

E640PC

Pneumatic Pin & Collar Setting Tool

USER MANUAL





SAFETY OPERATING INSTRUCTIONS

Please read this user manual carefully before operating the tool!

- This tool should be used exclusively to apply rivetnuts within specified tool capacity. **DO NOT** use for other purposes (e.g. as a replacement hammer).
- This tool should be always operated with compressed air supply within the air pressure range 5 bar ~ 7 bar.
- **DISCONNECT** the air supply from the tool before changing the tool parts, such as the nosepiece, etc;
- Do not use this tool in environments containing fuel and combustion air, rapidly changing temperatures, high humidity, rain, water, storms, or thunder.
- When using the tool, make sure it is properly secured and will not fall when suspended by the operation hook.
- Make sure that you have made the compressed air clean, dry, and oil lubrication.
- Before using, check all connections are firm.
- **DO NOT** put hands between the nosepiece and the workpiece under any circumstances.
- For safety reasons when using the tool, always use protective goggles, protective gloves, safety helmet, and other necessary protections.
- To use only genuine spare parts for repairs;
- The repair work must be carried out by skilled personnel, when in doubt, always return the tool to the distributor.
- Always keep these operating instructions together with the tester.

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Rights and Disclaimers

The company provides lifelong after-sales service for its products, guaranteeing their quality. The warranty covers issues related to product quality. However, damage to tools resulting from misuse, failure to follow tool use and maintenance instructions, the use of non-original parts, and other forms of man-made damage are not covered by the warranty. It's important to note that wearing parts are also excluded from warranty coverage.

The company does not accept responsibility for any personal, property, or equipment damage or loss caused by illegal operation or actions that violate the provided instructions. Users are advised to adhere to the instructions to avoid any potential risks or damages.

MAIN SPECIFICATIONS

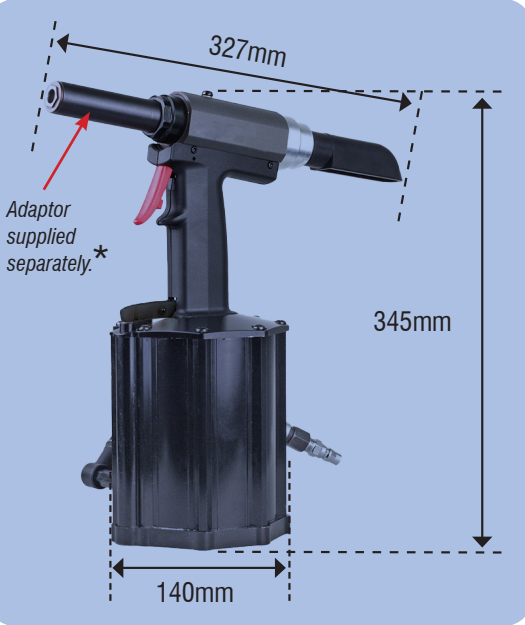
FOR PIN & COLLARS
3/16" (4.8mm) - 1/4" (6.4mm)



Main Specifications:

Air Supply: 5 bar ~ 7 bar
Traction Power: 28,000 N ~ 39,200 N
Stroke: 17mm
Net Weight: 2.90kg
(without nose set)

**Note: Tool is supplied as base unit only.
Nose sets and adaptors of various sizes can
be purchased separately (see chart below).
Please contact us for availability.*



TOOL NOSE SETS & CAPACITIES*

NOSE SETS	ADAPTOR	CAPACITIES	PAGE	SECTION
	A02046-00		6	A1
A02047-00	A02046-00	lockbolts C6 3/16"	7 - 9	A2
A02048-00	A02046-00	lockbolts C6 1/4"	7 - 9	A2
A02049-00	A02046-00	lockbolts MG 3/16"	7 - 9	A2
A02050-00	A02046-00	lockbolts MG 1/4"	7 - 9	A2
A02164-00	A02046-00	monobolt/interlok 3/16" – 1/4"	10 - 11	A3

Please refer to the Parts List in this manual to have a good understanding of the tool parts located in the tool or sets. The descriptions of the tool parts appear in this manual are in brackets with signal “#” and the parts position numbers corresponding to the tool exploded diagram (appendix A - Page 15).

