

INSTRUCTION MANUAL
AUTOMATIC FEEDING RIVET TOOL



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AUTOMATIC FEEDING RIVET TOOL

1. Specification data



Rivets type	Blind rivets
Rivets diameter	1.0-5.0mm
Driven power	Pneumatic, Electric
Dimensions	490*360*370mm
Rivet gun	According to customers requirement
Voltage	AC100-240V 50/60Hz 1 Phase
Working Pressure	2.8-4.0kgf/cm ²
Feeding Pressure	1.5-3.5kgf/cm ²

2. Safety precautions

Safety precautions

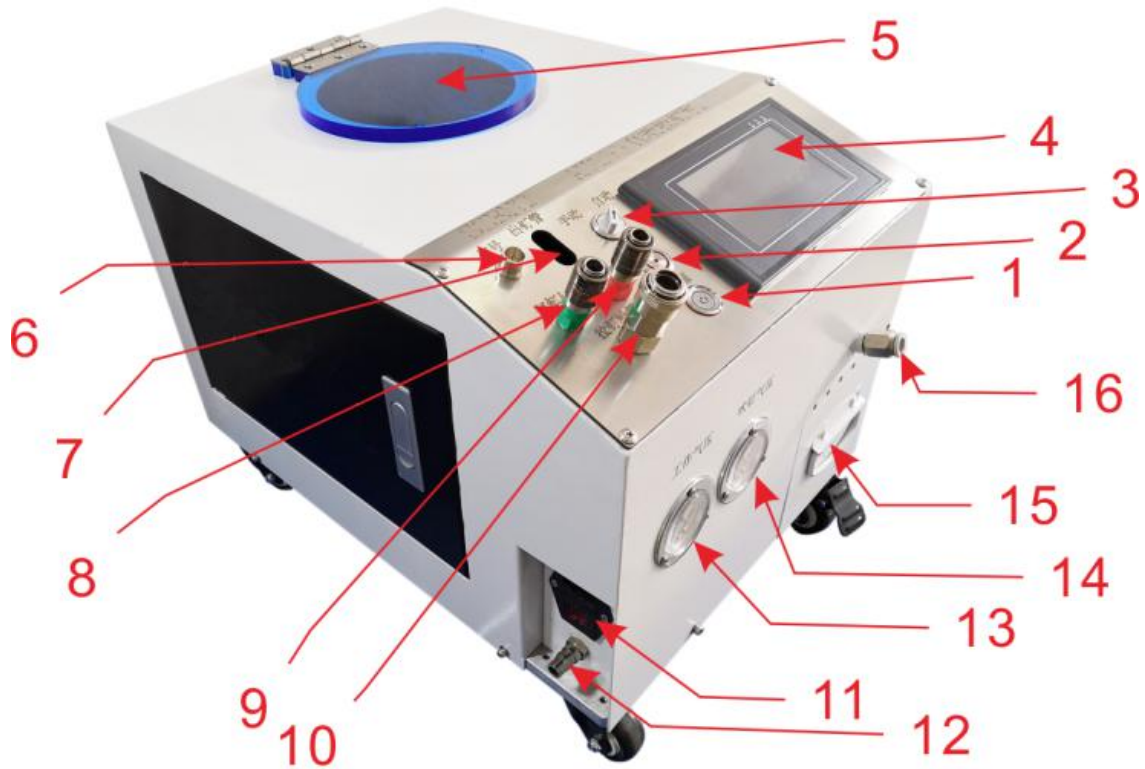
1. Ensure the machine power supply is AC100-240V 50/60Hz 1 Phase.
2. Ensure the machine power already connected ground, avoid electric shock.
3. Do not connect the machine power until **Rivets feeding tube** connect well to the rivet gun, otherwise the **Rivets feeding tube** may shoot rivets to hurt person.
4. Prohibit to pull out **Rivets feeding tube** when not turn off machine power, otherwise the **Rivets feeding tube** may shoot rivet to hurt person.
5. Prohibit to block riveter by hand or others during machine running, it may hurt hand or damage machine.
6. Prohibit to agitated vibration disk by hand or others during machine running, it may affect the stabilize of vibration bowl.
7. Prohibit to block the movement of pneumatic cylinder by hand or others, it may affect accuracy or damage pneumatic cylinder.

