



Instruction Manual  
Model#  
RK-8000LS



For sales, service or support call your local distributor or:

1800-BUY-RIVET or 1-800-289-7483

[www.rivet.com](http://www.rivet.com)

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## SAFETY

- DO NOT USE OUTSIDE DESIGN INTENT OR WITH EQUIPMENT THAT IS NOT RECOMMENDED BY THE MANUFACTURER.
- ALWAYS DISCONNECT THE AIR SUPPLY BEFORE ATTEMPTING ANY MAINTENANCE OR ADJUSTMENT/FITTING OF NOSE EQUIPMENT
- DO NOT OPERATE A TOOL THAT IS DIRECTED TOWARDS ANY PERSON(S) OR WITH THE MANDREL CATCHER OFF THE TOOL
- ALL MODIFICATIONS CARRIED OUT ON THE TOOL WITHOUT EXPRESS WRITTEN CONSENT OF THE MANUFACTURER SHALL BE DONE SO AT THE CUSTOMERS' SOLE RESPONSIBILITY
- REFER TO THIS MANUAL BEFORE ATTEMPTING ANY MAINTENANCE OPERATION. DO NOT DISASSEMBLE THIS TOOL BEFORE REFERRING TO THIS MANUAL.
- AVOID EXCESSIVE CONTACT WITH HYDRAULIC OIL, AS SOON AS POSSIBLE WASH HANDS THOROUGHLY
- DO NOT EXCEED 7 BAR / 100 PSI INLET PRESSURE, THE USE OF A PRESSURE REGULATOR IS HIGHLY RECOMMENDED
- INSPECT THE TOOL USING PREVENTITIVE MAINTENANCE TECHNIQUES AT REGULARLY SCHEDULED INTERVALS. INSPECT FOR DAMAGE AND FUNCTION BY TRAINED COMPETANT PERSONEL. REPLACE THE PNEUMATIC CYLINDER HOUSING OR HYDRAULIC CYLINDER HOUSING WHENEVER THERE IS EVIDANEC OF IMPACT DAMAGE, CHIPPING, OR CRACKING.
- WEAR SAFETY GLASSES AND ADOPT FIRM FOOTING DURING OPERATION.

## SPECIFICATIONS

The specifications and information contained in this manual are applicable only to the tool with which it was supplied. Industrial Rivet & Fastener Co reserve the right to make any changes without notice as part of Industrial Rivet & Fastener Co policy of continuous improvement.

SPECIFICATIONS FOR RK-800LS RIVET TOOL		
Air Pressure	85-95 psi	Min/Max
Stroke	1.05 Inches	
Pull Force	3,400 lbsF	@90psi
Cycle Time	0.9 seconds	Approximately
Noise Level	75 dB(A)	Less than
Weight	3.74 lbs	
Vibration	2.5m/s <sup>2</sup>	Less than
Hydraulic Oil	Mobil DTFE 24	
Nose Pieces	5/32, 3/16 , 1/4, 3/16 Monobolt 1/4 Monobolt	All material rivets
Nose Pieces	1/8	Purchased Separately



## AIR SUPPLY

- The rivet tool is powered by compressed air at an optimum pressure of 95 psi. **Do not exceed 115 PSI of air pressure. Explosion and harm to operators can result.**
- The use of a pressure regulator filter/lubricator unit within 3 meters of the tool is highly recommended to extend the life of the tool.

**Dirt and/or water in the air supply can seriously impact the performance and durability of the tool; damage to the tool caused by contaminated air supply is not covered under warranty.**

## OPERATION

1. Inspect for damage
2. Connect the tool to the air supply
3. The RK-8000LS has a valve for switching the air supply on and off to save air when the tool is not in use.

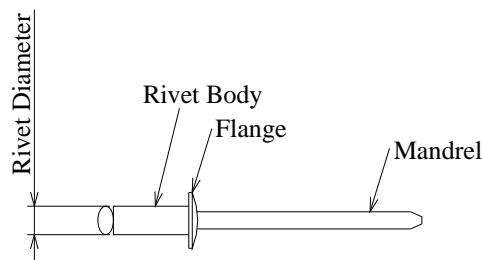
### **AIR SUPPLY ON (UP).**



### **AIR SUPPLY OFF (DOWN).**



4. Choose and securely install the applicable nose piece for the rivets you wish to apply. Different-Sized rivets can be used just by replacing the nosepieces. If you wish to use other sizes, use a spanner to remove and replace the nosepiece.
5. The nosepiece fitted is the one designated when ordering. The nosepiece should be changed if a different size of rivet is used.



**FOR OTHER OR SPECIAL RIVETS, PLEASE CONSULT INDUSTRIAL RIVET 1-800-289-7483**

- 6. Adjust the vacuum until rivet is held in the nose piece while tool is pointed downward and such that the mandrel after actuation flows to the back of the tool in any position...
  - a. Adjust vacuum by rotating the valve located at left of the blue handle.



**FIG 1**

**VACUUM ON (COUNTERCLOCKWISE)**

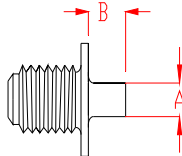
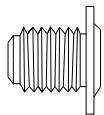


**FIG 2**

**VACUUM OFF (CLOCKWISE)**

- 7. Bring the tool and the rivet into the application hole. Insure the rivet head flat onto surface
- 8. Fully actuate the trigger. The tool will cycle and set the rivet while ejecting the nail into the rear mandrel catcher.
- 9. Empty catcher when at 50% capacity.

