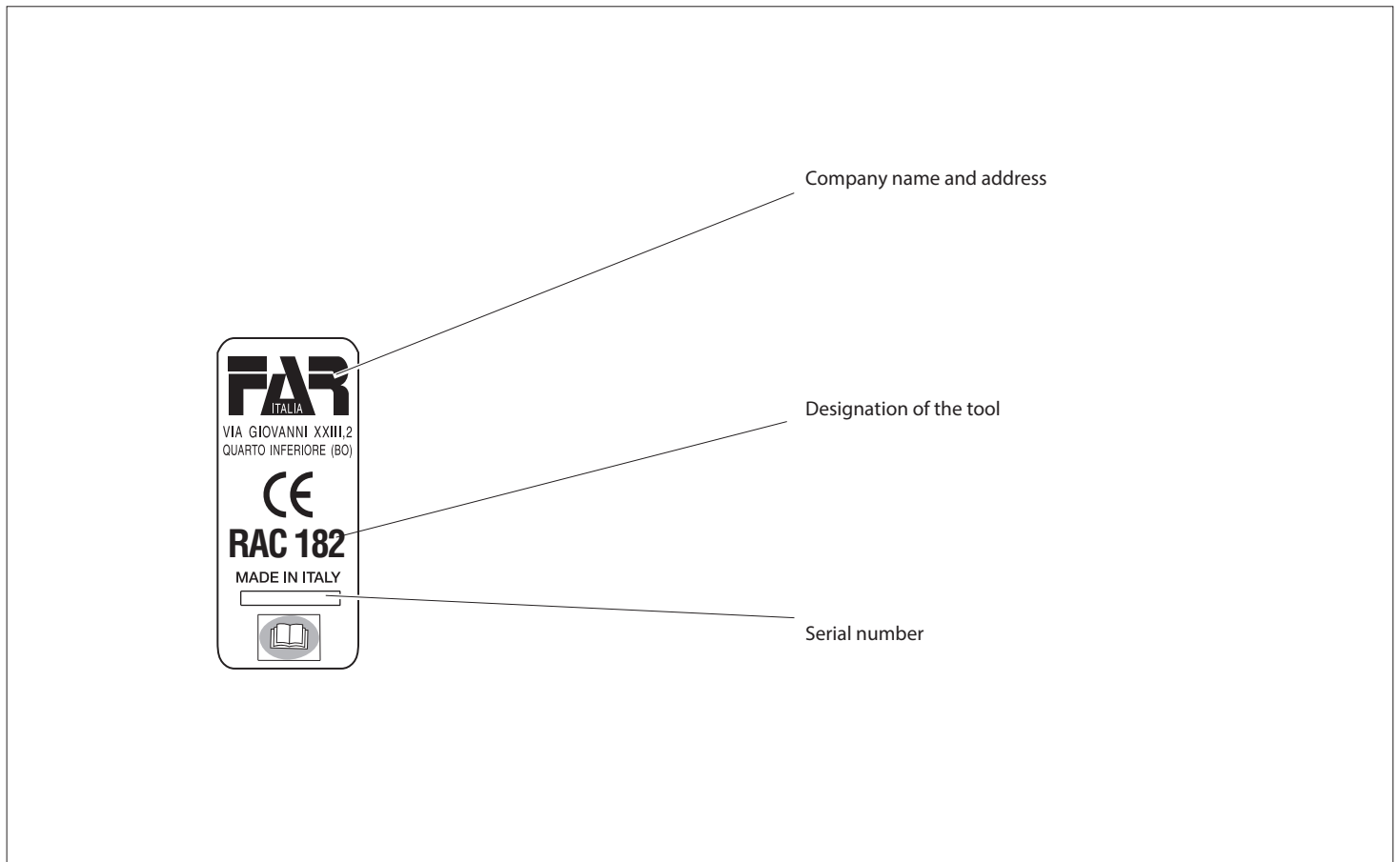




- If the A-weighted emission sound pressure level is more than 70 dB (A), you must use some hearing protections (anti-noise headset, etc.).
- The workbench and the work surface must be always clean and tidy. The untidy can cause damages to people.
- Do not allow unauthorized persons to use the working tools.
- Make you sure that the compressed air feeding hoses have the correct size to be used.
- Do not carry the connected tool by pulling the hose. The hole must be far from any heating sources or from cutting parts.
- Keep the tools in good conditions; do not remove either safety parts or silencers.
- After repairing and/or adjusting, make sure you have already removed the adjusting spanners.
- Before disconnecting the compressed air hose from the tool make sure that there is no pressure in the hose.
- These instructions must be carefully followed.
- Do not use the riveting tool in the case of visible damage.



The riveting tool RAC 182 is identified from a marking that shows company name and address of manufacturer, designation of the tool, CE. Always refer to the information on the riveting tool when requesting technical service.



**GB TECHNICAL DATAS**

- Working pressure ..... 6-7 BAR
- Min. int. Dia. of the compressed air feeding hose ..... min. dia. = 8 mm
- Air consumption per cycle..... 5,1 NI
- Maximum force..... 6 BAR - 10500 N
- Stroke ..... 20,5 mm
- Weight ..... 1,70 Kg
- Working temperature..... -5°/+50°
- Root mean square in total acceleration frequency (Ac) to which the arms are subjected. .... < 2,5 m/s<sup>2</sup>
- A-weighted emission sound pressure level ..... 76 dBA
- Peak C-weighted instantaneous sound pressure ..... < 130 dBC
- A-Weighted sound power ..... 87 dBA

