

INSTRUCTION MANUAL SAR008



SAR008

HYDRO-PNEUMATIC TOOL FOR
BLIND RIVETS
3.0 ÷ 6.4 MM ALL ALLOYS, AND
7.8 MM ALUMINUM

DISTRIBUTOR'S STAMP



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1 - SAFETY INSTRUCTIONS

Users must read the instructions given herein thoroughly before starting to use the tool.

If you have any doubts about the instructions contained in this user's manual, do not hesitate to contact Sariv S.r.l. (see Section 2.1) for further explanations.

In any case:

- wear safety glasses or goggles while using the riveter – rivets are dispensed with force and at high speed, and may cause damage or bodily harm;
- do not leave the riveter plugged into the air supply when the tool is not in use;
- never point the riveter towards someone;
- keep the tool out of reach of children at all times.

2 – GENERAL INFORMATION

2.1 - MANUFACTURER

Sariv S.r.l. has been operating on the fasteners market for years. The company has a consolidated technical experience and offers a wide range of products related to fastening systems.

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2.2 - ASSISTANCE

In case you need any assistance concerning the use and the maintenance of the tool, or in case you need to order any spare parts, you shall contact your local authorized dealer (or Sariv S.r.l. directly) specifying the version of the tool.

2.3 – CERTIFICATIONS AND EC MARKING

The tool is manufactured in compliance with the European Directives, which are in force when the tool itself is put on the market. As the tool is not included in ENCLOSURE IV of DIRECTIVE 89/392/EEC, Sariv S.r.l. issues a self-certification to apply the EC marking.

2.4 - WARRANTY

The warranty has a validity of 12 months, starting from the date indicated on the invoice, and covers only replaced parts (labor is not included).

Tool damages caused by any of these cases below are not covered by warranty:

- transport and/or handling,
- user's mistakes,
- failed servicing/maintenance, as indicated in section 5 of this manual,
- faults and/or breakages that are not attributable to tool anomalies,
- normal consumption of parts of the riveter.

The warranty is invalidated both in case of unauthorized tampering/replacements of tool components and in case of use of accessories different to those recommended by the manufacturer, which could even cause injuries to the tool's user.

Sariv S.r.l. assumes responsibilities only if the tool is originally defective, but declines all forms of responsibility if the user fails to follow the instructions given.

3 – TOOL DESCRIPTION

3.1 – OPERATING SYSTEM

The hydro-pneumatic SAR008 is designed to place blind rivets of diameters of 3,0 mm, 3,2 mm, 3,4 mm, 4,0 mm, 4,8 mm, 6,0 mm, 6,4 mm of all alloys and 7,8 aluminium.