**10. INDUSTRIAL RIVET OFFER SPECIAL NOSE PIECES.**



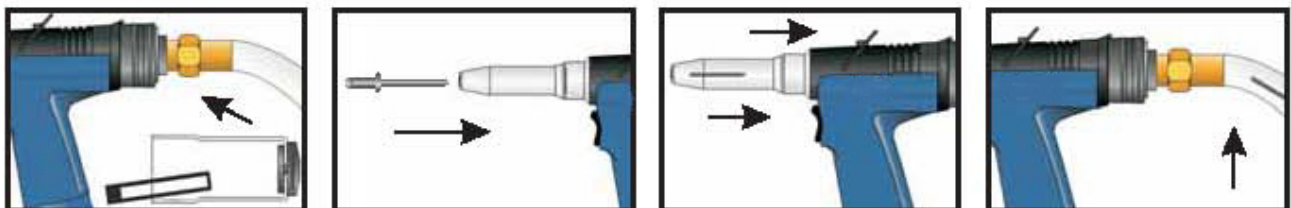
PART #	RIVET	A	B
4EXTP1/4	1/8	.200	.230
5EXTP1/4	3/16	.250	.230
6EXTP1/4	1/4	.315	.215

STANDARD NOSE PIECE

SPECIAL NOSE PIECE

**FOR SPECIAL NOSE PIECE OR SPECIAL RIVETS, PLEASE CONSULT INDUSTRIAL RIVET  
1-800-289-7483 or info@rivet.com**

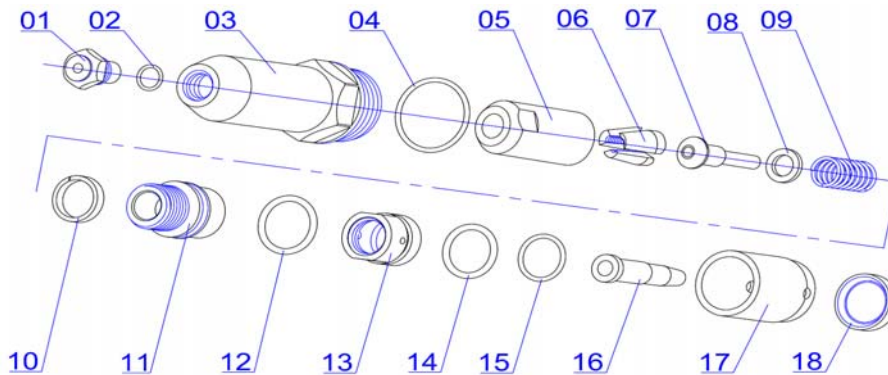
When the tool is in use for extended periods of time in a stationary production environment, a hose can be fitted to the rear of the tool to assist in the mass collection of mandrel. Contact the sales department for associated parts.



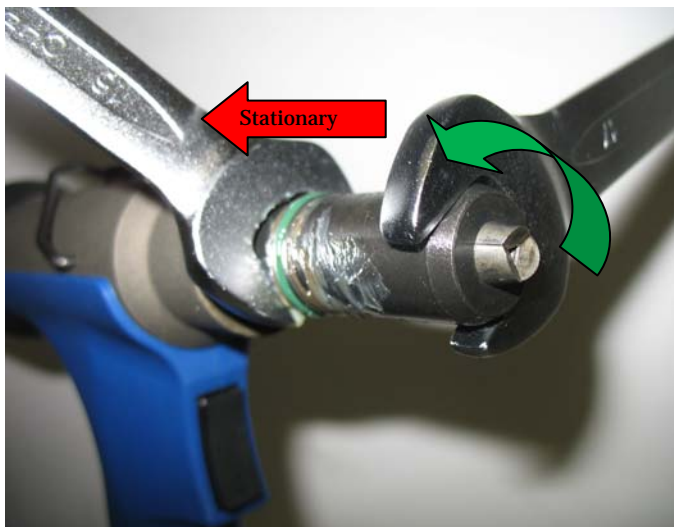
## JAW CLEANING PROCEDURE / JAMMED GUN REMEDY

1. Disconnect tool from air supply
2. Leaving the nose piece attached, remove the nose case **3** using the wrench provided by loosening at the wrench point.
3. Fit two wrenches, one on Jaw Case **05** and the other on **11** keeping the nut **11** stationary while unscrewing the jaw casing **05**. It is important that you only unscrew the nut closest to the jaws (jaw casing) **05**. **DO NOT ADJUST SET NUT 13**. See Fig. 5
4. Take care during removal as this jaw casing is spring loaded and contains 3 small jaws **06**, a jaw pusher **07**, washer **08**, and a spring **09**. Do not lose these pieces. Inspect **06**, **07**, **08**, **09** for wear, cracks or damage. Replace as necessary.
5. Once removed if a mandrel has jammed the tool, dislodge the mandrel from the jaws, discard mandrel.
6. Clean Jaws **06** with a mineral spirit then and coat outside of jaws (outside only) with a drop of clean oil or Moly EP Grease. Be sure to coat the outside of the jaws only. See Fig. 6. Oil is preferred.
7. Replace jaws into jaw case **05**.
8. Followed by jaw pusher **07**, and spring **09**, if necessary.
9. Re-apply jaw case **05** securely onto **11** using a wrench keeping 11 stationary..
10. Reapply the nose case **03** securely to the tool
11. Reattach air supply. Actuate tool without rivet. Check Function.

