

OPERATION MANUAL

PNEUMATIC RIVET
NUTS SETTING TOOL

E-312NP

ESSENTIAL RANGE



EN



M3-M12

ALUMINIUM - STEEL - STAINLESS STEEL



■ Scell-it® ■

GENERAL SAFETY INSTRUCTIONS AND PRINCIPLES



READ THIS MANUAL CAREFULLY BEFORE USING THE TOOL !

It is **IMPORTANT** to follow the safety instructions for adequate protection against injuries.

- This tool should be used exclusively to apply blind rivet nuts prescribed as **TOOL CAPACITY**. It can't be used for other purposes, such as hammer, etc...
- This tool must be used with treated compressed air supply in a pressure range 0.5MPa-0.7MPa.
- The tool must be, during any kind of maintenance or repair, **DISCONNECTED** from the source of compressed air.
- **DO NOT** use the tool when you are tired or under the influence of drugs, alcohol or medication. One moment of inattention when working with the tool can result in serious injuries.
- **DO NOT** use the tool in the environment described as below:
 - fuel and combustion air.
 - temperature rapidly rising.
 - humidity, rain, water, storm and thundering.
 The tool is not designed for explosive environment.
- When the tool is suspended by the operation hook during use, be sure the tool will not fall.
- When using the tool, always carry safety shoes, protective goggles, protective gloves, safety helmet, ear protectors and other necessary protections. It is highly recommended for safety reason.
- Remove the setting tools or wrenches before switching on the pneumatic tool. A wrench connected to a rotating part of the tool can result in injuries.
- Do not allow persons who have not read these instructions or who are not familiar with the tool to use it.
- Keep children and other persons away when you are working with the tool. If distracted, you may lose control over the tool.
- Have your tool repaired only by qualified specialist personnel and only with original spare parts. If in doubt, always return the tool to the distributor.
- Any alterations of the tool, its accessories or spare parts remain in sole responsibility of the customer.
- The tool must be kept in top condition and regularly tested for damage and proper operation. Check that moving parts function correctly and do not jam and that parts are not broken or damaged in such a way that the function of the tool is impaired. Have damaged parts repaired before using the tool.
- Never aim with the tool at another person.
- Oxygen or other flammable gasses from pressure cylinders must not serve as a driving agent.
- Avoid unnecessary contact with the hydraulic fluid to prevent possible allergy reaction of the skin.
- After the service life, discard the tool according to the applicable disposal.
- The pressure regulator has to be equipped with a filter to avoid impurities and water.

TOOL CAPACITY

blind rivet nuts M3 – M4 – M5 – M6 – M8 – M10 – M12 - All materials and styles

TOOL SPECIFICATIONS

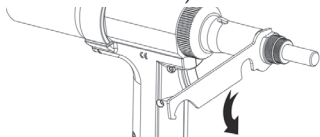
Air supply pressure :	0,5Mpa ~ 0,7Mpa
Output traction power:	21,000 N ~ 29,400 N
Stroke :	1 mm ~ 7 mm ajustable
Net weight:	1,91 kg

GETTING START TO WORK

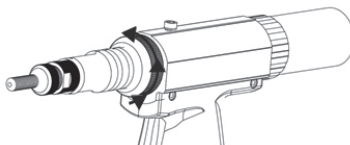
Please refer to the **TOOL EXPLOSIVE ILLUSTRATION** and the **PARTS LIST** in this manual in order to have a good understanding of the tool parts described. The descriptions of the tool parts appear in this manual are in **italics**.

- 1) This pneumatic powered tool should be worked with compressed air supply. It is recommended to use the air hose with diameter bigger than 8 mm.
- 2) To check the compressed air pressure within the specified range between 0,5Mpa and 0,7Mpa, and to connect the air hose adaptor onto the tool air adaptor. The air adaptor has its different versions in different countries and areas, normally the tools are equipped with the correct version as default, in case the air adaptor does not apply in your air supply hose adaptor, contact the tool distributor(s).
- 3) To change and use correct cap screw and anvil according to the size of the rivet nut to be set. This tool is equipped with cap screws and anvils from M3 up to M12 in the tool kit. For convenience, 7 identical locknuts provided in the tool kit for each size of the cap screw and anvil in pairs. The steel grade for the screw puller must be 12.9.

