39070/IL-1

In-Line Air/Hydraulic Rivet Tool



GENERAL NOTES AND USE

The tool must be used for open end blind rivet diameters 3/32", 1/8". 5/32" and 3/16" only in all alloys. (aluminum, steel and stainless steel)
The *IL-1* oil / pneumatic system assures more power than comparable models. That means a reduction in the problems due to the wear and tear of the components, therefore, there will be an increase in reliability. The tool design adopted reduces the dimensions and the weight of the tool which makes it easy to use and gets the rivet into tighter and hard to reach areas.

SAFETY MEASURES AND REQUIREMENTS

All the operations must be done in conformity with the safety requirements, in order to avoid any consequence for your and other people's safety and to allow the tool to work the best way.

Safety glasses must be worn when operating the tool.

- Use equipment recommended in the maintenance chapter to do any maintenance and/or regulation of the tool.
- For topping up the oil, we suggest using only fluids in accordance with the features specified in this instruction sheet
- Repairing and cleaning operations must be done when the tool is disconnected from the air supplied source.
- If it is possible, we suggest hanging the tool from a safety balancer.
- Hearing protection is recommended when using tool
- Keep the tools in good conditions; do not remove either safety parts or silencers.

TECHNICAL DATA

•	Working pressure	6 BAR
	Min. int. diam. of the compressed air feeding hose	
•	Air consumption per cycle	1.8 Lt.
	Max power	
	Weight	
	Working temperature	

AIR FEED

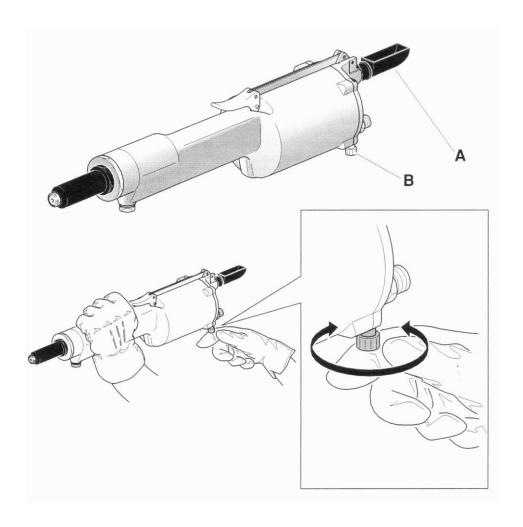
The air feed must be free from blockage and humidity in order to protect the tool from premature wear and tear of the components in movement. We recommend to use a filter / regulator / lubricating system for compressed air to achieve the best results.

HOW TO USE YOUR RIVETING TOOL

Select correct nosepiece for the rivet to be used. Place rivet in predrilled or punched hole. Squeeze trigger. After the rivet is upset, the sheared mandrel is drawn through by the riveting tool and is ejected from the back into the nail deviator (A).

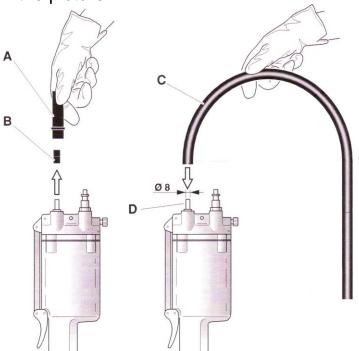
To activate the vacuum system or increase the suction turn the valve **(B)** counterclockwise. The advantage of this vacuum system allows the head of the riveting tool to be pointed vertically while holding the rivet in place. Do not hold the rivet with your fingers!

WARNING!! Do not remove the nail deviator (A) during the riveting operation, as the nail ejection from the back of the tool can cause injury to yourself or to others nearby.



If you want to convey the sheared nails into a container, remove the nail deviator (A) and its reducer (B) from the riveting tool. Connect a 5/16" hose (C) to the riveting tool introducing it into the union (D).

ATTENTION: the bending radius of the pipe should not be smaller than 12 inches and it should not be higher than 8 inches compared to the riveting tool, as shown in the picture.



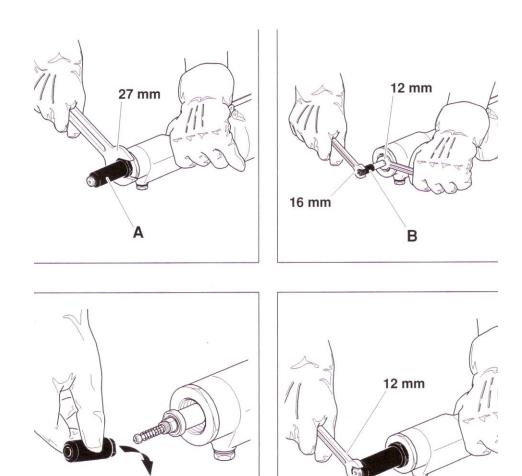
MAINTENANCE

WARNING!!! DISCONNECT AIR FEED WHEN PERFORMING THE FOLLOWING OPERATIONS!

The extended use of the tool can cause the slipping of the Jaws on the mandrel due to material build up into the grooves of the Jaw. Clean Jaw thoroughly with a wire brush to clean any debris in grooves. Apply a light coat of oil to the outside of the Jaws and reassemble.

However, if Jaws are worn out, replace them.

First remove the Frame Head which holds the nosepiece **(A)**, by means of a standard 1-1/16" wrench. Then, by using two wrenches of 11/16" (17mm) and 5/8" (16mm) remove the Jaw Case **(B)** and remove the Jaws **(C)**. When replacing the nosepiece **(D)**, we recommend to use the Wrench provided.

