

**Cleco**<sup>®</sup>  
Production Tools

Instruction Manual  
PL30-F4-PT  
2018-04

**F4-PT-RT-B**  
Riveter / Hammer



For additional product information visit our website at <http://www.ClecoTools.com>

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**Manufacturer**

Apex Tool Group, LLC  
670 Industrial Drive  
Lexington, South Carolina 29072  
USA

**Importer**

Apex Tool Group GmbH  
Industriestraße 1  
73463 Westhausen  
Germany

## Notes on this Hardware-Description

The original language of this description is English. This description is intended for all persons who will operate and maintain this equipment.

## Safety

### General requirements

- Keep this document in a safe place for future use! These safety instructions must be accessible to the operator at all times. They must be shown and made available to all people involved in the use of the tool.
- The operator must understand the Safety Instructions and the Installation, Operation, and Adjustment procedures provided in the Instruction Manual. These Safety Instructions are not intended to be all inclusive. Study and comply with all applicable Federal, State and Local Regulations. Contact your local distributor for assistance. Apex Tool Group, LLC is not the manufacturer or supplier of the cutting tools used with this product. Comply with all safety instructions provided by the manufacturer of the cutting tools.
- Always disconnect the tool from the air hose before adjusting or repairing.
- Immediately shut off the tool in the case of unusual sound or vibration. Disconnect the tool from the air hose. Have a qualified person check the tool and repair before using.
- When unpacking this tool, closely check for shipping damages and accuracy of the shipping documentation.
- Do not modify the tool, any guard or accessory unless approved in writing by Apex Tool Group, LLC.
- Implement and follow a comprehensive Safety Maintenance Program to provide inspection and maintenance of all phases of tool operation and air supply equipment.
- Do not operate any percussion tool unless the chisel, scaling tool, rivet set or other implement is in the tool and in contact with the work piece or work surface. Failure to do so can cause damage to the tool and/or serious injury.

### Noise and Vibration

Refer to CE-1017TD for noise and vibration test results.

### Intended use

This percussion tool is to be used for removing material with appropriate cutting devices. Do not modify this tool. All safety devices must be properly assembled and in working condition.

If there is any doubt regarding the safe operation of this product, consult Apex Tool Group, LLC before using.

Only use the product under the following conditions:

- under the prescribed environmental conditions
- with the permissible air pressure
- using clean air

Do not use the tool...

- as a hammer
- in hazardous area. When operating a percussion tool in an explosive or flammable environment, use only non-sparking cutting tools (example: made of beryllium copper).
- higher than rated air pressure

### Operator training

Main criteria for target group selection is the fact, whether the operator, based on his level of training and knowledge, is able to recognize possible risks and avoid hazards which can occur during production use and maintenance of machinery.

### Personal protective equipment (PPE)

Risk of injury by being wound up in and caught by machinery

- Do not wear loose clothing, jewelry or rings. Injury may result from being caught in tools.
- Avoid direct skin contact with lubricants, grease or adhesives.



→ Eye protection must be worn all times during the operation or maintenance of this tool.



→ Ear protection must be worn all times during the operation or maintenance of this tool.



→ Wear gloves when required.

## Warnings and notes

Warning notes are identified by a signal word and a pictogram:

- The signal word describes the severity and the probability of the impending danger.
- The pictogram describes the type of danger.

**CAUTION!** A symbol combined with the word **CAUTION** indicates a hazard with a **low level** of risk which, if not avoided, could result in minor or moderate injuries or environmental damage.



**WARNING!** A symbol combined with the word **WARNING** indicates a hazard with a **medium level** of risk which, if not avoided, could result in death or serious injury.



**DANGER!** A symbol combined with the word **DANGER** indicates a hazard with a **high level** of risk which, if not avoided, will result in death or serious injury.



**ATTENTION!**

This sign warns of a possibly damaging situation.

Failure to observe this note may cause the product or parts thereof to be damaged.



**General notes**

include application tips and useful information but no hazard warnings.

