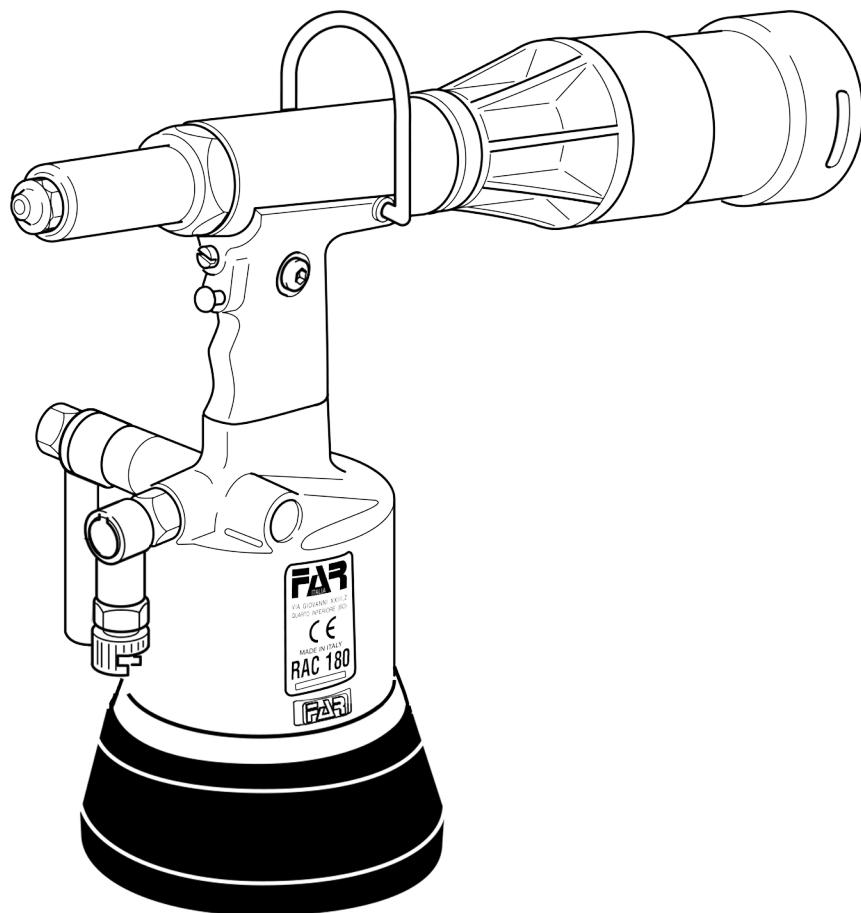
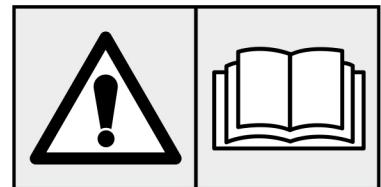
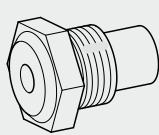
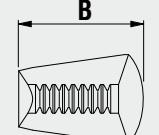
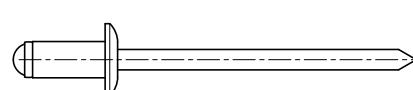
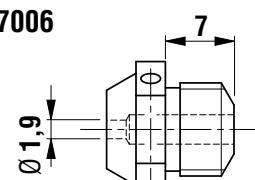
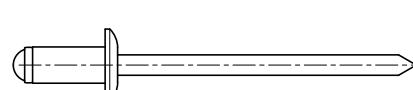
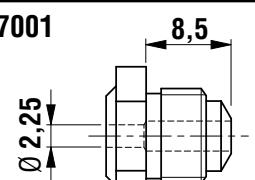
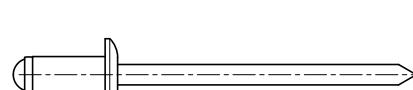
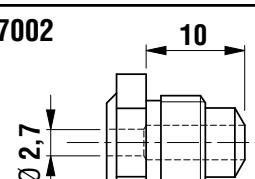
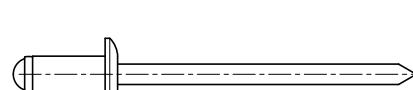
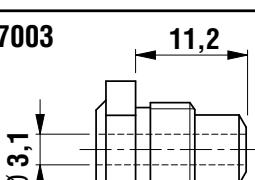
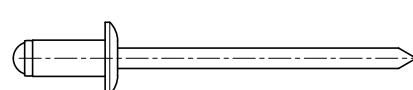
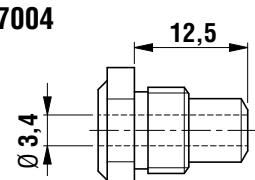
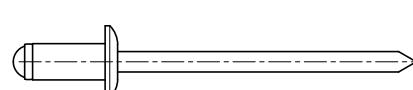
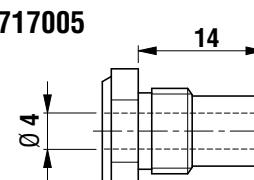
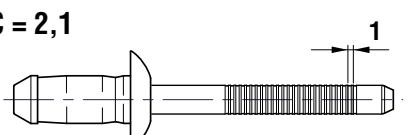
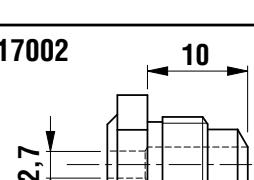
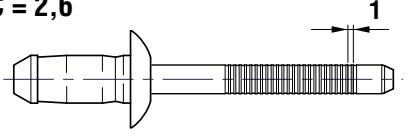
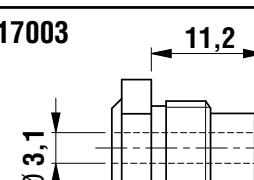
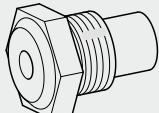
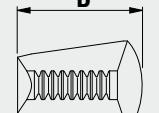
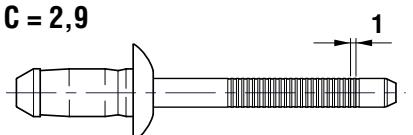
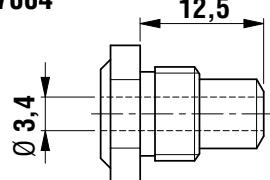
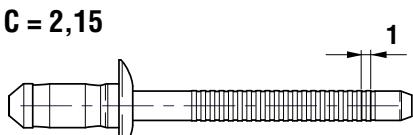
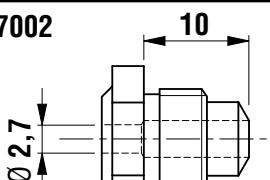
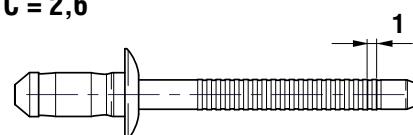
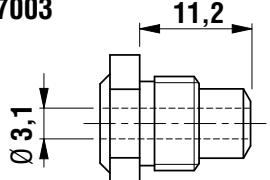
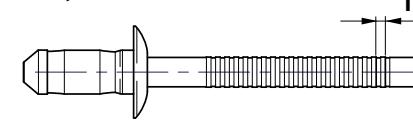
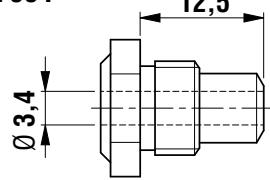
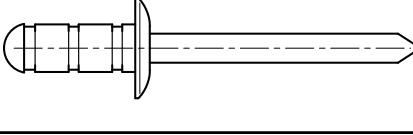
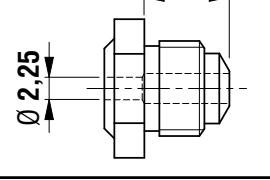
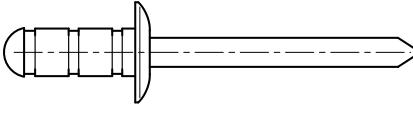
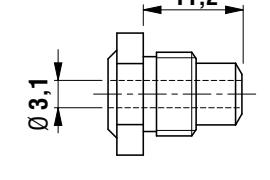
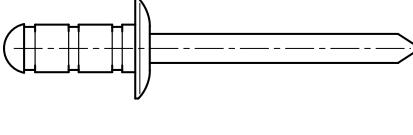
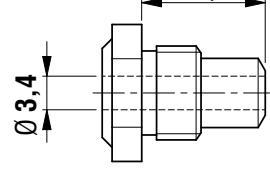
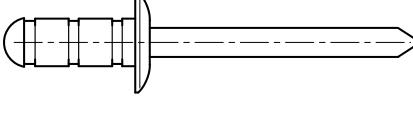
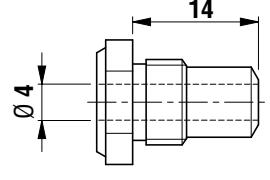