SETTING UP THE TOOL

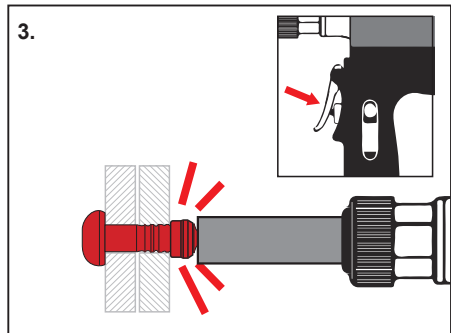
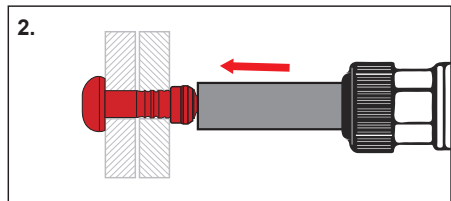
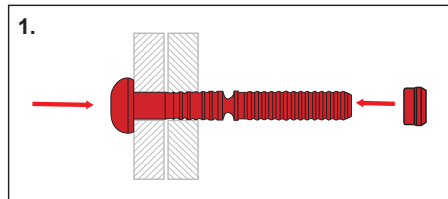
- 1) This pneumatic powered tool should be worked with compressed air supply. It is recommended to use the air hose with diameter bigger than 8 mm;
- 2) To check the compressed air pressure within the specified range between 5 bar and 7 bar, and to connect the air hose adaptor onto the tool air adaptor (#48). The air adaptor has 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 use and add on different NOSE SETS on the tool, see instructions in this manual;

SETTING A RIVET

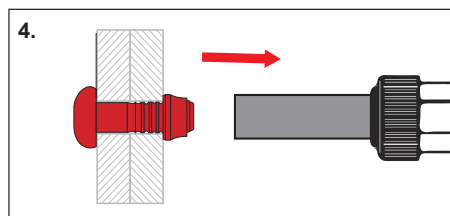
DO NOT exceed the tool's capacity when setting blind rivets.

Users of this tool should possess the necessary skills for operating air tools or undergo proper training.

After using the tool for a certain period, there may be a reduction in the tool's hydraulic oil, leading to a loss of power and stroke. Regularly check the tool's hydraulic oil levels and add oil as needed (see instructions in this manual).

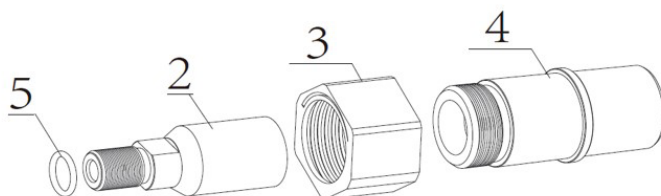


1. Place the pin into the hole and fit the collar onto it.
2. Insert the pin completely into the tool nose.
3. Press trigger until the pin breaks.
4. Broken pin will eject into the mandrel collector automatically or will be pushed through by the next pin inserted to be set.



HOW TO INSTAL ADAPTOR A02046-00 ON TOOL

Tool Adaptor set A02046-00



#5 – O-ring (P/N F00016-00)

#3 – locknut (P/N P03772-00)

#2 – inner sleeve (P/N P03773-00)

#4 – outer sleeve (P/N P03771-00)

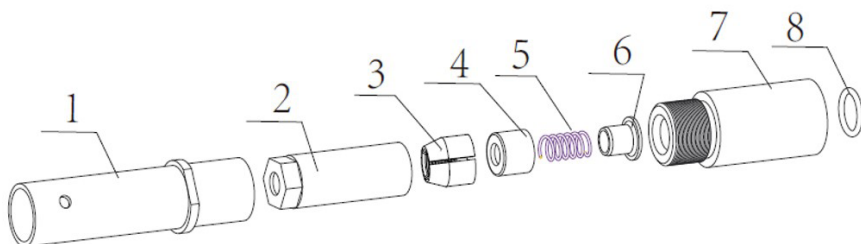
To install the adaptor on tool:

- 1) Put O-ring (#5) onto the groove of threads end of inner sleeve (#2), then install it on the assembly piston shaft (tool no. #17) of the tool;
- 2) Install outer sleeve (#4) onto the oil cylinder (tool no. #13) of the tool, then screw on the retaining ring (tool no. #6) of tool tightly on;
- 3) Screw on the locknut (#3) onto outer sleeve (#4);

HOW TO INSTAL NOSE SETS

A02047-00 / A02048-00 / A02049-00 / A02050-00 ON THE ADAPTOR A02046-00

A2



#1 – nose assembly;

#3 – jaw set;

#5 – pusher spring;

#7 – spring sleeve;

