

## TROUBLE SHOOTING

Indication	Cause	Solution
Tool not operating	Tool not connected to air supply Air pressure is insufficient or too high Hydraulic oil level is low	Connect to an air supply. Adjust air supply pressure to recommended level. Fill hydraulic oil (Refer to the "Hydraulic Oil Filling" section).
Tool not returning	Swarf jammed in jaw assembly	Clean and lubricate the jaw assembly (Refer to the "Front End Service" section).
Tool losing stroke	Hydraulic oil level is low	Fill hydraulic oil (Refer to the "Hydraulic Oil Filling" section).
Jaws slipping on mandrels	Jaws dirty	Clean and lubricate jaws (Refer to the "Front End Service" section).
	Jaws worn	Replace jaws.
Jaws fail to open	Dirty outer sleeving, jaw case or jaws	Internally clean the outer sleeving and the jaw assembly (Refer to the "Front End Service" section).
	Jaw assembly loose	Tighten the jaw assembly.
Rivet can not be inserted into nosepiece	Incorrect nosepiece	Install correct nosepiece (size is marked on nosepiece hex).
Rivet mandrel does not break	Rivet not fully set Insufficient air pressure	Repeat stroke, or change rivet Adjust air supply pressure to recommended level.
	Hydraulic oil level is low	Fill hydraulic oil (Refer to the "Hydraulic Oil Filling" section).

# RIVTEC®

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# RIVTEC®



## RT-C2

### Air Hydraulic Rivet Tool

## OPERATOR'S MANUAL



### IMPORTANT

Read this Operator's Manual carefully before operation.

Keep this manual for future reference.

## INTRODUCTION

Rivtec® RT-C2 Air Hydraulic Rivet Tool is a high performance economical air hydraulic rivet tool. It utilises a lightweight ergonomic design and installs rivets from Ø3.2mm to Ø6.4mm (steel).

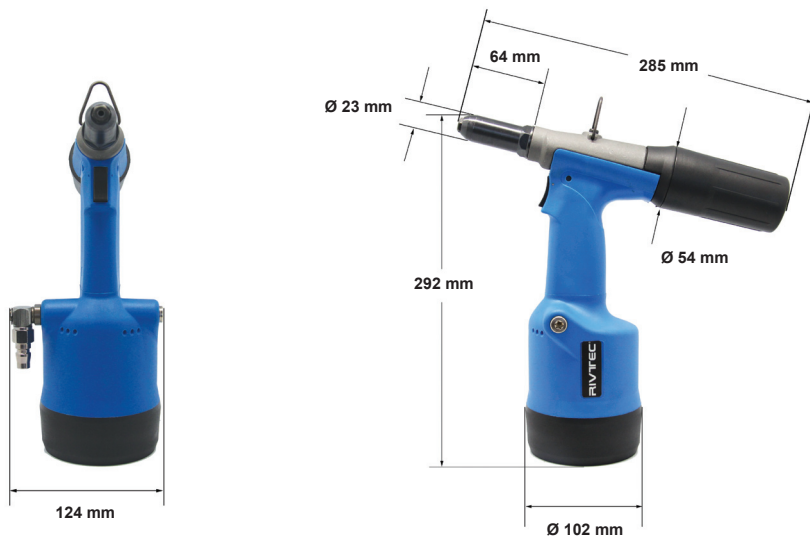
## SPECIFICATIONS

Weight .....	1.15kg	Air Pressure .....	5-7 bar
Pulling Force .....	10KN	Stroke .....	18mm

## PACKAGE ACCESSORIES

- |                              |                               |
|------------------------------|-------------------------------|
| ■ RT-C2 Rivet Tool           | ■ Spare Jaw Case              |
| ■ Operator's Manual          | ■ Spare Jaws (set of 3)       |
| ■ Nosepiece for 3.2mm rivets | ■ Spare Jaw Spreader & Spring |
| ■ Nosepiece for 4.0mm rivets | ■ Syringe                     |
| ■ Nosepiece for 4.8mm rivets | ■ 3mm Hex. Key                |
| ■ Nosepiece for 6.4mm rivets |                               |