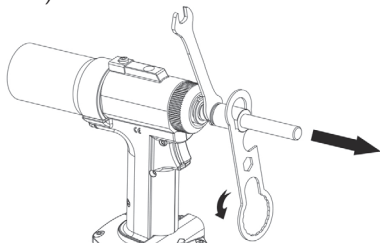
- a) To remove the anvil from the tool and the locknut (*spanner from the tool kit*):



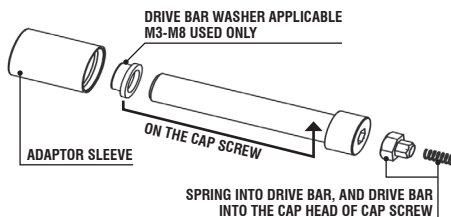
- b) To remove the retaining ring and nose sleeve:



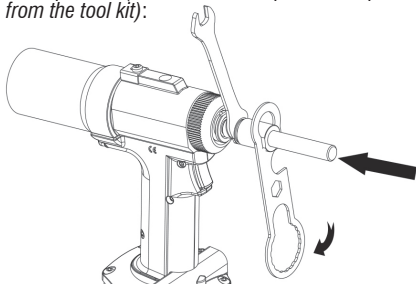
- c) To remove the adaptor sleeve, the screw puller, drive bar (M3 to M8) and drive bar washer (M3 to M8) (*17mm standard spanner + spanner from the tool kit*):



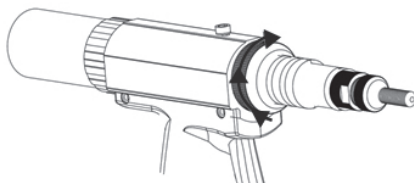
- d) To assemble the spring into the drive bar (M3 to M8), the drive bar (M3 to M8) into the cap head of cap screw, the drive bar washer (M3 to M8) on to the cap screw and the adaptor sleeve:



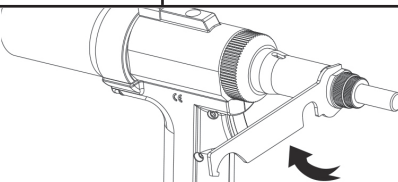
- e) To screw on adaptor sleeve tight with spring house with spanners (*17mm standard spanner + spanner from the tool kit*):



- f) To install the nose sleeve and screw on the retaining ring:

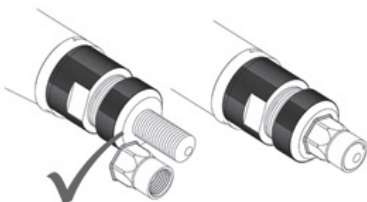


- g) To screw on the locknut and anvil (*spanner from the tool kit*):

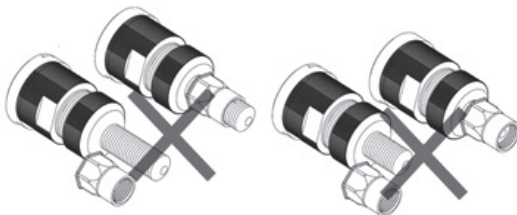


MANDREL PROTRUDING SET FOR BLIND NUT

- 1) To set the length of the cap screw protruding out of anvil according to blind rivet nut length, by positioning of the locknut and anvil locking each other:



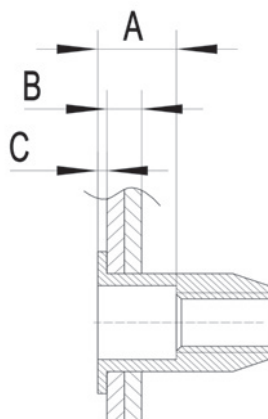
- 2) Never to set the cap screw protruding length too long nor too short according to the rivet nut to be set:



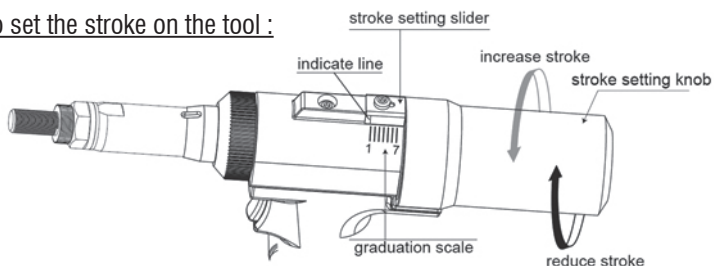
STROKE SETTING

- 1) It is very important step to define the stroke to be set on the tool, by measuring the rivet nut and calculating in formula:
Stroke = A - (B + C)

- A** = depth of the rivet nut (inside of the rivet nut non-threaded and no upset part of the nut when setting)
B = total thickness of work piece(s)
C = rivet nut head thickness (if countersunk head rivet nut, then C = 0)

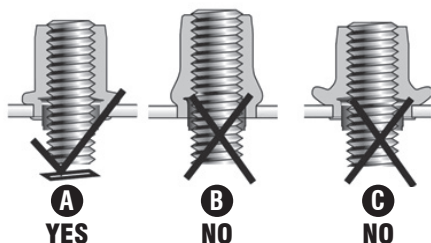


- 2) To set the stroke on the tool :



- a) The tool stroke can be set from 1mm up to 7mm, and it shows by the indicate line pointing on to the graduation scale precisely.
- b) To increase the stroke: slide the stroke setting slider in the direction of the tool front (cap screw), turning the stroke setting knob anti-clock wise, release the stroke setting slider back (to be sure the small needle tip seated back into the hole on the edge of the stroke setting knob) and checking the indicate line pointing.
- c) Repeat the operation until the indicate line pointing at the defined stroke; To reduce the stroke: operate in the same way but turning the stroke setting knob clock wise.

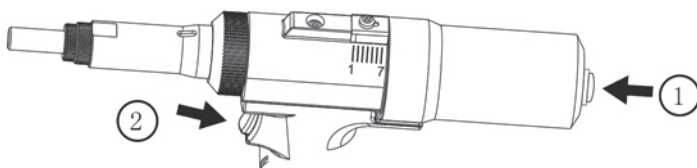
- 3) Checking the set stroke by initial rivet nuts setting. It is extremely important to have precise stroke setting and trial set on work piece and refer to the illustration below to see if you got a nice set up:



- A** Correctly set
B Not fully set
C Over-set. Do not pull the nut up too tightly as you may strip the thread in the nut or damage the tool mandrel.

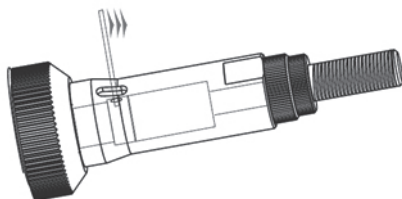
TO SET RIVET NUTS

- 1) After start-up preparations, stroke setting and initial trial setting, to put the rivet nut into work piece hole (pre-drilled), to insert the cap screw of the tool into the rivet nut and press the button of the tool, the operation of the rivet nut setting will be automatically finished.
- 2) The tool, after the button pressed, the tool will automatically insert into the rivet nut and set the rivet nut on the work piece then released automatically.
- 3) If users have not had the stroke setting correctly, the tool might can not be released, then follow the process described below to release the tool:



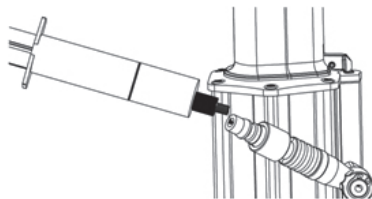
- a) Slightly press the release button at the rear of the tool.
- b) Press the button of the tool, then the tool will be release from the set rivet nut.

- 4) If the tool operator used a bad quality rivet nut or improper stroke setting, the tool might be blocked on the set rivet nut and work piece and can not be released according to the above 3) described, then to use the anti-block sticker in the tool kit, insert into the slot-shaped hole on the nose sleeve, then turning the tool with force anti-lock wise to release the tool.