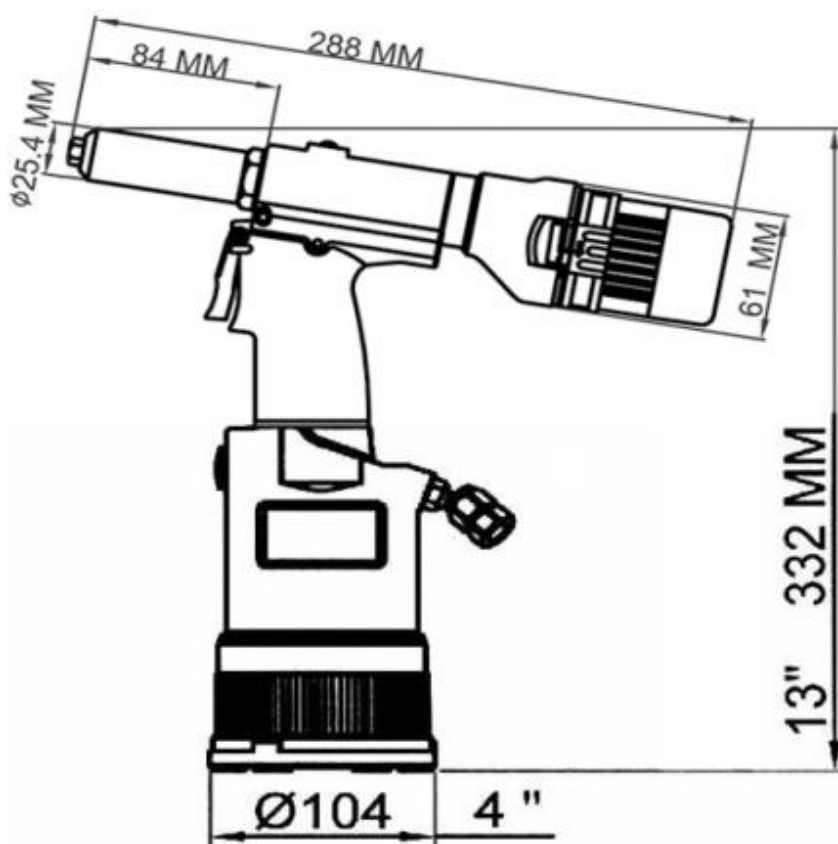
3.2 – TECHNICAL DATA

The following table provides the technical data and features of the tool:

TABLE 3.2 A – Technical features

TOOL WEIGHT	1.7 kg
TOOL LENGTH	332 mm
AIR PRESSURE	85 – 110 psi
PULLING PRESSURE	1580 kg
STROKE LENGTH	19 mm
HYDRAULIC OIL	ISO VG 68

3.3 – DIMENSIONS



4 – OPERATION

4.1 – TOOL PREPARATION

1. Prior to each operation of the Riveter, you must choose the size rivet you'll be using. If setting diam. 6,0 – 6,4 - 7,8 mm rivets, no changes to the tool are necessary.
2. If setting 4,0 - 4,8 mm rivets, you need to remove Jaw Pusher (#05) and replace it with Pusher Tube (#21), to pull 3,0 – 3,2 mm rivets, change #5 and replace (#22.) To do this, remove Nosepiece (#01) and Head (#02) from Riveter. (Use 11mm wrench to loosen Nosepiece.) Unscrew Jaw Housing (#03) from Jaw Housing Coupler(#07); when Housing is removed, Jaw Pusher (#05) as well as 3 pieces of Jaws (#04) will be loose inside Housing. Remove Jaw Pusher (#05) and set the correct pusher tube.
3. Place metal (tube) end of Pusher Tube inside Spring (#06) that now protrudes from tool. Replace Jaws back into Housing (as detailed in step 4); screw Housing back onto Jaw Housing Coupler (#07). Securely tighten Housing onto Coupler, using 14mm wrench (included in Accessory bag). Hold Coupler securely with another 14mm wrench to prevent it from turning while tightening Housing onto it.
4. NOTE: Jaws must be correctly positioned inside Housing for optimal performance. Place 3 pieces of Jaws down into small end of Housing. The narrow ends of jaws face downward and protrude out the small end of Housing. The long-serrated edges face inward toward each other. Make sure that the 3 jaws are in the correct position. The riveter will not operate correctly if Jaw pieces are not properly inserted. You may need to adjust how far each piece of Jaw protrudes through small opening, to insure they are equally distributed.
5. Carefully screw Head (#02) back onto tool securely. Making sure the Jaw pieces stay in place. Lastly, screw correct Nosepiece onto tool (corresponding to rivet size you are using).
Note: you will be pushing jaws back into tool slightly as you are attaching Nosepiece.
Use 11mm Wrench (included in Accessory bag) to tighten Nosepiece onto tool.
6. Attach Mandrel Bottle (#95), to screw it onto the back of the tool.

