

OPERATING MANUAL



W-6A

RIVTEC® PNEUMATIC RIVET NUT TOOL

(Please read this manual before using this tool)

The W-6A is a professional and highly efficient pneumatic rivet nut tool.

The W6A is capable of setting different size rivet nuts by changing the mandrel to correspond with the rivet nut. Control the clamping force by adjusting the stroke accordingly.

Under normal conditions of use, the daily capacity of the W6A is about 6000 rivet nuts.

SPECIFICATIONS:

Model W6A

Weight 1.8KG

Stroke Up to 5mm

Working pressure: 5~7KG

Capacity M4,M5,M6, (M8 Aluminium)

PACKING CHECK LIST:

- 1 x Carry case
- 1 x W6A
- 1 x M3, M4, M6 Mandrel and nose piece
- 3 x M3, M4, M6 spare mandrels
- 1 x Air inlet lubricating oil

PREPARATION:

1. Adjusting the extended length of the mandrel from the nosepiece. Ensure that the collar of the nut is facing towards the nosepiece and the mandrel is protruding 1 or 2 threads through the rivet nut.

2. Before every shift starts, inject 2 or 3 drops of motor lubricant oil into the air fitting on the tool. Only use air tool lubricant.

3. This tool is designed to operate on clean, dry, regulated compressed air, between 75-100psi. It is preferable to include an air filter, pressure regulator, and automatic oiler within 15 feet of the tool.

ADJUSTING THE STROKE



When a smaller size rivet nut is used such as M3 or M4, the stroke must be adjusted to prevent damaging the mandrel and inside thread of rivet nut.

1. Unscrew the mandrel holder locknut.



2. Turn the locknut anti-clockwise and turn the outer sleeve clockwise to shorten the stroke. Then tighten the locknut.

(Correct adjustment will ensure there is 1 thread of the mandrel exposed when the rivet nut is engaged.)

SETTING A RIVET NUT



1. Present the rivet nut to the mandrel and start the thread
2. Press on the mandrel and rivet nut will automatically thread on
3. Insert the rivet nut into the prepared hole in the work piece
4. Actuate the trigger, the rivet nut will be set into the work piece.
5. Press the button on the side with your thumb and the mandrel will be reversed from the work piece.

EXCHANGING A MANDREL



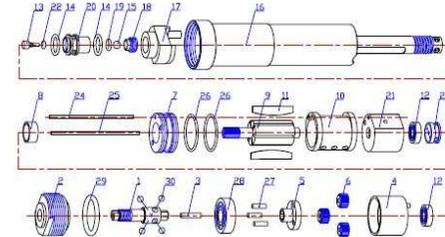
Unlock the locknut and nosepiece and remove.



Push the cover backwards to release the mandrel. Release the mandrel by turning it counter-clockwise.



Push the cover backwards and install the replacement mandrel turning clockwise until it stops. Release the cover in install the matching nose piece.



Code	Part Name	Req'd
1	pulling rod	1
2	cover	1
3	pin	1
4	planet gear	1
5	planet seat	1
6	planet	3
7	bearing seat	1
8	gasket	1
9	rotor	1
10	stator	1
11	vane	6
12	bearing	2
13	rod	1
14	O ring	2
15	steel ball	1
16	piston rod	1

Code	Part Name	Req'd
17	ventilate seat	1
18	adjust nut	1
19	O ring	1
20	valve seat	1
21	bearing seat	1
22	O ring	1
23	gasket	1
24	pin	1
25	pin	1
26	O ring	2
27	gear pin	3
28	bearing	1
29	O ring	1
30	steel ball	4