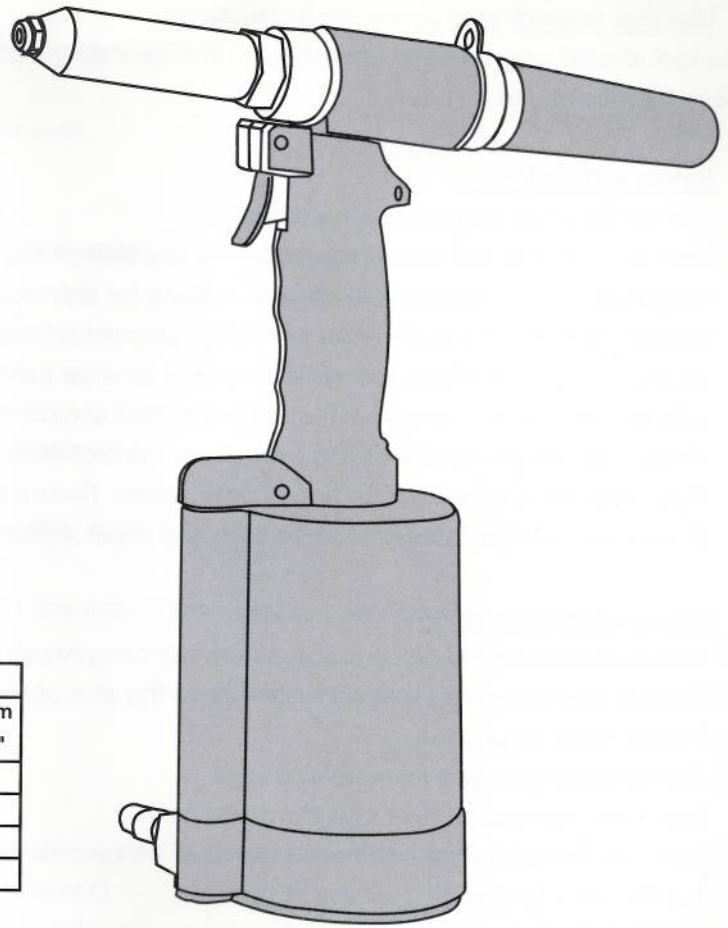




Heavy Duty Air Hydraulic Riveter Manual



Model. NO AR100

Net Weight	1.55 kg
Operational air pressure	5.5-6 kg/cm ²
	540-590 kpa
Stroke	16mm

Capacity

Material	Rivet Size			
	2.4mm 3/32"	3.2mm 1/8"	4.0mm 5/32"	4.8mm 3/16"
Aluminum	0	0	0	0
Aluminum Steel	0	0	0	0
Steel	0	0	0	0
Stainless steel	0	0	0	0



NCG TOOLS INDUSTRY CO., LTD

1. Use tool according to operating instruction

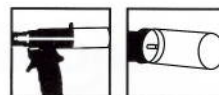
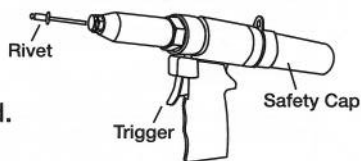
The tool should only be used according to the operating instructions given for setting rivets. The safety instructions are to be followed at all times.

2. Safety instructions

- The tool is used only for setting rivets.
- Only operate the tool within the indicated capability range.
- Regularly check compressed air connections for tightness and leakage.
- When tool is not in use or when servicing, disconnect the tool from compressed air supply.
- When operating the tool, it is recommended to wear safety equipment such as safety goggles, protective gloves and clothing, and hearing protection to prevent accidents.
- Keep long hair or loose clothing away from the tool during operation or when servicing.
- Only trained personnel should carry out repairs. Return the tool to supplier if in doubt.
- Environmental regulations must be followed when disposing hydraulic oil.

3. Operating instructions

- Make sure the tool is disconnected from the compressed air supply.
- Choose the nosepiece that corresponds to the size of rivet to be used.
- Screw in the nosepiece.
- Connect compressed air supply to tool.
- Insert the mandrel of rivet into the nosepiece.
- Insert the head of rivet into the workpiece. Make sure the fastener's head is fully seated.
- Set the rivet by pressing on the trigger.
- Release trigger when the mandrel of the rivet has been cut.
- After successfully fastening the workpiece, point the nosepiece upward.
- The leg of rivet will drop into the container.



4. Maintenance and Trouble Shooting

When about 3000 rivets have been handled, the jae will be clogged with chips.

Then the part must be cleaned.

Also clean the air cylinder section after handling about 6 month.

A: Riveting cannot be done by operation the trigger once

- (1) Rivet length is not suitable for work thickness.(Use suitable rivets.)
- (2) Hydraulic oil is insufficient.(Replenish.)
- (3) Air is mixed in with hydraulic oil.(Change oil.)
- (4) Jaw is worn out.(Replace jaw.)
- (5) Jaw case position is wrong.
- (6) Air pressure is defective.(Check air pressure and compressor.)

B: Rivet cannot be inserted. Mandrel cannot be pulled out after rivet

- (1) Jaw case position is wrong.
- (2) Operation is defective due to stains sticking to jaw and jaw case.(Disassemble and clean jaw case.)
- (3) Air cylinder is stained or oil is insufficient.
- (4) Nose piece and booster head are not correctly locked.