## TOOL DIMENSIONS



## SAFETY INSTRUCTIONS



**Caution!** To ensure proper functioning and safe operation, read this Operator's Manual carefully before operating the RIVTEC® RT-C2 tool

- The rivet tool should be used exclusively to set blind rivets.
- DO NOT overload the tool – work within the prescribed work capacity
- ALWAYS wear eye protection when working with the tool. Personal protection such as clothes, gloves, safety helmet, non-slipping shoes, ear protectors and protection against fall are highly recommended.
- This tool is NOT designed for use in explosive atmospheres.
- DO NOT use the tool as a hammer.
- Ensure the tool is not damaged before connecting to the air supply.
- Repair work must be carried out by trained personnel. In case of doubt, ALWAYS send back the tool to the supplier.
- ALWAYS disconnect the air supply when adjusting, servicing or removing any part of the tool.
- Keep fingers off the trigger when connecting the air supply or if the air supply fails.
- Keep fingers away from the front of the tool when connecting the air supply or setting rivets.
- DO NOT point the tool at anyone.
- DO NOT operate tool with the nose housing removed.
- DO NOT operate tool without the mandrel collector.
- DO NOT modify the tool in any way. Modification could damage the tool.
- The operating pressure must not exceed 7 bar.
- DO NOT direct tool exhaust towards anyone.
- Wash hands if exposed to hydraulic fluid or lubricant.
- Keep hair, fingers and loose clothing away from moving parts of the tool.

## BASIC TOOL OPERATION

1. Inspect tool for damage or oil leaking – do not use tool if it is damaged or leaking oil.
2. Ensure correct nosepiece is installed and tightened with a 12mm spanner. (The size of the nosepiece is marked on the edge of the nosepiece)
3. Ensure the **outer sleeving** (3) is tightened, by using a 24mm spanner.
4. Connect tool to an air supply.
5. Ensure the **mandrel collector** (28) is installed.
6. Insert a correct rivet into nosepiece.
7. Pull trigger to install the rivet.
8. Release trigger – When releasing the trigger the jaw assembly returns to the start position automatically.
9. Eject the spent mandrel by tilting to the rear into the mandrel collector.
10. When the collector is half full, do not use the tool. Disconnect the air supply, unscrew the collector and empty it.

## HYDRAULIC OIL FILLING



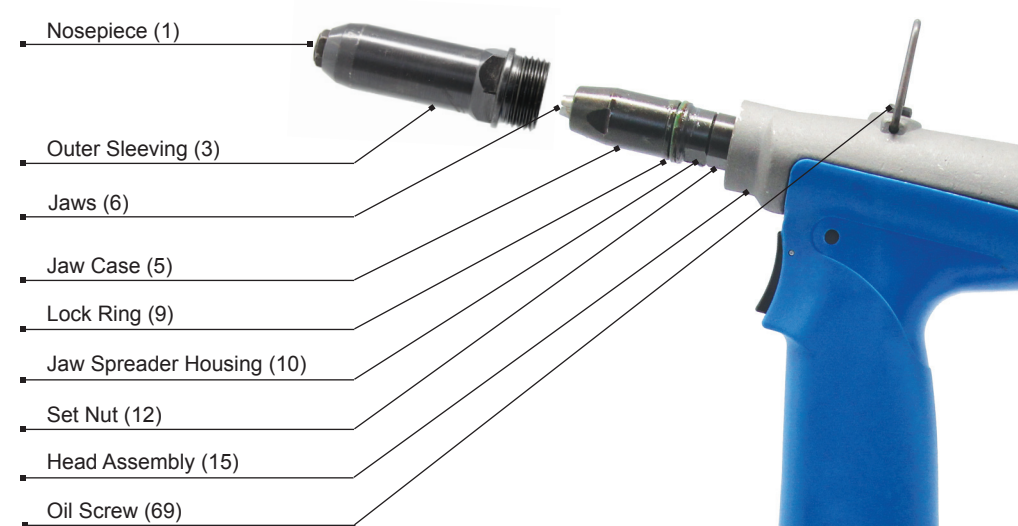
**Caution!** Disconnect the air supply while refilling the hydraulic oil. Keep the tool upright during all operations.