GB

- TRANSLATION OF ORIGINAL INSTRUCTIONS
HYDROPNEUMATIC RIVETING TOOL
FOR RIVETS Ø 2,4 ÷ Ø 6
(Ø 6 ALUMINIUM ONLY)
INSTRUCTIONS FOR USE - SPARE PARTS

**CE**

			
$\varnothing C = 1,43$ 	717006 	B = 13 71345507	$\varnothing A = 8,3$ 710859
$\varnothing C = 1,7 \div 2,1$ 	717001 	B = 13 71345507	$\varnothing A = 8,3$ 710859
$\varnothing C = 2,15 \div 2,4$ 	717002 	B = 13 71345507	$\varnothing A = 8,3$ 710859
$\varnothing C = 2,6$ 	717003 	B = 13 71345507	$\varnothing A = 8,3$ 710859
$\varnothing C = 2,9 \div 3$ 	717004 	B = 13 71345507	$\varnothing A = 8,3$ 710859
$\varnothing C = 3,5$ 	717005 	B = 13 71345507	$\varnothing A = 8,3$ 710859
TAMP Acc. $\varnothing 3,2$ $\varnothing C = 2,1$ 	717002 	B = 13 71345507	$\varnothing A = 8,3$ 710859
TAMP Acc. $\varnothing 4$ $\varnothing C = 2,6$ 	717003 	B = 13 71345507	$\varnothing A = 8,3$ 710859

			
TAMP Acc. Ø 4,8 Ø C = 2,9 	717004 	B = 13 71345507	Ø A = 8,3 710859
MULTIFAR Inox. Ø 3,2 Ø C = 2,15 	717002 	B = 13 71345507	Ø A = 8,3 710859
MULTIFAR Inox. Ø 4 Ø C = 2,6 	717003 	B = 13 71345507	Ø A = 8,3 710859
MULTIFAR Inox. Ø 4,8 Ø C = 3,2 	717004 	B = 13 71345507	Ø A = 8,3 710859
Ø C = 1,80 ÷ 2,15 	717001 	B = 13 71345507	Ø A = 8,3 710859
Ø C = 2,6 	717003 	B = 13 71345507	Ø A = 8,3 710859
Ø C = 3,2 	717004 	B = 13 71345507	Ø A = 8,3 710859
Ø C = 3,4 	717005 	B = 13 71345507	Ø A = 8,3 710859

INSTRUCTIONS FOR USE

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GUARANTEE

FAR riveting tools are covered by a **12-month** warranty. The tool warranty period starts on the date of delivery to the buyer, as specified in the relevant document. The warranty covers the user/buyer provided that the tool is purchased through an authorized dealer and only if it is used for the purposes for which it was conceived. The warranty shall not be valid if the tool is not used or maintained as specified in the instruction and maintenance handbook. In the event of defects or failures, **FAR S.r.l.** shall undertake solely to repair and/or replace the components it judges to be faulty.

SAFETY MEASURES AND REQUIREMENTS



CAUTION!!!

All the operations must be done in conformity with the safety requirements, in order to avoid any consequence for your and other people's security and to allow the best tool work way.