C: Machine operates but is unable to perform riveting.

- (1) Jaw is worn out.(Replace jaw.)
- (2) Operation is defective due to stains sticking to jaw case.(Disassemble and clean jaw case.)
- (3) Air pressure is defective.(Check air pressure and compressor.)

1.1 Maintenance

Remove the jaw case housing.

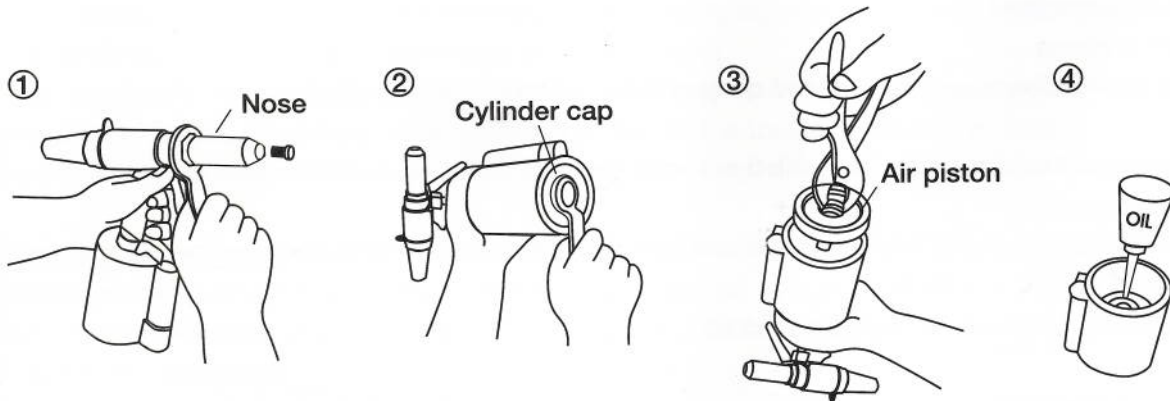
Unscrew the cylinder cap.

Pull out the air piston using pliers.

Clean the inside of the air cylinder and apply grease to the cylinder walls.

Hold the tool upside down, and supply hydraulic oil to the oil inlet until it overflows.

Install the cleaned air piston and assemble the parts by reversing the disassembling procedure.



AR100 PARTS LIST

PART NO.	DESCRIPTION	Q'TY	PART NO.	DESCRIPTION	Q'TY
AR100-01	Frame	1	AR100-29	Rubber Cushion	1
AR100-02	O-Ring	2	AR100-30	Air Piston Rod	1
AR100-03	Back up Ring	1	AR100-31	Air Piston O-Ring	1
HI-04-04	Jaw Case Head	1	AR100-32	Air Piston Lock Nut	1
HI-04-05	Jaws	1	AR100-33	Cylinder Cap	1
HI-04-2-06	Jaws Pusher	1	AR100-34	Cylinder O-Ring	1
HI-04-3-07	Jaw Pusher Spring	1	AR100-35	Valve Pusher	1
AR100-08	Jaw Case Lock Nut	1	AR100-36	Valve Pusher O-Ring	2
AR100-09	Piston Adapter	1	AR100-37	Valve Spring	1
AR100-10	Lock Nut	1	AR100-38	Valve Coller	1
AR100-11	Oil Piston	1	AR100-39	Valve	1
AR100-12	Oil Piston O-Ring	1	AR100-40	Valve Spring	1
AR100-13	Back up Ring	1	AR100-41	Valve Cap	1
AR100-14	Mandrel Exit Tube	1	AR100-42	Valve Cap O-Ring	1
AR100-15	Return Spring (outer)	1	AR100-43	Trigger Lever	1
AR100-16	Return Spring (inner)	1	AR100-44	Lever Pin	1
AR100-17	Frame Cap	1	AR100-45	Trigger Rod	1
AR100-18	Frame Cap O-Ring	1	AR100-46	Trigger Pin	2
AR100-19	Hanger Clip	1	AR100-47	Trigger Pin	1
AR100-20	Fram Head	1	AR100-48	Trigger	1
AR100-21A	Nose Piece 2.4mm	1	AR100-49	Handle	1
AR100-21B	Nose Piece 3.2mm	1	AR100-50	Connector Screw	1
AR100-21C	Nose Piece 4.0mm	1	AR100-51	Connector Screw	2
AR100-21D	Nose Piece 4.8mm	1	AR100-52	Connector Screw	2
AR100-22	Safety Cap	1	AR100-53	Connector Lock Nut	2
AR100-23	Air Cylinder	1	AR100-54	Spanner 12,14,5,6	1
AR100-24	Setting Screw	1	AR100-55	Spanner 15,19	1
AR100-25	Frame Lock Nut	1	AR100-56	Spanner 15,24H.	1
AR100-26	Air Piston Rod	1	AR100-57	Thread Joint PM20	1
AR100-27	Back up o Ring	2	AR100-58	Frame Cap	1
AR100-28	Back up Ring	1	AR100-59	Back up Ring	1

AR100 EXPLODED VIEW

