



Assembly & Instruction Manual **ITEM 1106**



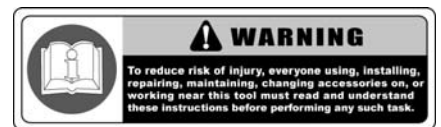
Heavy Duty Air Riveter

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Your new HEAVY DUTY AIR RIVETER has been engineered and manufactured to Cummins Industrial Tools high standards for dependability, ease of operation, and operator safety. Pay close attention to the Rules for Safe Operation, Warnings, and Cautions. If you use your machine properly and only for what it is intended, you will enjoy years of safe, reliable service.

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INTRODUCTION


- THIS PRODUCT has many features for making the use of this product more pleasant and enjoyable. Safety, performance, and dependability have been given top priority in the design of this product making it easy to maintain and operate.

 **WARNING:** Do not attempt to use this product until you thoroughly read and completely understand the operator's manual. Pay close attention to the safety rules, including Dangers, Warnings, and Cautions. If you use your product properly and only as intended, you will enjoy years of safe, reliable service.




Look for this symbol to point out important safety precautions. It means attention!!! Your safety is involved.




 **WARNING:** The operation of any tool can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Before beginning operation, always wear safety goggles or safety glasses with side shields and a full face shield when needed. We recommend Wide Vision Safety Mask for use over eyeglasses or standard safety glasses with side shields. Always wear eye protection which is marked to comply with ANSI Z87.1.

GENERAL SAFETY RULES

 **WARNING:** When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment. Read all instructions before using the tool.

- **Work area condition.** Cluttered areas invite injuries.
- **Additional work area conditions.** Do not use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted.
- **Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools or extension cords.
- **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- **Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. There are certain applications for which this tool was designed. It will do the job better and more safely at the rate for which it was intended. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
- **Use eye protection.** Always wear ANSI approved impact safety glasses underneath a full face shield during use. Also wear heavy duty work gloves.
- **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines.
- **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. The handles must be kept clean, dry, and free from oil and grease at all times.
- **Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before starting work.
- **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Any part that is damaged should be replaced.
- **Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from Cummins Industrial Tools.
- **Do not operate tools if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

 **WARNING:** The warnings, cautions, and instructions discussed in this instruction manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which can not be built into this product, but must be supplied by the operator.

SPECIFIC SAFETY RULES

- DO NOT ABUSE THE POWER CORD. Do not yank compressor's cord to disconnect it from the receptacle. Do not carry tools by the cord.
- REMOVE ADJUSTING KEYS AND WRENCHES. Make it a habit to check that keys and adjusting wrenches are removed from the tool or machine work surface before plugging it in.
- AVOID UNINTENTIONAL STARTING. Do not carry any tool with your finger on the trigger, whether it is connected to the compressor or not.
- DRAIN COMPRESSOR EVERY DAY. Do not allow moisture to build up inside the compressor. Do not allow compressor to sit pressurized for longer than one hour.
- MAKE SURE ALL EQUIPMENT IS RATED TO THE APPROPRIATE CAPACITY. Make sure that regulator is set at least 10 PSI lower than the lowest rated piece of equipment you are using.
- DO NOT POINT AT PEOPLE OR ANIMALS. Whether the Riveter is loaded or not, do not point at anything but what you plan on riveting.

PACKING LIST

- 1B 5/32" Nose Piece
- 1C 1/8" Nose Piece
- 1D 3/32" Nose Piece
- 06-1 Jaw Case Front Tart (3/32", 1/8", 5/32")
- 06-2 Jaw Case End Tart
- 7 Jaw
- 8 Jaw Pusher
- 10 Jaw Pusher Spring
- 19 Reium Spring
- 35 Spanner
- 36 3-Way Spanner
- 47 Quick Coupler

PRODUCT SPECIFICATIONS


Item	Description
Rivet size	3/32", 1/8", 5/32" and 3/16"
Air Pressure	65-100 PSI
Average Air Consumption	4.2 CFM
Air Inlet	1/4" NPT
Hose Size	3/8" ID
Weight	3.74 lbs

UNPACKING

INSTRUCTIONS

When unpacking the tool:

- Carefully remove the tool and accessories from the box.
- Make sure that all items listed in the packing list are included.
- Inspect the tool carefully to make sure no breakage or damage occurred during shipping.
- Do not discard the packing material until you have carefully inspected and satisfactorily operated the tool.

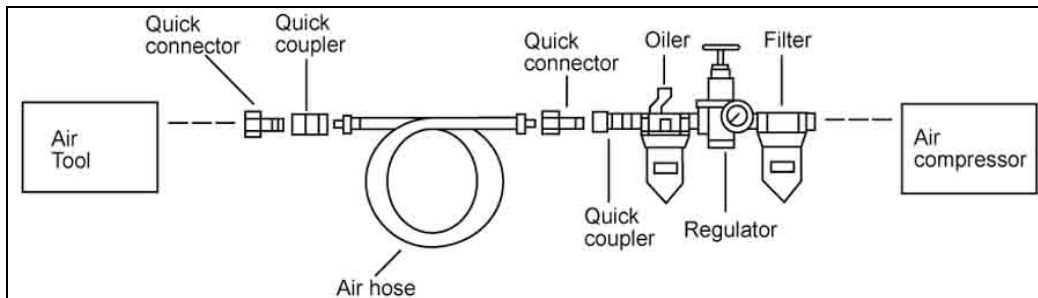
 **WARNING:** If any part is missing do not operate the tool until the missing part is replaced. Failure to do so could result in possible serious personal injury.