- Read the instructions carefully before using the tool.
- For all maintenance and/or repairs please contact **FAR s.r.l.** authorized service centers and use only **original spare parts**. **FAR s.r.l.** may not be held liable for damages from defective parts caused by failure to observe what above mentioned (**EEC directive 85/374**).

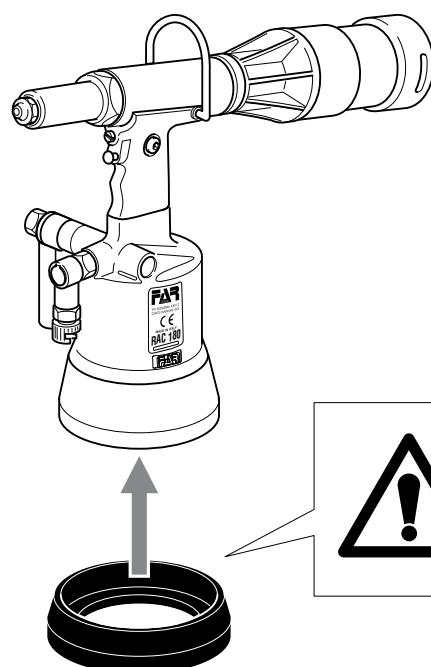
The list of the service centres is available on our website
<http://www.far.bo.it> (Organization)

- The tool must be used only by expert workers.
- A protective visor and gloves must be put on when using the tool.
- Use equipment recommended in the maintenance chapter to do any maintenance and/or regulation of the tool.
- For topping up the oil, we suggest using only fluids in accordance with the features specified in this working book.
- If any drop of oil touches your skin, you must wash with water and alkaline soap.
- The tool can be carried and we suggest putting it into its box after using.

- The tool needs a thorough six-monthly overhaul.
- Repairing and cleaning operations must be done when the tool is not fed.
- If it is possible, we suggest a safety balancer.
- If the A-weighted emission sound pressure level is more than 70 dB (A), you must use some hearing protections (anti-noise headset, etc.).
- The workbench and the work surface must be always clean and tidy. The untidy can cause damages to people.
- Do not allow unauthorized persons to use the working tools.
- Make you sure that the compressed air feeding hoses have the correct size to be used.
- Do not carry the connected tool by pulling the hose. The hole must be far from any heating sources or from cutting parts.
- Keep the tools in good conditions; do not remove either safety parts or silencers.
- After repairing and/or adjusting, make sure you have already removed the adjusting spanners.
- Before disconnecting the compressed air hose from the tool make sure that there is no pressure in the hose.
- These instructions must be carefully followed.

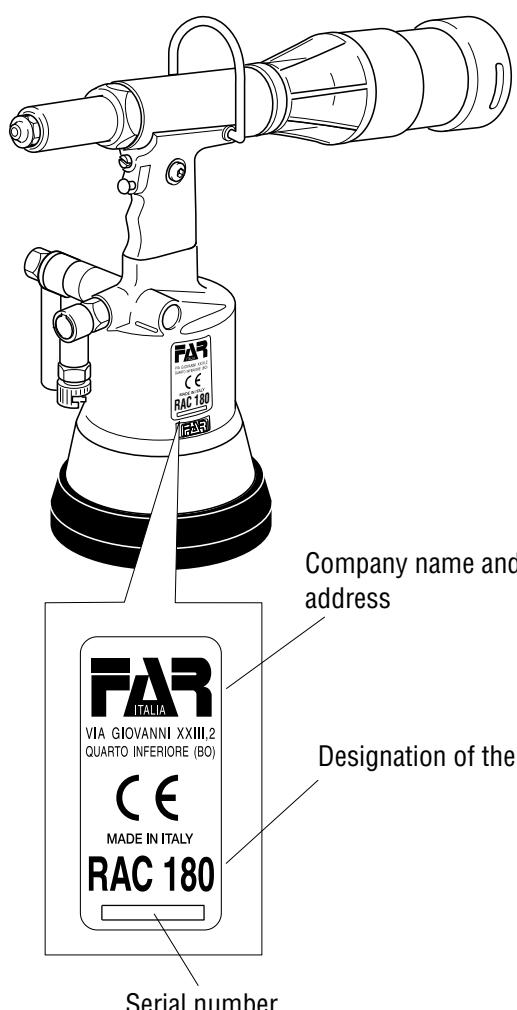
WARNING!

Before using the tool, assemble the protection bottom supplied with the tool, as indicated in the picture below. **FAR** has no responsibility for any damages on the tool, persons or things caused by lack of the protection bottom.



TOOL IDENTIFICATION

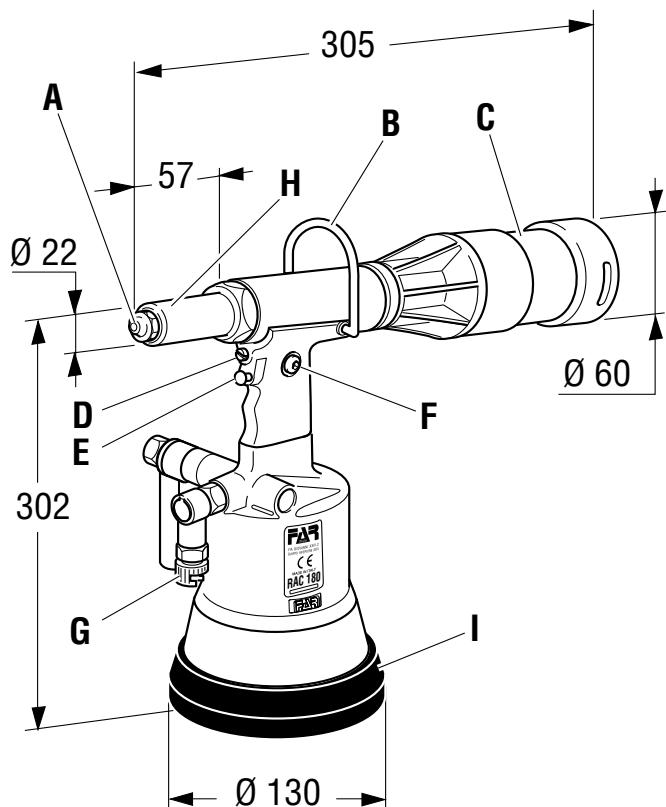
The riveting tool **RAC 180** is identified from a marking that shows company name and address of manufacturer, designation of the tool, CE. Always refer to the information on the riveting tool when requesting technical service.