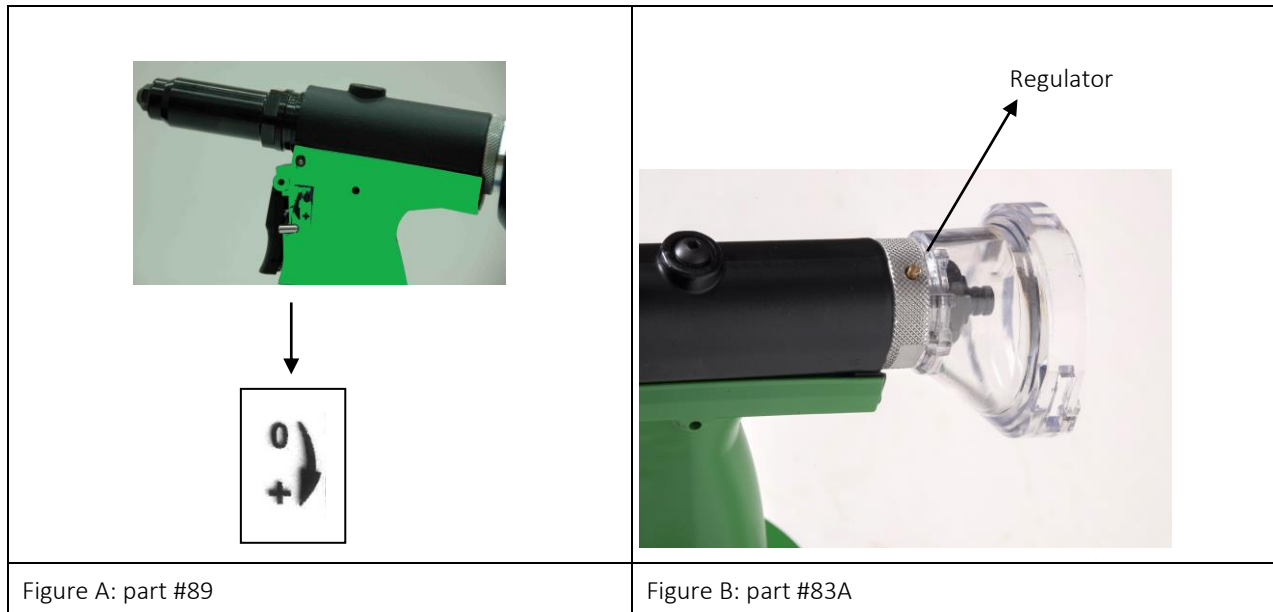
4.2 – OPERATING INSTRUCTIONS

1. Attach a ¼" NPT (Quick Connect Valve) to the Universal Joiner (#45). Plug air supply into Quick Connect Valve; air supply should operate at no higher than 110 PSI.
2. Squeeze Lever (#89) to start the vacuum system
3. Insert mandrel of rivet into Riveter. Rivet will be held in Riveter by air vacuum. If rivet falls out of tool, vacuum is not strong enough. Amount of vacuum can be adjusted via Regulator (#83A). Turn this screw counterclockwise to increase vacuum, or clockwise to decrease vacuum.



4. Mandrel will be ejected into Mandrel Bottle once Trigger is released.

5. NEVER allow Mandrel Bottle to fill more than 1/3 full; damage to Hydraulic Plunger may occur. To empty Mandrel Bottle, turn knob at end of bottle to reveal bottle opening. Shake mandrels out of hole. Once emptied, turn knob until opening is closed and Mandrel Bottle is resealed.
6. If you pull different rivets, shut off "0" the air flow Lever #89 see (A), then adjust to Regulator #83A (see fig. B) till suitable for the air flow.



IMPORTANT: CORRESPONDANCE NOSEPIECE – PUSHER TUBE

The standard tool is supplied with nosepiece and relevant pusher tube already installed.

If you need to install different rivet measures, make sure you change both the nosepiece and the pusher tube, choosing them accordingly to the rivet to be applied (see table ACCESSORIES).

5 – CARE AND MAINTENANCE

1. Regular service should be performed on this tool for best performance and longer life of tool.
2. Empty Mandrel Bottle before it gets more than 1/3 full of mandrels. Too many mandrels in collector can damage the Hydraulic Plunger and/or cause a hazardous condition for the operator.
3. Make sure that jaws are clean and free of metal shavings, dirt and oil. To access Jaws, remove Nosepiece (#1) and Head (#02) from Riveter. Jaws will be loose in narrow end of Head. Remove the 3 Jaw pieces, clean serrations with a wire brush or steel wool to remove debris. Once Jaws are clean, carefully reassemble by inserting 3 pieces of Jaws into narrow end of Head, with serrations of jaws facing inward towards each other. Tighten Head (#02) onto tool. Screw Nosepiece onto Riveter by turning clockwise. You will be pushing the Jaws into the tool as you're attaching Nosepiece; securely tighten Nosepiece to Riveter with wrench.
4. Keep oil at optimum level. With use of tool there may be a gradual loss of oil. When you notice a reduction in the stroke, you need to add a small amount of oil.
5. Change nosepiece to largest diameter that the tool accepts. This is necessary in order to test the tool after the oil has been filled.
6. Remove air supply to Riveter and remove Oil Plug (#17) on top of Riveter using Allen wrench (included).