ASSEMBLY

Oil and Filter Connection

Dirt, water, and the lack of pneumatic tool oil are major causes for tool wear. Install an optional oiler-filter, as illustrated below for better performance.

1. Connect the air tool, air hoses, filter, and oiler to the Compressor Air Outlet as illustrated below.
2. The filter and oiler (not supplied) are recommended but not mandatory for operation.
3. If the filter and oiler are not used, connect the air hose directly to the $\frac{1}{4}$ " 18 NPT connector located at the Air Inlet (13) fitting. Also a few drop of pneumatic tool oil the must be added through the air line before each use.



NOTE: Use pipe thread seal or Teflon tape on all threaded connections.

OPERATION

Attaching the Air Inlet and Valve

Use the quick-coupler and screw it to the air inlet receiver. See Figure 1.

Setting Up Air Compressor and Air Delivery Line

Step 1: It is advisable to use an in-line oiler.

Step 2: If you are not using an in-line oiler, put a few drops of pneumatic oil into the quick coupler (#47) prior to every operation.

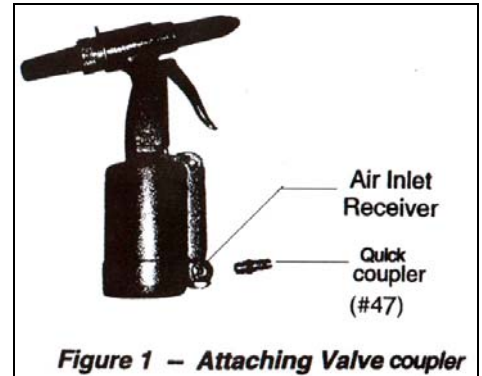


Figure 1 – Attaching Valve coupler

Changing Nose Pieces

When changing NOSE PIECES (#1 A to # 1 D), simply unscrew the NOSE PIECE, and tightly screw in the desired NOSE PIECE. (The unit comes with the 3/16" NOSE PIECE (#1A) installed.) See Figure 2.

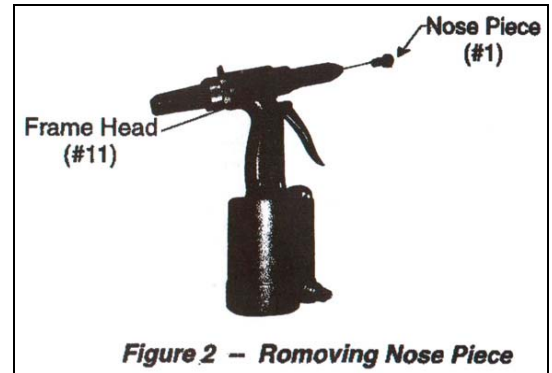


Figure 2 – Removing Nose Piece

MAINTENANCE

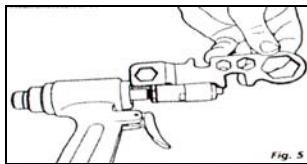
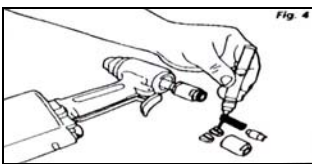
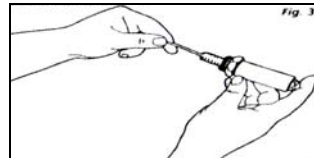
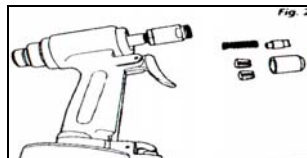
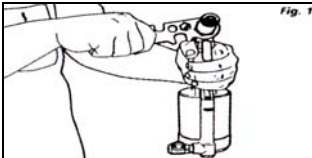
Adding oil for Hydraulic Riveter

- 1- Disconnect air hose.
- 2- Use the spanner to take apart the head as fig 1.
- 3- Use the spanner to open the bottom cover as fig 2.
- 4- Remove the piston of the cylinder as fig 3.
- 5- Clean the inside of the cylinder and the frame body.
- 6- Full the lubricate oil as fig 4.
- 7- Clean the stem of piston, apply grease to the inner wall of cylinder and the inner wall of cylinder and the O-ring as fig 5.
- 8- Reassemble the riveter by following the disassembly procedure in reverse.