It is important that the tool be properly maintained. If the hydraulic oil level is low, the tool will not work properly.

1. Unscrew **oil screw** (69) from the body by using the 3mm Hex. Key (supplied). Check whether the **o ring** (29) remains in the hole.
2. Fill the syringe (supplied) with hydraulic oil.
3. Screw the filled syringe up to the o ring in the hole. Then slowly inject the oil into the tool. Ensure no air is injected. Adequate oil has been added as soon as resistance is sensed. The excess oil will flow back when the syringe is release if more oil is added than necessary.
4. Unscrew and remove the syringe from the body. Check whether the o ring remains in the hole.
5. Screw the oil screw into the hole with the Hex. Key.
6. Wipe off any excess oil.

If the oil level is too low and the tool fails to operate, service is required by a qualified service person.

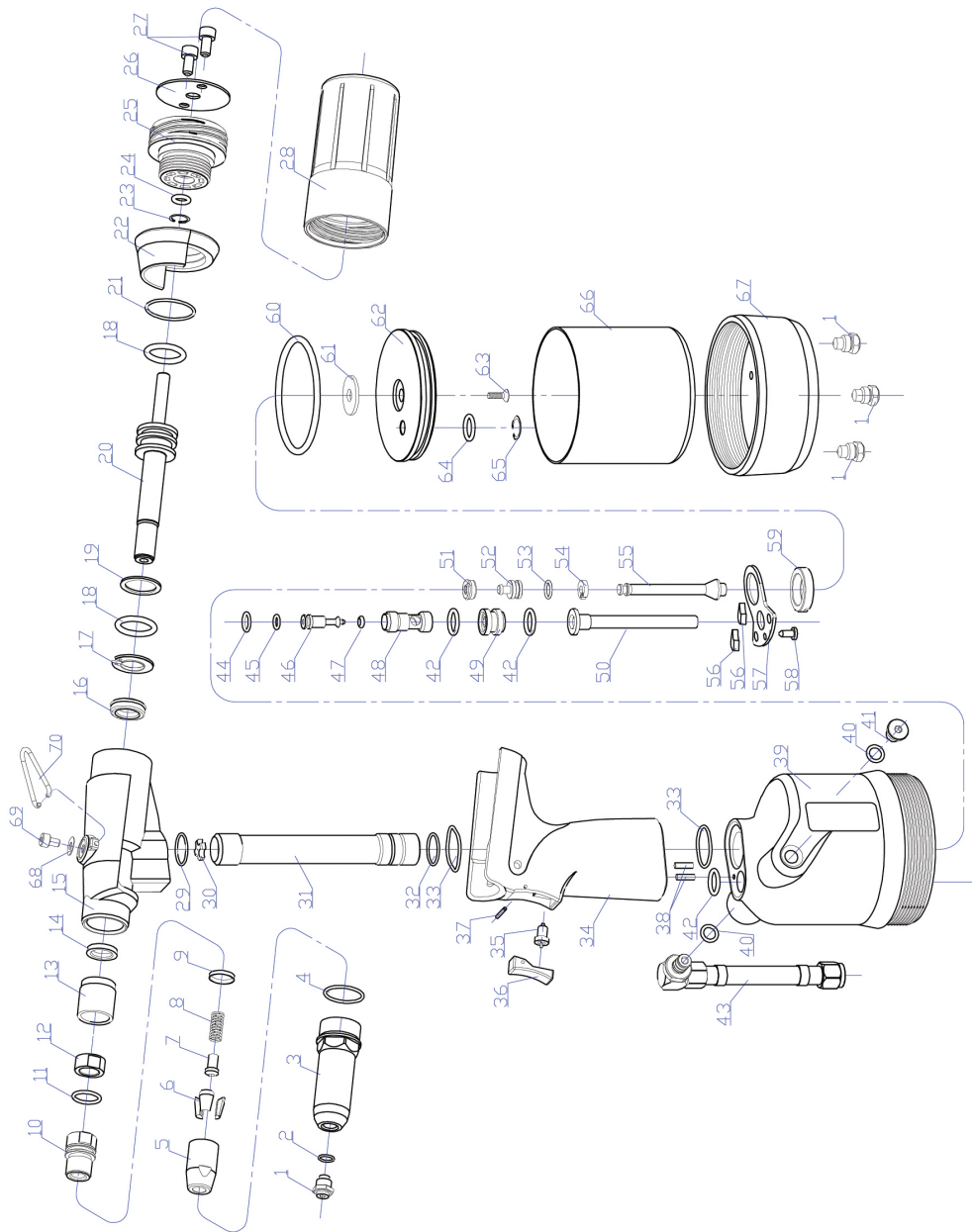
## FRONT END SERVICE



**Caution!** Disconnect the air supply while servicing front end to avoid injury.

1. **Remove outer sleeving (3)**  
Unscrew the outer sleeving with a 24mm spanner and slide the sleeving off the jaw assembly.
2. **Remove jaw case (5) to access jaws and internal parts**  
Unscrew and remove the jaw case by using a 17mm spanner on jaw case and a 16mm spanner on **jaw spreader housing** (10). Remove **jaws** (6), **jaw spreader** (7), **spring** (8) and **lock ring** (9).
3. **Cleaning**  
Clean jaws, jaw spreader, spring, lock ring and the thread of the jaw case. Apply lubricant on jaws and the thread area. Replace jaws if worn or damaged.