Company name and address

Designation of the tool

Serial number

**MAIN COMPONENTS**

- A) Nozzle
- B) Balancer connection
- C) Nails container
- D) Suction valve
- E) Tensile strength button
- F) Oil tank plug
- G) Compressed air connection
- H) Head carrying nozzle Ø 22 mm
- I) Protection bottom

TECHNICAL DATA

- Working pressure **6 BAR**
- Min. int. diam. of the compressed air feeding hose **min. diam = 8 mm**
- Air consumption per cycle **5,4 NI**
- Maximum force **6 BAR - 10526 N**
- Weight **2,050 Kg**
- Working temperature **-5°+50°**
- Root mean square in total acceleration frequency (Ac) to which the arms are subjected **5,7 m/s²**
- A-weighted emission sound pressure level **75,5 dBA**
- Peak C-weighted instantaneous sound pressure **<130 dBC**
- A-weighted sound power **93 dBA**

AIR FEED

The air feed must be free from foreign bodies and humidity in order to protect the tool from premature wear and tear of the components in movement, therefore we suggest to use a lubricator group for compressed air.

HOW TO USE YOUR RIVETING TOOL (fig. f1-f2)

After the clamping, the sheared nail is piped by the riveting tool and ejected from the back into the special container (**C**). By swinging the valve (**D**) you can adjust the suction power. By the suction nail system, the rivet remains in the nozzle also turning over the head of the riveting tool downwards: this detail increases a lot the usefulness of the riveting tool.

Do not keep the rivet with your fingers!

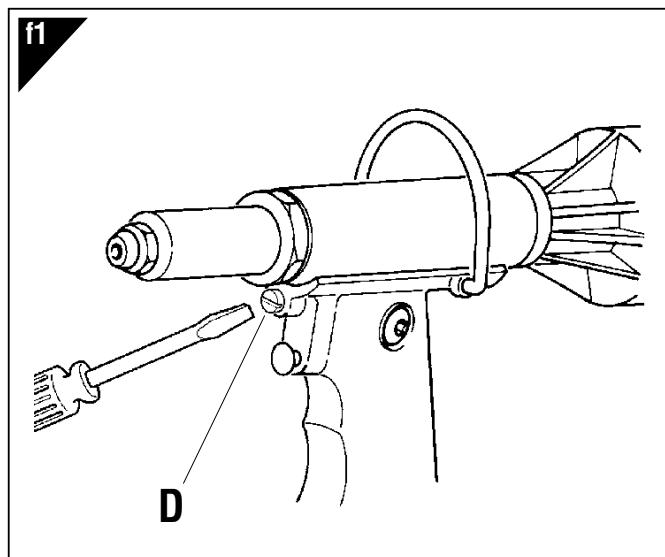
**WARNING!**

Do not remove the container (**C**) during the riveting operation, as the nail ejection can cause damages to the worker or to persons who are nearby the work surface.

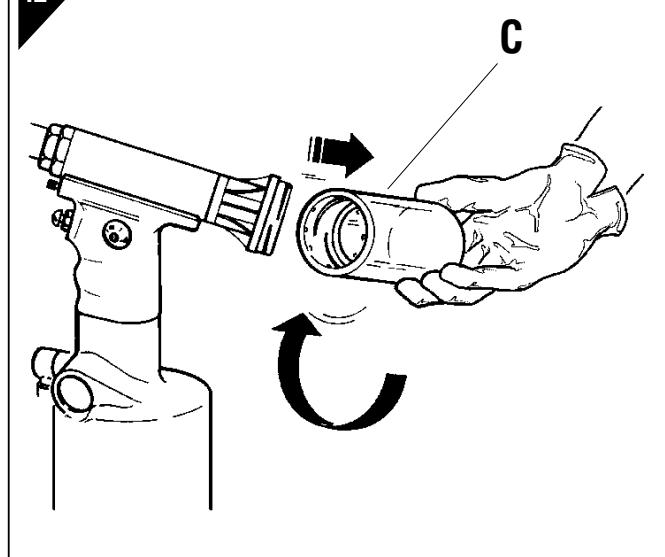
When the container (**C**) is full of nails do not use the riveting tool. Disconnect the tool, unscrew the container (**C**) and empty it.

DO NOT DISPERSE ANY NAIL!

Screw the container and start again to work.



f2

**MAINTENANCE AND CHANGE OF SIZE (fig. f3-f4-f5-f6)**

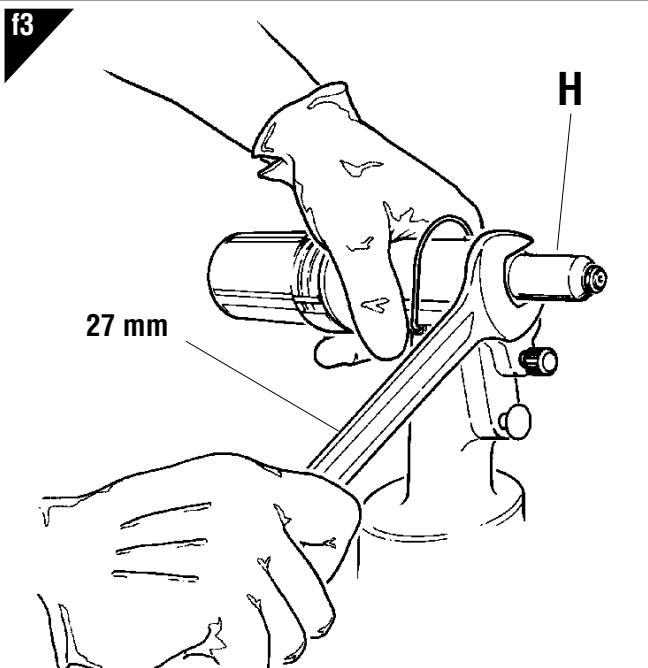
The extended utilization of the riveting tool can cause the slipping of the clamps on the nail due to the deposited impurities.

