

**TPR81H**  
**Instruction manual**

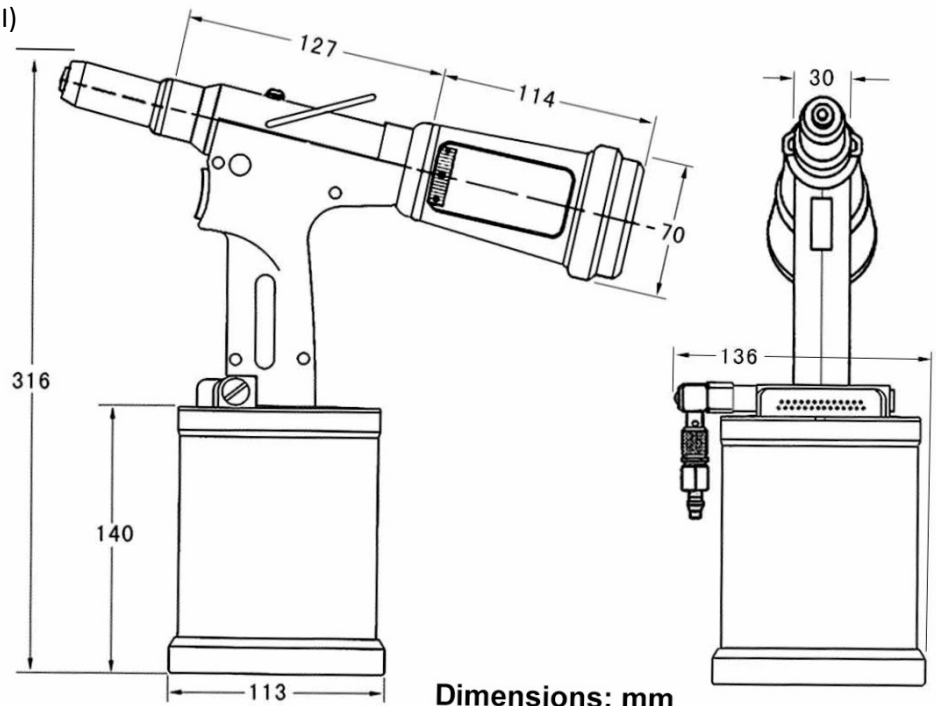


## Safety Instructions

- This instruction manual must be read by any person installing, operating or servicing this tool.
- Never dismantle the tool without first having thoroughly studied the instructions given in this user manual.
- Always use the tool in accordance with the specified safety instructions. Direct any queries regarding optimal and safe operation or use of the tool to our company.
- The safety instructions must be made clear to all persons involved.
- Never connect the tool to any medium other than compressed air. Set the air pressure between 72 and 102 pound/square inch (PSI).
- The tool must be maintained in a safe working condition at all times and examined at regular intervals by trained competent personnel. Do not dismantle this tool without prior reference to the maintenance and service instructions.
- Always disconnect the airline from the tool inlet before attempting to maintenance and service.
- Do not operate the tool that is directed towards any person or the operator.
- **CAUTION: When using the tool, the wearing of safety glasses is suggested, by the operator and others in the vicinity to protect against rivet stem ejection.**

## Specifications

- Riveting capacity: From 5/32" to 1/4"  $\varnothing$  all materials (4,0mm to 6,4mm  $\varnothing$  all materials)
- Pull: 3 420 lb
- Stroke: 1,02" (26mm)
- Air pressure: 90 lb/in<sup>2</sup> (90 PSI)
- Weight: 4,04 lb (1,83 kg)
- Sound level: < 75 dBA
- Vibration level: < 2,5 m/s<sup>2</sup>
- Warranty = 6 months



## **Air supply requirements**

The tool is operated with compressed air in the range of 5 to 7 bar (72 to 102 psi). We recommend the use of pressure regulators and filtering systems on the main air supply. These should be fitted within 3 meters of the tool to ensure maximum tool life and minimum tool maintenance.