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3. Installation consideration

3.1 Installation instruction

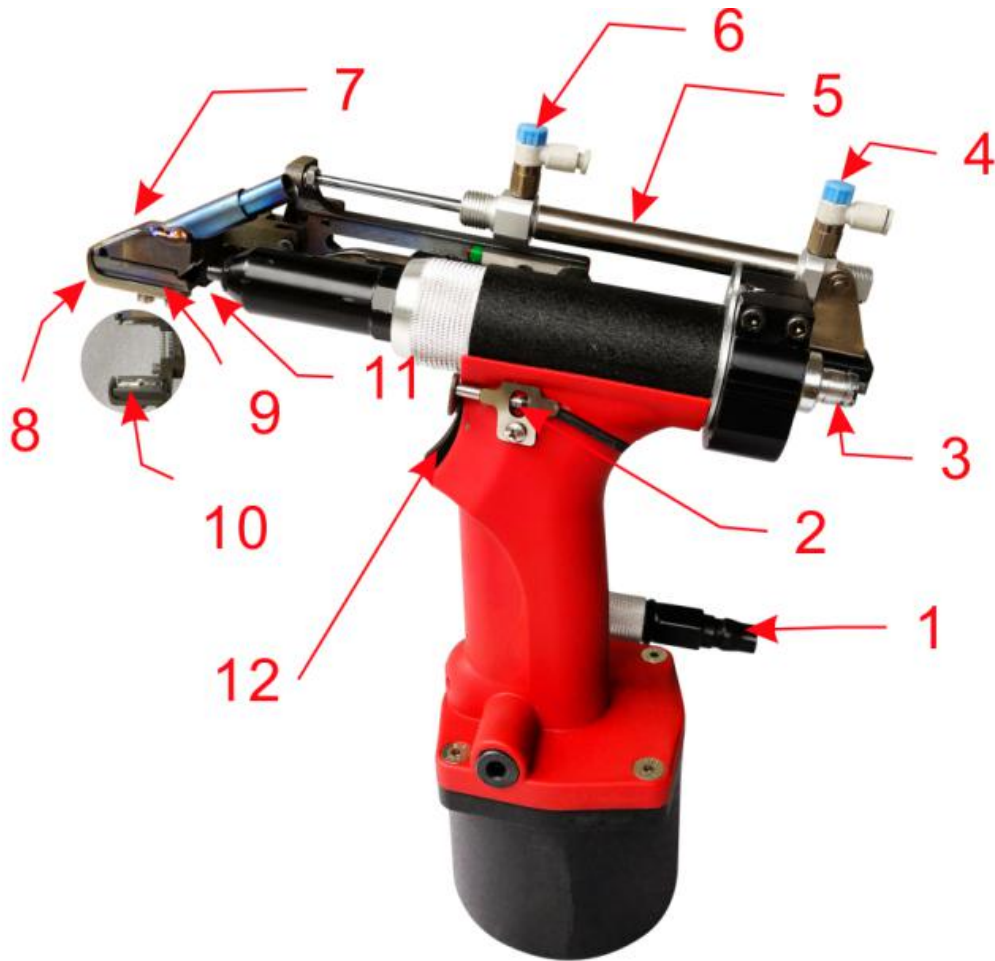
Part 1, Automatic Feeding Rivet Unit



1-1	Power Switch
1-2	Buzzer
1-3	Manual/Auto Model Switch
1-4	Touch Screen
1-5	Rivets Vibratory Feeder
1-6	Signal Cable
1-7	Rivet Tube
1-8	Cylinder A port(Green)
1-9	Cylinder B port(Red)
1-10	Rivet Gun Air Source
1-11	Electricity Socket
1-12	Air Inlet Connector
1-13	Working pressure(Supply pressure to Rivet selecting and Rivet gun pressure)
1-14	Feeding Pressure(Supply pressure to feed rivets)
1-15	Rivet Mandrel Box
1-16	Rivet Mandrel Tube