4. **Re-assemble jaws, internal parts and outer sleeving**  
Place the jaws into the jaw case and slide the jaw spreader, spring and lock ring into the jaw case. Apply lubricant to the thread of jaw spreader housing. Screw the jaw case onto the jaw spreader housing by using the 17mm spanner and the 16mm spanner. Slide the outer sleeving onto the jaw assembly and tighten with the 24mm spanner.

## DIAGRAM



## PARTS LIST

NO.	DESCRIPTION	QTY.
1	NOSEPIECE 3.2MM	1
1	NOSEPIECE 4.0MM	1
1	NOSEPIECE 4.8MM	1
1	NOSEPIECE 6.4MM	1
2	O RING	1
3	OUTER SLEEVING	1
4	O RING	1
5	JAW CASE	1
6	JAWS	1
7	JAW SPREADER	1
8	SPRING	1
9	LOCK RING	1
10	JAW SPREADER HOUSING	1
11	O RING	1
12	SET NUT	1
13	PLASTIC SEAL SLEEVING	1
14	SEALING RING	1
15	HEAD ASSEMBLY	1
16	LIP SEAL	1
17	SEAL RETAINER	1
18	O RING	2
19	PLASTIC RING	1
20	HEAD PISTON	1
21	O RING	1
22	STEM COLLECTOR ADAPTOR	1
23	CIRCLIP	1
24	O RING	1
25	END CAP	1
26	STEEL PLATE COVER	1
27	BOLT	2
28	MANDREL COLLECTOR	1
29	O RING	1
30	STAR WASHER	1
31	OIL TUBE	1
32	O RING	1
33	O RING	2
34	HANDLE	1

NO.	DESCRIPTION	QTY.
35	TRIGGER VALVE	1
36	TRIGGER	1
37	TRIGGER PIN	1
38	SPRING PIN	2
39	PLASTIC CYLINDER	1
40	O RING	1
41	SCREW	1
42	O RING	3
43	AIR INLET	1
44	O RING	1
45	O RING	1
46	VALVE CORE	1
47	O RING	1
48	VALVE BODY	1
49	VALVE BASE	1
50	TRANSFER TUBE	1
51	LIP SEAL	1
52	AIR TUBE PISTON	1
53	O RING	1
54	PISTON RING	1
55	PISTON ROD	1
56	SILENCER	2
57	CLAMP PLATE	1
58	TAPPING SCREW	1
59	SET NUT	1
60	O RING	1
61	WASHER	1
62	CYLINDER PISTON	1
63	BOLT	1
64	LIP SEAL	1
65	CIRCLIP	1
66	AIR CYLINDER	1
67	BASE COVER	1
68	WASHER	1
69	OIL SCREW	1
70	HOOK	1