

OPERATING INSTRUCTIONS

Riveting machine PUN-1



Riveting machine PUN-1

Serial number

Manufacturing date

MANUFACTURER

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The manufacturer reserves the right to introduce changes to improve the operation of the device without the need to amend this manual.

DESCRIPTION

Pneumatic device for riveting of brake linings type PUN-1 (bellow named: riveter PUN-1) is designed to riveting of truck brake linings by tubular rivets (steel, brass or copper) or solid rivets (aluminum).

Working parts of the device are moved by a pneumatic actuator controlled by pedal.

Parts of the device shown in figure 1.

TECHNICAL DATA

Stroke of working plunger	28 mm
Air supply	7 to 10 bar
Working pressure	4 to 7 bar
Seat of anvil	moved
Range of working temperature	0°C to 40°C
Overall dimension	675x550x200 mm
Weight	60 kg

EQUIPMENT

Solid aluminium rivets header	1 pce.
Tubular rivets header diam. 5 mm	1 pce.
Tubular rivets header diam. 6 mm	1 pce.
Tubular rivets header diam. 8 mm	1 pce.
Tubular rivets header diam. 10 mm	1 pce.
Tubular rivets driver diam. 5 mm	1 pce.
Tubular rivets driver diam. 6 mm	1 pce.
Tubular rivets driver diam. 8 mm	1 pce.
Tubular rivets driver diam. 10 mm	1 pce.
Anvil of rivets diam. 5 and 6 mm	1 pce.
Anvil of rivets diam. 8 mm	1 pce.
Anvil of rivets diam. 10 mm	1 pce.
Anvil of driver	1 pce.
Stand of tools	1 pce.

driver = drive pin punch

PRINCIPAL RULES OF SAFETY

Riveter PUN-1 should be operated only by personnel specially trained and authorized.

Riveter PUN-1 is intended for riveting and unriveting the brake linings only - it is forbidden to use the machine for other purpose.

The manufacturer is not liable for any losses arising from the introduction of the machine changes without consultation with the manufacturer.

The operator of riveter should use protection work clothes, hat, glasses, gloves and shoes with non-slip soles.

Around the machine should be removed objects that could be a threat during operation. Operator should also keep in mind about removing from the floor a worn rivets.

Control pedal of riveter should be placed on a non-slip surface.
After the finished work, operator should disconnect the air supply.

INSTALLATION

The pneumatic diagram of the riveter shown in figure 2.

The riveter should be set on the top of table (high approx. 1 m) and fixed to its 4 pcs screws M10. Also, the table should be fixed to the floor, to prevent it from tipping.

Riveter should be connected to the compressed air through the shut-off valve, see Fig. 2.

Compressed air must be connected to the fitting marked "P", on the rear of the body of the riveter. Connection hose with quick fitting Ø10 and shut-off valve is not delivered in standard equipment.

Set the pressure operation at ca. 6 bar. Pressure regulator is located on a side wall of the body.

OPERATING

Pressing the pedal moves the plunger down, releasing the pedal cause its return to initial position.

After inserting tools (header or driver) in toolholder, it must be blocked by set screw (item.15 Fig. 3).

Distance between anvil and tool (header or driver) can be regulated according to total thickness a connected elements (see Fig.3.). Mentioned distance can be adjusted by unscrewing/screwing the sleeve (4) and blocking it by the nut (5).

During unriveting, the anvil of driver set in such position that removed rivets will not fall on the floor.

OPERATING GUIDELINES

Each every three months, the grease should be supplemented in places between rotational parts by grease nipples or superficially.

Working plunger is displaced in a self-lubricating bushes - the parts does not require lubrication.

WARRANTY

All repairs and regulations should be made by the manufacturer during the warranty period. The user can make small repairs after determining its by manufacturer service.

List of principal elements of riveter (Figures 1 and 3):

1. Body
2. Working plunger
3. Pocket of anvils / deflected /
4. Sleeve /rotated/
5. Blocking nut
6. Washer
7. Protection hood
8. Air cylinder
9. Regulator of pressure
10. Control pedal
11. Air hoses
12. Quick fitting Ø10
13. Catch
14. Link mechanism
15. Blocking nut
16. Bumper