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Part 2, Rivet Gun and Feeding Device



2-1	Rivet Gun Air Source
2-2	Trigger Signal Cable
2-3	Rivet Mandrel Tube
2-4	Cylinder A port(Green)
2-5	Cylinder
2-6	Cylinder B port(Red)
2-7	Rivet Tube
2-8	Rivet Holder
2-9	Rivet Clamp
2-10	Rivet Lower Clamp
2-11	Rivet Gun Nozzle
2-12	Rivet Gun Trigger

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1. Install the machine on horizontal floor or stable platform.
2. Connect the **Part 2-7 Rivet Tube** to **Part 1-7 Rivet Tube**
3. Connect the **Part 2-4 Cylinder A port(Green)** to **Part 1-8 Cylinder A port(Green)**, **Part 2-6 Cylinder B port(Red)** to **Part 1-9 Cylinder B port(Red)**.
4. Connect Signal Cable from **Part 1, Automatic Feeding Rivet Unit** to **Part 2, Rivet Gun and Feeding Device**.
5. Connect the **Part 2-3 Rivet Mandrel Tube** to **Part 1-16 Rivet Mandrel Tube**.
6. Connect **Part 2-1 Rivet Gun Air Source** to **Part 1-10 Rivet Gun Air Source**.
7. Connect compress air to **Part 1-12 Air Inlet Connector**, air pressure should keep 5.5-8kgf/cm² stable.
8. Connect electricity to **Part 1-11 Electricity Socket**
9. Machine installation is completed.

3.2 Installation Notice


1. Must follow the installation step as above.
2. Ensure the power is AC100-240V 50/60Hz 1 Phases
3. Ensure the main machine platform is stabilize.
4. Ensure the air compressor pipe no water inside, it may affect machine use life.
5. After connecting the air source, the cylinder on the Rivet gun should be in a retracted state, otherwise it will cause a failure of the pull-out rivet, and the direction of the air inlet and outlet should be reversed so that the cylinder on the riveting gun is in a retracted state.

3.3 Attention

Improper place, which may affect the safe operation of the machine, it also affect the performance and life. Do not use the machine in the following place.

- Avoiding installing in a rough or rock place to avoid falling and rolling to damage the machine and the operator.
- Avoiding installing in wet or dusty place, cleaning the dirt plug first to avoid sparks and electric shock.
- Avoiding installing the machine in the place where is close the window or direct sunlight.
- Avoiding installing the machine in the place where is easy to vibrate.

3.4 Power ground

- Do not use the power to exceed voltage specification, do not use the porous plug to avoid spark or electric shock.
- The plug must be fully inserted into the socket to avoid any other metal to touch plug to cause spark.
-  The machine should be always connected the ground socket to avoid short circuit, spark and electric shock.

4. Operating instruction

4.1 Initial debugging

After installation, users have to debug the machine because it is first time to use.

1. Due to machine is customized, so the display screen parameters do not need to change.

- In case users need to change parameter settings.

Please contact us for help.

2. Air pressure: Normally do not need to adjust air pressure, all settings are adjusted before factory deliver, the suitable pressure 2.5-4kgf/cm².

- In case users need to adjust the air pressure.

Please open the machine cover then adjust the air pressure knob inside of machine.

3. Vibration adjustment: Adjust the Vibration plate knob. Normally, the vibration do not need adjust.

- In case vibration bowl feeding speed is too slow.

Users can adjust the Vibration plate knob, so that it can be normal feeding, pay attention to the vibration bowl feeding speed should not be too fast.