Air supply hoses should have a minimum working pressure rating of 150% of the maximum pressure produced in the system or 10 bar (150 psi), whichever is the highest. Air hoses should be oil resistant, have an abrasion resistant exterior and should be armored where operating conditions may result in hoses being damaged. All air hoses must have a minimum bore diameter of 6.4 millimeters (1/4 inch).

## **Operation**

Determine the size rivet that you are going to use. To change the nosepiece, remove it from rivet tool using wrench included. Select the nosepiece that corresponds to the size rivet you are using and screw nosepiece clockwise onto the rivet tool head.

- 1) Attach air line to air supply.
- 2) Turn on the air valve by pushing the deflector ring up (See Figure 1)
- 3) Insert a blind rivet into nosepiece. Direct the riveter with rivet to the hole needed to be operated then pull the trigger. The stems automatically reverse to the collector and the work is done.

### **Caution:**

- The rivet will be held in place by the vacuum system. If rivet falls out of the nosepiece, vacuum is not strong enough. To increase volume of vacuum, turn the hex nut/vacuum adjuster nut clockwise. (See Figure 2). To turn it off, turn it counter clockwise.
- If operating without the nail collector, please wear goggles or turn off the vacuum.

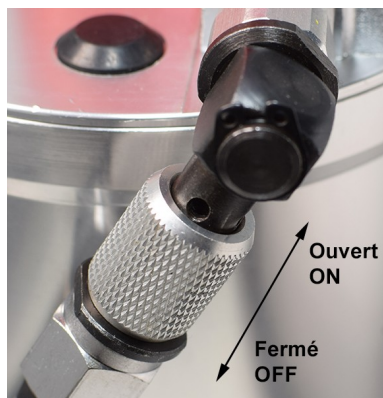


Figure 1



Figure 2

## Oiling

It is important that the tool be properly lubricated. Every 10,000 cycles the tool should be oiled with lubricating oil. There may be insufficient oil if the stroke of the tool is too small for proper installation. Without proper lubrication the tool will not work properly and parts will wear prematurely.

1. Keep the tool upright during all operations. Connect the tool to the air supply and turn the air valve by pushing the deflector ring up (Figure 1). Please note: don't press the trigger.
2. Unscrew the oil fill screw (See Figure 3) from the body using the Allen wrench included.
3. Fill the syringe (included) with hydraulic oil.
4. Screw the filled syringe in the oil fill screw hole (See Figure 4). Then slowly inject the oil into the tool (Make sure no air is injected.) Adequate oil has been added as soon as resistance is sensed. The excess oil will flow back when the syringe is released if more oil is added than necessary.
5. Unscrew and remove the syringe from the body.
6. Screw the oil fill screw into the hole using the Allen wrench.
7. Wipe off any excess oil.

To test oil level, press trigger two to three times. Insert rivet into nosepiece (use the largest diameter rivet that tool accepts). Check to see if rivet mandrel can be inserted completely into nosepiece – head of rivet must touch nosepiece. If rivet cannot be completely inserted into tool, too much oil has been added and some must be removed. To remove excess oil, unscrew oil fill screw approximately 1/4 turn. Once the tool is properly adjusted tighten the oil fill screw firmly with Allen wrench and wipe off any excess oil. When the oil fill screw is unscrewed, oil will seep from the chamber. After the rivet mandrel is full seated into the nosepiece, the oil level is then ready for operation.



Figure 3



Figure 4

## **Jaw cleaning**

Every 10,000 cycles the jaws of the tool should be cleaned and oiled. Disconnect the air supply. To access jaws, remove the head (See Figure 5) to expose the jaw case. To remove jaw case from pulling mechanism, use two wrenches (See Figure 6). Jaws will be under slight spring pressure from the jaw pusher. Separate the jaw case from pusher. Jaws will be loose. Clean jaws with a wire brush. Place a small dab of multi-purpose lithium grease on the outside of jaws (not serrated side). Return jaws into jaw case ensuring proper placement of jaws. All serrated faces should be touching each other.