Riveting machine PUN-1

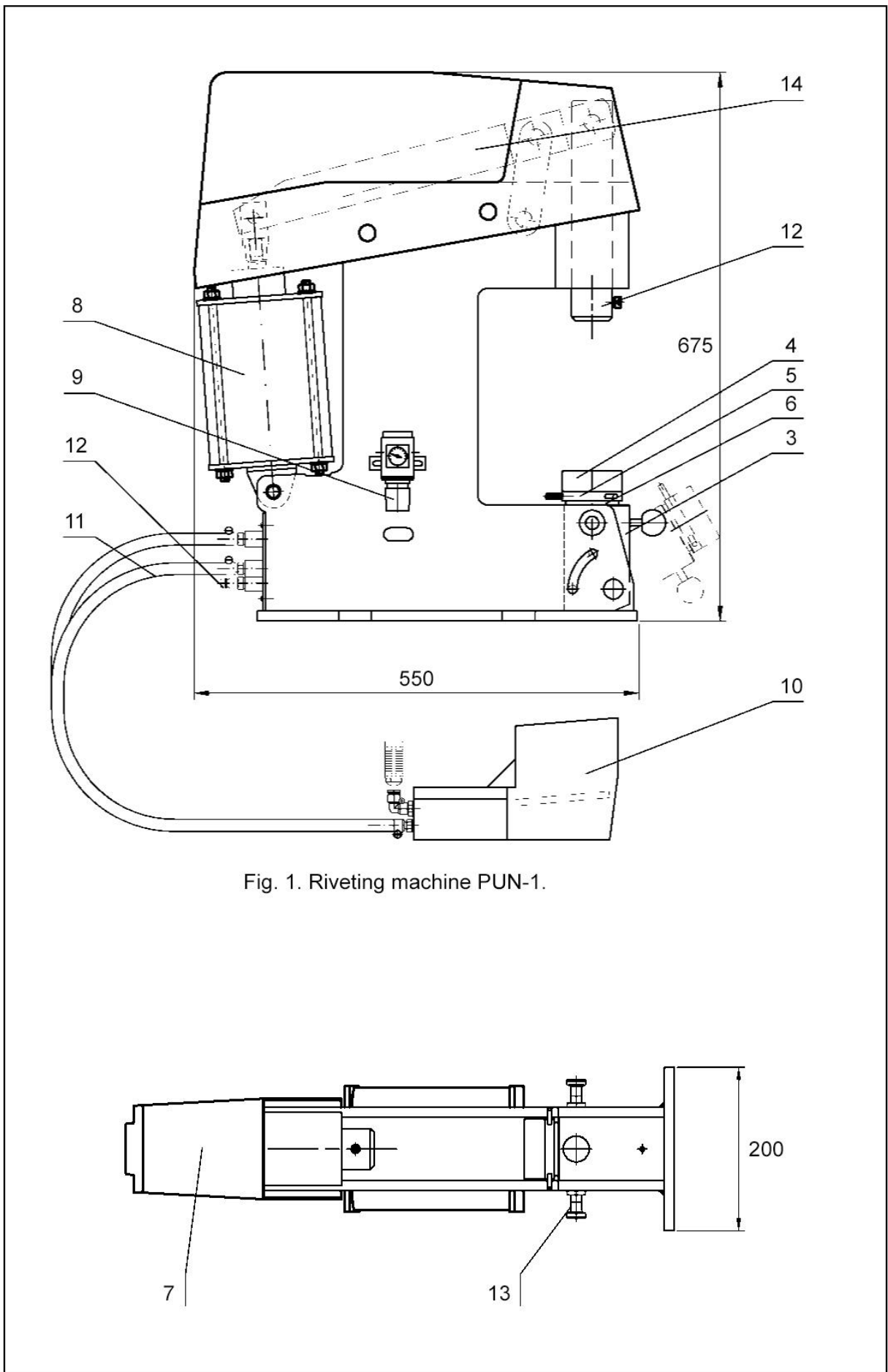


Fig. 1. Riveting machine PUN-1.