For this reason, it is necessary to lubricate the clamps after having cleaned them. However, if clamps are worn out and as a consequence their working is jeopardized, replace them. First remove the head which carries the nozzle (**H**), by means of a standard spanner of 27 mm. Then, by using two standard spanners of 11 mm and 16 mm, remove the chuck (**I**) and extract the clamps (**L**).

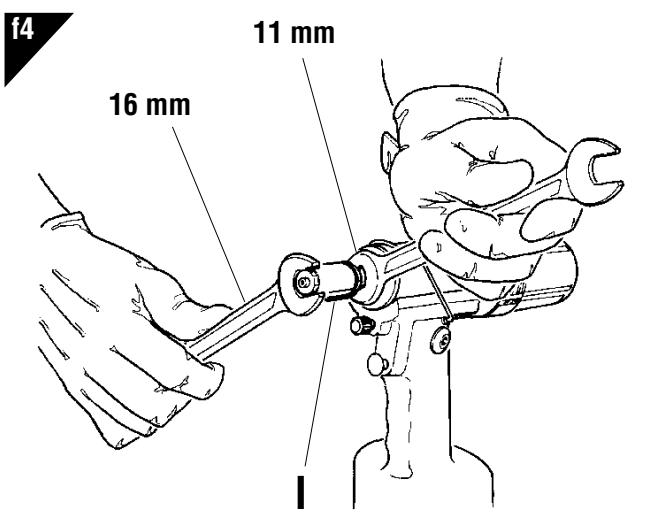
When replacing the nozzle (**A**), we recommend to use a 12-mm standard spanner and fit the removed nozzle in the proper housing located on the bottom of your riveting tool, in order to avoid losing the nozzle.

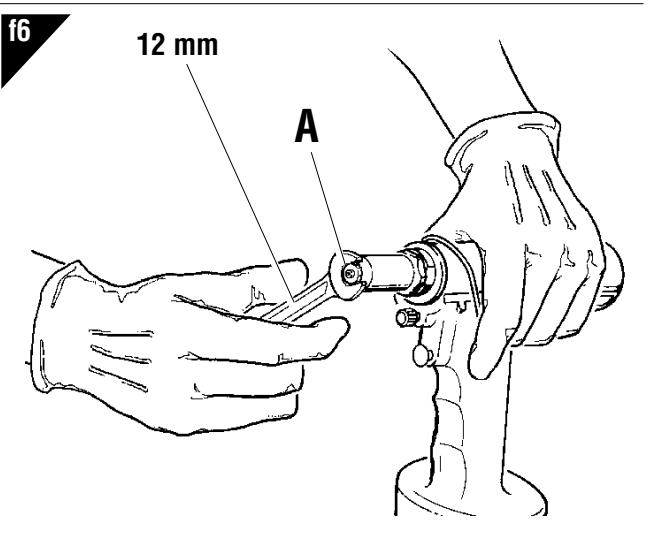
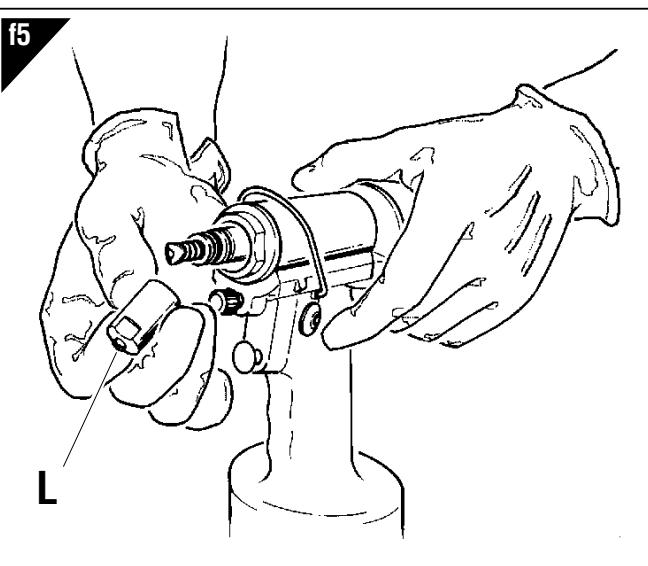
**WARNING!**

Disconnect air feed when performing those operations.



