



# INSTRUCTIONS FOR: AIR/HYDRAULIC RIVETER Model: SA31

Thank you for purchasing a Sealey product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

**IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS & CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.**

## 1. SAFETY INSTRUCTIONS

- p **WARNING!** Ensure that Health & Safety, local authority and general workshop practice regulations are adhered to when using this equipment.
- 3 Familiarise yourself with the applications, limitations and potential hazards peculiar to the riveter.
- p **WARNING!** Disconnect the riveter from the air supply before changing accessories, servicing or performing any maintenance.
- 3 Maintain the riveter in good condition (use an authorised service agent).
- 3 Replace or repair damaged parts. *Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.*
- 3 Keep the work area clean, uncluttered and ensure that there is adequate lighting.
- 3 Keep the riveter clean for best and safest performance.
- p **WARNING!** Always wear approved eye or face protection when operating the riveter.
- 3 Maintain correct balance and footing. Ensure the floor is not slippery and wear non-slip shoes.
- 3 Remove ill fitting clothing. Remove ties, watches, rings and other loose jewellery and contain, and/or tie back, long hair.
- 3 Keep the riveter away from your body and at a safe distance from others.
- 3 Keep children and unauthorised persons away from the work area.
- 3 Secure unstable workpiece with a clamp, vice or other adequate holding device.
- 3 Ensure that spent rivet stems are disposed of correctly and do not cause a hazard.
- p **WARNING!** Ensure that the correct air pressure is maintained and not exceeded.
- 3 Keep air hose away from heat, oil and sharp edges. Check air hose for wear before each use and ensure that all connections are secure.
- 7 DO NOT use the riveter for any purpose other than that for which it is designed.
- 7 DO NOT use the riveter if the safety cap is not in place (see para. 4.4.).
- 7 DO NOT operate the riveter if any parts are damaged or missing and ensure that the safety cap (part 23) is correctly fitted.
- 7 DO NOT carry the riveter by the hose, or yank the hose from the air supply.
- 7 DO NOT get the riveter wet or use in damp or wet locations or areas where there is condensation.
- 7 DO NOT allow untrained persons to operate the riveter.
- 7 DO NOT point or fire the riveter at people or animals.
- 7 DO NOT operate the riveter when you are tired or under the influence of alcohol, drugs or intoxicating medication.
- 7 DO NOT direct air from the air hose at yourself or others.
- 3 When not in use disconnect from the air supply and store in a safe, dry, childproof area.

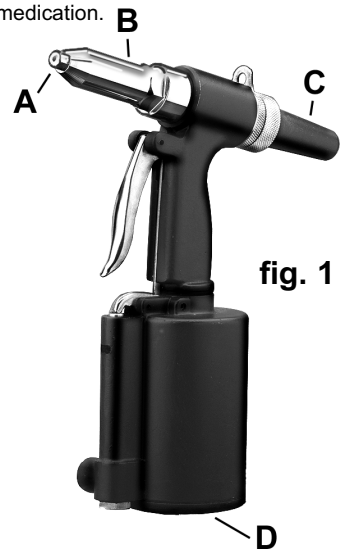


fig. 1

## 2. INTRODUCTION & SPECIFICATION

This heavy duty riveter is suitable for both aluminium and steel rivets up to 3/16" diameter. Supplied with four riveting nozzles and two spanners. Trigger operated, with hardened steel jaw assembly and rivet stem safety cap. The riveter is suitable for heavy assembly work.

Nozzle Sizes . . . . .	3/32" (2.4mm), 1/8" (3.2mm) 5/32" (4.0mm), 3/16" (4.8mm)
Air Consumption . . . . .	4.2cfm
Operating Pressure . . . . .	90psi
Air Inlet . . . . .	1/4" BSP
Weight . . . . .	1.3kg

## 3. AIR SUPPLY

The recommended air system is shown in fig. 2.

- 3.1. Ensure that the trigger is in the "Off" position before connecting to the air supply.
- 3.2. Ensure that the air pressure (90psi) is set correctly.
- 3.3. p **WARNING!** Ensure that the air supply is clean and does not exceed 90psi. Too high an air pressure and/or unclean air will shorten the life of the riveter due to accelerated wear, and may cause damage and/or personal injury.
- 3.4. Drain the air tank daily. Water in the air line will damage the riveter.
- 3.5. Clean the compressor air inlet filter screen weekly.
- 3.6. Line pressure should be increased to compensate for unusually long air hoses (over 8 metres). The minimum hose bore should be 10mm and fittings must have the same inside dimensions.
- 3.7. Keep hoses away from heat, oil and sharp edges.  
Check hoses for wear, and make certain that all connections are secure.

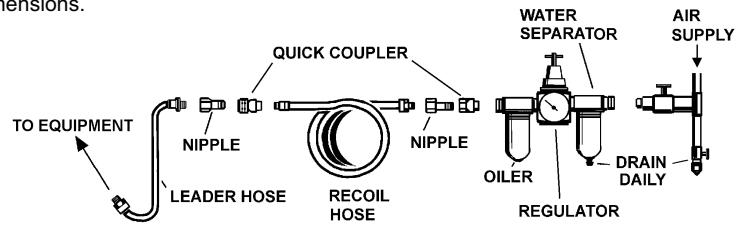


fig. 2

## 4. ADJUSTMENTS & OPERATION

**WARNING!** Ensure you read, understand and apply the Section 1 safety instructions. This tool is designed for riveting metal, primarily in workshops and garages. We do not recommend any other use.