Figure 5

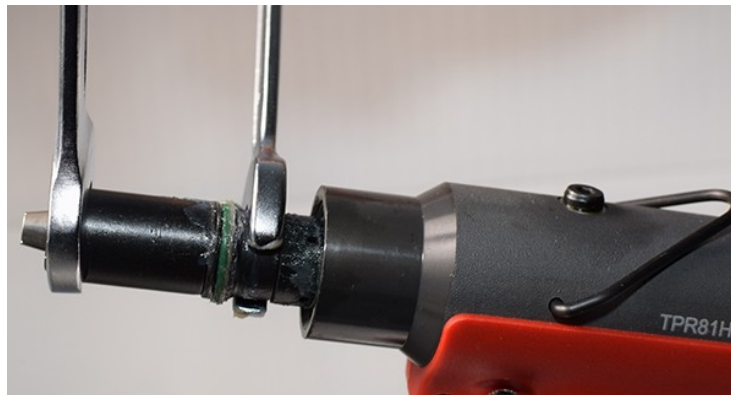
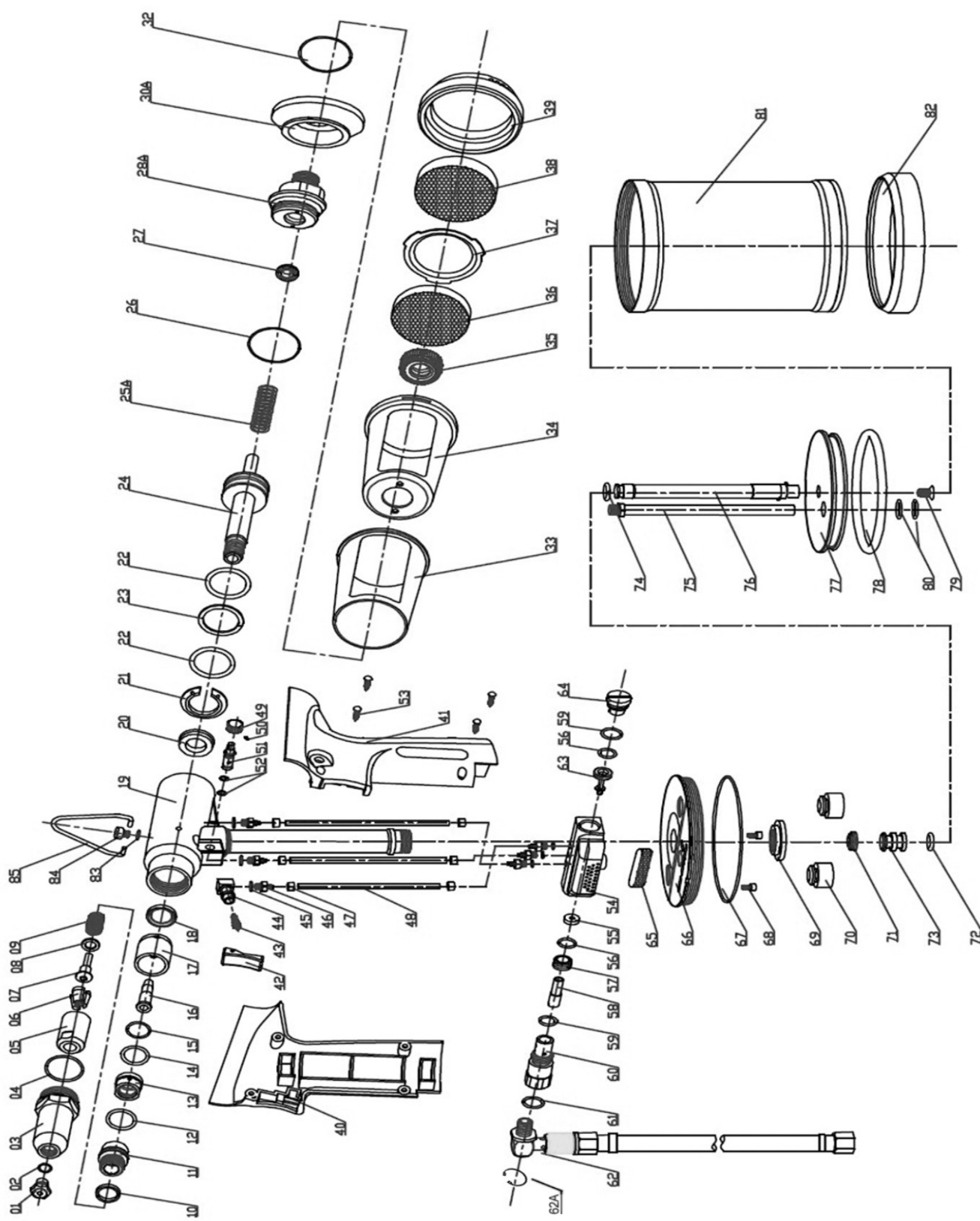