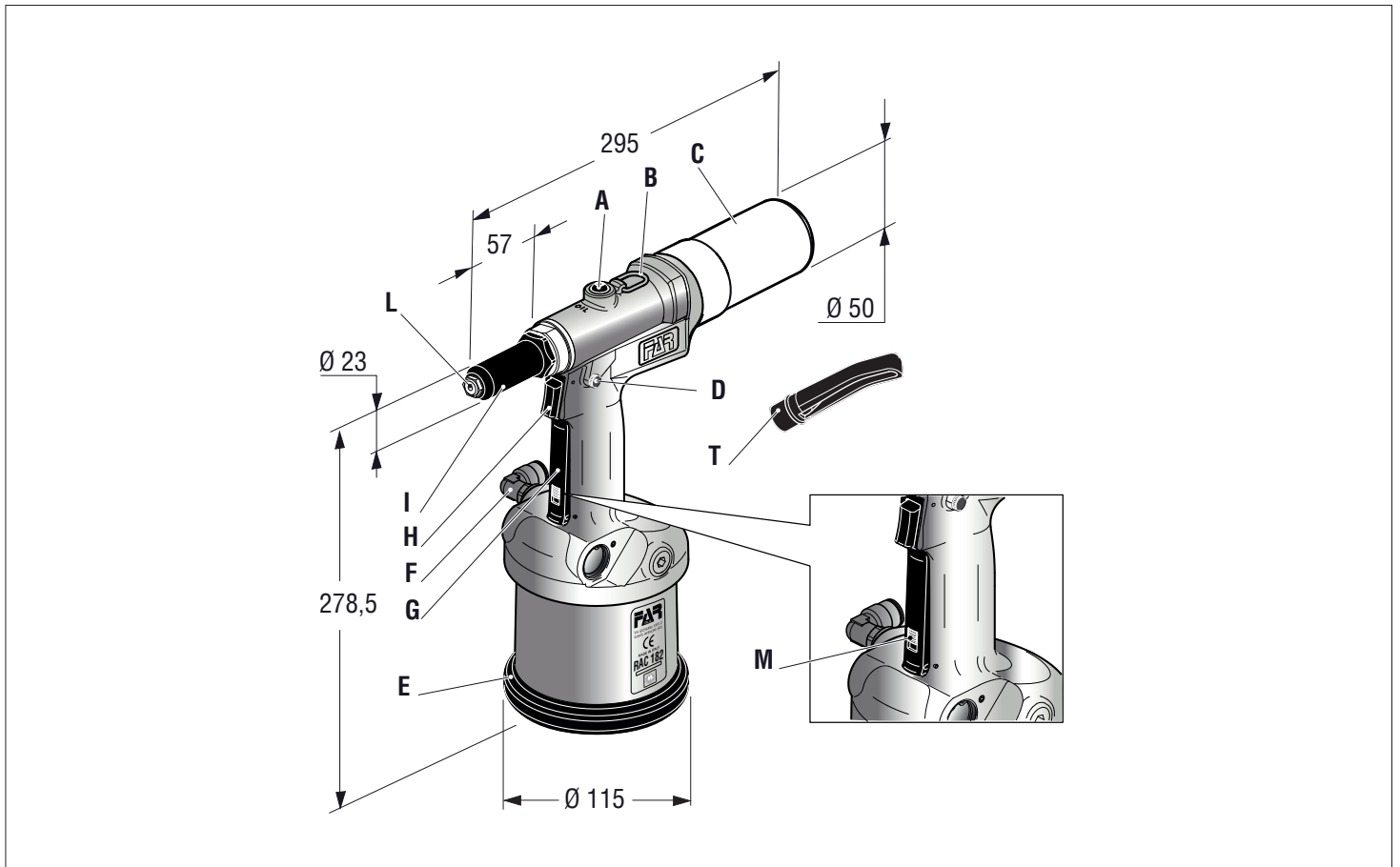
**AIR FEEDING**

The air feed must be free from foreign bodies and humidity in order to protect the tool from premature wear and tear of the components in movement, therefore we suggest to use a lubricator group for compressed air.



MAIN COMPONENTS

- |         |                           |         |                          |
|---------|---------------------------|---------|--------------------------|
| A)..... | Oil tank plug             | G)..... | Suction control          |
| B)..... | Balancer connection       | H)..... | Tensile strenght button  |
| C)..... | Nails container           | I)..... | Sleeve carrying nozzle   |
| D)..... | Suction regulation knob   | L)..... | Nozzle                   |
| E)..... | Rubber protective base    | M)..... | Suction Device always on |
| F)..... | Compressed air connection | T)..... | Nails baffle             |





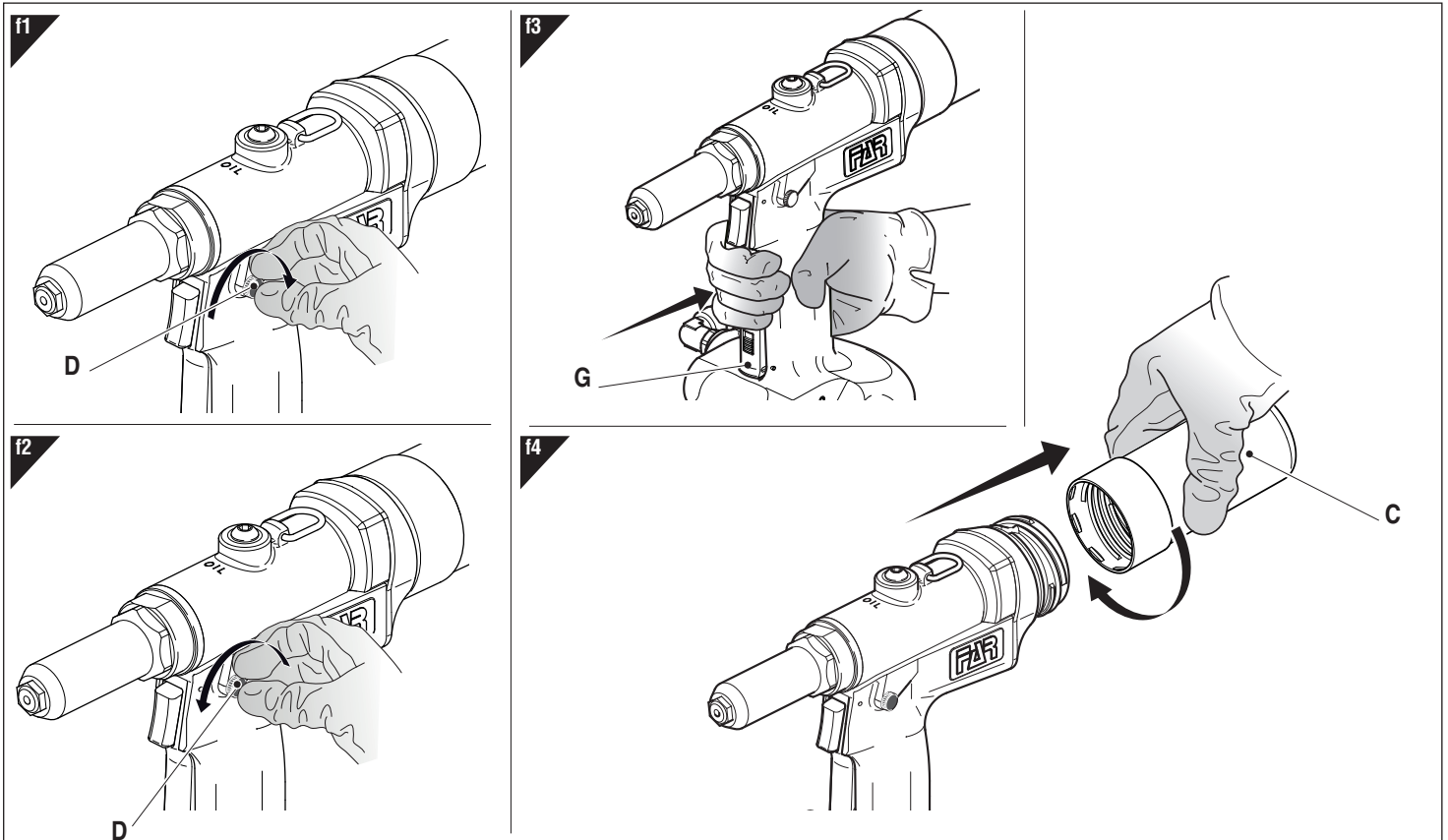
**ATTENTION!!!** Before using the tool it is absolutely necessary to fit the nails container (C), or the nails baffle (T).