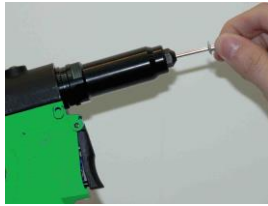
Remove Oil Plug

7. Use proper oil as listed under Specifications. Put small amount of oil in a saucer or cup; place syringe nozzle (syringe included) down into oil, then draw plunger of syringe back to fill body of syringe.
8. Screw syringe oil (#SR) nozzle into Riveter in top hole where Oil Plug (#17) was removed. Very slowly push in plunger of syringe to deliver oil into tool.

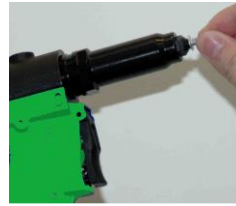


Add Oil

9. Unscrew syringe nozzle from Riveter and insert Oil Plug (#17) back into Riveter; tighten Oil Plug firmly. Reconnect the Riveter to the air supply and depress trigger 2-3 times.
10. To test oil level, insert rivet into Nosepiece (use largest diameter rivet that tool accepts). Check to see if rivet mandrel can be inserted completely into Nosepiece – head of rivet must touch Nosepiece. If rivet cannot be completely inserted into tool, too much oil has been added and some must be removed.



Insert the rivet



*The rivet body touches
the nosepiece*

11. To remove excess oil, unscrew Oil Plug (#17) approximately 1/4 turn. Depress and release the trigger to cycle air through the Riveter – oil will leak from the top of the tool at the Oil Plug hole as trigger is depressed.



Remove excess oil

12. Wipe excess oil off of tool as you continue to depress and release the trigger as needed, until rivet head touches the Nosepiece. Once tool is properly adjusted, tighten Oil Plug (#17) completely with Allen wrench.