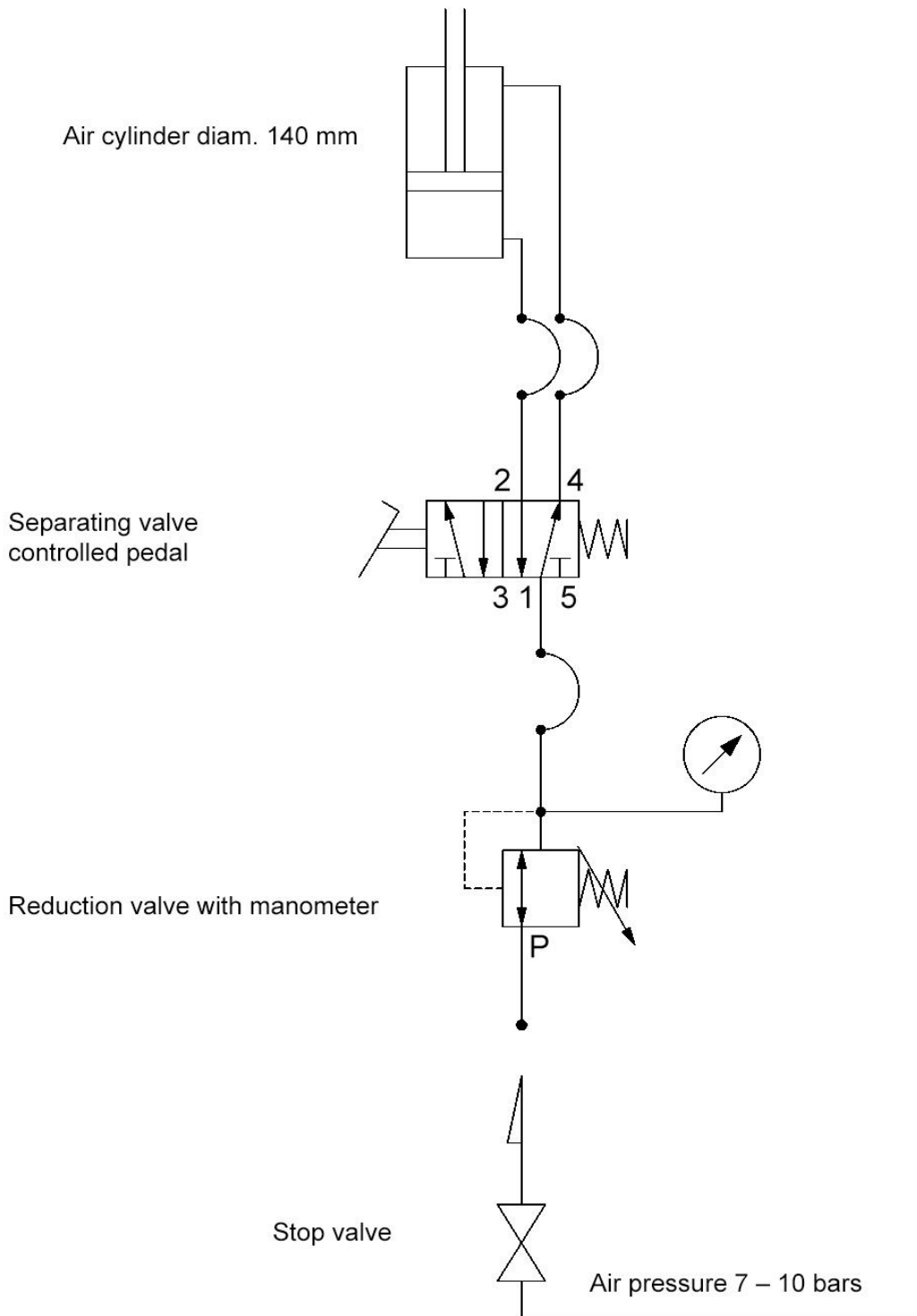


Fig. 2. Pneumatic diagram.

