



MAINTENANCE TIPS FAR HYDRO-PNEUMATIC INSTALLATION TOOLS RAC 181 RIVETING TOOL

Here are some handy weekly maintenance tips to help with the investment you have made in your tooling, to ensure its best operating life and minimise valuable down time.

- ◆ **Nose Tip.** Check and tighten if necessary (12mm Spanner) the Nose Tip of the tool to ensure the tool jaws are opening correctly.
- ◆ **Clean Jaws.** Remove the nose tip holding cone (27mm Spanner). Remove the jaw holder and jaws (16mm & 11mm Spanner). Clean any deposits that may be in the nose tip holding cone, jaw holder, pusher and spring. Clean jaws with a rag and lube. Assemble in reverse.
Extra Tip: Try INOX or similar to clean away deposits because it also acts as a lubricant.
- ◆ **Lube Pneumatics.** Add a few drops of air oil to the air fitting to lubricate the internal pneumatic workings of the tool. This will also help prevent formation of corrosion from moisture that is known to build in compressed air lines. Minimum internal diameter of the compressed air feed is 6.0mm.
- ◆ **Hydraulic Oil Circuit Bleeding.** A weekly check of the hydraulic oil circuit level is necessary. Disconnect the tool from the air supply, remove the Nose Tip Holding Cone and shut off the vacuum extraction. Ensure the tool is upright and remove the bleed plug with a 4mm allen key. If the oil is dirty in appearance it will require replacing. Connect tool to air, invert tool over bucket to drain the oil (dispose of oil safely) and pull the trigger. If the oil is clean but low or to re-prime completely, screw priming bottle securely into place (note: only use hydraulic oil with a viscosity of 32 in the tool's oil priming bottle). Connect air supply (6.0bar or 87psi) to the tool and cycle the tool twelve times to bleed out any air voids, holding the trigger and waiting for 5 seconds and releasing the trigger and waiting for 5 seconds. Remove the priming bottle from tool with the air supply *STILL CONNECTED* (this is so the main pneumatic piston does not relax and disgorge any oil over the operator). Refit the bleed plug and Nose Tip Holding Cone to tool and tighten.

Please Note: A protective visor & gloves must be worn when operating or maintaining this tool.

Special care should be taken during the Bleed procedure, NOT to press the trigger WITHOUT either the Grub Screw or Priming Bottle attached!

Always remember to empty the mandrel catcher regularly as excess build-up of spent mandrels will cause damage to the tool

Information provided is advice only and does not account for the specific circumstances of your tooling. If in doubt, always contact Profast before attempting any repairs

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