**WARNING:** When the riveting tool is used in the absence of nails tank (C), it is essential to fit the baffle (T) and the relative reduction (S) (pic.F14), in order to avoid injury to the operator and / or persons close to him. PLEASE DISPOSE OF NAILS CAREFULLY!  
Do not use the riveting tool when the container (C) is overflowing with spent mandrels, but unscrew the container (C) and empty it (pic. f4).

Controlled suction (factory settings) (pic. f1 ÷ f3)

Make sure that the knob (D) is completely screwed (pic. f1).

Hold down the lever (G) as shown in the picture (pic. f3), turn the knob (D) anticlockwise (pic.f2) to open and adjust the air flow necessary to suck the spent mandrel.

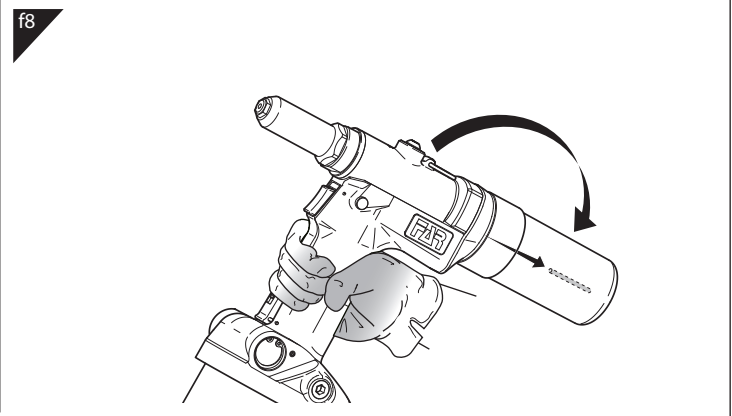
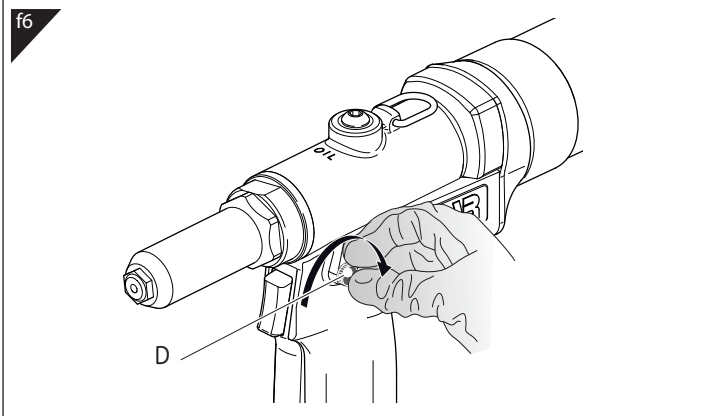
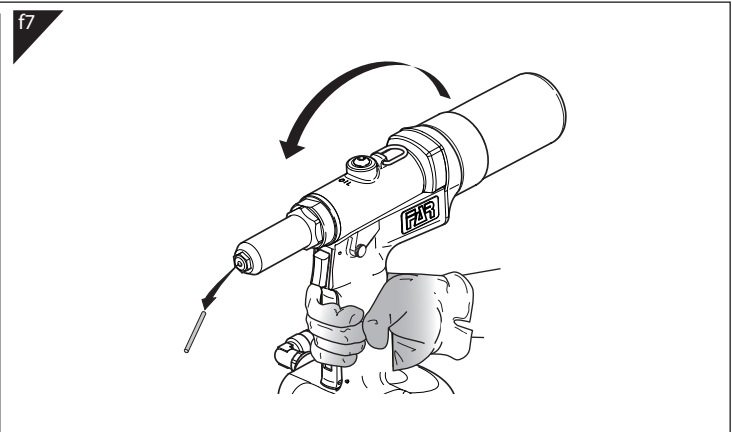
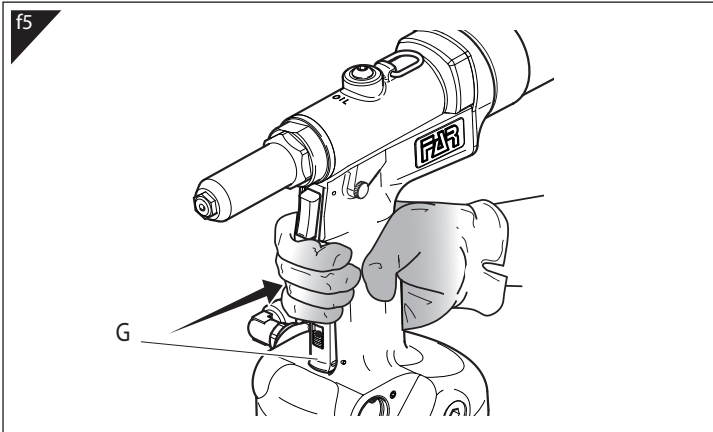




HOW TO USE YOUR RIVETING TOOL

Suction OFF (pic. f5-f8)