## Symbols on the product

Be sure that you understand their meaning before operation



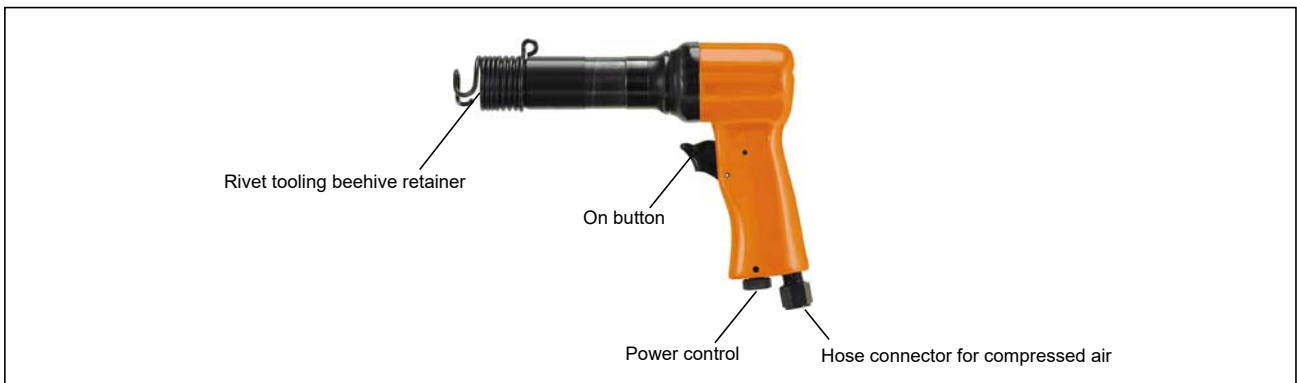
CE compliant

The product corresponds to the prescribed technical requirements in Europe.



Read all instructions.

## Product Description



## Technical Data

Model no.	Length		Weight		Piston Stroke		Blows per minute	Throttle Handle	Bore		For use with Rivet Set Shank Diameter		Air Inlet (NPT)
	In.	mm	lbs.	kg	In.	mm			In.	mm	In.	mm	
F4-PT-RT-B	8.8	223	3.3	1.5	4	102	1,700	Lever	.56	14	.401	10.2	1/4"


## Ambient conditions


Ambient temperature	-13 °F to +104 °F (-25 °C to +40 °C)
Humidity	0 to 80 % (at +40 °C), not with dew
Working height	up to 3000 m above sea level

## Air Line


Parameter	Description
Air Hose	Minimum inside diameter of 1/4" (6,35 mm) Maximum length 8.0' (2,4 m)
Working pressure	Performance rated at: 90 psi (620 kPa)
Compressed air	Air quality according to ISO 8573-1, quality class 2.4.3. The compressed air must be clean and dry.

## Operating Instructions

**CAUTION!** Shock by reaction of impact  
 → Firmly grasp the handle before starting.  
 Be prepared for high short-term impacts.

**CAUTION!** Moving parts, throw out of parts  
 → Disconnect air supply before installing or replacing chisel / rivet bit.

The Cleco Production Tools "F" series riveters are designed to operate on 90 psi air pressure using a 1/4" I.D. hose up to 8' in length.

**CAUTION!**  
 The handle should be checked after the first eight hours of operation and occasionally thereafter to make sure it is tight.

### Air Line Lubrication

Part No.	Packaged	Designation
540397	1 Quar (0,94 liter)	Airlube 10W/NR-420LB DR
533485	1 US Gallon (3,78 liter)	

## INSTALLATION AND OPERATION

Only qualified and trained personnel should install, adjust or use this equipment.

- Connect the tool to an airline with a maximum pressure of 6.2 bar (90 psi).
- Adjust the airline lubrication to a minimum to reduce possible contamination of the environment by the exhaust air. The work area must be well ventilated.
- Inspect the air hose and fittings thoroughly.
- Do not use damaged, frayed or deteriorated hoses. A hose rupture can cause serious injury.
- Keep the tool clean and dry to provide the best possible grip. The tool should be held in such a way to be safe and comfortable.
- Do not lay the tool down until the cutting device has stopped. Stop the tool before moving to a different location.