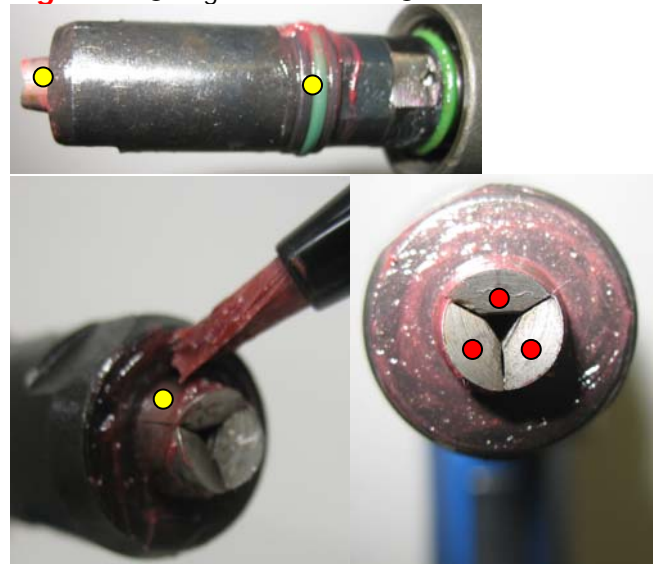
### Drawing



**Fig. 5**



**Fig. 6 -** ● =light lubrication ● =liberal lubrication



## **MAINTENANCE**

**IMPORTANT:** DISCONNECT THE TOOL FROM THE AIR SUPPLY OR SWITCH OFF AT VALVE (54). REMOVE NOSE ASSEMBLY OR SWIVEL HEAD COMPONENTS. All operations should be carried out on a clean bench, with clean hands in a clean area. Ensure that the new oil is perfectly clean and free from air bubbles. Care **MUST** be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.

### **Oil Priming**

After 100,000 cycles, or when the tool loses enough stroke and/or power to place rivets in one actuation, a priming procedure may be required. Please use the oil provided with the tool. Replacements are available at 1-800-BUY-RIVET.



**Do not remove the bleed screw unless you have extensive knowledge in the maintenance of hydraulic tools.**

- The bleed screw **IS NOT AN ADJUSTMENT**.
- Removal of the bleed screw **WILL NOT FIX A JAMED GUN**.
- If the bleed screw is loosed, even slightly, oil will leak out of the tool which may create an air bubble in hydraulic system causing loss of stroke and stroke cavitation.
- If the bleed screw is loosed or the oil priming procedure is attempted without proper training, the tool will need to be returned to the service center for maintenance and a labor fee may be charged.

### **Oil Priming Procedure (For trained personnel only! See above!)**

**DISCONNECT THE TOOL FROM THE AIR SUPPLY OR SWITCH OFF AT VALVE.  
REMOVE NOSE ASSEMBLY OR SWIVEL HEAD COMPONENTS.**

**All operations should be carried out on a clean bench, with clean hands in a clean area.  
Ensure that the new oil is perfectly clean and free from air bubbles.**

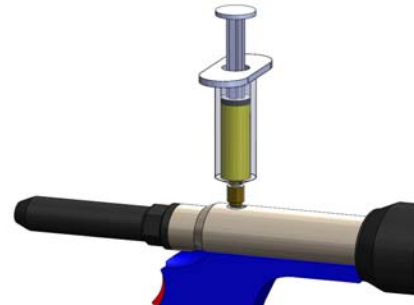
**Care MUST be taken at all times, to ensure that no foreign matter enters the tool, or serious damage may result.**

- Remove bleed screw **BP76** and seal **BP75**. (Figure 7)
- Connect air supply to tool and switch ON/OFF valve **BP54** to 'ON" position.
- Invert tool over suitable container and actuate trigger. Waste oil will be ejected through the bleed screw hole.
- Fill the syringe (priming pump) with oil and screw it into the bleed screw hole. Actuate the pump by pressing down and releasing 17mm. (Figure 8)
- Remove the priming pump and the excessive oil will flow out. Then clean out the excessive oil and replace the bleed screw and seal.

Figure 7



Figure 8



## Valve Spool Assembly Maintenance

- Send into authorized repair center for service.

### Trigger Maintenance Procedure

- Inspect trigger pin valve by insuring **35** has not come loose. The proper depth should be just under the valve stem.
- If adjustment is necessary using a fork wrench or tire valve tool, screw the trigger pin **34** into the valve stem. A very small amount of loctite243 is ok around the threaded portion only.
- If the trigger still fails, remove the trigger pin assembly from the valve stem and inspect the seal around the trigger pin for damage. If damaged, purchase a replacement part. Re-assemble according to the previous step.

## PREVENTIVE MAINTENANCE

In order to maintain the tool in a safe working order it is important to carry out regular maintenance as prescribed by the manufacturer. A thorough inspection replacement of all seals within the tool should be carried out after 500,000 actuations or annually, whichever is the sooner. Seal Life is dependent on the size of the rivet applied, the frequency of use in one minute, the cleanliness of the tool, proper maintenance within the time interval suggested and total number of actuations. The seal life is a limited warranty item and should only be replaced by trained personnel. Item numbers in parentheses refer to assembly drawing part numbers

### Daily

- Check for air leaks. Any damaged hoses should be replaced
- Lubricate the tool by pouring a 1 drop of the enclosed lubricating oil into the air inlet on the tool.
- If there is no filter on the pressure regulator, bleed the airline to clear it of accumulated dirt or water before connecting the air.
- Hose to the tool. If there is a filter, drain it.
- If there is no pressure regulator, bleed the airline to clear it of accumulated dirt or water before connecting the air hose to the tool. If there is a filter, drain it.
  
