

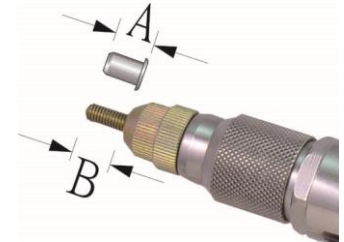
ARX-0123A Operation & Maintenance Manual

Before using ARX-0123A, please read the instructions.

Operation

1.Air Pressure: 6.0~7.0 kg/cm² (85~100psi)

2.Setting up for Standard Length Nut Rivets: When using the standard length of nut rivet (10mm), please ensuring that the Stroke Set Adaptor (#2) and Nose nut (#3) are fully threaded into the Stroke adaptor cover (#5). Adjusting #2 & #3 parts for making rivet nut length A=length B.



3.Setting up for Short Nut Rivets : If using the shorter length of nut rivet, then screw the Stroke set adaptor (#2) out adjusting for the shorter rivet.

4.Stroke Adjustment: The Stroke adaptor cover (#5) is the main stroke adjusting part for ARX-0123A, Stroke range is 2mm~10mm, Stroke traction load that depending upon the size and material of nut rivet, also need to considering about the riveting thickness. Please set up correcting stroke before using ARX-0123A for avoiding screw mandrel and rivet nut damaging. Connecting air and Holding trigger then Turning #5 parts away or close to #6 parts (Connector Housing) for increasing or reducing stroke length, turning #5 one cycle away from #6 increasing 1mm stroke. The stroke range is 2mm when #5 part contacted with #6 part. Please refer to the table 1 adjusting stroke.

Table 1		
Rivet Size	Suggestion Stroke	#5 turning away from #6 cycle
M3	2.0~2.3mm	0~0.5
M4	2.5~3.0mm	0.5~1
M5 (3/16")	3.5~4.0mm	1.5~2.0
M6 (1/4")	4.0~4.5mm	2.0~2.5
M8 (5/16")	5.0~5.5mm	3.0~3.5
M10 (3/8")	5.5~6.0mm	3.5~4.0



*Turning #5 one Cycle away from #6 for Increasing 1mm Stroke.

*Holding trigger will make turning #5 easier.

[Note] If the thickness of the riveting plate is less than 1.0 ±0.5mm. Please turn #5 away from #6 part slowly and carefully for avoiding to damage the mandrel.

5. Holding rivet nut and turning clockwise #48(Safety Cap Nut) for screwing up rivet nut.



* Turning clockwise #48(Safety Cap Nut) for screwing up rivet nut..

6. Pressing #53(Trigger) riveting. [Note] When the first riveting, please testing 1~2 rivet nuts freely for ensuring the correction stroke.

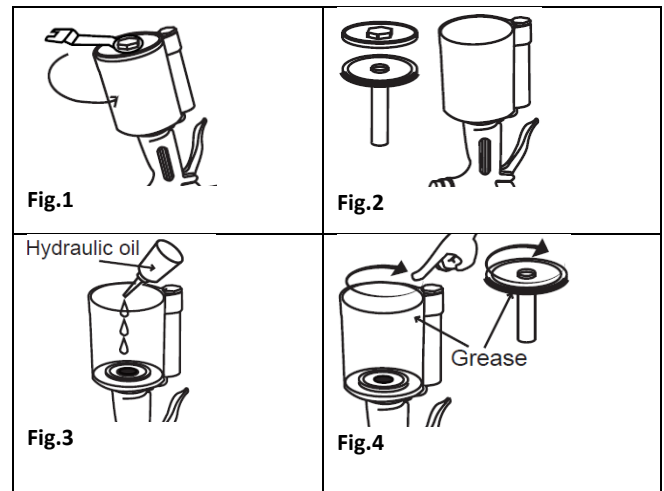
7. Turning anti-clockwise #48(Safety Cap Nut) for loosening rivet nut.



Maintenance

When adjusting adaptor cover (#5) to the Max. stroke(10mm) without action after pressing trigger. It might be empty of Hydraulic Oil. Please follow below steps to refill Hydraulic Oil.

1. Disconnect from air supply
2. Using spanner to remove cylinder cap #35 as in Fig. 1
3. Removing the piston assembly using pliers as in Fig.2
4. Fill with hydraulic oil, Viscosity ISO: VG46 as in Fig.3
5. Use silicone grease on wall of cylinder and piston as in Fig.4
6. Reassemble in reverse process.



Maintenance for Nut Riveter Head

1. Using spanner to remove Connector Housing #6
2. Using spanners to take apart the inner housing parts
3. loosening all parts
4. Lubricate the 1A ~1F Screw Mandrel and piston with silicone grease.
5. Reassemble in reverse process.

Mandrel Replacement

1. Connecting air supply then pressing trigger and removing #3, #2 and #5 parts as in Fig.5.
2. Disconnecting air supply then use spanner to luck #4 parts and loosen the #1 mandrel as in Fig 6.
3. Using spanner to luck #4 parts and screw up the new or another size #1 mandrel as in Fig.7.
4. Connecting air then pressing trigger and reassemble #3, #2,#5 parts.
5. Adjusting the gap of #5 between #6 around 1.5~2.0mm as in Fig.8.