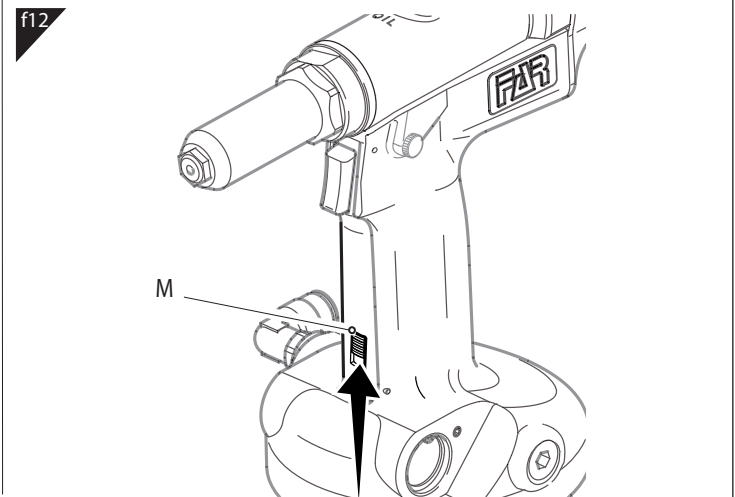
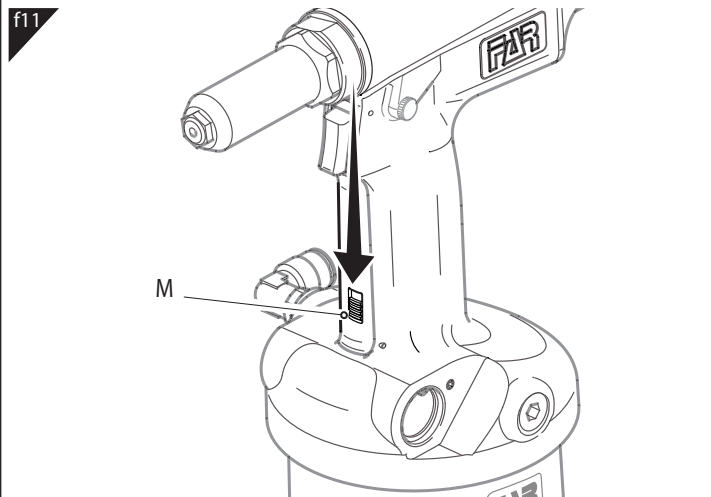
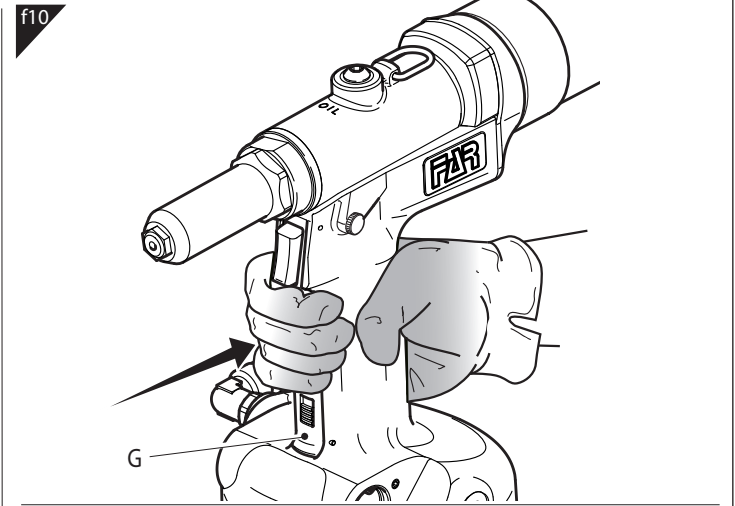
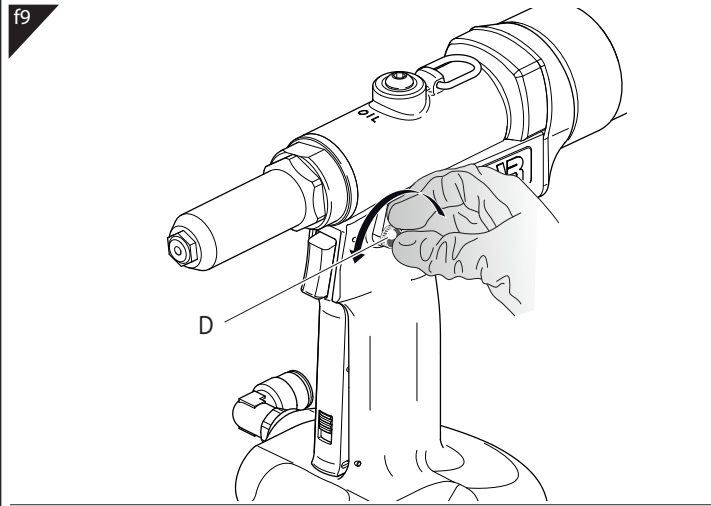
Keep the lever (G) pressed as shown (pic. f5), turn the knob (D) clockwise (pic.f6), until the suction stops. In this configuration, the spent mandrel will come out by gravity, from the front or back, tilting the riveting tool as shown in the picture (pic. f7-f8).



HOW TO USE YOUR RIVETING TOOL

Air suction always on (pic. f9÷f12)

With air suction on (pic. f9), keep the lever (G) pressed (pic. f10) and push down the locking device (M) (pic. f11). To return to controlled suction, keep the lever (G) pressed (pic. f10) and push the locking device (M) from the opposite side (pic. f12).



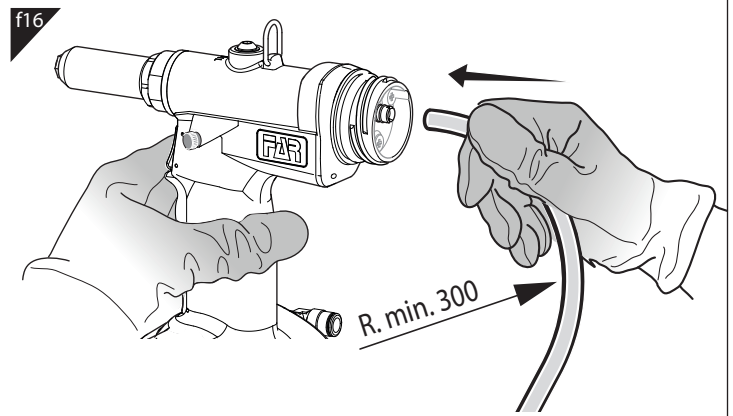
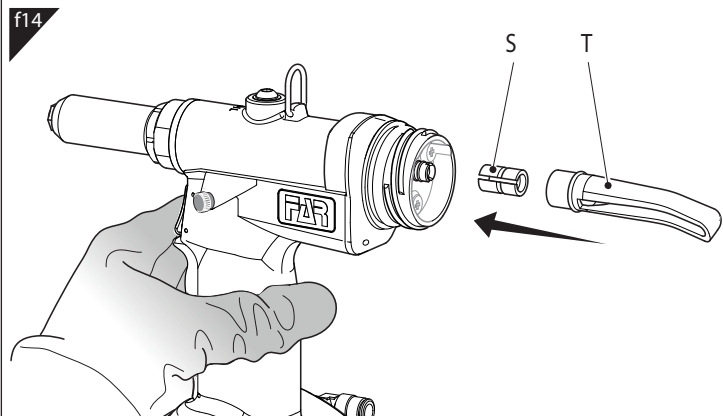
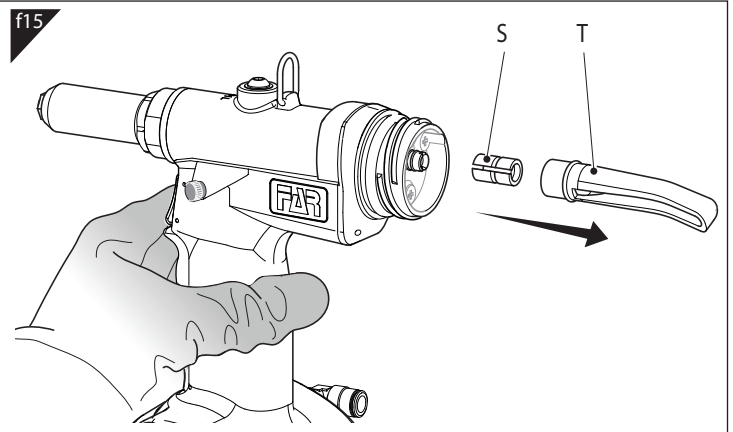
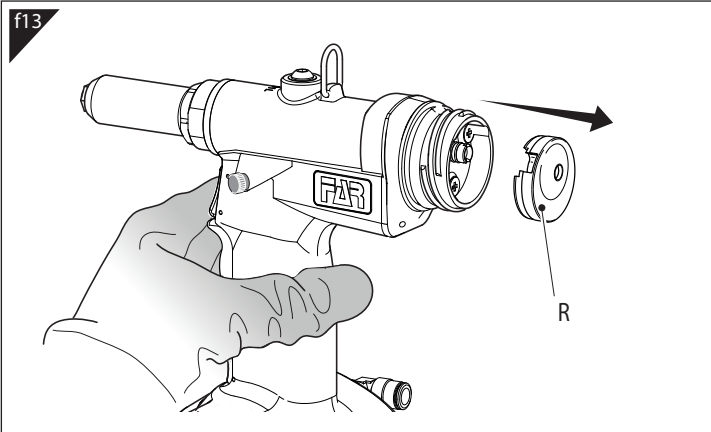
Broken mandrel recovery (pic. f13÷f16)

To assemble the baffle (T) proceed as follows: remove the nails tank (C) (pic. f4) as well as the cover (R) (pic. f13), assemble the reduction (S) on the connector and insert the baffle (T) with a slight pressure (pic. f14).