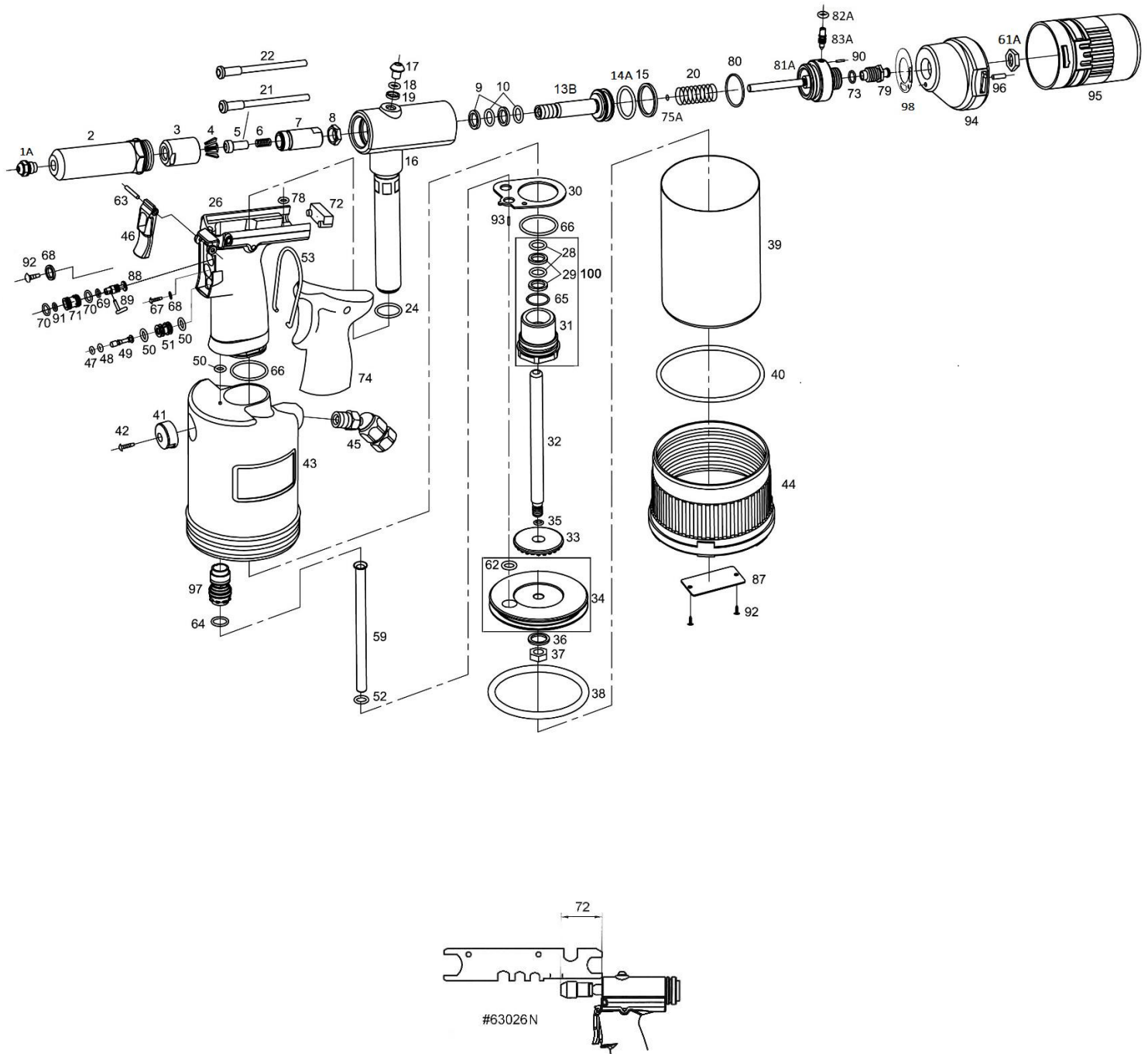


Tighten oil plug

Now the tool is ready.