Figure 6



NO. DE LISTE	NUMÉRO DE PIÈCE	DESCRIPTION	ENGLISH
LIST NUMBER	PART NUMBER	FRANÇAISE	DESCRIPTION
1	1H1532	TETE DE PIÈCE 4.0 (5/32)	NOSEPIECE 4.0 (5/32)
1	1H1532A	TETE DE PIÈCE 4.0 (5/32) ALLONGEE	NOSEPIECE 4.0 (5/32) ELONGATED
1	1H1316	TETE DE PIÈCE 4.8 (3/16)	NOSEPIECE 4.8 (3/16)
1	1H1316A	TETE DE PIÈCE 4.8 (3/16) ALLONGEE	NOSEPIECE 4.8 (3/16) ELONGATED
1	1H114	TETE DE PIÈCE 6,4 (1/4)	NOSEPIECE 6.4 (1/4)
1	1H114A	TETE DE PIÈCE 6,4 (1/4) ALLONGEE	NOSEPIECE 6,4 (1/4) ELONGATED
1	1H114H	TETE DE PIÈCE 6,4 (1/4) POUR HEMTEC	NOSEPIECE 6,4 (1/4) FOR HEMTEC
1	1H1316M	TETE DE PIÈCE MONOBOLT 4.8 (3/16)	NOSEPIECE MONOBOLT 4,8 (3/16)
1	1H114M	TETE DE PIÈCE MONOBOLT 6,4 (1/4)	NOSEPIECE MONOBOLT 6,4 (1/4)
2	1H02	JOINT TORIQUE	O RING
3	1H03	CANON	HEAD
4	1H04	JOINT TORIQUE	O RING
5	1H05	CARTER DE MACHOIRES	JAW CASE
6	1H06	MACHOIRES, 3 PIÈCES	JAWS 3PCS
7	1H07	POUSOIR DE MACHOIRES	JAWS PUSHER
8	1H08	RONDELLE	WASHER
9	1H09	RESSORT	SPRING
10	1H10	BAGUE DE VERROUILLAGE	LOCK RING
11	1H11	UNION DU CARTER	FRONT HOUSING
12	1H12	BAGUE EN POLYURÉTHANE	POLYURETHANE RING
13	1H13	CONTRE-ÉCROU	SET NUT
14	1H14	BAGUE EN POLYURÉTHANE	POLYURETHANE RING
15	1H15	JOINT TORIQUE	O RING
16	1H16	TUBE DU VACUUM	VACUUM TUBE
17	1H17	BAGUE D'ÉTANCHÉITÉ EN PLASTIQUE	PLASTIC SEALING RING
18	1H18	BAGUE D'ÉTANCHÉITÉ	SEALING RING
19	1H19	ASSEMBLAGE DE LA TÊTE	HEAD ASSEMBLY
20	1H20	JOINT EN « V »	V-RING
21	1H21	ECROU DE RETENUE	RETAINING NUT
22	1H22	JOINT TORIQUE	O RING
23	1H23	JOINT EN « V »	V-RING
24	1H24	PLONGEUR HYDRAULIQUE	OIL PISTON
25A	1H25A	RESSORT	SPRING
26	1H26	JOINT TORIQUE	O RING
27	1H27	ESSUYEUR	LIP SEAL
28A	1H28A	EMBOUT	END CAP
30A	1H30A	ADAPTATEUR DU COLLECTEUR DE TIGE	STEM COLLECTOR ADAPTOR
32	1H32	JOINT TORIQUE	O RING
33	1H33	COLLECTEUR EXTÉRIEUR	COLLECTOR OUTER
34	1H34	CORPS DU COLLECTEUR	COLLECTOR BODY
35	1H35	CONTRE-ÉCROU	SET NUT
36	1H36	SILENCIEUX	SILENCER
37	1H37	JANTE	RIM
38	1H38	SILENCIEUX	SILENCER
39	1H39	EMBOUT	END CAP