In case you want to convey the pieces of sheared nails inside a container, pull out the baffle (T) and the relative reduction (S) from the tool (pic. f15).

Connect the riveter with a pipe  $\varnothing 10 \times 8$  (C) by inserting it on the fitting (pic. f16).


CAUTION: the radius of curvature of the pipe must not be less than 300 mm, as shown in (pic. f16).

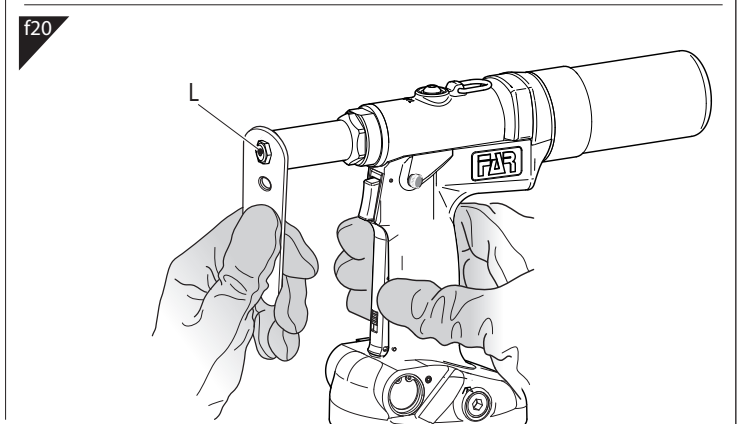
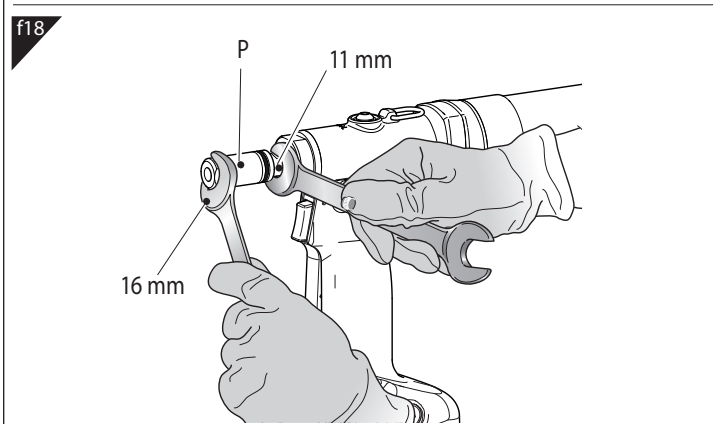
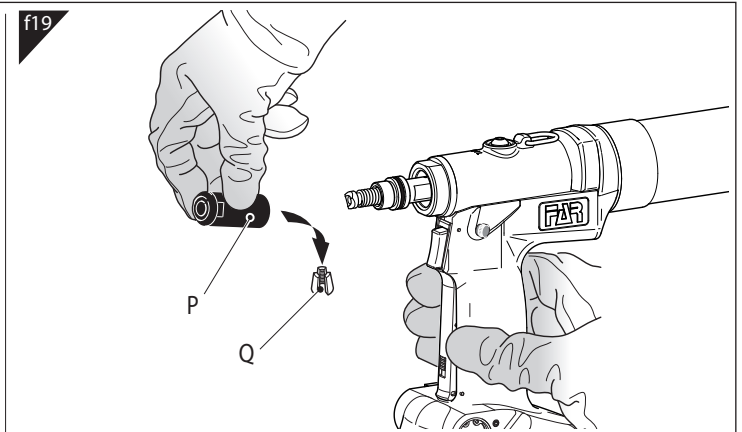
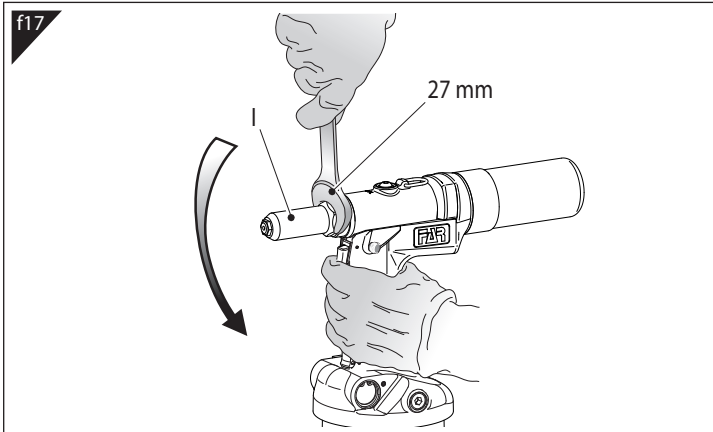




CLAMPS MAINTENANCE AND CHANGE OF SIZE (pic. f17-f20)

The prolonged use of the riveting tool can cause the slipping of the clamps on the nail because of the impurities. For this reason, it is necessary to lubricate the clamps after cleaning. However, if clamps are worn out and their proper functioning compromised, they must be replaced. First remove the head which carries the nozzle (I), by means of a standard spanner of 27 mm. Then, by using two standard spanners of 11 mm and 16 mm, remove the cone (P) and extract the clamps (Q). When replacing the nozzle (L), use the proper supplied wrench and screw the removed nozzle in it in order to avoid losing the nozzle.


**WARNING!**  
 DISCONNECT AIR FEED WHEN PERFORMING THOSE OPERATIONS.





TOPPING UP OIL IN THE HYDRAULIC CIRCUIT ( pic. f 21)

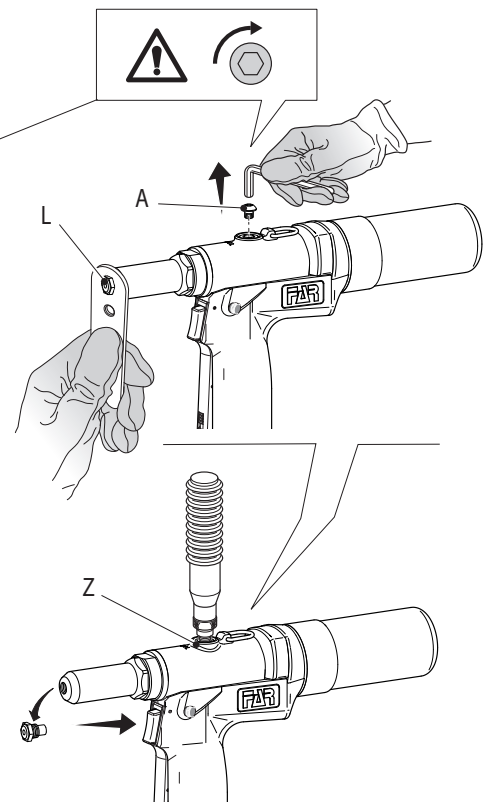
Topping up the oil in the hydraulic circuit is necessary after a long period of work (15000 cycles), when there is a reduction of the riveter stroke. Then proceed as follows: riveting tool on standby but fed and in a vertical position, remove the cap (A) using the allen wrench 4 mm., remove also the nozzle (L) with the provided key. When doing this operation use extreme caution to prevent oil spills. Screw the oil container (Z), previously filled with commercial hydraulic oil HLP 32 cSt, into the place of the cap (A). By keeping the riveting tool vertically, press the trigger several times until the riveter ends to make bubbles from the oil container (Z). It means that the oil filling has been fully achieved. With the riveter still vertical and fed, unscrew the oil container (Z) and then proceed by placing the cap (A).  
**WARNING:** it is very important to follow the about mentioned instructions and use gloves and protection glasses or protective visors. If you need to empty fully the hydraulic circuit, you must put the oil in a suitable container and contact a Company that is authorized to discharge any waste.