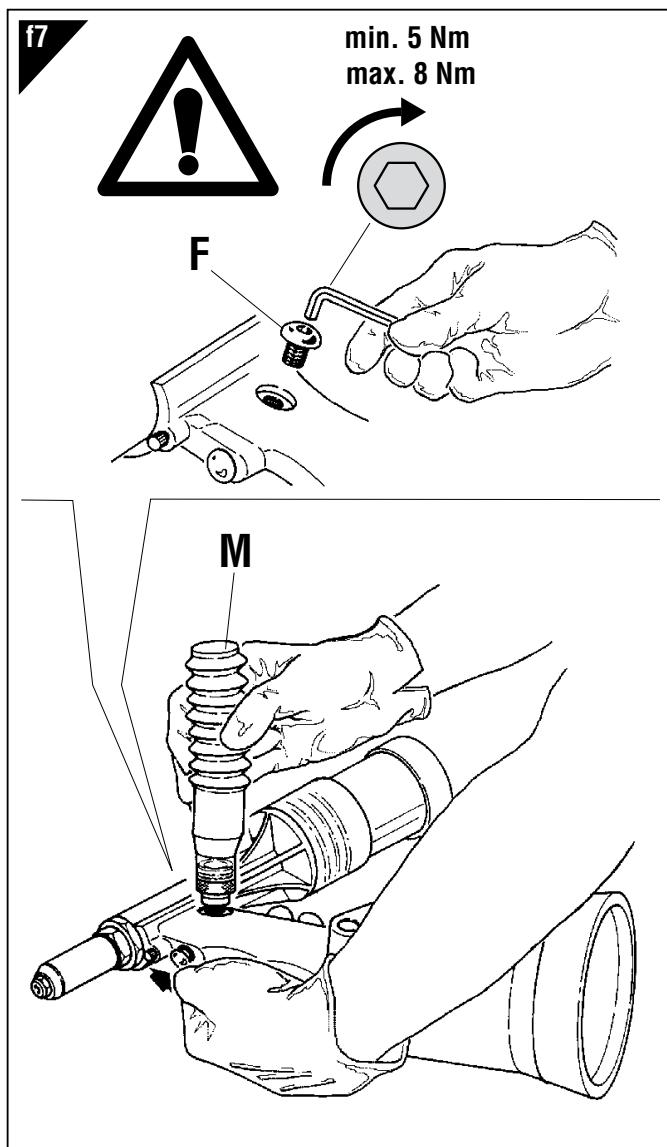
f4





ATTENTION!
Before disconnecting the compressed air hose, make sure that it is not under pressure!

ATTENTION: Make sure that the oil filler cap (F) is tightened at a torque corresponding to **Min. 5 Nm ÷ Max. 8 Nm**.
We recommend to use oil **HLP 32 cSt** or similars.



TOPPING UP THE OIL-DYNAMIC CIRCUIT (fig. f7)

You need to top up the oil-dynamic circuit after a long period of work, when you note a power loss.

Put the riveting tool (**DWELL AND NOT FED**) in a horizontal position and remove the plug (F), by means of a 5 mm Allen wrench (equipped with the riveting tool); during this operation, check the oil level in order to avoid any overflowing. Then, slowly pour the oil **HLP 32 cSt** into the bellows container (M) which shall be screwed to its seat on the plug (F). While keeping the riveting tool in a horizontal position and **starting air feeding**, push the tensile strength button and make the riveting tool carry out some cycles until air bubbles inside the container (M) stop coming out. This condition indicates that the topping up of the oil has fully been achieved. At this point **stop the air feeding** and, while keeping the riveting tool in a horizontal position, unscrew and close up the container (M) and the plug (F).

WARNING: it is very important to follow the about mentioned instructions and use gloves. If you need to empty fully the hydraulic circuit, you must put the oil in a suitable container and contact a Company that is authorized to discharge any waste.

DISPOSAL OF THE RIVETING TOOL

Follow the prescriptions of the national laws for disposing of the riveting tool.

After disconnecting the tool from the pneumatic system, disassemble and split all the components according to the material: steel, aluminium, plastic material, etc.

Then proceed to scrap the materials in accordance with current laws.

SPARE PARTS

No.	CODE	Q.ty	DESCRIPTION	KIT
002	712716	1	Body cover	
003	710300	1	Gasket OR 020	
004A	710837	1	Screw TE M9 x 20	A
005	710920	1	Gasket OR 2-337	
006	720815	1	Pneumatic piston	
007A	710836	1	Washer	A
008	710860	1	Rod	
009A	710829	1	Shock absorber	A
010	710915	1	Gasket OR 2-124	
011	710931	1	Gasket OR 614	
012	710856	1	Rod guide connector	
013	710390	1	Gasket B-075047	
014	711827	1	Gasket TTS-12-19-5,7 / L	
015	710914	1	Gasket OR 2-116	
017	710402	1	Seeger ring 22 UNI 7437	
018	710922	2	Gasket OR 018	
019	712268	1	Spring guide plug	
020	710905	1	Seeger ring 11 UNI 7437	
021	710258	1	Gasket OR 5-612	
022	710822	1	Valve piston	
024	710916	2	Gasket OR 2-015	
025	710841	1	Coil	
026	710853	1	Springs	
027B	710823	3	Cage	B
028B	710921	3	Gasket OR 2-115	B
029B	710840	1	Valve spacer	B
031	720811	1	Riveting tool body	
032	710350	1	Gasket OR 2-109	
033	711304	1	Silencer 1/4"	
034	710906	1	Washer 400-020-4490	
035	710839	1	Oil tank plug	
038	710909	1	Connector 2023 - 1/4"- 1/4"	
041	710838	1	Out put connector	
042	710824	1	Push button	
043	710919	1	Gasket OR 2-004	
044	710847	1	Valve body	
045	710528	2	Gasket OR 008	
046	710848	1	Valve piston	
047	710918	1	Gasket OR 2-005	
048	710385	4	Gasket OR 2-006	
049	710842	1	Suction regulation knob	
050	720812	1	Handgrip	
054	710816	1	Oil-dynamic cylinder	
055	717004	1	Nozzle for rivet ø 4,8 Cu / Steel	
056	710843	1	Sleeve carrying nozzle	
057	710859	1	Clamps holding cone	
058	71345507	3	High-performance clamps	
059	710849	1	Clamps opener	
060E	710819	1	Nails container	E
061G	710834	1	Suction sleeve	G
062	710102	1	Gasket OR 113	
063G	710858	1	Cone holder	G
064G	710832	1	Expeller extension	G
065	710854	1	Balancer hook	
066	710917	1	Gasket OR 2-118	
067	710855	1	Sleeving gasket	
068	710577	1	Gasket B-086055	
069	710908	1	Washer	
070C	711973	1	Seeger ring AV 16	C
071C	710845	1	Stop ring	C
072	710901	1	Gasket B-102070	
073C	710821	1	Anti-extrusion ring	C
074	712281	1	Piston	
075D	710852	1	Spring	D
076D	710851	1	Spring	D
077	710850	1	Spring guide plug	
078	710818	1	Container connector	
079	717006	1	Nozzle for rivet ø 2,4	
080	717001	1	Nozzle for rivet ø 2,5 ÷ 3,4	

