



***"Ergonomic Solutions"***

**HTO P-51CR, DR RIVETERS**



**MADE IN THE USA**

**Honsa Ergonomic Technologies, Inc.**

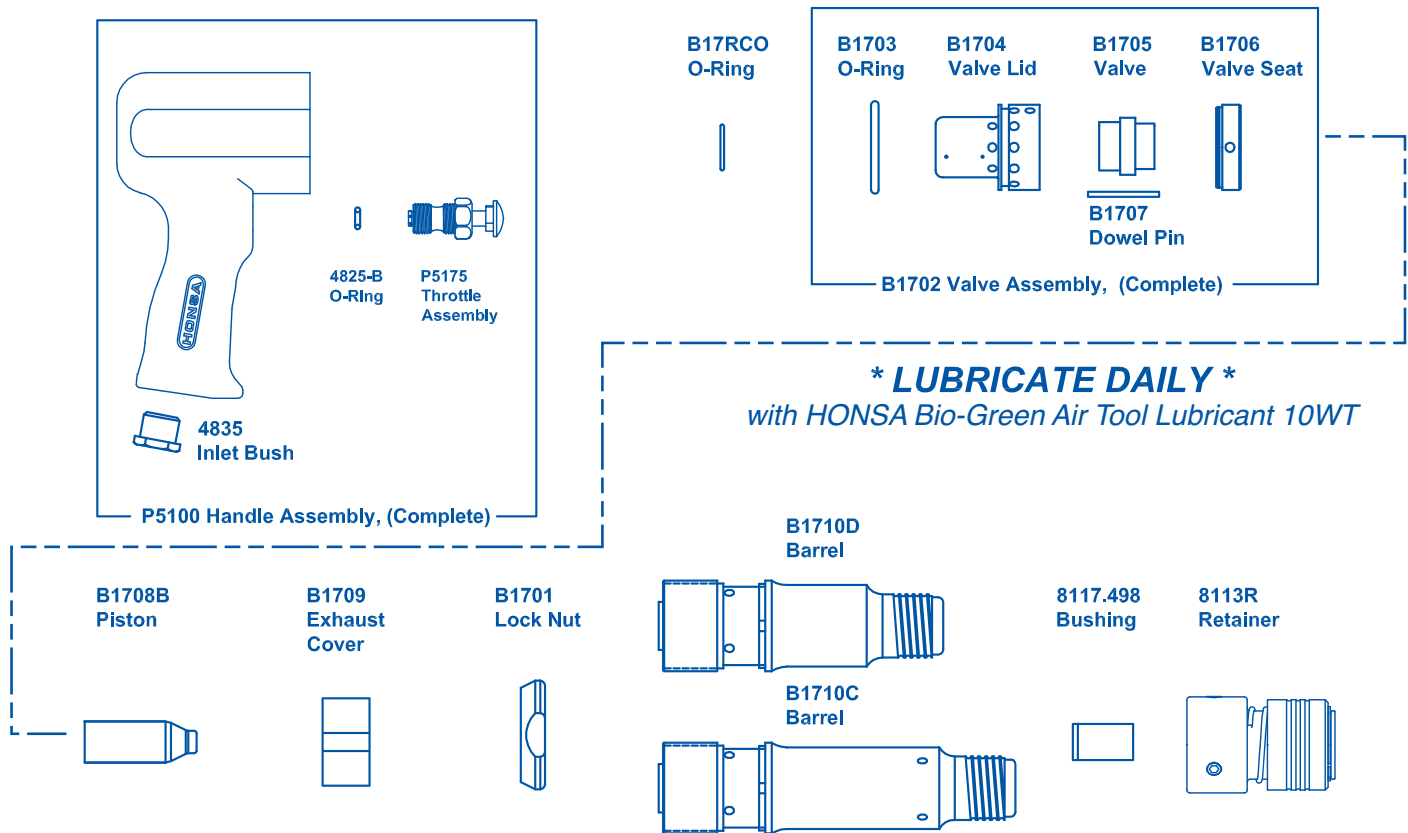
***Made in the U.S.A.***

1300 11th Street West | Milan, IL 61264 | Tel: 309.756.0200 | Fax: 309.756.0700 | Toll Free 800.800.9371 | [www.honsatools.com](http://www.honsatools.com)

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## HTO P-51CR & HTO P-51DR RIVETERS



**\* LUBRICATE DAILY \***  
with HONSA Bio-Green Air Tool Lubricant 10WT

## MAINTENANCE PROCEDURES FOR HONSA TOOLS HTO P-51CR & HTO P-51DR RIVETERS

### DISASSEMBLY

1. Disconnect air supply from tool. Remove chisel from nose end of tool.
2. Place handle into vise jaw protectors (P-51 VISE). Place jaw protectors in vise. Loosen lock ring, and loosen barrel.
3. Inspect all parts for wear and/or damage. Replace as necessary. Clean and flush all parts, lightly oil, and reassemble as directed above.