#2 – jaw case;

#4 – pusher;

#6 – spring seat;

#8 – O-ring;

To install noses:

- 1) Put jaw set (#3) into jaw case (#2), be sure the correct direction as shown as above illustration, and jaws seated fit;
- 2) Insert pusher spring (#5) into the pusher (#4), and put the spring seat into the pusher spring (#5);
- 3) Insert the pusher (#4) – pusher spring (#5) – spring seat (#6) assembled in last step into jaw case (#2) next to the jaw sets (#3) seated inside;
- 4) Install O-ring (#8) into the bottom of inner threads of spring sleeve (#7), and screw on with the part assembled at previous step;
- 5) Then screw the assembly above with spring sleeve (#7) end onto the installed adaptor A02046-00;
- 6) Unscrew off the locknut (adaptor #3) from the adaptor;
- 7) Screw the nose assembly (#1) on, then screw on the locknut (adaptor #3) back again on the adaptor firmly.

continued...

Nose Set **A02047-00** – for lockbolts C6 3/16"

ID-No	Parts	P/N
#1	nose assembly	A02062-00
#2	jaw case	P03790-00
#3	jaw set	P03791-00
#4	pusher	P03784-00
#5	pusher spring	P03785-00
#6	spring seat	P03786-00
#7	spring sleeve	P03780-00
#8	O-ring	F00202-00

Nose Set **A02048-00** – for lockbolts C6 1/4"

ID-No	Parts	P/N
#1	nose assembly	A02061-00
#2	jaw case	P03781-00
#3	jaw set	P03788-00
#4	pusher	P03784-00
#5	pusher spring	P03785-00
#6	spring seat	P03786-00
#7	spring sleeve	P03780-00
#8	O-ring	F00202-00

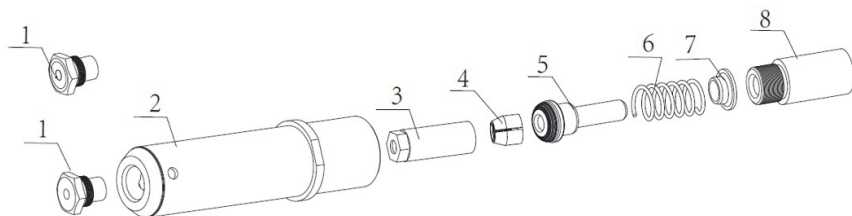
Nose Set **A02049-00** – for lockbolts MG 3/16"

ID-No	Parts	P/N
#1	nose assembly	A02105-00
#2	jaw case	P03790-00
#3	jaw set	P04061-00
#4	pusher	P03784-00
#5	pusher spring	P03785-00
#6	spring seat	P03786-00
#7	spring sleeve	P03780-00
#8	O-ring	F00202-00

Nose Set **A02050-00** – for lockbolts MG 1/4"

ID-No	Parts	P/N
#1	nose assembly	A02060-00
#2	jaw case	P03781-00
#3	jaw set	P03783-00
#4	pusher	P03784-00
#5	pusher spring	P03785-00
#6	spring seat	P03786-00
#7	spring sleeve	P03780-00
#8	O-ring	F00202-00

HOW TO INSTAL NOSE SET A02164-00 ON THE TOOL



#1 – nosepiece
#3 – jaw case;
#5 – pusher;
#7 – spring seat;

#2 – front sleeve;
#4 – jaw set;
#6 – pusher spring;
#8 – spring sleeve

To install the nose:

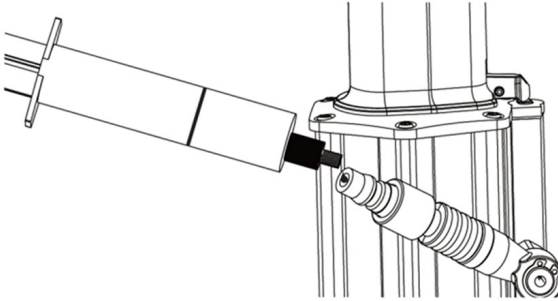
- 1) Put the jaw set (#4) into jaw case (#3), be sure the jaw set (#4) seated fit inside;
- 2) Put the pusher spring (#6) into pusher (#5), and spring seat (#7) into pusher spring (#6), then put them into the jaw case (#3) next to the jaw set (#4) inside, then install it on the assembly piston shaft (tool no. #17) of the tool;
- 3) Screw on the selected nosepiece (#1) or (#8) onto front sleeve (#2), then insert it into the assembly air cylinder (tool no. #13) of the tool;
- 4) Screw on tight the retaining ring (tool no. #6) of the tool.