ATTENTION! WE RECOMMEND TO USE OIL HLP 32 CST OR SIMILARS

f21

- |   |  |
|---|--|
| <p><b>I</b> <b>IMPORTANTE:</b> Assicurarsi che il tappo di rabbocco olio(A) venga serrato con una coppia pari a: Max. 5 Nm.</p> <p><b>GB</b> <b>ATTENTION:</b> Make sure that the oil filler cap (A) is tightened at a torque corresponding to Max. 5 Nm.</p> <p><b>F</b> <b>IMPORTANT:</b> S'assurer que le bouchon de remplissage d'huile (A) soit vissé avec couple démin. Max. 5 Nm.</p> <p><b>D</b> <b>WICHTIG:</b> Es muß sichergestellt werden, daß der Öltankverschluß (A) mit einemMax. 5 Nm liegenden Anzugsmoment angeschraubt wird.</p> | <p><b>E</b> <b>IMPORTANTE:</b> Asegurarse que el tapón de llenado aceite(A) sea enroscado con un par de acople correspondiente a: Máx. 5 Nm.</p> <p><b>PL</b> <b>UWAGA!</b> Upewnić się że korek wlewu oleju (A) został dokręcony z siłą równą <b>Maks. 5 NM.</b></p> <p><b>RU</b> <b>ВНИМАНИЕ!</b> Убедиться в том, что пробка масляного бака (A) завинчивается с усилием затяжки от <b>макс. 5 Нм.</b></p> <p><b>PT</b> <b>IMPORTANTE:</b> Certificar-se que a tampa de reabastecimento de óleo (A) seja apertada com um binário igual a: Máx. 5 Nm.</p> |
|---|--|





## REGULAR MAINTENANCE

## Daily maintenance

- Check the supply system of the compressed air.
- Check that there are neither air nor oil leakages. In this case replace possible damaged connectors or seals.
- Check that the supply pressure of the compressed air does not exceed 7 bar.

## Weekly maintenance

- Check the oil level controlling the stroke of the riveting tool. If necessary fill up for preventing failures of the riveting tool as indicated (fig. f21).

## Overhaul of the riveting tool

It is advisable to carry out a complete overhaul of the riveting tool after 600,000 cycles or every year.

In this case apply only to centres authorized by FAR S.r.l.

## DISPOSAL OF THE RIVETING TOOL



Follow the prescriptions of the national laws for disposing of the riveting tool.

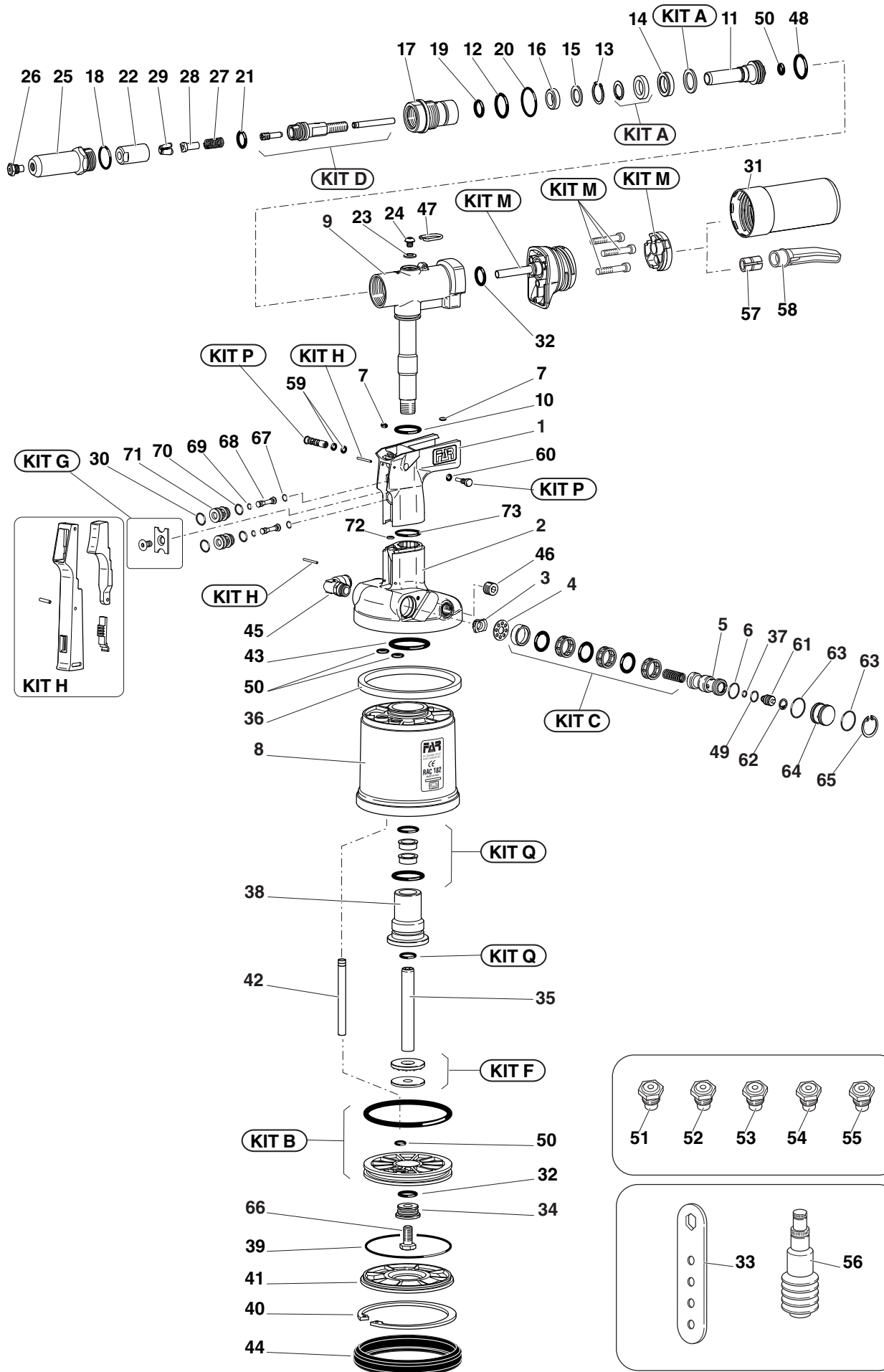
After disconnecting the tool from the pneumatic system, disassemble and split all the components according to the material: steel, aluminium, plastic material, etc. Then proceed to scrap the materials in accordance with current laws.