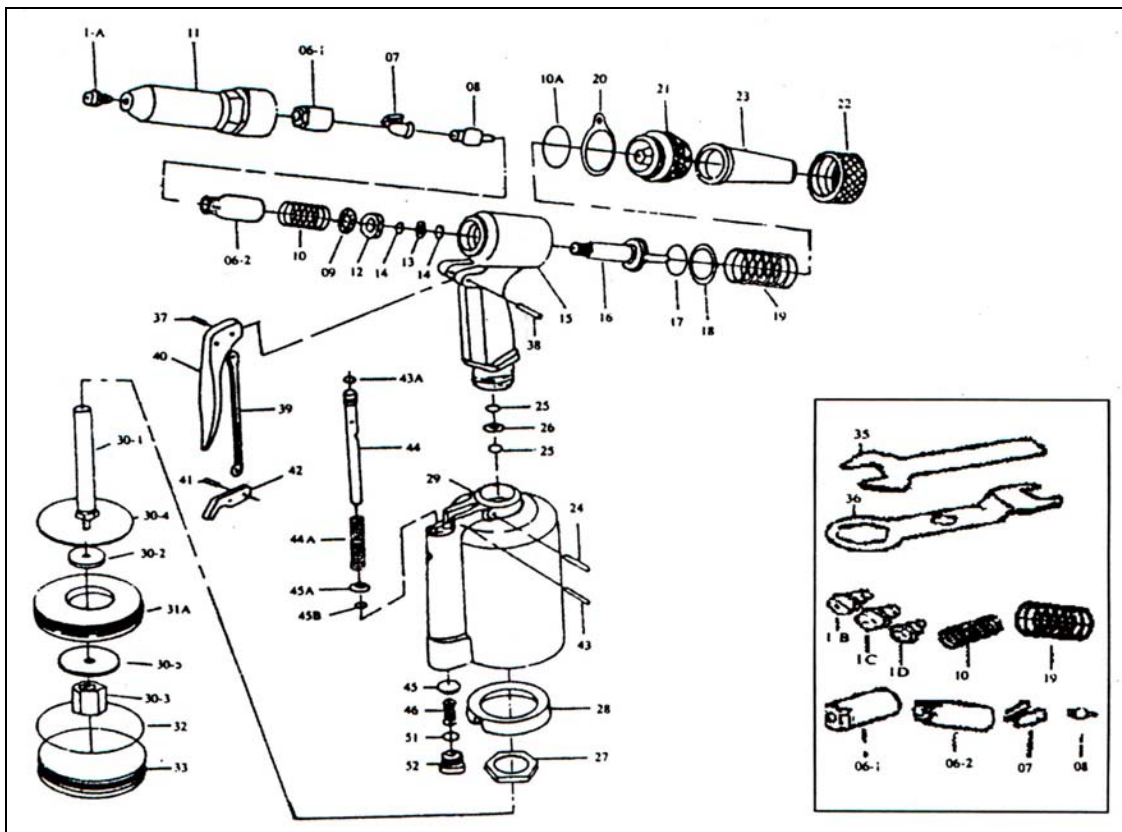


TROUBLESHOOTING

- 1- Make sure that there is no air flow going to the River Gun.
- 2- Use the spanner to remove the head from the frame. (Fig 1)
- 3- Use the spanner to remove the Jaw Housing, Jaws, Jaw Pusher, and the Pusher Spring. (Fig 2)
- 4- Thoroughly clean the inside of the Frame Head. (Fig 3)
- 5- Use a light gauge machine oil to lubricate the parts shown in Fig 4.



EXPLODED DIAGRAM



PARTS LIST

1A	Nosepiece (3/16")
1B	Nosepiece (5/32")
1C	Nosepiece (1/8")
1D	Nosepiece (3/32")
06-1	Jaw Case Front Tart (3/32", 1/8", 5/32")
06-2	Jaw Case End Tart
7	Jaw
8	Jaw Pusher
9	Case Washer Ring
10	Jaw pusher Spring
10A	Frame Cap O Ring 27x2
11	Frame Head
12	Case Lock Nut
13	Back Up Ring
14	Back Up O Ring P12
15	Frame
16	Oil Piston
17	Oil Piston O Ring P22A
18	Back Up Ring
19	Reium Spring
20	Hanging Clip
21	Frame Cap
22	Frame Cap Nut
23	Safety Cap
24	Setting Screw Pin
25	Back Up O Ring P12
26	Back Up Ring
27	Frame Lock Nut
28	Rubber Cushion

29	Air Cylinder
30-1	Air Piston Stem
30-2	Air Piston Ai
30-3	Air Piston Lock Nut
30-4	Big Iron Plate
30-5	Small Iron Plate
31A	Air Piston Ring
32	Cylinder O Ring 67.94x2.62
33	Cylinder Cap
35	Spanner Gague
36	Spanner
37	Trigger Pin
38	Connector
39	Trigger Rod
40	Trigger
41	Connector
42	Trigger Lever
43	Lever Pin
43A	Valve Pusher O Ring P7
44	Valve Pusher
44A	Valve Spring
45	Valve
45A	Valve Collar
45B	Collar O Ring P5
46	Valve Spring
51	Valve Cap O Ring P11
52	Valve Cap