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4.2 Operating instruction

1. Turn on machine power, connect the air source.
2. Put the rivets into vibration plate, it is suitable under 500-1000pcs, the rivets quantity should depends on the rivets size.
3. Prior to the first operation, one rivet should be load to the Rivet gun nozzle and waiting for operation.
4. When the first time the Rivet gun trigger is pressed, the Rivets feeding system will run once but without rivets delivered to the nozzle of the Rivet gun. Once the trigger is pressed again, the machine will deliver one piece of rivets to the nozzle of the Rivet gun.
5. After ensuring one piece of rivets loaded on the gun nozzle of the Rivet gun, hold Rivet gun on one hand, hold the workpiece on the other hand and align the riveting point to perform the riveting operation.
6. The machine will automatically send one piece of rivets to Rivet gun nozzle, then wait for the next riveting operation.

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4.3 When using the machine, you should pay attention to the following tips.



Warning

- Do not touch the drive parts when the machine is running.
- Do not touch the Vibrating bowl when it rotating.

4.4 When filling material, you should pay attention to the following tips.



Notice

- When filling material, the Rivets must be the same specification as the setting eyelets by machine.
- When filling material, do not use the other type of rivets to avoid block up.
- Do not filling machine fully, only 2/3, fully filling will reduce the running speed.

4.5 Other notice tips

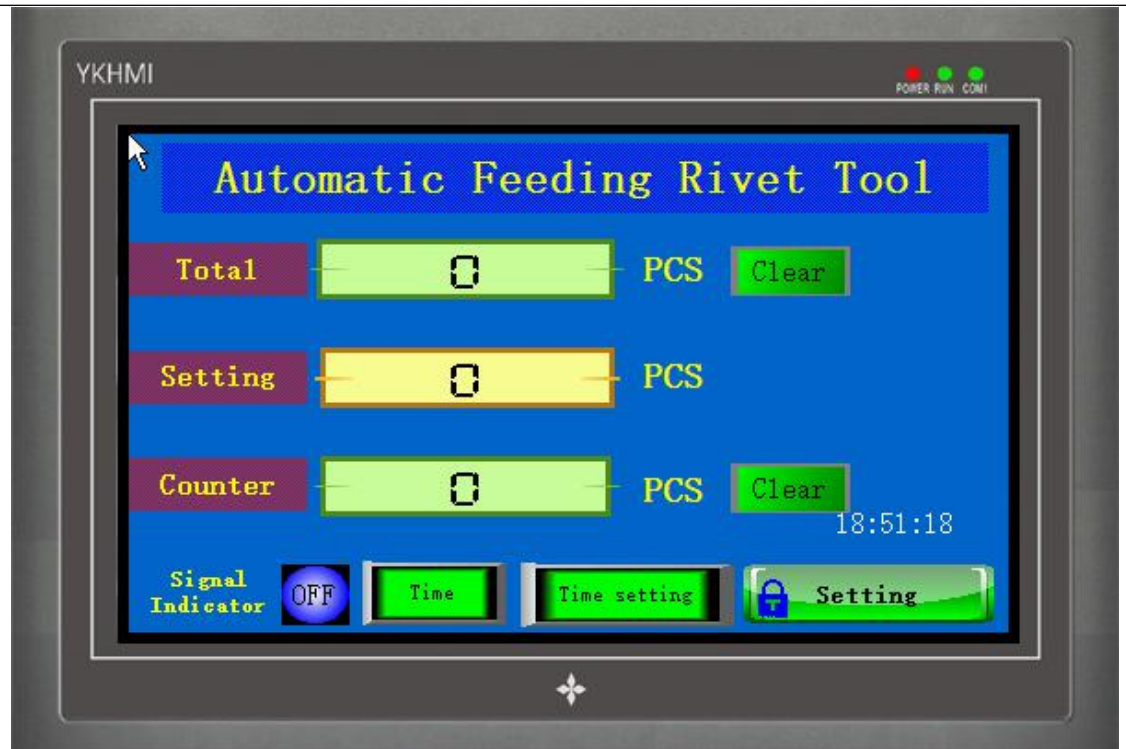


Warning

- Do not use wet hand to insert or pull off plug avoid electric shock.
- Pull off plug carefully, do not damage plug avoid spark or electric shock.