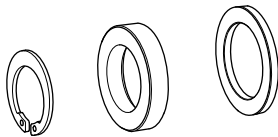
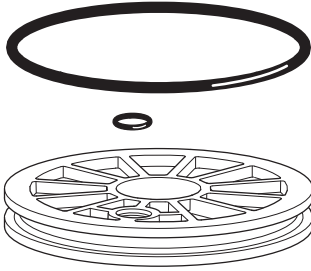
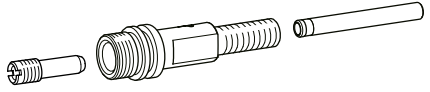
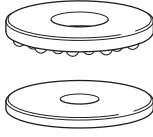
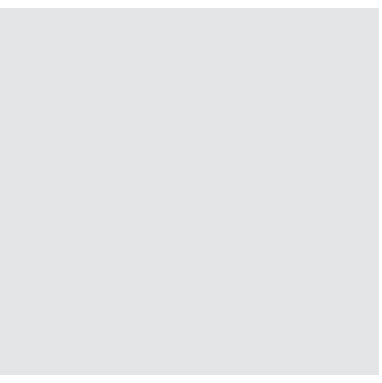
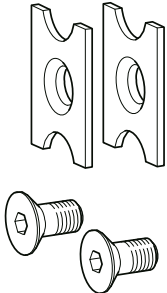
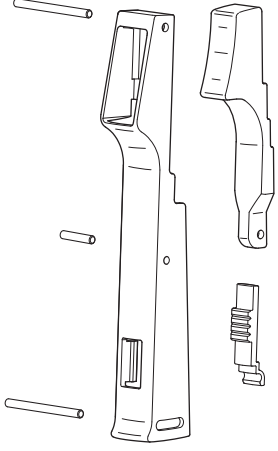
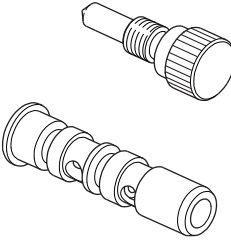
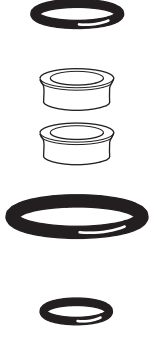
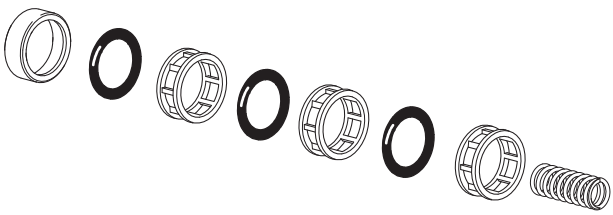
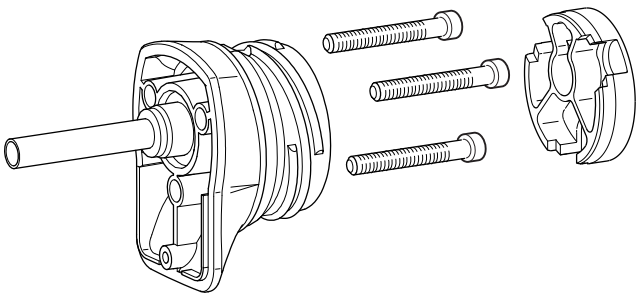
## TROUBLE SHOOTING

SIGNALS	CAUSE	SOLUTIONS
- Does not fasten the rivet	- Non-powered tool	- Connect the riveting tools to the compressed air
	- Slipping of the clamps on the nail	- Perform clamps maintenance
	- Lack of oil	- Top up oil
	- Incorrect nozzle	- Replace the nozzle as shown in the table
	- Unfiltered and unlubricated air	- Equip yourself with lubricator filter assembly
- Oil leak	- Worn gaskets	- Contact the service center
	- Oil filler cap not tightened	- Tighten correctly
- Air leak	- Incorrect positioning of the feeding tube	- Position the feeding tube correctly
	- Worn gaskets	- Contact the service center
	- Breaks on the riveting machine body	- Contact the service center
- Not ejected nail	- Incorrect nozzle	- Replace the nozzle as shown in the table
	- Closed suction system	- Open the suction system
	- Full nails container	- Empty the container

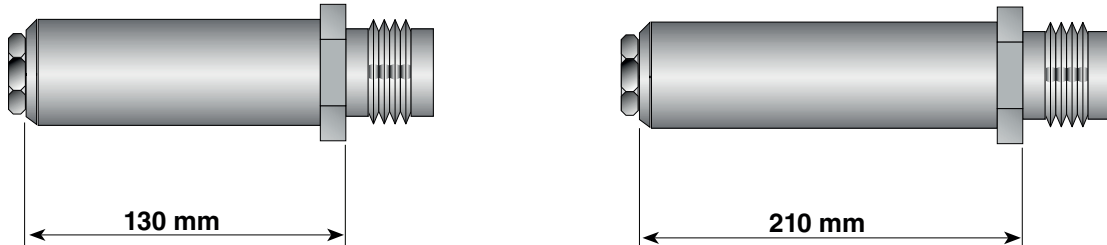


• SPARE PARTS •

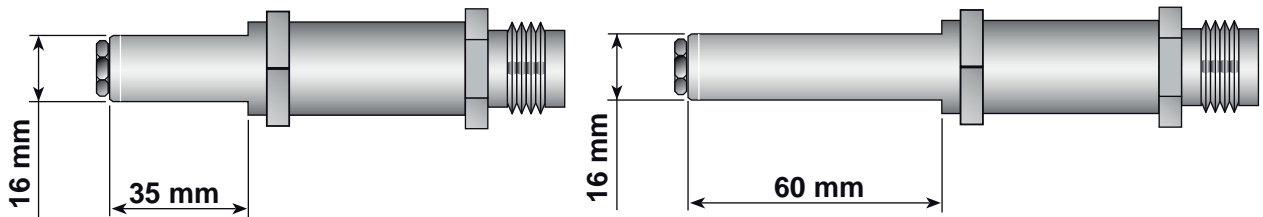


<p>KIT A</p> 	<p>KIT B</p> 	<p>KIT D</p> 
<p>KIT F</p> 		<p>KIT G</p> 
<p>KIT H</p> 	<p>KIT P</p> 	<p>KIT Q</p> 
<p>KIT C</p> 		<p>KIT M</p> 

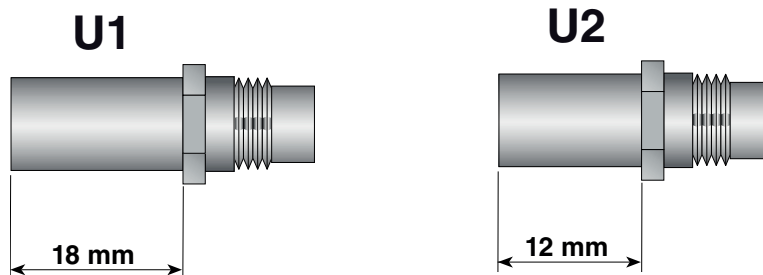
**TESTE PROLUNGATE - EXTENDED HEADS - TÊTES ALLONGÉES - VERLÄNGERTE KÖPFE - CABEZAS ALARGADAS - PRZEDŁUŻONE GŁOWICE - УДЛИНЕННЫЕ ГОЛОВКИ - CABEÇAS PROLONGADAS**



