



***"Ergonomic Solutions"***

**HTP 2X(WT), 3X(WT), 4X(WT) RIVETER**



**MADE IN THE USA**

**Honsa Ergonomic Technologies, Inc.**

*Made in the U.S.A.*

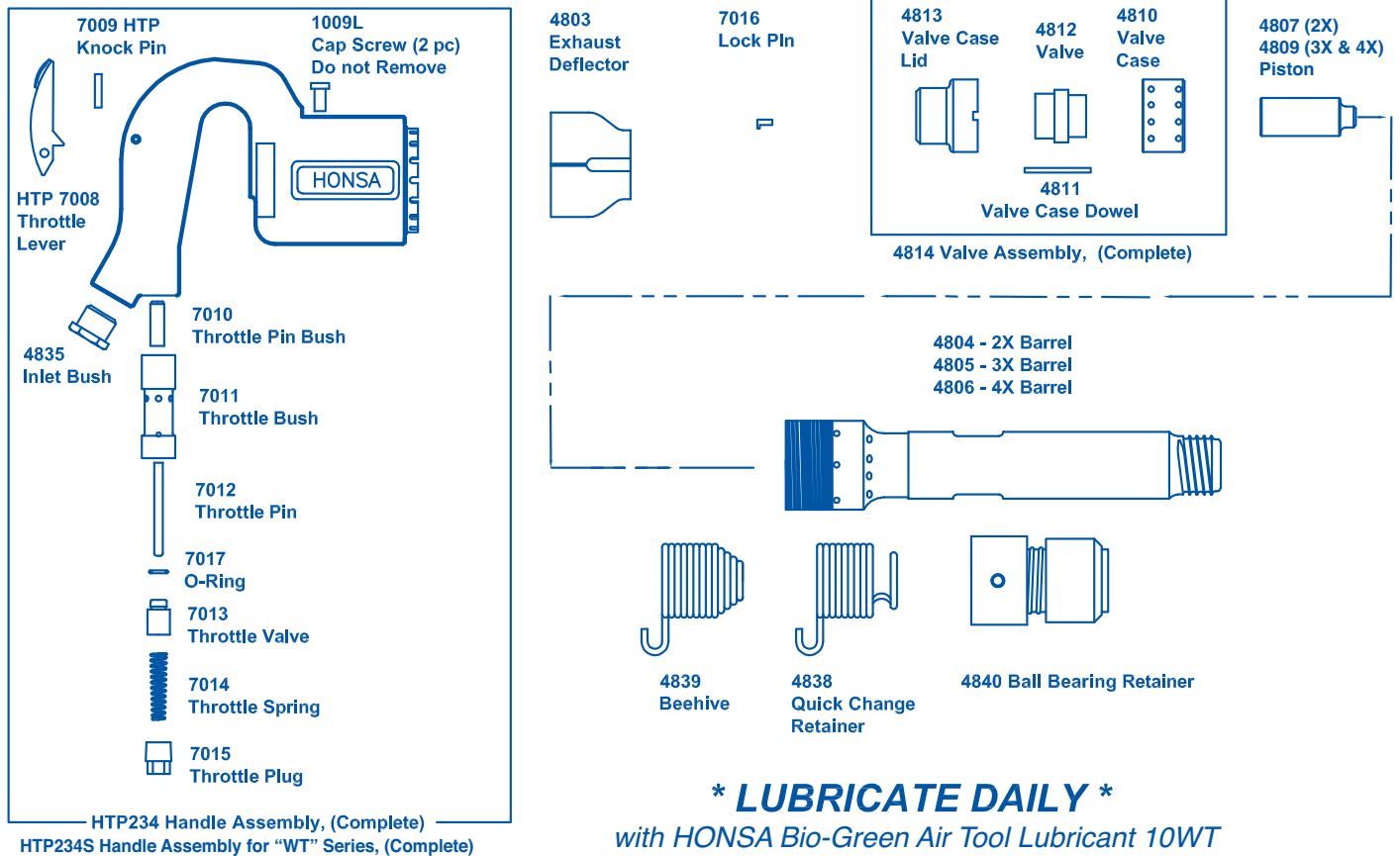
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## HTP 2X(WT), 3X(WT), 4X(WT) RIVETER



## MAINTENANCE PROCEDURES FOR HONSA TOOLS HTP 2X(WT), 3X(WT), 4X(WT) RIVETERS

### TO ASSEMBLE TOOL

1. Remove original handle/backhead, if installing a retro-fit handle, otherwise proceed to step 2 to remove barrel from Honsa hammer for maintenance.
2. Before installation or removal of any barrel, the socket head cap screws must be in both holes in the handle housing. **These screws are installed by the manufacturer and should permanently remain in place.** If missing, **DO NOT PROCEED** as permanent damage may result to the urethane during the tightening or loosening. **FAILURE TO USE PROPER PARTS VOIDS WARRANTY.**
3. Hand tighten barrel into Honsa handle, oil and run tool for 5 seconds to ensure proper valve operation.
4. Place handle flats against vise jaws and tighten with barrel pointing up. (Use vise jaw protectors if possible). Using a 1/2" drive torque wrench, tighten barrel to minimum 120 ft lbs, ensuring that lock pin hole is aligned with a slot in the receiver cup. (During maintenance should an overtightened barrel not loosen after normal attempts, place entire tool in a freezer overnight and attempt to loosen while frozen. Do not use a torch to loosen barrel. Should barrel not break free after frozen, contact manufacturer for further information.)
5. Position lock pin to slot. (Wrench barrel to precise lock slot position if needed), install exhaust deflector with 90° to 180° from lock pin. Remove from vise.
6. After 24 hours of operation, re-tighten barrel.

### TO DISASSEMBLE TOOL

1. Disconnect air supply from tool. Remove chisel from nose end of tool.
2. Before installation or removal of any barrel, the socket head cap screws must be in both holes in the handle housing. **These screws are installed by the manufacturer and should permanently remain in place.** If missing, **DO NOT PROCEED** as permanent damage may result to the urethane during the tightening or loosening. **FAILURE TO USE PROPER PARTS VOIDS WARRANTY.**
3. Place handle into vise, ensuring that the flats on either side of the handle are in contact with the vise jaws. Remove exhaust deflector, and lock pin. Loosen barrel (use vise jaw protectors if possible).
4. 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.**

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## 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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