- Check for proper nose piece use depending on the size of the rivet.
- Remove front jaw nose assembly and clean all visible areas beneath the Nose Cap (**3**) with an air hose to remove metal shavings and debris. Remove jaw housing as necessary and consumable parts
- Check that the stroke of the tool meets the minimum specification of 58mm .To check the stroke, measure the distance between the front face of jaw spreader housing and the front face of the head.
  
- Thoroughly with mineral spirits. Inspect for cracks or other damage to jaw or nose area. Replace if necessary.
  
- Insure that rotary valve for the vacuum on the mandrel collection unit is correctly adjusted for fastener retention

### Weekly

- Carry out procedures as per daily maintenance instructions above
- Clean and inspect the jaws for signs of damage or wear (groove running through the jaw serrations). Follow the instructions on page 4 for cleaning of jaws. Reassemble the tail jaws with a light coating of red grease on the outer face that contacts the jaw housing. Do not allow grease to contaminate the grooved inner face of the jaws as mandrel slippage may result.

### Monthly

- Carry out procedures as per weekly maintenance instructions above
- Check and replace cylinder bodies if there are signs of damage or cracks.

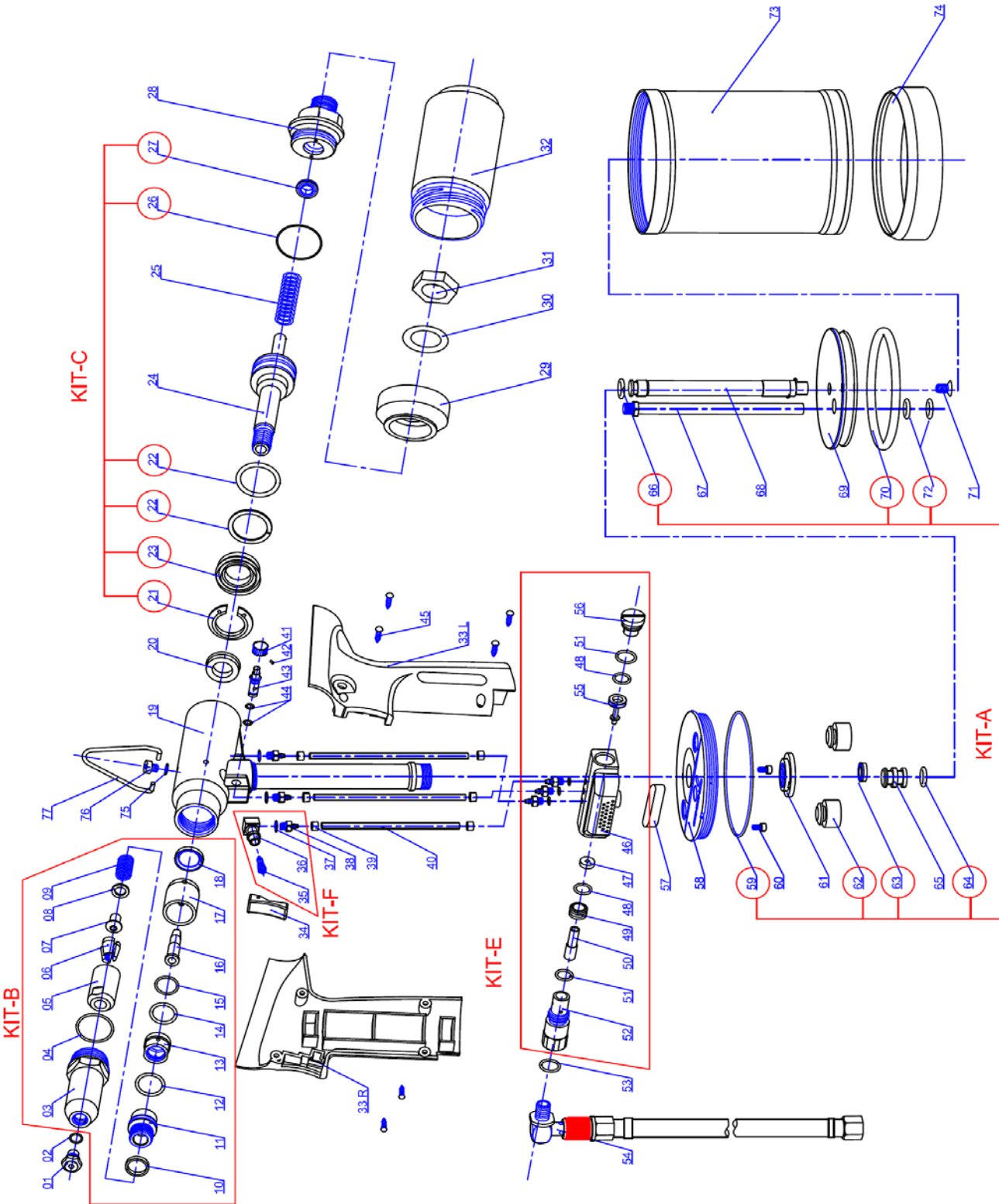
### Semi-Annually

- Carry out procedures as per monthly maintenance instructions above
- Check that the stroke is greater than 1.0". If less, follow bleeding procedure.
- Depending on the frequency of use, further maintenance may be required to replace the hydraulic seals.