NO. DE LISTE	NUMÉRO DE PIÈCE	DESCRIPTION	ENGLISH
LIST NUMBER	PART NUMBER	FRANÇAISE	DESCRIPTION
40/41	1H4041	POIGNÉE	HANDLE
42	1H42	GACHETTE	TRIGGER
43	1H43	VALVE DE LA GACHETTE	TRIGGER VALVE
44	1H44	BASE ON/OFF	ON/OFF BASE
45	1H45	JOINT TORIQUE	O RING
46	1H46	INTERFACE	INTERFACE
47	1H47	BAGUE	RING
48	1H48	TUYAU D'AIR	AIR TUBE
49	1H49	BOUTON DU VACUUM	VACUUM BUTTON
50	1H50	VIS DE RETENUE	RETAINING SCREW
51	1H51	SOUPAPE DU VACUUM	VACUUM VALVE
52	1H52	JOINT TORIQUE	O RING
53	1H53	VIS TARAUDEUSE	TAPPING SCREW
54	1H54	CORPS DE LA SOUPAPE D'AIR	AIR VALVE BODY
55	1H55	BAGUE DE LA SOUPAPE D'AIR	AIR VALVE RING
56	1H56	JOINT TORIQUE	O RING
57	1H57	BASE DE LA SOUPAPE D'AIR	AIR VALVE BASE
58	1H58	TUBE INFÉRIEUR	INFERIOR TUBE
59	1H59	JOINT TORIQUE	O RING
60	1H60	BASE DE CONNEXION	CONNECTING BASE
61	1H61	JOINT TORIQUE	O RING
62	1H62	ASSEMBLAGE ON/OFF	ON/OFF ASSEMBLY
62A	1H62A	BAGUE DE RETENUE	RETAINING RING
63	1H63	TIGE DE LA SOUPAPE	VALVE ROD
64	1H64	BOUCHON	SCREW PLUG
65	1H65	SILENCIEUX	SILENCER
66	1H66	COUVERCLE DU CYLINDRE	CYLINDER COVER
67	1H67	JOINT TORIQUE	O RING
68	1H68	VIS À TÊTE HEXAGONALE	HEX HEAD SCREW
69	1H69	ECROU BLOQUANTE	LOCK NUT
70	1H70	AMORTISSEUR	SHOCK ABSORBER
71	1H71	ESSUYEUR	LIP SEAL
72	1H72	JOINT TORIQUE	O RING
73	1H73	TUBE DU PISTON À AIR	AIR PISTON TUBE
74	1H74	SEGMENT DU PISTON	PISTON RING
75	1H75	TUBE DE TRANSFERT	TRANSFER TUBE
76	1H76	TIGE DU PISTON	PISTON ROD
77	1H77	PISTON	PISTON
78	1H78	JOINT TORIQUE	O RING
79	1H79	BOULON	BOLT
80	1H80	JOINT TORIQUE	O RING
81	1H81	CYLINDRE	CYLINDER
82	1H85	COUVERCLE DE LA BASE	BASE COVER
83	1H83	JOINT COLLÉ	BONDED SEAL
84	1H84	VIS DU RÉSERVOIR D'HUILE	OIL REFILL SCREW
85	1H85	CROCHET	HOOK