A02164-00 for 3/16" - 1/4" Monobolt / Magnalok Nose Set:

ID-No.	PARTS	ART. CODES
#1	<i>1/4" magnalok concave nosepiece mark "L" hole 4.5mm</i>	P03758-00
#1	<i>1/4" monobolt protrude nosepiece mark "M" hole 4.2mm</i>	P04294-00
#1	<i>1.4" csk flat nosepiece mark "Q" hole 4.3mm</i>	P04337-00
#1	<i>3/16" magnalok concave nosepiece mark "J" hole 3.2mm</i>	P04474-00
#1	<i>3/16" monobolt protrude nosepiece mark "K" hole 3.1mm</i>	P04339-00
#1	<i>3/16" csk flat nosepiece mark "P" hole 3.3mm</i>	P04338-00
#2	<i>front sleeve</i>	P03759-00
#3	<i>jaw case</i>	P03768-00
#4	<i>jaw set</i>	P03767-00
#5	<i>pusher</i>	P03760-00
#6	<i>pusher spring</i>	P03769-00
#7	<i>spring seat</i>	P03770-00
#8	<i>spring sleeve</i>	P03761-00

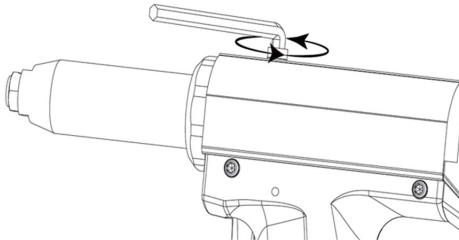
MAINTENANCE OF THE E640PC

Normally after several weeks of working, for better performance of the tool, add a few drops of hydraulic oil on the inlet of the air adaptor (#48) 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.

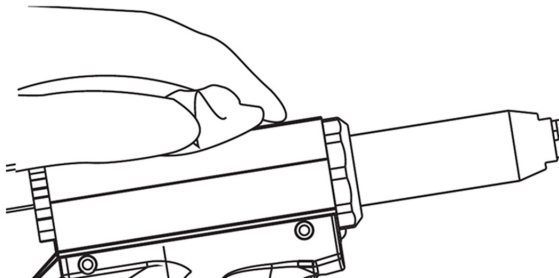


After a certain period of use, the tool's performance may decline, indicating the need to refill or change the hydraulic oil.

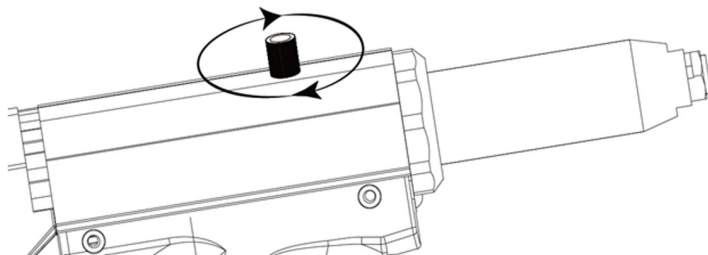
- 1) Remove the screw (#11) using a hexagon wrench



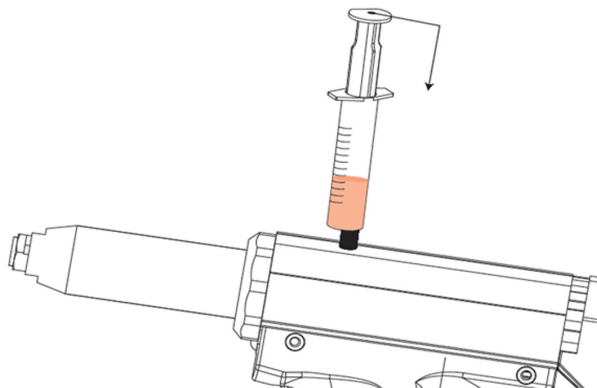
- 2) Connect the air supply and to cover some cloth over the hole where the screw (#11) was removed, then pull the trigger (#44) and the oil will leak out from the tool:



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- 3) Screw the oil inject adaptor (on oil injector set in the accessories pack) into the hole where screw (#11) was removed:

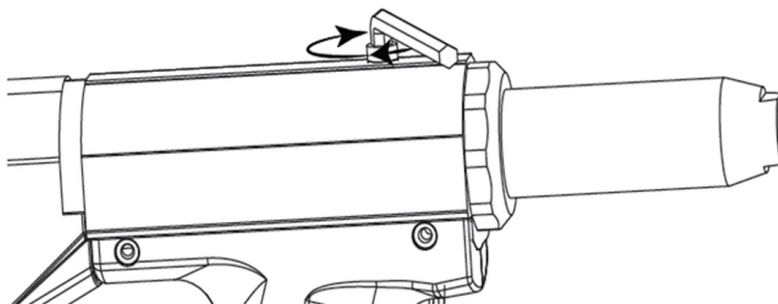


- 4) To use the oil injector (in the accessories pack) inject the oil slowly until not able to refill (approx. 15ml), remove the injector and its adaptor, then clean the oil on the tool and tightly screw on the screw (#11) back on to the tool:



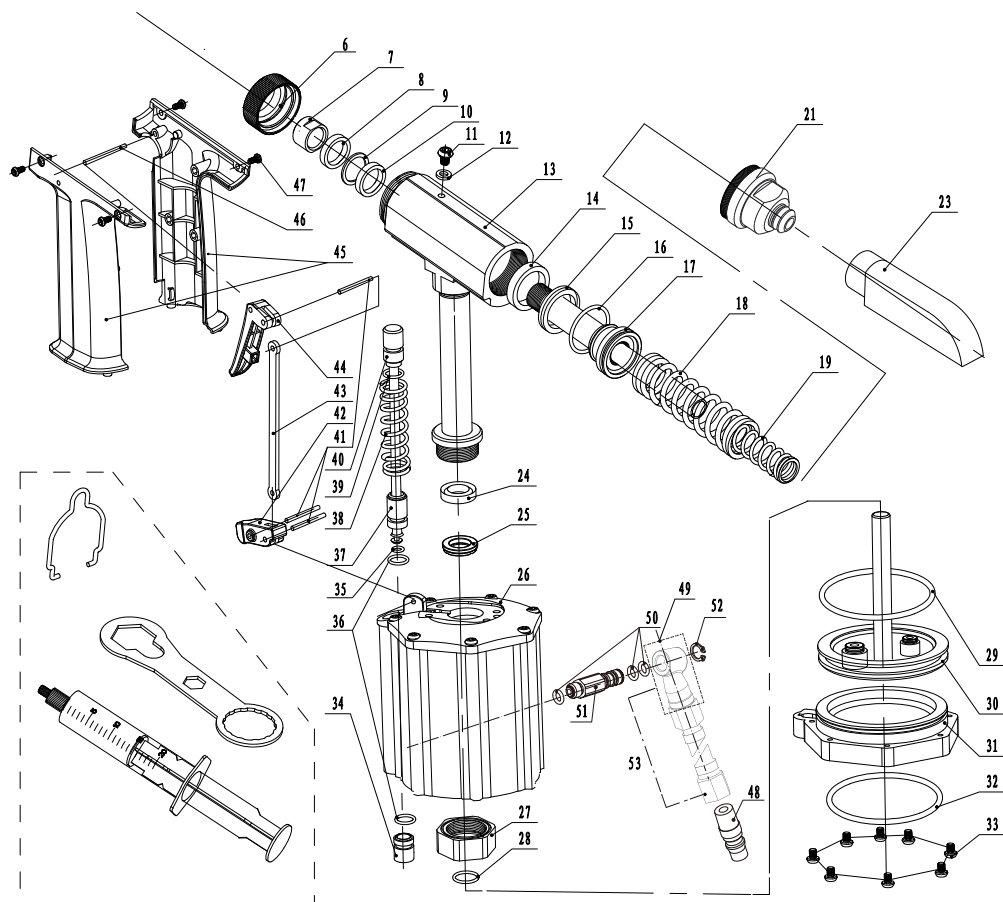
5) Test the tool stroke. If the stroke still not enough, it means there could be some air in the oil cylinder (#13) when you refilled the oil. The excess air needs to be released from the tool.

Connect the tool with air supply, pull the tool trigger (#44) 6 or 7 times, then loosen the screw (#11), let the extra air leaking out, then screw on the screw (#11) tight again:



After a certain period of use, it is possible that the metal chips from fasteners setting remains in the nose assembly of the tool and the tool efficiency will be reduced, therefore it is recommended to have the nose assembly parts cleaned or the parts changed periodically.

APPENDIX A: E640PC EXPLODED DIAGRAM





E640PC