No.	CODE	Q.ty	DESCRIPTION	KIT
081	717002	1	Nozzle for rivet ø 4	
082	717003	1	Nozzle for rivet ø 4,8 All.	
083	717005	1	Nozzle for rivet ø 6 / 6,4	
084	721387	1	Oil container	
085	711092	1	Wrench 5 mm	
086B	711158	1	Spring	B
087E	711136	1	Air conveyor	E
088	711305	1	Connector 1631-01 - 1/4"	
089F	710186	1	Gasket OR 010	F
090F	711401	1	End bush	F
095	711974	1	Seeger ring JV 22	
096	711736	1	Protection bottom	
097	712162	1	Outside silencer protection	
098	710831	1	Tube ø 8 x 7	
099	712117	1	Washer	
100	712133	1	Rotating connector	

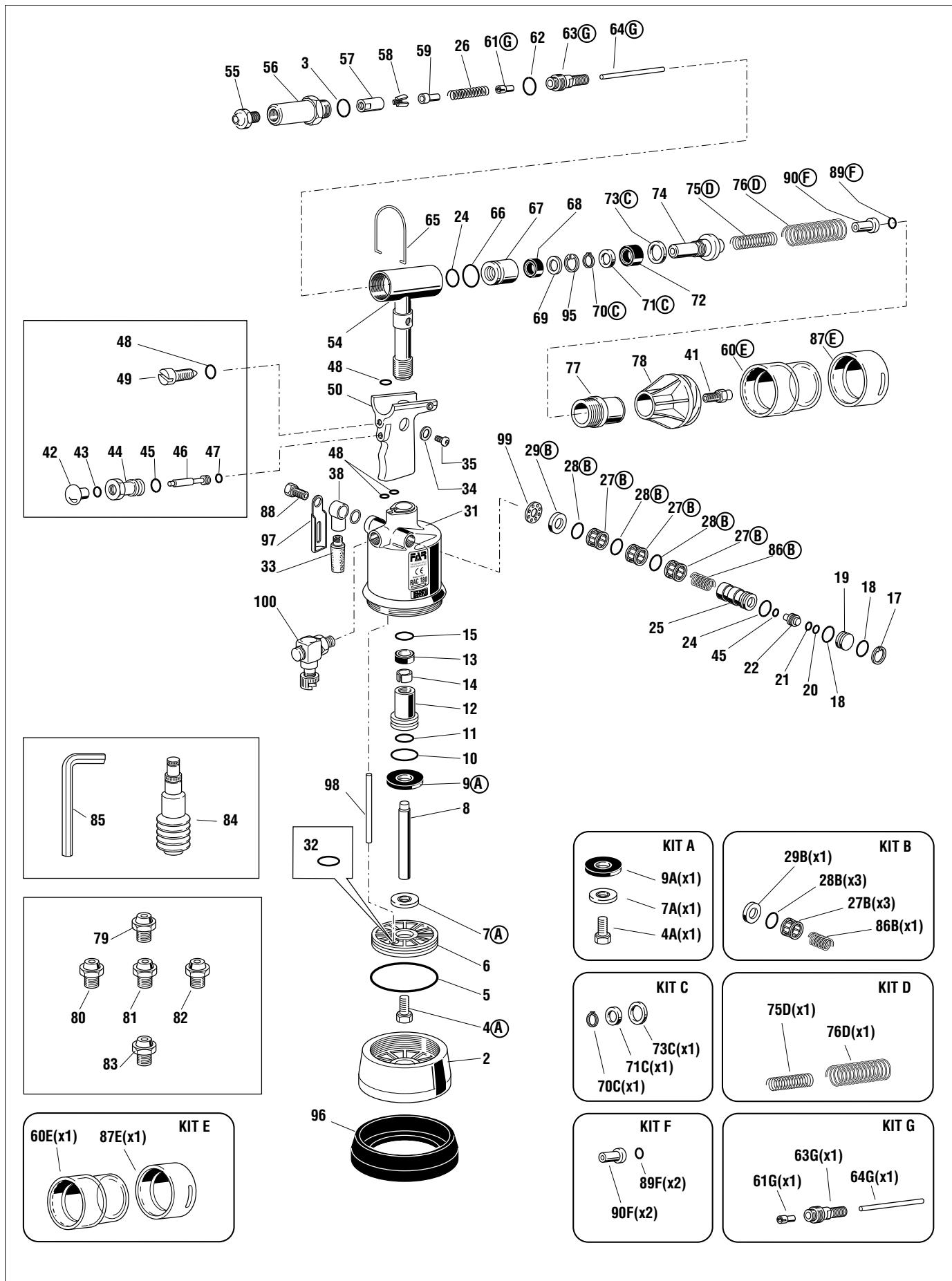
KIT

No.	CODE	Q.ty	DESCRIPTION
KITA	740837		Screw stem kit
004A	710837	1	Screw TE M9 x 20
007A	710836	1	Washer
009A	710829	1	Shock absorber
KITB	740840		Valve spacer kit
027B	710823	3	Cage
028B	710921	3	Gasket OR 2-115
029B	710840	1	Valve spacer
086B	711158	1	Spring
KITC	740821		Anti-extrusion ring kit
070C	711973	1	Seeger ring AV 16
071C	710845	1	Stop ring
073C	710821	1	Anti-extrusion ring
KITD	740851		Spring reversal piston Kit
075D	710852	1	Spring
076D	710851	1	Spring
KITE	740819		Nails container kit
060E	710819	1	Nails container
087E	711136	1	Air conveyor
KITF	741401		End bush kit
089F	710186	1	Gasket OR 010
090F	711401	1	End bush
KITG	740858		Cone holder kit
061G	710834	1	Suction sleeve
063G	710858	1	Cone holder
064G	710832	1	Expeller extension

KIT

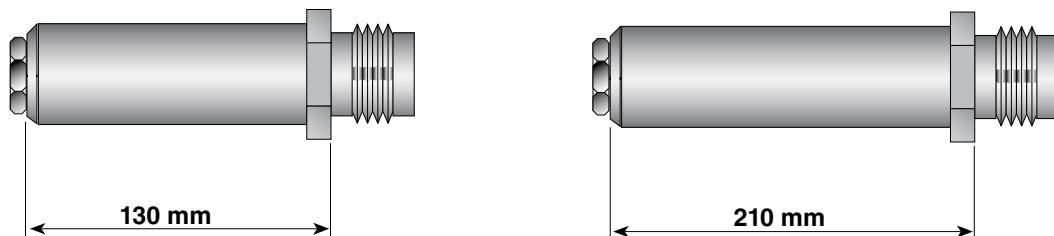
It indicates that the part is sold in kits consisting of different parts in different quantities.