### 4.1. Hydraulic oil level:

- 4.1.1. Disconnect the riveter from the air line.
- 4.1.2. Hold upside-down and remove the air cylinder cap (fig. 1.D) with the spanner provided.
- 4.1.3. Remove the air/hydraulic piston assembly (grip exposed nut and pull).
- 4.1.4. Add hydraulic oil to hydraulic cylinder until level is just below junction with air cylinder, see fig. 3.
- 4.1.5. Lightly lubricate the inner wall of the air cylinder.
- 4.1.6. Replace the air/hydraulic piston assembly and press in as far as it will go.
- 4.1.7. Refit and tighten the air cylinder cap.

### 4.2. Adjusting the stroke:

- 4.2.1. Check that the hydraulic level is correct (see para. 4.1.).
- 4.2.2. Remove the frame head (fig. 1.B) using the spanner provided.
- 4.2.3. Check the jaw stroke by using the supplied spanner/gauge as in fig. 4.
- 4.2.4. If necessary, adjust the stroke as follows:
  - 1) Hold the rear jaw case (fig. 4.2) with the larger spanner and loosen the lock nut (fig. 4.1) with the spanner/gauge.
  - 2) Adjust the stroke by rotating the jaw case assembly and tighten the lock nut when adjustment is complete.
- 4.2.5. Refit the frame head.

### 4.3. Changing jaws:

- 4.3.1. Disconnect the tool from the air line.
- 4.3.2. Remove the frame head (fig. 1.B) using the spanner provided.
- 4.3.3. Use both spanners to unscrew the front jaw case (fig. 4.3) from the rear jaw case (fig. 4.2).
- 4.3.4. Remove the jaws (fig. 4.4) and clean with solvent and brush. If the teeth are blunted, replace with new jaws.
- 4.3.5. Reverse the above procedure to reassemble.

### 4.4. Operation:

- 4.4.1. **DANGER!** Always fit the safety cap (fig. 1.C) to the rear of the frame before use to prevent injury from ejected rivet stems. Fit with the slot facing downwards so that stems fall to the floor.
- 4.4.2. Select the nosepiece (fig. 1.A) to suit the rivet size and fit to the frame head using the spanner provided.
- 4.4.3. Insert the rivet stem fully through the nosepiece and thus into the jaws.
- 4.4.4. Press the rivet body through the pre-drilled hole and hold with the rivet flange flush on the workpiece.
- 4.4.5. Squeeze the trigger. The rivet will be compressed and the rivet stem will be ejected into the safety cap.

fig. 3

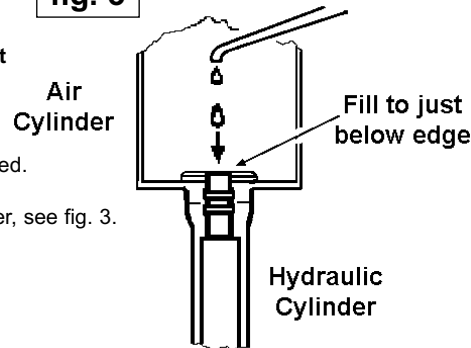
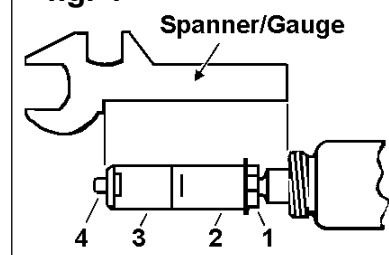


fig. 4



## 5. MAINTENANCE

**WARNING!** Ensure you disconnect the tool from the air supply system before attempting any service or maintenance.

- 5.1. Maintain the tool with care. Keep it oiled for optimum performance.
- 5.2. Lubricate the air tool daily with a high quality air tool oil (Sealey No. ATO/500 or ATO/1000) either via an oiler in the air supply system or by placing a few drops into the riveter air inlet immediately before use.
- 5.3. Store the tool in a safe, dry, secure environment.
- 5.4. Factors that may inhibit performance:
 

Loss of power or erratic action may be caused by reduced compressor output, an excessive drain on the air line, moisture or restrictions in air pipes or the use of hose connections of incorrect size. Grit or gum deposits in the tool may cut power and can be corrected by flushing out the tool with gum solvent oil or an equivalent de-greaser. If all external conditions are in order, disconnect the tool from the air supply, disassemble and replace any worn or damaged parts with Sealey original parts. Clean all parts, reassemble and lubricate. Alternatively, take the tool to your nearest authorised service agent.

**Declaration of Conformity** We, the sole importer into the UK, declare that the product listed below is in conformity with the following standards and directives.

**Air Riveter Model SA31**

98/37/EC Machinery Directive  
93/68/EEC Marking Directive



The construction file for this product is held by the Manufacturer and may be inspected, by a national authority, upon request to Jack Sealey Ltd.

Signed by Mark Sweetman

23rd November 2001

For Jack Sealey Ltd. Sole importer into the UK of Sealey Power Tools.

**NOTE:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.

**IMPORTANT:** No liability is accepted for incorrect use of this product.

**WARRANTY:** Guarantee is 12 months from purchase date, proof of which will be required for any claim.

**INFORMATION:** For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name, address and postcode.

**SEALEY POWER TOOLS**

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