## Service Instructions

### SPEED CHECK

- Check the tool speed regularly with a tachometer to assure it does not exceed the rated speed marked on the tool at 6.2 bar. Check with every 20 hours of use or

weekly. Remove the abrasive before checking.

- Carefully observe the maximum speed recommended for the cutting device. This speed must be greater than the rated speed of the tool.

### CUTTING DEVICE INSPECTION

- Inspect the cutting device before using. Make sure there are no chips, cracks or other visual damage.

### PROPER MOUNTING

- Disconnect the air supply from the tool before mounting or changing the cutting device.
- Consult and comply with the mounting safety instructions of the cutting device manufacturer.

### GUARDS

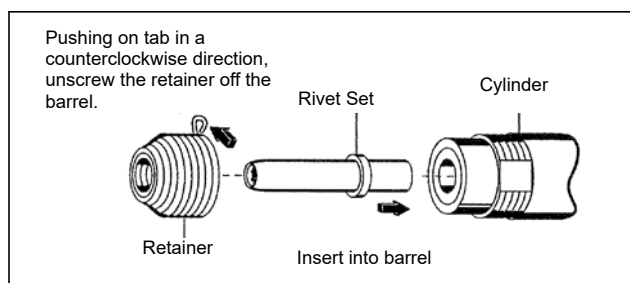
- Always use prescribed guards, properly mounted for the cutting device being used. If the guard has been damaged, it must be discarded and replaced. Do not alter the guard in any manner.

### MAINTENANCE, ASSEMBLY & DISASSEMBLY

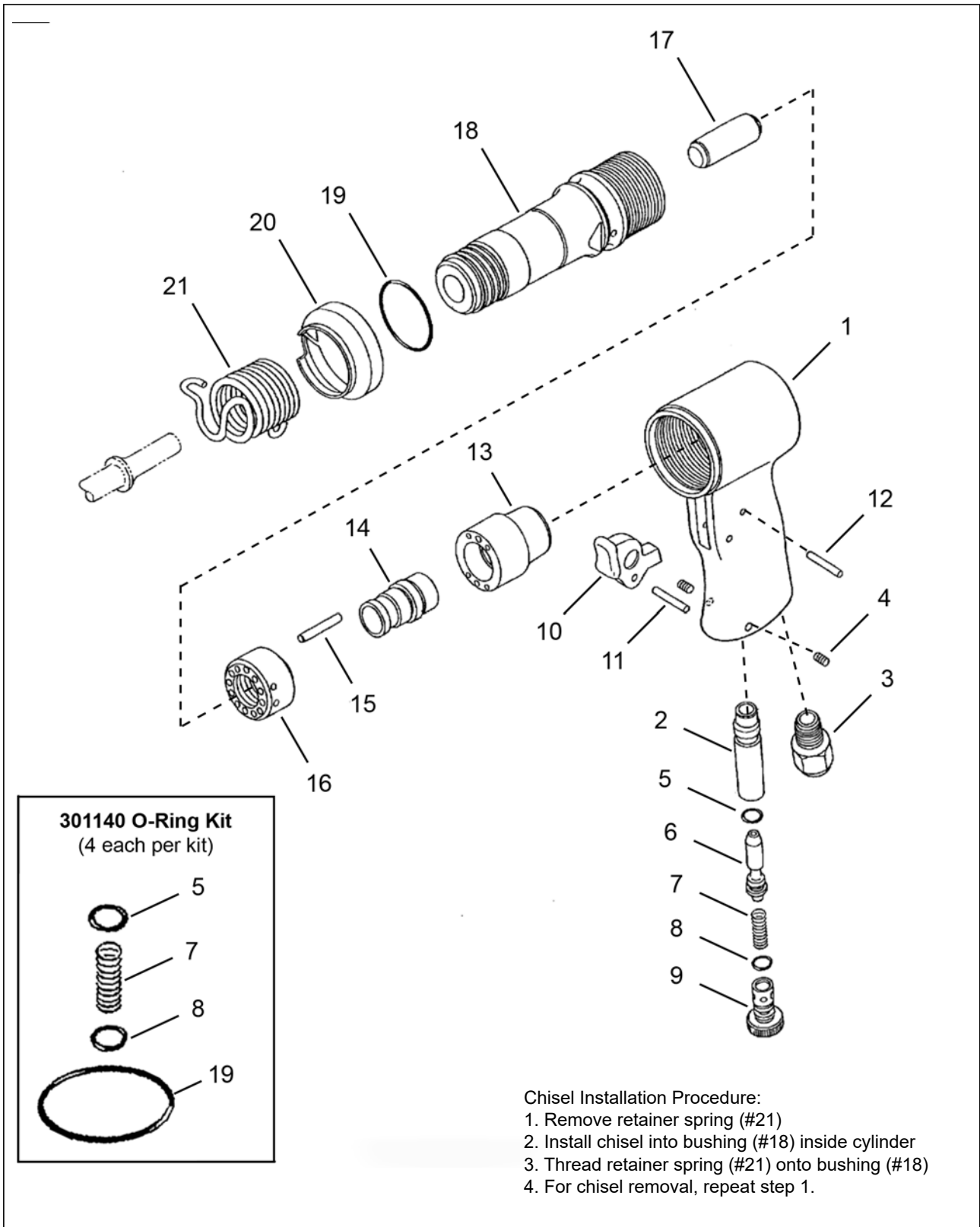
- Inspect this equipment every 500 operating hours or every six months, whichever comes first.
- Replace worn parts using only appropriate brand replacements parts manufactured by Apex Tool Group, LLC.
- Chisel or rivet set retainers are recommended and furnished as standard equipment. Periodically inspect the retainer for wear or damage. Damaged retainers can allow the cutting device to eject from the tool.