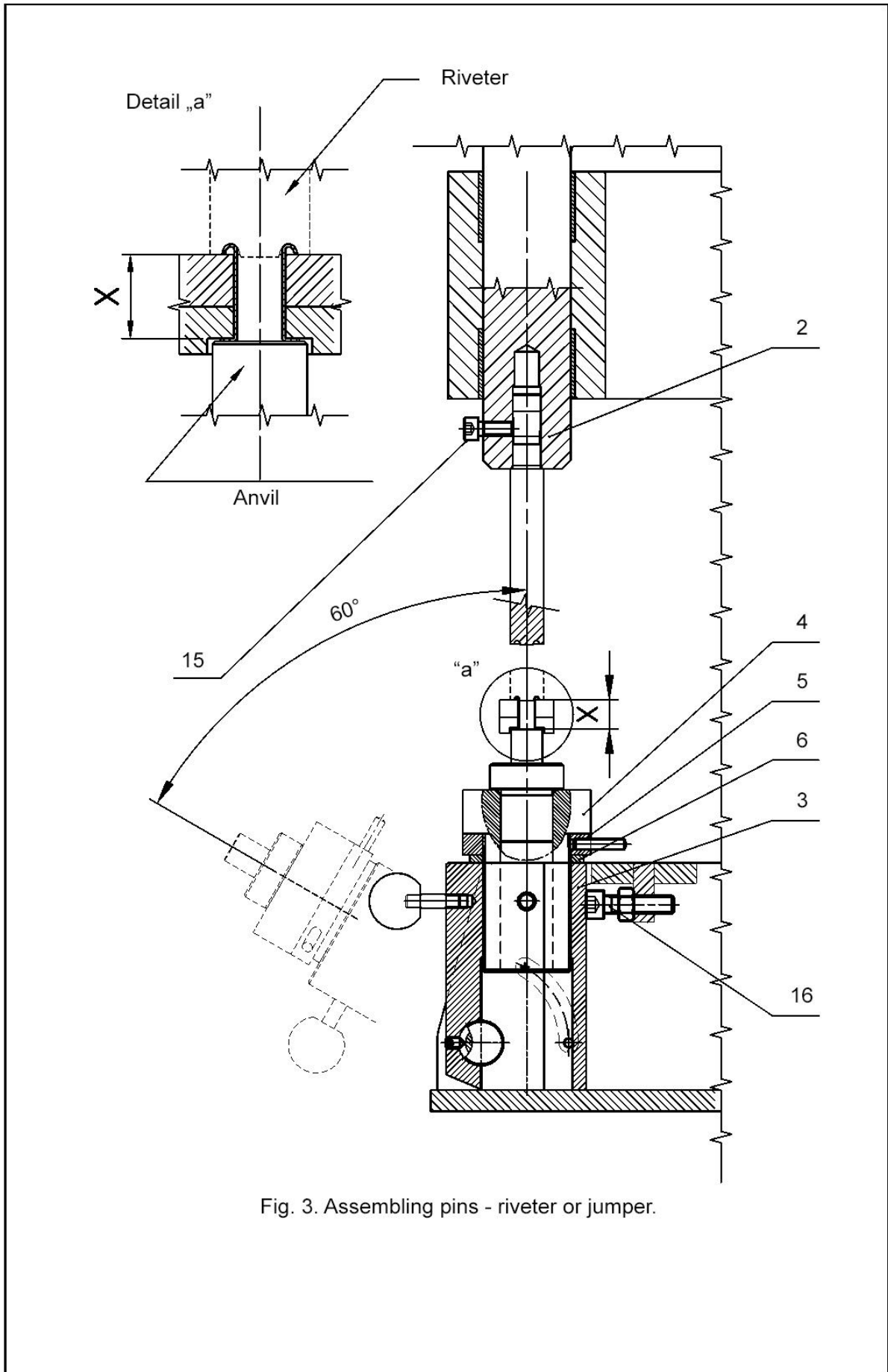


Fig. 3. Assembling pins - riveter or jumper.

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EC Declaration of Conformity

in accordance with directive 2014/68/EU

We :

Uni-trol Co. Ltd.

Ul. Estrady 56

01-932 Warsaw

Poland

declare, under our exclusive responsibility, that the product

PNEUMATIC DEVICE FOR RIVETING OF BRAKE LININGS

Type : PUN-1

Serial number

and its pressure components to which this declaration applies have been designed and manufactured and checked in relation to the applicable essential requirements and relevant conformity assessment procedures of the directive:

- **directive 2014/68/EU** (pressure equipment).

The pressure components of the device: safety valve, has been assessed by their manufacturers in terms of the requirements of the above-mentioned directives and confirmed by declarations of conformity, which are also attachment to the product.

In order to verification of compliance with the applicable legal regulations have been consulted the harmonized standards and other normative documents:

PN-EN ISO 4414:2011E

Pneumatic fluid power - General rules and safety requirements for systems and their components

EN ISO 4126-1:2013

Safety devices for protection against excessive pressure — Part 1: Safety valves

PN-EN ISO 11201:2012P

Acoustics. Noise emitted by machinery and equipment. Determination of emission sound pressure levels at a work station and at other specified positions in an essentially free field over a reflecting plane with negligible environmental corrections

PN-EN ISO 11202:2012P

Acoustics -- Noise emitted by machinery and equipment -- Determination of emission sound pressure levels at a work station and at other specified positions applying approximate environmental corrections

PN-EN ISO 4871:2012P

Acoustics -- Declaration and verification of noise emission values of machinery and equipment

Riveting machine PUN-1

The technical documentation of this device, referred to in point 1 of Annex VII A of the Machinery Directive, is located in the headquarters Uni-trol Ltd. (address as above) and will be made available to the competent national authorities for at least 10 years after the last piece.

The person responsible for the preparation of the technical documentation of the product and introducing changes in it, is MSc. Gregory Tworek .

This EC Declaration of Conformity will be kept by the manufacturer of the product for 10 years from the date of produce the last unit and will available for market supervisory authorities for verification.

MSc. Gregory Tworek

Warsaw, 30.10.2019

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Signature