# SCHEMATIC

## SCHEMATIC - RK-8000LS



# SERVICE KITS & SPARE

PARTS LIST			
No.	Part #	Description	Qty
01-1/4	RK8000LS-NS01-1/4	1/4 NOSEPIECE	1
01-3/16	RK8000LS-NS01-3/16	3/16 NOSEPIECE	1
01-5/32	RK8000LS-NS01-5/32	5/32 NOSEPIECE	1
01-1/8	RK8000LS-NS01-1/8	1/8 NOSEPIECE	1
01-MB-3/16	RK8000LS-MB-3/16	3/16 MONOBOL NOSEPIECE	1
01-MB-1/4	RK8000LS-MB-1/4	1/4 MONOBOL NOSEPIECE	1
2	RK8000LS-BP2	O-RING	1
3	RK8000LS-BP3	NOSE CAP	1
4	RK8000LS-BP4	O-RING	1
5	RK8000LS-BP5	JAW HOUSING	1
6	RK8000LS-BP6	JAW SET(3PCS)	1
7	RK8000LS-BP7	PUSHER	1
8	RK8000LS-BP8	WASHER	1
9	RK8000LS-BP9	JAWS PUSHER SPRING	1
10	RK8000LS-BP10	LOCK RING	1
11	RK8000LS-BP11	UPPER HOUSING	1
12	RK8000LS-BP12	O-RING	1
13	RK8000LS-BP13	SET NUT	1
14	RK8000LS-BP14	POLYURETHANE RING	1
15	RK8000LS-BP15	O-RING	1
16	RK8000LS-BP16	VACCUUM SLEEVE	1
17	RK8000LS-BP17	PLASTIC SEALING SLEEVE	1
18	RK8000LS-BP18	SEAL RING	1
19	RK8000LS-BP19	OIL CYLINDER	1
20	RK8000LS-BP20	O-RING	1
21	RK8000LS-BP21	RETAINING NUT	1
22	RK8000LS-BP22-B	O-RING	2
23	RK8000LS-BP23-B	O-RING	1
24	RK8000LS-BP24-B	PRINCIPAL AXIS UNIT	1
25	RK8000LS-BP25-B	SPRING	1
26	RK8000LS-BP26	O-RING	1
27	RK8000LS-BP27	O-RING	2
28	RK8000LS-BP28-B	CAP	1
29	RK8000LS-BP29	LINKER COBER	1
30	RK8000LS-BP30	GASKET	1
31	RK8000LS-BP31	NUT	1
32	RK8000LS-BP32	NAIL CONTAINER	1
33	RK8000LS-BP33L	HANDLE(LEFT)	1
33	RK8000LS-BP33R	HANDLE(RIGHT)	1
34	RK8000LS-BP34	TRIGGER	1
35	RK8000LS-BP35	TRIGGER VALVE	1
36	RK8000LS-BP36	ON/OFF BASE	1
37	RK8000LS-BP37	O-RING	6
38	RK8000LS-BP38	AIR INTERFACE	6
39	RK8000LS-BP39	RESTRAIN RING	6
40	RK8000LS-BP40	AIR TUBE	3
41	RK8000LS-BP41	ADJUSTING BUTTON	1
42	RK8000LS-BP42	RETAINING SCREW	1
43	RK8000LS-BP43	VACCUUM VALVE	1
44	RK8000LS-BP44	O-RING	2
45	RK8000LS-BP45	TAPPING SCREW	4
46	RK8000LS-BP46	AIR VALVE BODY	1
47	RK8000LS-BP47	AIR VALVE RING	1
48	RK8000LS-BP48	O-RING	2
49	RK8000LS-BP49	AIR VALVE BASE	1
50	RK8000LS-BP50	SUBORDINATE TUBE	1
51	RK8000LS-BP51	O-RING	2
52	RK8000LS-BP52	CONNECTIONG BASE	1
53	RK8000LS-BP53	O-RING	1
54	RK8000LS-BP54	ON/OFF ASSEMBLY	1
55	RK8000LS-BP55	VALVE ROD	1
56	RK8000LS-BP56	SCREW PLUG	1
57	RK8000LS-BP57	SILENCER FILTER	1
58	RK8000LS-BP58	CYLINDER COVER	1
59	RK8000LS-BP59	O-RING	1
60	RK8000LS-BP60	BOLT	2
61	RK8000LS-BP61	ROCK NUT	1
62	RK8000LS-BP62	BUFFER	2
63	RK8000LS-BP63	SEAL RING	1
64	RK8000LS-BP64	O-RING	1
65	RK8000LS-BP65	AIR TUBE PISTON	1
66	RK8000LS-BP66	PISTON RING	1
67	RK8000LS-BP67	TRANSFER TUBE	1
68	RK8000LS-BP68	PISTON ROD	1
69	RK8000LS-BP69	CYLINDER PISTON	1
70	RK8000LS-BP70	O-RING	1
71	RK8000LS-BP71	BOLT	1
72	RK8000LS-BP72	O-RING	1
73	RK8000LS-BP73	CYLINDER	1
74	RK8000LS-BP74	BASE COBER	1
75	RK8000LS-BP75	O-RING	1
76	RK8000LS-BP76	SEAL SCREW	1