### RIVET SET INSTALLATION & REMOVAL

**WARNING!** Turn off the air and drain the air hose before installing or removing any chisel or implement. Follow the procedure below for installing any chisel or implement. Reverse the procedure for removal.



### Riveter



- Chisel Installation Procedure:
1. Remove retainer spring (#21)
  2. Install chisel into bushing (#18) inside cylinder
  3. Thread retainer spring (#21) onto bushing (#18)
  4. For chisel removal, repeat step 1.



Index	Order no	Quantity	1)	Description
1	---	1	K1	Handle (includes Ref. 2)
2	---	1	K1	Throttle Valve Bushing
3	---	1	K1	Inlet Bushing (NPT)
4	---	2	K1	Hex Socket Head Cap Screw (M5 x 8)
* 5	---	1	K3	Throttle Valve O-Ring (S-6)
6	---	1	K3	Throttle Valve
* 7	---	1	K3	Throttle Valve Spring
* 8	---	1	K3	Control Valve O-Ring (S-8)
9	---	1	K3	Control Valve
10	---	1	K2	Lever
11	---	1	K2	Spring Pin (3 x 22)
12	---	1	K2	Spring Pin (3 x 16)
13	---	1	K4	Valve Box
14	---	1	K4	Valve
15	---	1	K4	Valve Knock Pin
16	---	1	K4	Valve Seat
17	207195	1		Piston
18	207194	1		Cylinder
19	---	1	K5	O-Ring (JASO-2035)
20	207196	1		Exhaust Band
21	207197	1		Spring Retainer
<b>Repair Kits</b>				
K1	301136	1		Handle Assembly Kit
K2	301137	1		Trigger Assembly Kit
K3	301138	1		Control Valve Assembly Kit
K4	301139	1		Valve Assembly Kit
K5	301140	1		O-Ring / Spring Kit

1) Included in Repair Kit

\* Parts also included in (K5) 301140 O-Ring/Spring Repair Kit

## POWER TOOLS SALES & SERVICE CENTERS

Please note that all locations may not service all products.  
Contact the nearest Cleco® Sales & Service Center for the appropriate facility to handle your service requirements.