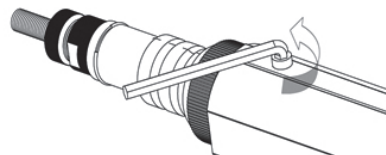


TOOL MAINTENANCE

If there is no lubricating device connected in the air distribution, daily and before starting work, for better performance of the tool, add a few drops of hydraulic oil on the inlet of the air adaptor of the tool in order to reduce the frictions of the tool parts since the oil will be blown inside the tool when tool operates.

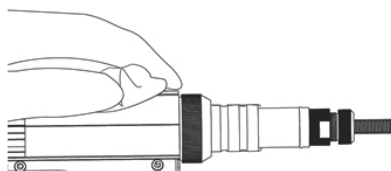


After certain period of use, the tool stroke might be reduced, it shows the hydraulic oil of the pneumatic tool is necessary to be refilled or changed:

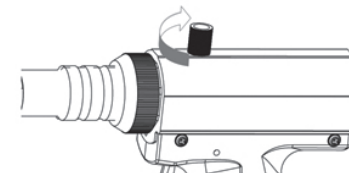


1) To remove the screw by hexagon wrench:

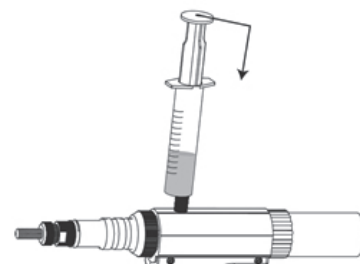
2) To connect the air supply and to cover some cloth over the hole where the screw removed, then to press the button and the oil will be leaked out from the tool :



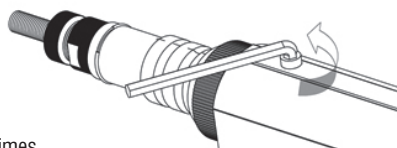
3) To screw the oil inject adaptor (on oil injection tube set in the accessories pack) into the hole where screw removed :



4) To use the oil injection tube (in the accessories pack) to inject the oil slowly until not able to refill, to remove the injection tube and its adaptor, then clean the oil on the tool and tightly screw on the screw back to the tool:

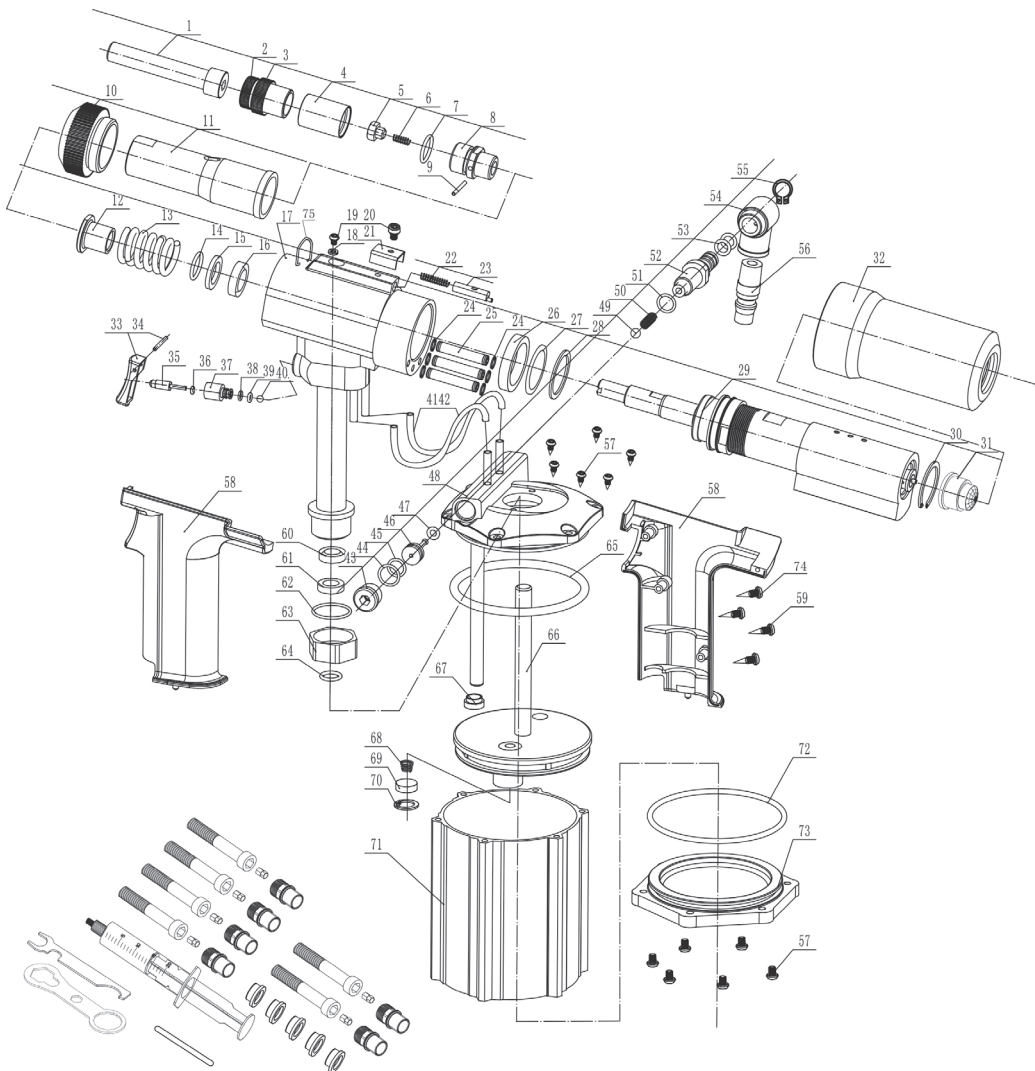


5) To test the tool stroke. If the stroke still not enough as it should be, it means there could be some air in the oil cylinder when you refilling the oil to the tool. Then the extra air needs to be released from the tool.



To connect the tool with air supply, to pull the tool button 6 or 7 times, then loosen the screw , let the extra air leaking out, then screw on the screw tight again:

TOOL EXPLOSIVE ILLUSTRATION



WARRANTY CONDITIONS

During the warranty period, the customer must not perform any alterations other than those permitted by the manufacturer (maintenance). The repairs must be done by an authorized service center.

To admit warranty repair, the customer must return the defective tool to the service center of the manufacturer with the proof of purchase. Warranty is valid only if the tool is in its warranty period (12 months from the date of purchase confirmed by the proof of purchase) and if the conditions of use have been respected.

Warranty is not valid if worn spare parts have to be replaced (further to a normal use of the tool).

EC CERTIFICATE OF CONFORMITY – EC DIRECTIVE 2006/42/EC ANNEX II 1A

The manufacturer :

SCCELL-IT
28 RUE PAUL DUBRULE
59810 LESQUIN
FRANCE
Tél.: +33(0) 320 329 818

Declares hereby that the following product :

Manual pneumatic hydraulic rivet nuts setting tool type E-312NPP

Complies with the following relevant conditions :

EC Machinery Directive 2006/42/EC Annex I

If the machine is modified without our knowledge and consent, this EC Declaration of conformity will be voided

Most important applied harmonized standards :

EN ISO12100:2010 + EN ISO11148-1:2011

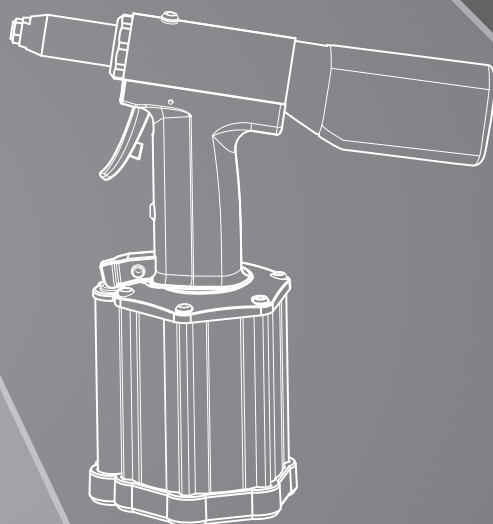
Name of documentation officer : Nadia FAYTRE

Address of documentation officer : see address of manufacturer

Lesquin, 30/07/2019

Franck DEBRUYNE
(Directeur général)





Scell-it UK Ltd, Unit 7, Beacon Business Park, Weston Road, Stafford ST18 0DG, UK.

TEL: 01785 246539

www.scellit.co.uk