PARTS LIST			
No.	Part #	Description	Qty
77	RK8000LS-BP77	HOOK	1
78	RK8000LS-BP78	WRENCHES	3
79	RK8000LS-BP79	TOOL BOX	1
80	RK8000LS-BP80	SYRINGE	1
81	RK8000LS-BP81	HYDRAULIC OIL	1
KIT A - #RK8000LS-BPKA LOWER HYDRAULIC SEAL KIT			
No.	Part #	Description	Qty
59	RK8000LS-BP59	O-RING	1
62	RK8000LS-BP62	BUFFER	2
63	RK8000LS-BP63	SEAL RING	1
64	RK8000LS-BP64	O-RING	1
66	RK8000LS-BP66	PISTON RING	1
70	RK8000LS-BP70	O-RING	1
72	RK8000LS-BP72	O-RING	1
KIT B - #RK8000LS-BPKB NOSE HEAD KIT			
No.	Part #	Description	Qty
3	RK8000LS-BP3	NOSE CAP	1
4	RK8000LS-BP4	O-RING	1
5	RK8000LS-BP5	JAW HOUSING	1
6	RK8000LS-BP6	JAW SET(3PCS)	1
7	RK8000LS-BP7	PUSHER	1
8	RK8000LS-BP8	WASHER	1
9	RK8000LS-BP9	JAWS PUSHER SPRING	1
10	RK8000LS-BP10	LOCK RING	1
11	RK8000LS-BP11	UPPER HOUSING	1
12	RK8000LS-BP12	O-RING	1
13	RK8000LS-BP13	SET NUT	1
14	RK8000LS-BP14	POLYURETHANE RING	1
15	RK8000LS-BP15	O-RING	1
16	RK8000LS-BP16	VACCUUM SLEEVE	1
17	RK8000LS-BP17	PLASTIC SEALING SLEEVE	1
18	RK8000LS-BP18	SEAL RING	1
KIT C - #RK8000LS-BPKC UPPER HYDRAULIC SEAL KIT			
No.	Part #	Description	Qty
20	RK8000LS-BP20	O-RING	1
21	RK8000LS-BP21	RETAINING NUT	1
22	RK8000LS-BP22-B	O-RING	2
23	RK8000LS-BP23-B	O-RING	1
26	RK8000LS-BP26	O-RING	1
27	RK8000LS-BP27	O-RING	2
KIT D - #RK8000LS-BPKD NOSE PIECE KIT			
No.	Part #	Description	Qty
01-1/4	RK8000LS-NS01-1/4	1/4 NOSEPIECE	1
01-3/16	RK8000LS-NS01-3/16	3/16 NOSEPIECE	1
01-5/32	RK8000LS-NS01-5/32	5/32 NOSEPIECE	1
01-1/8	RK8000LS-NS01-1/8	1/8 NOSEPIECE	1
01-MB-3/16	RK8000LS-MB-3/16	3/16 MONOBOL	1
01-MB-1/4	RK8000LS-MB-1/4	1/4 MONOBOL	1
KIT E - #RK8000LS-BPKE AIR VALVE KIT			
No.	Part #	Description	Qty
46	RK8000LS-BP46	AIR VALVE BODY	1
47	RK8000LS-BP47	AIR VALVE RING	1
48	RK8000LS-BP48	O-RING	2
49	RK8000LS-BP49	AIR VALVE BASE	1
50	RK8000LS-BP50	SUBORDINATE TUBE	1
51	RK8000LS-BP51	O-RING	2
52	RK8000LS-BP52	CONNECTIONG BASE	1
55	RK8000LS-BP55	VALVE ROD	1
56	RK8000LS-BP56	SCREW PLUG	1
KIT F - #RK8000LS-BPKF TRIGGER KIT			
No.	Part #	Description	Qty
35	RK8000LS-BP35	TRIGGER VALVE	1
36	RK8000LS-BP36	ON/OFF BASE	1
37	RK8000LS-BP37	O-RING	1
25	RK8000LS-BP25	BUFFER (Obsolete)	1



## MSDS

### Lubricant Details

#### MOLY GREASE (MSC P/N: 60002136)

**Manufacturer:**

T.S. Moly-Lubricants, Inc., Houston, TX  
Emergency: (713)671-2676  
MSDS Number: TS-122 Lithium EP-2 Moly Poly Grease

**First Aid:****SKIN:**

Prolonged or repeated skin contact with this product tends to remove skin oils, possibly leading to irritation and dermatitis. No chronic health problems known.

**INGESTION:**

May cause irritation and gastrointestinal discomfort consisting of nausea, vomiting, lethargy and/or diarrhea.

**EYES:**

Flush eyes with plenty of water for several minutes. Get medical attention if eye irritation persists.

**Fire:**

FLASH POINT: 450°F/232°C

Use water to cool containers exposed to fire. For fires in enclosed areas, firefighters should use self-contained breathing apparatus. Avoid fumes or burning product.

**Environment:****WASTE DISPOSAL:**

Because material uses, transformations, mixtures, processes, etc. may affect classification, it is the responsibility of the user to determine the method of disposal according to the latest EPA, state and local regulations

**SPILLAGE:**

Recover free product. Add sand, earth, or some other suitable adsorbent. Keep product out of sewers and watercourses by diking or impounding.

**Handling/ Storage:**

Store in cool dry area in original or equivalent container in accordance with all applicable regulations. Do not apply high heat or flame to container.

**Emhart Approved Equivalents:**

None

#### MOBIL □ VELOCITE OIL #10 (MSC P/N: 60002144)

**Manufacturer:**

EXXONMOBIL Oil Corp., Fairfax, VA  
Emergency: (609)737-4411 (call collect)  
MSDS Number: 600684-00

**First Aid:****SKIN:**

Remove contaminated clothing and shoes and wipe excess from skin. Flush skin with water, and then wash with soap and water. If irritation occurs, get medical attention. Do not reuse clothing until cleaned.