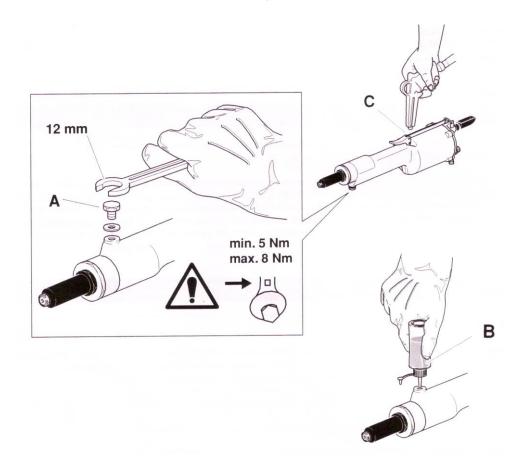


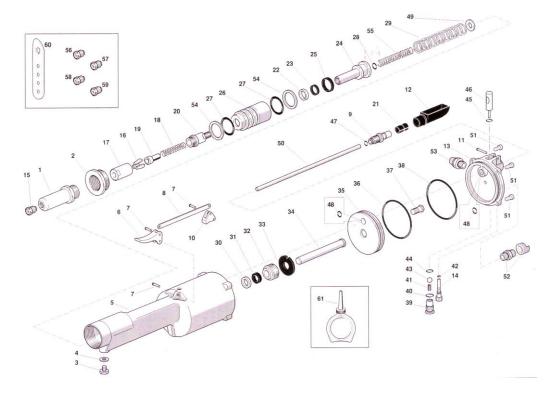
TOPPING OFF HYDRAULIC FLUID

WARNING!!! DISCONNECT AIR FEED WHEN PERFORMING THE FOLLOWING OPERATIONS

You need to top off the oil-dynamic circuit after a long period of work or a notice of some stroke loss. Proceed as follows: by means of a short jet of compressed air through hole (C) to make the piston completely go back. Unscrew the screw (A) with a 15/32" wrench, extract the seal and top off by means of the oil container (B) supplied with the tool (VISCOSITY 32°). This operation has to be carried out slowly in order to enable the air to come out of the tank. The procedure has been fulfilled when the oil level arrives at the threaded port. Then, fit the o-ring in it's seat and tighten the screw (A) with a torque of min. 5 Nm to max. 8 Nm. At this point, the topping off operation has been finished.

Screw the riveting tool head **(B)** again on the body **(A)** and continue with the normal work cycle. **WARNING:** it is very important to follow the about mentioned instructions and use gloves. If you need to empty fully the hydraulic circuit, you must put the oil in a suitable container and contact a Company that is authorized to discharge any waste.





Parts List for 39070 IL-1

Ref#	Item #		Qty	Description		Ref#	Item #	Qty	Description	
1	88056		1	Head Carrying Nozzle		32	712322	1	Ring nut	
2	712342		1	Ring nut		33	712321	1	Air Piston Stop	
3	710554		1	Cap	34		712320	1	Air Piston Rod	
4	710555		1	Washer Dowtry 400-004-4490		35 722319		1	Air Piston	
5	712341		1	Tool body		36	712318	1	Air Piston O'Ring	
6	712340	712340 1 Push Button 37 88004		88004	1	Screw Stem				
7	712337		3	Trigger Set Pin	38 712317		1	Cylinder Cap O'Ring		
8	712338	1 Trigger Rod		39	712316	1	Spring guide plug			
9	712334		1	Connector		40	88321	1	O Ring 2-12 P	
10	712339		1	Rod Holder		41	712315	1	Spring	
11	712335		1	Trigger Rod Set Pin		42	88023	1	Valve/Frame ORing (X3)	
12	712283		1	Guard		43	710377	1	Ball RB-8	
13	722333		1	Bottom		44	712314	1	O Ring 2-107	
14	712332		1	Vacuum adjustment knob		45	712313	1	O Ring 2-104	
15	88055		1	3/16" Nosepiece		46	712312	1	Piston	
16	88058		3	Jaws		47	710003	1	O Ring 5-052	
17	88057		1	Jaw Case		48	710002	2	O Ring 2-108	
18	88026		1	Jaw Pusher spring		49	712416	1	Washer 9.4x20x1.5	
19	88059		1	Jaw Pusher		50	712293	1	Vacuum Tube	
20	712331		1	Rear Jaw Case		51	710303	4	Screw TCE M5x16 UNI 5931	
21	712329		1	Reducer		52	88040	1	Milled nut connector 1/4	
22	712330		1	Piston guide		53	712343	1	Silencer 2 SEM 1/4" M	
23	88068		1	Stem Guide		54	88220-94	2	O-Ring Spacer 8-121	
24	712328		1	Piston		55	712327	1	Interior Spring	
25	88668		1	Gasket		56	717001	1	1/8" Nosepiece	
26	712326		1	Oil dynamic cylinder		57	717002	1	5/32" Nosepiece	
27	88210-12		2	O Ring 2-121 N552/90 P	58		717003	1	3/16" Nosepiece for Closed End Rivets	
28	716060		1	O Ring 2-10	59 717006		717006	1	3/32" Nos3piece	
29	712325		1	Exterior Spring		60 88220-78 1 Nosepiece Holder / Wrench		Nosepiece Holder / Wrench		
30	712324		1	Stem Guide		61 710969 1 Oil container		Oil container		
31	712315		1	Spring						