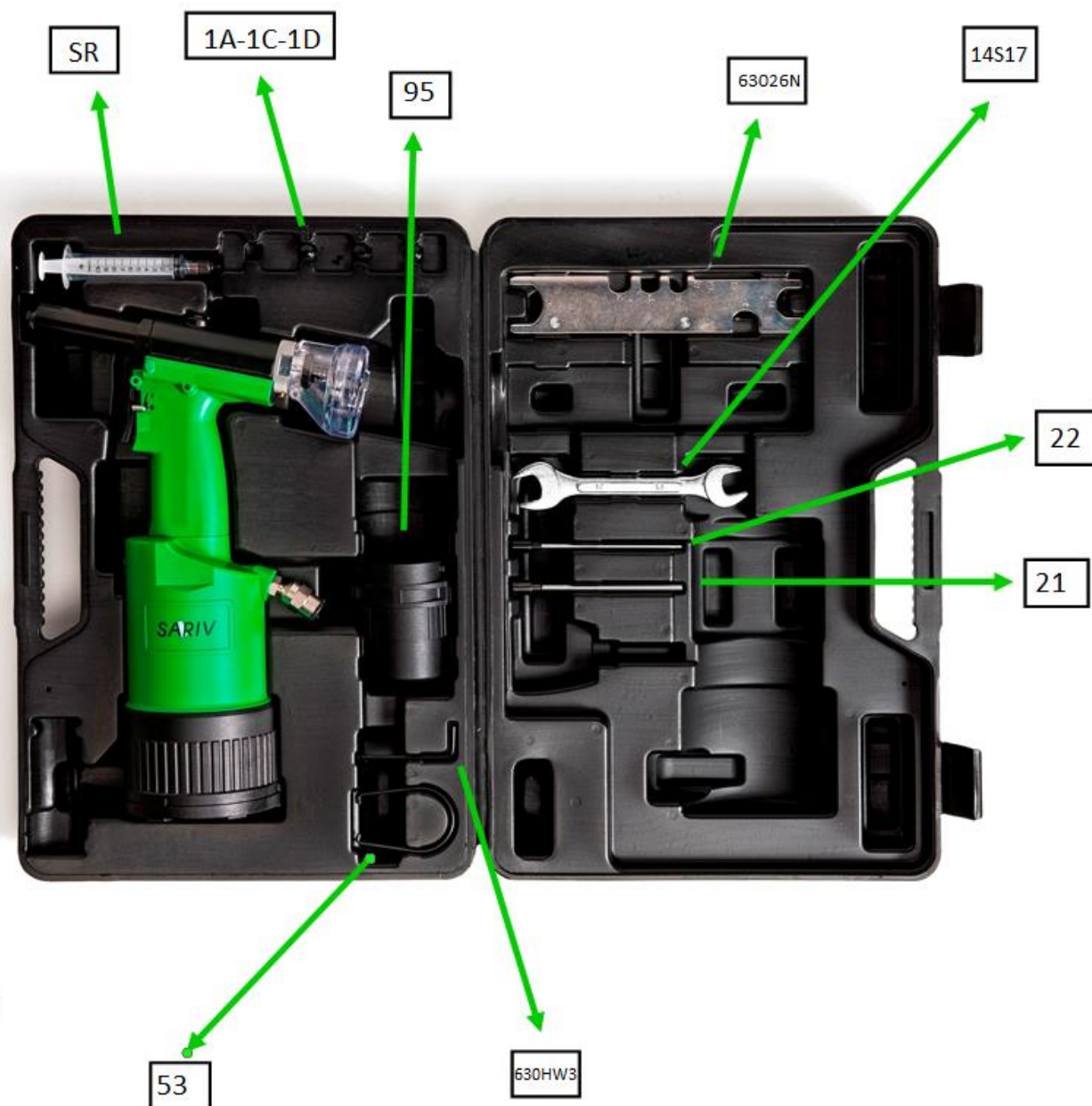
6 – SPARE PARTS

Figure 6.1-A –Spare Parts



TOOL SPARE PARTS			
CODE	DESCRIPTION	CODE	DESCRIPTION
SAR008-01E	6.4 mm NOSEPIECE	SAR008-63	ELASTIC PIN FOR TRIGGER
SAR008-02	HEAD	SAR008-64	O-RING FOR AIR DISCHARGE VALVE
SAR008-03	JAW HOUSING CONE	SAR008-65	SEALED O-RING FOR AIR DISCHARGE VALVE
SAR002/8-04A	JAWS	SAR008-66	INTERMEDIATE O-RING
SAR008-05	PUSHING PIPE FOR RIVETS 6,0-6,4	SAR008-67	SELF TAPPING SCREW FOR TRIGGER
SAR008-06	SPRING FOR JAW PUSHING	SAR008-68	WASHER FOR SELF TAPPING SCREW FOR TRIGGER
SAR008-07	JAW HOUSING COUPLER	SAR008-69	O-RING R4x15 FOR AIR SETTING PIN
SAR008-08	NUT FOR HYDRAULIC PISTON STEM	SAR008-70	O-RING FOR AIR SETTING BUSH
SAR008-09	WASHER FOR HYDRAULIC PISTON	SAR008-71	AIR SETTING BUSH
SAR008-10	X-RING FOR HYDRAULIC PISTON	SAR008-72	RUBBER SUPPORT FOR HYDRAULIC BODY
SAR008-13B	HYDRAULIC PISTON	SAR008-73	O-RING FOR SCREW CAP
SAR008-14A	O-RING P22x2.4	SAR008-75A	INTERNAL O-RING FOR HYDRAULIC PISTON
SAR008-15	WASHER FOR HYDRAULIC PISTON	SAR008-78	O-RING FOR HYDRAULIC BODY SUPPORT
SAR008-16	HYDRAULIC BODY	SAR008-79	NOSEPIECE FOR SCREW CAP
SAR008-17	OIL PLUG	SAR008-80	O-RING FOR SCREW CAP
SAR008-18	O-RING FOR OIL SCREW CAP	SAR008-81A	SCREW CAP
SAR008-19	WASHER FOR OIL SCREW CAP	SAR008-82A	O-RING FOR AIR SETTING SCREW
SAR008-20	SPRING FOR HYDRAULIC PISTON	SAR008-83A	AIR SETTING SCREW
SAR008-24	LOWER O-RING FOR HYDRAULIC PISTON	SAR002/8-61A	NUT FOR COLLECTOR JOINT
SAR008-26	TRIGGER HANDLE	SAR008-88	AIR SETTING PIN
SAR008-28	X-RING FOR SCREW CAP	SAR008-89	LEVER FOR AIR SETTING PIN
SAR008-29	WASHER FOR SCREW CAP	SAR008-90	AIR SETTING ANTI-THREAD PIN
SAR008-30	PERFORATED PLATE	SAR008-91	WASHER
SAR008-31	SCREW CAP	SAR008-92	SELF TAPPING SCREW FOR AIR SETTING KIT
SAR008-32	PNEUMATIC PISTON STEM	SAR008-93	ANTI-ROTATION PIN FOR PERFORATED PLATE