**TESTE PROLUNGATE A SEZIONE RIDOTTA - EXTENDED HEADS WITH REDUCED SECTION - TÊTES ALLONGÉES AVEC SECTION RÉDUITE - VERLÄNGERTE KÖPFE MIT VERKLEINERTEM QUERSCHNITT - CABEZAS ALARGADAS DE SECCION REDUCIDA - GŁOWICE WYDŁUŻANE O ZREDUKOWANYM PRZEKROJU - УДЛИНЕННЫЕ ГОЛОВКИ С ЗАНИЖЕННЫМ СЕЧЕНИЕМ - CABEÇAS PROLONGADAS DE SECÇÃO REDUZIDA**

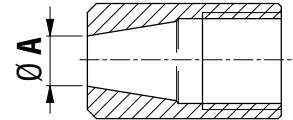
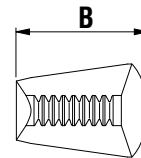
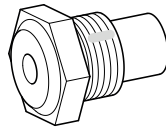
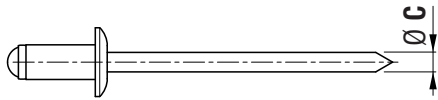
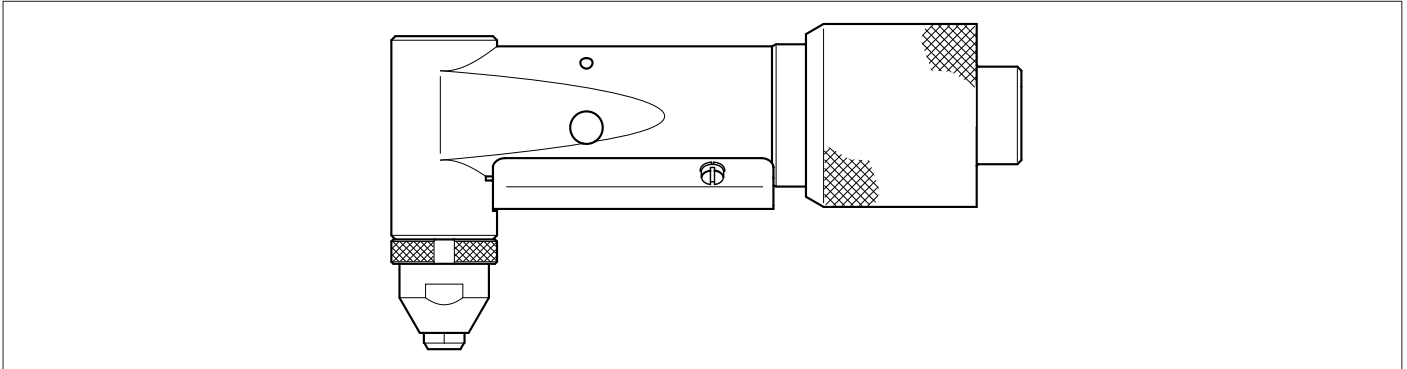


**UGELLI PROLUNGATI - EXTENDED NOZZLES - EMBOUCHURES ALLONGÉES - VERLÄNGERTE MUNDSTÜCKE - BOQUILLAS ALARGADAS - PRZEDŁUŻONE DYSZE - УДЛИНЕННЫЕ СОПЛА - BOCAIS PROLONGADOS**





**TESTA ANGOLARE - ANGLE HEAD - TÊTE ANGULAIRE - WINKELKOPF - CABEZA ANGULAR - GŁOWICA KĄTOWA -**  
**- УГЛОВАЯ ГОЛОВКА - CABEÇA ANGULAR**

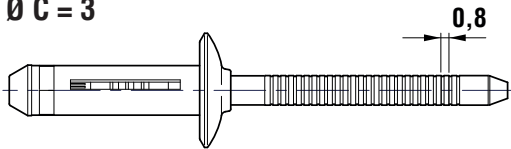


**PER L'UTILIZZO DI RIVETTI S-TRIFAR / X TRIFAR - TO USE S-TRIFAR / X TRIFAR RIVETS -**

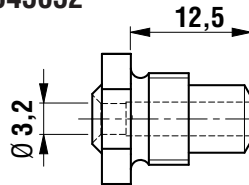
- POUR L'UTILISATION DE RIVETS S-TRIFAR / X TRIFAR - FÜR DIE VERWENDUNG VON BLINDNIETEN S-TRIFAR / X-TRIFAR -  
 - PARA EL USO DE REMACHES S-TRIFAR / X TRIFAR - DO NITÓW S-TRIFAR / X TRIFAR - ДЛЯ ПРИМЕНЕНИЯ С ЗАКЛЕПКАМИ S-  
 - TRIFAR / X TRIFAR - PARA O USO DE REBITES S-TRIFAR

**S-TRIFAR / X-TRIFAR Ø 5,2**

**Ø C = 3**



**71345652**



**B = 13**

**71345507**

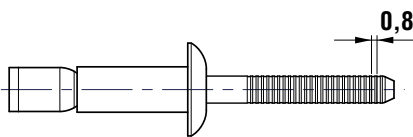
**Ø A = 8,3**

**710859**

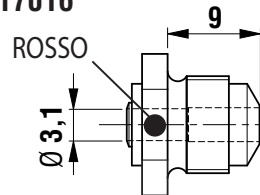
**KIT PER RIVETTI AD ALTE PRESTAZIONI - KIT FOR HIGH-PERFORMANCE RIVETS - KIT POUR RIVETS AVEUGLES HAUTES PERFORMANCES -**

- KIT FÜR HOCHLEISTUNGSBLINDNIETEN - KIT PARA REMACHES ALTO RENDIMIENTO -  
 - ZESTAW DO NITÓW WYSOKIEJ WYTRZYMAŁOŚCI - ВЫСОКОПРОИЗВОДИТЕЛЬНАЯ ЗАКЛЕПОЧНАЯ СИСТЕМА  
 - KIT PARA REBITES DE ELEVADO DESEMPENHO

**Ø C = 3**



**717016**



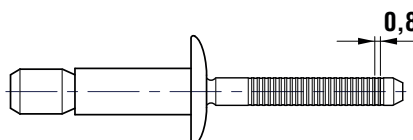
**B = 14**

**71345476**

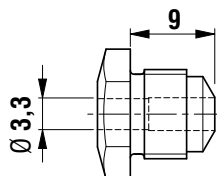
**Ø A = 8,3**

**710859**

**Ø C = 3**



**717018**



**B = 14**

**71345476**

**Ø A = 8,3**

**710859**

MONITORING SYSTEM



**FAR**  
BOLOGNA  
ITALY

**60<sup>th</sup>**  
**SINCE**  
**1957**