PARTI DI RICAMBIO • SPARE PARTS • PIECES DETACHEES • ERSATZTEILE • PIEZAS DE REPUESTO • CZEŚCI ZAMIENNE • ДЕТАЛИ

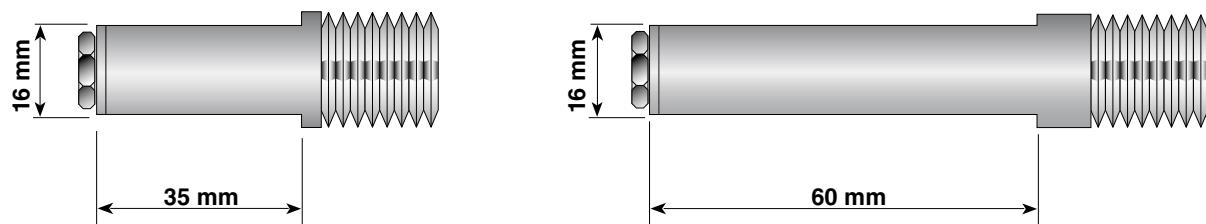


ACCESSORI - ACCESSORIES - ACCESSOIRES - ZUBEHÖR - ACCESORIOS - AKCESORIA - ПРИНАДЛЕЖНОСТИ

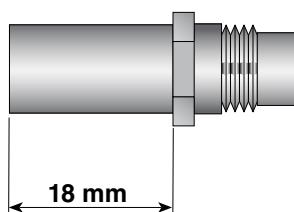
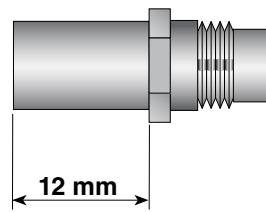
TESTE PROLUNGATE - EXTENDED HEADS - TÊTES ALLONGÉES - VERLÄNGERTE KÖPFE - CABEZAS ALARGADAS - PRZEDŁUŻANE GŁOWICE - УДЛИНЕННЫЕ ГОЛОВКИ



TESTE PROLUNGATE A SEZIONE RIDOTTA - EXTENDED HEADS WITH REDUCED SECTION - TÊTES ALLONGÉES AVEC SECTION RÉDUITE - VERLÄNGERTE KÖPFE MIT VERKLEINERTEM QUERSCHNITT - CABEZAS ALARGADAS DE SECCION REDUCIDA - GŁOWICE WYDŁUŻANE O ZREDUKOWANYM PRZEKRÓJ - УДЛИНЕННЫЕ ГОЛОВКИ С ЗАНИЖЕННЫМ СЕЧЕНИЕМ

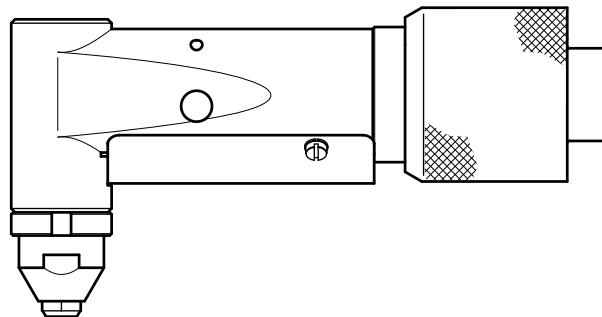


UGELLI PROLUNGATI - EXTENDED NOZZLES - EMBOUCHURES ALLONGÉES - VERLÄNGERTE MUNDSTÜCKE - BOQUILLAS ALARGADAS - PRZEDŁUŻANE DYSZE - УДЛИНЕННЫЕ СОПЛА

U1**U2**

ACCESSORI - ACCESSORIES - ACCESSOIRES - ZUBEHÖR - ACCESORIOS - AKCESORIA - ПРИНАДЛЕЖНОСТИ

TESTA ANGOLARE - ANGLE HEAD - TÊTE ANGULAIRE - WINKELKOPF - CABEZA ANGULAR - GŁOWICA KĄTOWA - УГЛОВАЯ ГОЛОВКА



S-TRIFAR / X-TRIFAR Ø 5,2 Ø C = 3 	71345652 	B = 13 71345507	Ø A = 8,3 710859

RIVETTI ALTE PRESTAZIONI - HIGH PERFORMANCE RIVETS - RIVETS HAUTES PERFORMANCES - HOCHLEISTUNGSDRITTELN -
- REMACHES ALTAS PRESTACIONES - NITY WYSOKOWYTRZYMAŁE - ЗАКЛЁПКИ С УЛУЧШЕННЫМИ ХАРАКТЕРИСТИКАМИ

Ø C = 3 	717016 ROSSO 	B = 14 71345476	Ø A = 8,3 710859
Ø C = 3 	717018 	B = 14 71345476	Ø A = 8,3 710859

- I** L'elenco dei centri di assistenza è disponibile sul Ns. sito web: <http://www.far.bo.it> (**Organizzazione**)
- GB** The list of the service centres is available on our website <http://www.far.bo.it> (**Organization**)
- F** La liste des centres d'assistance est disponible sur notre site internet <http://www.far.bo.it> (**Organisation**)
- D** Die Liste der Reparaturservices ist verfügbar unter unserer Webseite <http://www.far.bo.it> (**Organisation**)
- E** La lista de los servicios postventa es disponible en nuestro sitio web <http://www.far.bo.it> (**Organización**)
- PL** Lista punktów serwisowych jest dostępna na naszej stronie internetowej <http://www.far.bo.it> (**Organizacja**)
- RUS** Список сервисных центров приведен на нашем веб-сайте <http://www.far.bo.it> (**ОРГАНИЗАЦИЯ**)



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