SAR008-33	RUBBER SHOCK ABSORBER	SAR002/8-94	COLLECTOR JOINT
SAR008-34	DISC FOR PNEUMATIC PISTON	SAR008-95	MANDREL COLLECTOR
SAR008-35	O-RING FOR PNEUMATIC PISTON STEM	SAR008-96	ANTI-ROTATION PIN
SAR008-36	WASHER FOR PNEUMATIC PISTON STEM	SAR002/8-98	MOTOR GASKET
SAR008-37	NUT FOR PNEUMATIC PISTON STEM	ACCESSORIES	
SAR008-38	O-RING FOR PNEUMATIC PISTON	CODE	DESCRIPTION
SAR008-39	PNEUMATIC PISTON SLIDING TUBE	SAR002/8-01A	3.2 mm NOSEPIECE
SAR008-40	O-RING FOR BOTTOM PLASTIC CAP	SAR002/8-01AL	3.2 mm EXTENSION NOSEPIECE 15mm
SAR008-41	DISCHARGE CAP	SAR002/8-01B	2.4 mm NOSEPIECE
SAR008-42	SCREW FOR DISCHARGE CAP	SAR002/8-01BL	2.4 mm EXTENSION NOSEPIECE 15mm
SAR008-43	PNEUMATIC BODY	SAR002/8-01C	4.0 mm NOSEPIECE
SAR008-44	BOTTOM PLASTIC CAP	SAR002/8-01CL	4.0 mm EXTENTION NOSEPIECE 15mm
SAR008-46	TRIGGER LEVER	SAR002/8-01D	4.8 mm NOSEPIECE
SAR008-47	FRONT O-RING FOR TRIGGER	SAR002/8-01DL	4.8 mm EXTENTION NOSEPIECE 15mm
SAR008-48	BACK O-RING FOR TRIGGER	SAR002/8-01EL	6.4 mm EXTENTION NOSEPIECE 15mm
SAR008-49	TRIGGER	SAR008-21	PUSHING PIPE FOR RIVETS 2,4-3,0-3,2
SAR008-50	O-RING FOR TRIGGER BUSH	SAR008-22	PUSHING PIPE FOR RIVETS 4,0-4,8
SAR008-51	TRIGGER BUSH	SAR008-45	ADJUSTABLE AIR JOINT
SAR008-52	O-RING FOR VALVE PIPE	SAR008-53	HANGING RING
SAR008-59	VALVE PIPE	SAR008-97	AIR DISCHARGE VALVE KIT
SAR008-62	O-RING FOR VALVE PIPE SLIDING	SAR008-SR	OIL SYRINGE

7 – ACCESSORIES



DECLARATION OF CONFORMITY

We, SARIV s.r.l. Unipersonale

Via del Progresso, 2 – Fontaniva (PD) – Italy

STATE

In the person of the Legal Representative Nicola Sartore
that the following tool

SAR008 – Hydro pneumatic riveting tool for blind rivets

IS MANUFACTURED ACCORDING TO

the requirements Council Directive Machineries
C.E.E. 89/392 (Machinery), subsequent amendments,
and standards EN292-1, EN292-2

SARIV s.r.l. Unipersonale