**USE OF OTHER THAN HONSA REPLACEMENT PARTS  
MAY DECREASE PERFORMANCE, INCREASE MAINTENANCE  
AND MAY VOID WARRANTY.**

### ASSEMBLY

1. Install lock ring onto threaded portion of barrel. Install exhaust cover onto barrel. Stand barrel on nose end.
2. Assemble valve assembly by lining up the indentations on the valve cases. Insert piston into barrel. Place valve assembly on barrel, ensuring that the indentations on the valve assembly align with the indentation on the barrel.
3. Slide handle onto barrel and valve assembly until threads come into contact with each other. Screw barrel into the handle with the handle in the upright position. Hand tighten barrel into handle, oil, and run tool to insure proper operation.
4. Place handle into vise jaw protectors (P-51 VISE). Place jaw protectors in vise. Tighten barrel firmly. Using a 1/2" drive torque wrench and crowfoot head (B171916), tighten barrel to 145 ft lbs.
5. Using a 1/2" drive torque wrench and crowfoot head (B172116), tighten lock ring to 130 ft lbs.
6. After 24 hours of operation, re-tighten barrel.

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rev 01/2020

## HONSA TOOL OPERATING INSTRUCTIONS/CAUTIONS

### **-BEFORE PLACING THIS TOOL IN OPERATION, READ THE FOLLOWING INSTRUCTIONS-**

This new tool is designed to reduce the vibration normally transmitted to the Operator. To be effective, it must be used safely. The Operator should only hold the tool by the handle provided. The vibration damping system is built into this handle, so the Operator should not hold this tool by the barrel, chisel, or rivet set. If the operation requires holding a chisel or rivet set, a HONSA TOOLS ISOLATOR should be utilized on that portion of the tool.

**WARNING:** While this tool is designed to significantly reduce the vibration, it is not guaranteed, nor implied to totally remove vibration. Safety procedures and evaluation systems such as those recommended and described in ANSI s3.34, ISO 5349 & ISO 8662 and by the ACGIH for threshold limits of vibration should be used as guidelines for daily exposure of hand-arm vibration. These values should be used as guides for the control of hand-arm exposure and because of individual susceptibility, should not be regarded as defining a boundary between safe and dangerous levels.

### **THE FOLLOWING SAFETY PROCEDURES ARE RECOMMENDED BY THE COMPRESSED AIR AND GAS INSTITUTE:**

1. Eye protection **must** be worn at all times when operating power tools.
2. Ear protection **must** be worn at all times when operating power tools.
3. A retainer should be installed on a percussion tool which, without such a retainer, can eject the chisel or rivet set, punch or similar equipment, when the tool is operated off a work surface. **NEVER OPERATE TOOL WITHOUT A RETAINER OR WHEEL GUARD.**
4. If a Quick Disconnect coupling is used on a percussion tool, it should be separated from the tool with a whip hose.
5. A percussion tool should not be operated unless the chisel, rivet set, scaling tool, or other is in position in the tool and in contact with the work place. Tools should be used in such a manner that ejection of an accessory **will not** endanger adjacent personnel.
6. When percussion tools are not in use, the dies and accessories should be removed unless they are retained in a positive manner.

### **PROPER OPERATION AND MAINTENANCE**

Daily before using, before putting a new or old tool into service and after eight hours of use, pour about one tablespoon of HONSA Bio-Green Air Tool Lubricant 10WT into air inlet, connect air hose and operate tool to allow oil to be carried throughout the interior.

Never operate the tool without a chisel, rivet set, or plunger in the set sleeve and without holding the tool against the work surface. This precaution avoids damage caused by the piston striking the cylinder/barrel retaining wall. When a rivet set, chisel, or plunger is in the set sleeve, the end protrudes beyond the retaining wall so that the piston never strikes the retaining wall, resulting a freezing piston in the cylinder/barrel.

1. Keep tool properly lubricated with HONSA Bio-Green Air Tool Lubricant 10WT.
2. Provide 90 PSIG (6.2 bar) of clean, dry air **AT THE TOOL**.
3. Set up and maintain an inspection and repair program, regularly scheduled at intervals, governed by the degree of use to which the tool is subjected.
4. Blow out any dust and debris from inside hose before connecting it to tool.
5. Ensure that the cylinder/barrel is completely tight in the handle assembly.
6. Replacement of worn minor parts will avoid more extensive repairs and maintain the tool at its highest efficiency.



## **WARRANTY**

Honsa Tools warrants this tool to be free of defects in materials and original workmanship for **1 year from date of purchase. The obligation assumed under this guarantee is limited to the replacing of any part or parts which prove to our satisfaction, under examination, to have been defective. This guarantee does not cover damage caused by misuse or normal wear, dirt or debris.**

Honsa Tools makes no other warranty, and implied warranties for fitness for a particular use or purpose are hereby disclaimed. Honsa Tools' liability is limited to the purchase price of the tool and Honsa tools shall not be liable for consequential, indirect or special damages of any nature arising from the sale or use of Honsa tools.

The warranty shall not apply to any tool that has been subjected to: misuse, accident, negligence or modification; or in which parts not made and supplied by Honsa Tools have been used, altered or repaired by other than Honsa Tools personnel or authorized repair/maintenance companies, or in the determination of Honsa Tools, any non intended use affecting its' operation.

## **Factory Service**

Any tool being returned for service must be pre-approved and a return authorization number must be issued for each tool by approved Honsa Tools personnel.

All Honsa Tools must be sent prepaid to:

**Honsa Ergonomic Technologies, Inc.  
1300 11<sup>th</sup> Street West  
Milan, IL 61264**

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