-  Sales Center
-  Service Center

### NORTH AMERICA | SOUTH AMERICA

#### Detroit, Michigan

Apex Tool Group  
2630 Superior Court  
Auburn Hills, MI 48236  
Phone: +1 (248) 393-5644  
Fax: +1 (248) 391-6295

#### Lexington, South Carolina

Apex Tool Group  
670 Industrial Drive  
Lexington, SC 29072  
Phone: +1 (800) 845-5629  
Phone: +1 (919) 387-0099  
Fax: +1 (803) 358-7681

#### Canada

Apex Tool Canada, Ltd.  
7631 Bath Road  
Mississauga, Ontario L4T 3T1  
Canada  
Phone: (866) 691-6212  
Fax: (905) 673-4400

#### Mexico

Apex Tool Group  
Vialidad El Pueblito #103  
Parque Industrial Querétaro  
Querétaro, QRO 76220  
Mexico  
Phone: +52 (442) 211 3800  
Fax: +52 (800) 685 5560

#### Brazil

Apex Tool Group  
Av. Liberdade, 4055  
Zona Industrial Iporanga  
Sorocaba, São Paulo  
CEP# 18087-170  
Brazil  
Phone: +55 15 3238 3870  
Fax: +55 15 3238 3938

### EUROPE | MIDDLE EAST | AFRICA

#### England

Apex Tool Group GmbH  
C/O Spline Gauges  
Piccadilly, Tamworth  
Staffordshire B78 2ER  
United Kingdom  
Phone: +44 1827 8727 71  
Fax: +44 1827 8741 28

#### France

Apex Tool Group SAS  
25 Avenue Maurice Chevalier - ZI  
77330 Ozoir-La-Ferrière  
France  
Phone: +33 1 64 43 22 00  
Fax: +33 1 64 43 17 17

#### Germany

Apex Tool Group GmbH  
Industriestraße 1  
73463 Westhausen  
Germany  
Phone: +49 (0) 73 63 81 0  
Fax: +49 (0) 73 63 81 222

#### Hungary

Apex Tool Group  
Hungária Kft.  
Platánfa u. 2  
9027 Győr  
Hungary  
Phone: +36 96 66 1383  
Fax: +36 96 66 1135

### ASIA PACIFIC

#### Australia

Apex Tool Group  
519 Nungong Street, Albury  
NSW 2640  
Australia  
Phone: +61 2 6058 0300

#### China

Apex Power Tool Trading  
(Shanghai) Co., Ltd.  
2nd Floor, Area C  
177 Bi Bo Road  
Pu Dong New Area, Shanghai  
China 201203 P.R.C.  
Phone: +86 21 60880320  
Fax: +86 21 60880298

#### India

Apex Power Tool India  
Private Limited  
Gala No. 1, Plot No. 5  
S. No. 234, 235 & 245  
Indialand Global  
Industrial Park  
Taluka-Mulsi, Phase I  
Hinjawadi, Pune 411057  
Maharashtra, India  
Phone: +91 020 66761111

#### Japan

Apex Tool Group Japan  
Korin-Kaikan 5F,  
3-6-23 Shibakoen, Minato-Ku,  
Tokyo 105-0011, JAPAN  
Phone: +81-3-6450-1840  
Fax: +81-3-6450-1841

#### Korea

Apex Tool Group Korea  
#1503, Hibrand Living Bldg.,  
215 Yangjae-dong,  
Seocho-gu, Seoul 137-924,  
Korea  
Phone: +82-2-2155-0250  
Fax: +82-2-2155-0252

**Cleco**®  
Production Tools

#### Apex Tool Group, LLC

Phone: +1 (800) 845-5629  
Phone: +1 (919) 387-0099  
Fax: +1 (803) 358-7681  
www.ClecoTools.com  
www.ClecoTools.de