**INGESTION:**

Do not induce vomiting. In general, no treatment is necessary unless large quantities of product are ingested. However, get medical attention.

**EYES:**

Flush with water. If irritation occurs, get medical attention.

**Fire:**

FLASH POINT: 345 °F/174 °C

Material will float and can be re-ignited on the surface of water. Use water fog, 'alcohol foam', dry chemical or carbon dioxide (CO<sub>2</sub>) to extinguish flames. Do not use a direct stream of water.

**Environment:****WASTE DISPOSAL:**

Because material uses, transformations, mixtures, processes, etc. may affect classification, it is the responsibility of the user to determine the method of disposal according to the latest EPA, state and local regulations.

**SPILLAGE:**

Soak up residue with an absorbent such as clay, sand or other suitable material. Place in a non-leaking container and seal tightly for proper disposal. Report spills/releases as required to appropriate authorities.

**Handling:**

Wash with soap and water before eating, drinking, smoking, applying cosmetics, or using toilet. Properly dispose of leather articles such as shoes or belts that cannot be decontaminated. Use in a well ventilated area. High pressure injection under the skin may occur due to the rupture of pressurized lines. Always seek medical attention.

**Storage:**

Keep containers closed when not in use. Do not store in open or unlabelled containers. Store away from strong oxidizing agents and combustible materials. Do not store near heat, sparks, flame or strong oxidants.

**Emhart Approved Equivalents:**

- Shell Spindle Oil #22
- Shell Tellus Oil #22

# TROUBLESHOOTING

Item numbers in parentheses refer to assembly drawing part numbers on page 9.

Problem	Possible Cause	Remedy
More than one operation of the trigger needed to place fastener	<ul style="list-style-type: none"> <li>▪ Air leak</li> <li>▪ Insufficient air pressure</li> <li>▪ Air Lubrication</li> <li>▪ Worn or broken jaws</li> <li>▪ Improper adjustment of set nut <b>(13)</b></li> <li>▪ Low oil level or air bubble in hydraulic oil</li> <li>▪ Buildup of dirt inside the nose assembly</li> </ul>	<ul style="list-style-type: none"> <li>▪ Tighten joints or replace components</li> <li>▪ Adjust air pressure to within specification</li> <li>▪ Lubricate tool at air inlet point</li> <li>▪ Install new jaws</li> <li>▪ adjust set nut <b>(13)</b> clockwise 1 rotation</li> <li>▪ See Priming Procedure</li> <li>▪ Service nose assembly</li> </ul>
Tool will not grip stem of fastener	<ul style="list-style-type: none"> <li>▪ Worn, broken or missing jaws</li> <li>▪ Buildup of dirt inside the nose assembly</li> <li>▪ Loose jaw housing</li> <li>▪ Weak or broken spring in nose assembly</li> <li>▪ Incorrect component in nose assembly</li> <li>▪ Rotary valve incorrectly adjusted</li> </ul>	<ul style="list-style-type: none"> <li>▪ Fit new jaws</li> <li>▪ See Jaw Cleaning Procedure</li> <li>▪ Tighten against locking ring</li> <li>▪ Fit new spring</li> <li>▪ Identify and replace</li> <li>▪ Read 'Operation'</li> </ul>
Jaws will not release broken stem of fastener	<ul style="list-style-type: none"> <li>▪ Buildup of dirt inside the nose assembly</li> <li>▪ Jaw housing, nose tip or nose casing not properly seated</li> <li>▪ Improper adjustment of set nut <b>(13)</b></li> <li>▪ Weak or broken spring in nose assembly</li> <li>▪ Air Leak or Air pressure below 90 psi</li> <li>▪ Low oil level or air bubble in hydraulic oil</li> </ul>	<ul style="list-style-type: none"> <li>▪ See Jaw Cleaning Procedure</li> <li>▪ Tighten nose assembly and adjust if necessary</li> <li>▪ adjust set nut <b>(13)</b> counter-clockwise 1 rotation</li> <li>▪ Fit new spring</li> <li>▪ Tighten joints or replace components</li> <li>▪ Adjust as in 'Operating Procedure' to 90 psi</li> <li>▪ See Priming Procedure</li> </ul>
Jammed Gun / Cannot feed next fastener	<ul style="list-style-type: none"> <li>▪ Broken stems jammed inside tool</li> <li>▪ Rotary valve incorrectly adjusted</li> <li>▪ Air pressure below 90 psi</li> </ul>	<ul style="list-style-type: none"> <li>▪ Empty mandrel collector</li> <li>▪ Check if jaw pusher <b>(7)</b> is cracked/broken</li> <li>▪ Check if Vacuum Sleeve <b>(16)</b> is cracked/broken</li> <li>▪ Adjust vacuum pressure</li> <li>▪ Adjust as in 'Operating Procedure' to 90 psi</li> </ul>
Slow cycle	<ul style="list-style-type: none"> <li>▪ Lack of lubrication</li> <li>▪ Low air pressure</li> <li>▪ Low oil level or air bubble in hydraulic oil</li> <li>▪ Buildup of dirt inside the nose assembly</li> </ul>	<ul style="list-style-type: none"> <li>▪ Lubricate tool at air inlet point</li> <li>▪ Adjust air pressure to within specification</li> <li>▪ See Priming Procedure</li> <li>▪ Service nose assembly</li> </ul>
Tool fails to operate	<ul style="list-style-type: none"> <li>▪ No air pressure</li> <li>▪ On/Off switch is in off position</li> <li>▪ Damaged trigger valve</li> <li>▪ Loose pneumatic piston cover</li> <li>▪ Loose stem collector</li> <li>▪ Oil leaking in the air filter</li> <li>▪ Air leaking in the air filter</li> </ul>	<ul style="list-style-type: none"> <li>▪ Adjust as in 'Operating Procedure' to 90 psi</li> <li>▪ Slide On/Off sleeve <b>(54)</b> down until air is flowing</li> <li>▪ See 'Trigger Maintenance' <b>Page 7</b></li> <li>▪ Disconnect Air Pressure, Tighten all connections</li> <li>▪ Disconnect Air Pressure, Tighten Cap <b>(28)</b></li> <li>▪ Replace part number RK8000LS-BP63 With Berent Tool (call for service for especial tool )</li> <li>▪ Replace Number # 48 , 47 , 48 , 55 , 49 .</li> </ul>
Fastener fails to break	<ul style="list-style-type: none"> <li>▪ Insufficient air pressure</li> <li>▪ Fastener outside tool capability</li> <li>▪ Low oil level or air present in oil</li> </ul>	<ul style="list-style-type: none"> <li>▪ Adjust as in 'Operating Procedure' to 90 psi</li> <li>▪ Use more powerful tool</li> <li>▪ Contact Industrial Rivet for assistance</li> <li>▪ See Priming Procedure</li> </ul>
Insufficient Vacuum Pressure	<ul style="list-style-type: none"> <li>▪ Insufficient Air Pressure</li> <li>▪ Improper Vacuum Pressure Adjustment</li> <li>▪ The part # (17) plastic sealing sleeve are broke.</li> <li>▪ The air is pushed the mandrel out from the nose.</li> </ul>	<ul style="list-style-type: none"> <li>▪ Adjust as in 'Operating Procedure' to 90 psi</li> <li>▪ See "Operation" for proper adjustment</li> <li>▪ Replace with new part</li> <li>▪ Make sure the part # (13) set nut are in the correct distance.</li> </ul>