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5. Parameters adjustment



	Display total rivets quantity which processed, click to zero and re-counting the rivet quantity.
	Input the rivet quantity in , machine will sound alarm once reach the setting quantity.
	Counter the processed rivet quantity within Setting quantity, click to zero and re-counting the rivet quantity.
	Indicate the signal status.
	Set saver time,for example, set saver time as 20 minutes, saver will automatic stop machine after 20 minutes if no action.
	Set time according to users' local time.
	Timing Setting. This is locked page for prevent non-skilled person adjust the timing to cause problem. Password is 1688.

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Gun Head Time	Adjust how long the compressed air drive cylinder, default setting is 0.35s
Rivet Feed Time	Adjust how long the compressed air feed rivet, default setting is 0.35s
Rivet Deliver Time	Adjust how long the compressed air select and deliver rivet, default setting is 0.28s
Gun Head Delay	Adjust how long delay the compressed air drive cylinder, default setting is 0s
Vibratory Plate Alarm	Alarm sound after vibratory bowl empty time reach the setting time, default setting is 10s, means alarm will sound after vibratory bowl empty 10s .

Notice,

Above timing setting will be adjusted according to rivets strength by manufacturer.

Do not adjust them without manufacturer guides.

6. Users precautions

1. Because the movable Rivet gun is used for the telescopic movement driven by the cylinder, and the rivets is loaded on the rivet gun nozzle, therefore, it is strictly forbidden to use the movable gun nozzle of the rivet gun to attack the workpiece or the workbench so as not to affect the accuracy of the gun nozzle.
2. It is not allowed to limit the telescopic movement of the air cylinder and rivets feeding mechanism by hands or other objects. The movable rivets feeding mechanism needs enough space for operation.
3. Do not bend or bundle the riveting tube, otherwise it will cause the rivet to buckle or bind in the rivets delivery process.
4. Do not throw broken rivets or the rivets pull stick into the vibrating bowl to avoid block the vibrating bowl.
5. When it is necessary to adjust the angle of the pull rivets gun, the movable wrench can be used to loosen the rivet gun nozzle, adjust the active gun nozzle of the rivet gun to a suitable position, and then tighten the movable gun nozzle of the rivet gun. Pay attention to the adjustment, the pull gun machine should be free to move freely, there should be no touch sensor, so as to avoid unstable signal output.
6. When it is found that the rivet gun is not stable, the silicone ring on the rivet gun nozzle can be replaced.

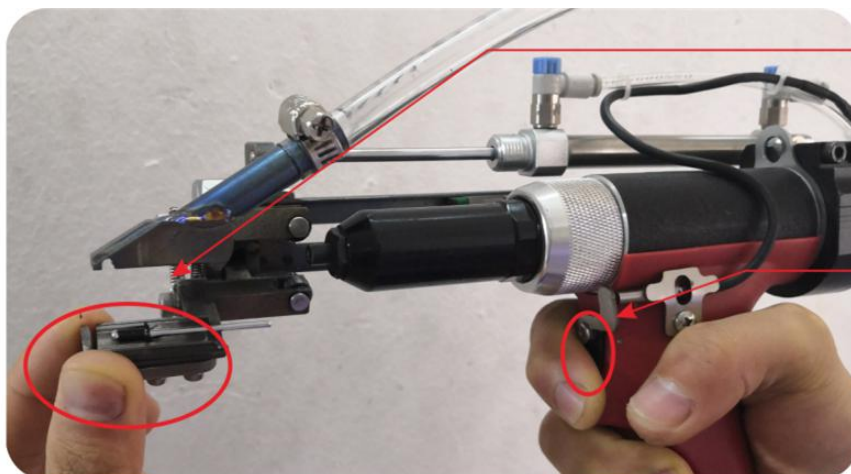
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7. When transporting, please clean out the rivets in feeder rails or move the connector parts away from the feeder rails, so as not to accidentally drop rivets in whole system.
8. In case rivets was stuck in the rivet gun nozzle,
 - 1) **Step 1:** Please hold the trigger of the rivet gun more than 0.8 seconds. The cylinder will automatically extend, and then check the rivets feeding mechanism. Clean out the blocked rivets.
 - 2) **Step 2:** Release the trigger, the rivet gun nozzle will automatically return to the retracted position.