## Warranty Statement:

Industrial Rivet & Fastener Co. Inc. (hereinafter "IRF"), hereby warrants to the initial retail customer or original authorized distributor ("Warrantee") only that its products will be free from defects in material and workmanship for a period of 1 year from the purchase date provided that the products are used in accordance with "IRF's" instructions as to maintenance, operation and use.

The said warranty does not extend to goods subjected to misuse, neglect, accidental/improper installation, improper maintenance or which have been altered/repared by anyone other than the seller or its certifiably authorized agents. The said warranty does not extend to consumable components or wear components as listed in schedule A.

The warrantee's only remedy and IRF's only obligation in the event of a defect or failure in the products, is that IRF, at its sole option, repair, replace or re work the products, but in no case shall the cost of the foregoing exceed the invoice price of the products.

This warranty shall be void if any person seeking to make a claim for defective products fails to notify IRF within 30 days, or, if distributor fails to provide evidence that the product failed within 30 days of the failure. Proof and date of purchase, maintenance records as well as details regarding failure must be sent via e-mail, and a sample of the failed products sent via postal service is required for warranty evaluation.

**This warranty is in lieu of all other warranties, expressed or implied, including merchantability, or fitness provided for herein. Under no circumstance shall IRF be liable for incidental or consequential damages arising from the defect or failure in its products.**

Seller's sole obligation under the foregoing warranty will be limited to, at Seller's option, repair or replacement of the tool (and shipping to the buyer with transportation charges paid to any place within the contiguous 48 states). Returned goods will be evaluated by our warranty repair department and a conclusion will be determined and classified as:

- a) Warranty Repair (free of charge)
- b) Non-Warranty repair or Abuse/Neglect (Hourly rate, Schedule B)
- c) Maintenance (Flat Fee, Schedule B)

Schedule A – Limited Warranty
The following are considered consumable or wear parts and are not covered under the warranty. <b>Consumables:</b> Jaws, Nosepieces, Jaw Pusher, Jaw Spring <b>Wear Parts:</b> Mandrel Catcher, O-Rings, Pneumatic Seals, Hydraulic Seals* *Hydraulic seals have a limited warranty (6 months) and the replacement is at the sole discretion of the manufacturer.
Schedule B – Maintenance/Repair
Price Schedule as of 1/1/2011 Bench Fee: \$ 60.00 (up to one hour) Hourly Rate: \$ 60.00 per hour Flat Fee: Level 1 - Adjustments, cleaning and light repair \$45.00 + parts Level 2 – Maintenance, Oil Change, plus Level 1 service \$65.00 + parts Level 3 – Complete disassembly, change all seals, plus level 2 service \$120.00 + parts

If inspection by the seller of returned goods shows no breach of the forgoing warranty, Seller's regular conditioning charges (Schedule B) apply. Upon this conclusion we will either repair the tool at no cost to you and return it postage paid, or call you to inform you of the repair cost. The repair will need to be approved in writing before any work is performed.

A comprehensive tool service and repair program, for details contact your local area sales representative or call:

Industrial Rivet & Fastener Co.  
200 Paris Ave  
Northvale, NJ 07647  
**1-800-BUY-RIVET or [info@rivet.com](mailto:info@rivet.com)**