Warning

Never trigger the rivet gun trigger again and again if rivets stuck in nozzle, the machine will repeatedly sent rivets to the rivet gun nozzle, it will stuck more rivets in nozzle.



Remove the stucked rivets by hand.

Warning:
NEVER Loose the trigger when you pick out rivets.

Keep pressing the trigger,
the cylinder will move forward and
open holder and clamp.

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7. Maintenance

1. Clean the vibratory plate regularly to ensure that the vibratory plate is clean. It is recommended to use a compressed air gun to blow the residue out of the vibratory plate and clean it once a day when no rivets in the vibratory plate.
2. Regularly clean the inside of the Rivet gun nozzle, usually every day or every other day.
3. Lubricating the Rivet gun regularly, it is recommended to Lubricating once a day.
4. When Lubricating or cleaning the Rivet gun, only open the rivet gun nozzle after holding the main part of the Rivet gun, and do not touch the rivets feeding mechanism.
5. When Lubricating or cleaning the Rivet gun, first remove the spring hooked on the movable platen to avoid damaging the spring.
6. Regularly clean the rivets rail to ensure that the rivets smoothly transported in the rivets rail. It is recommended to clean it twice a week.
7. Regularly clean the delivery system to ensure that the delivery system runs smoothly. It is recommended that compressed air guns be blown once a week and appropriate lubricating all of those moving parts.
8. Periodically clean the outside of the chassis.
9. Turn off the power after work and when not in use.

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8. Trouble Shooting

Problem	Checking	Solutions
Power switch indicator is off	Machine power connection	Connect the machine power well
	Power switch is on or off	Turn on power switch
Machine alarm	No rivets in vibration bowl	Add rivets
	With rivet in vibration plate	Check whether rivet block in vibration rail
	Rivets on feeder rails do not move	Increase vibration
Feeder move too fast or too slow	Air pressure is too high	Reduce the pressure by regulator.
	Air cylinder is damage	Replace the cylinder
Rivet gun can not riveting	Rivet mandrel in rivet gun	Remove rivet mandrel
	Air pressure is not correct	Keep air pressure properly

9. After sales-service

9.1 Quality Assurance

1. Products with warranty terms, within 24 months from the date of purchase, the users can enjoy free warranty service during proper use.
2. Out of warranty period, provides implement lifetime maintenance service if any quality problems occur. Users should charge the parts replace and our technicians labor cost.
3. Rivet gun is worn parts, it is not covered by warranty for 24 months, but it is covered for 6 months.

9.2 Warranty instructions

Below term not in free warranty

1. Over warranty period
2. The product was damaged due to misuse, negligent use.
3. The product is repaired, disassembled and modified by unauthorized persons.
4. Failure to use, maintain, or maintain the product in accordance with this instructions requires.
5. The product worn parts and man-made damage are not covered by the warranty.
6. For the parts that need to be returned to the factory, our company will

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mail them by designated means and be responsible for the postage of one-way parts return.

9.3 Explanation

1. The company will not bear any responsibility for property or personal injury caused by improper use.
2. All compensation is based on the total value of the purchase price.
3. All accessories except the automatic feeding system are worn parts.