

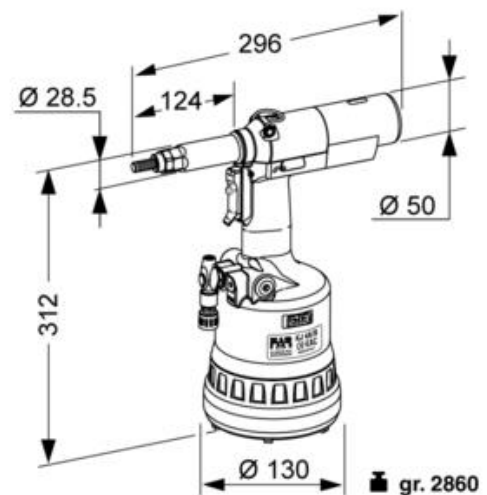
NUTSERT TOOL – FAR KJ45S

Air nutsert setting tool for sizes from M4-M12

The Far KJ45S combines reliability, power and ergonomics all in one tool. It is a Italian-made tool that is powered via a hydro-pneumatic system (oil & air) rather than just air, which means it works harder and lives longer. It installs a wide range of nutserts via a spin in/pull out motion, eliminating torque on the thread during installation and offering greater flexibility with nutsert sizes. New to nutserts? Check out our [blog article](#) for more information.



NT-KJ45S Specifications	
Weight	2.8Kg
Pull Force	27.4kN
Stroke	7.6mm
Cycle Time	2.5 seconds
Air Pressure	6-7 bar
Fastener Capacity	M4-M12 threaded inserts in all material (all nosepieces included)



Technical Data

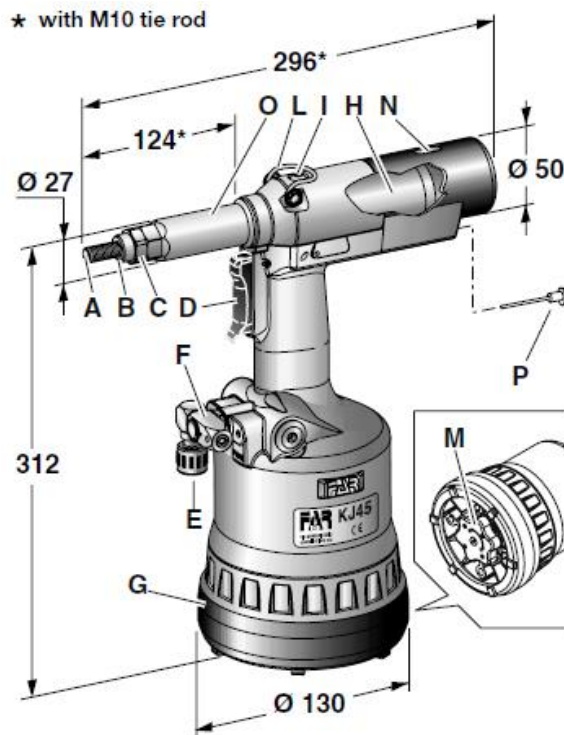
Working pressure	6 - 7 BAR
Min. int. diam. of the compressed air feeding hose	∅ min. = 8 mm
Max free air consumption per cycle	11 NI
Force (6 BAR)	28 KN
Noise level.....	< 75 db(A)
Weight (with equipment for M10)	2.9 Kg
Working temperature	-5°/+50°
Root mean square in total acceleration frequency (Ac) to which the arms are subjected	< 2.5 m/sec ²

General Notes and Use

The tool can be employed only for threaded inserts M4-M12. The KJ45 hydropneumatic system assures more power than the pneumatic system used for other models. That means a reduction in the problems due to the wear and tear of the components, therefore, there will be an increase in reliability. The technical solutions adopted reduce the dimensions and the weight of the tool, which is very handy for these reasons. The possibilities of leakage from the oil-dynamic system, are eliminated by some sealed gaskets, which solves this problem.

Tool Identification

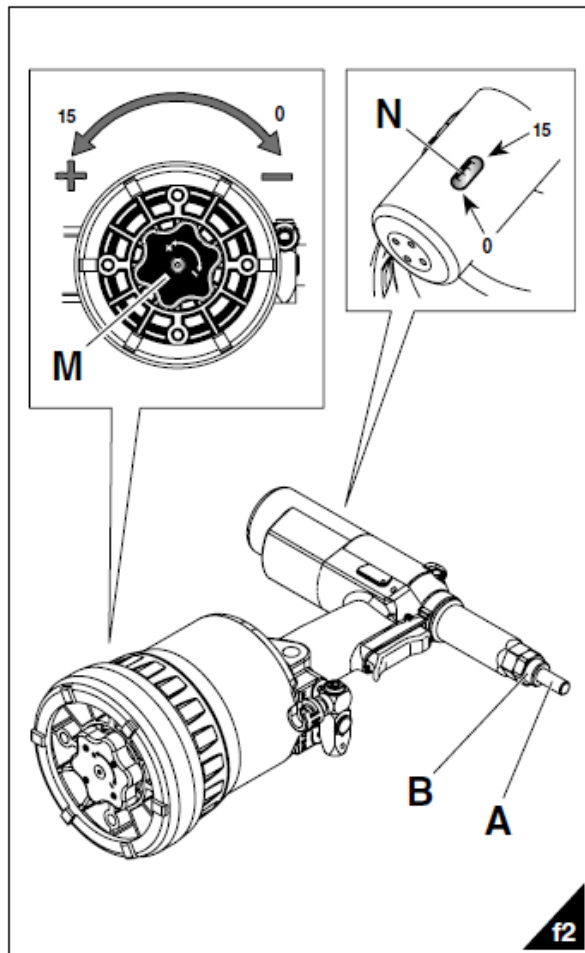
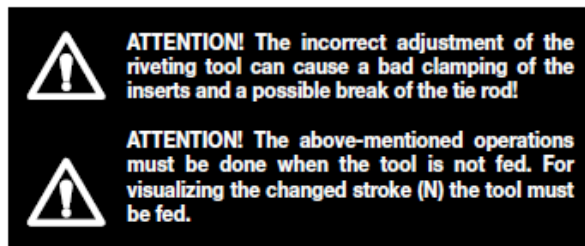
- A) Threaded tie rod
- B) Head
- C) Ring-nut clamping head
- D) Control push-button
- E) Compressed air connection
- F) Pressure control valve
- G) Protection bottom
- H) Pneumatic motor
- I) Oil tank plug
- L) Balancer connection
- M) Stroke-adjusting knob
- N) Stroke indicator
- O) Tube carrying head
- P) Forced unscrewing rod

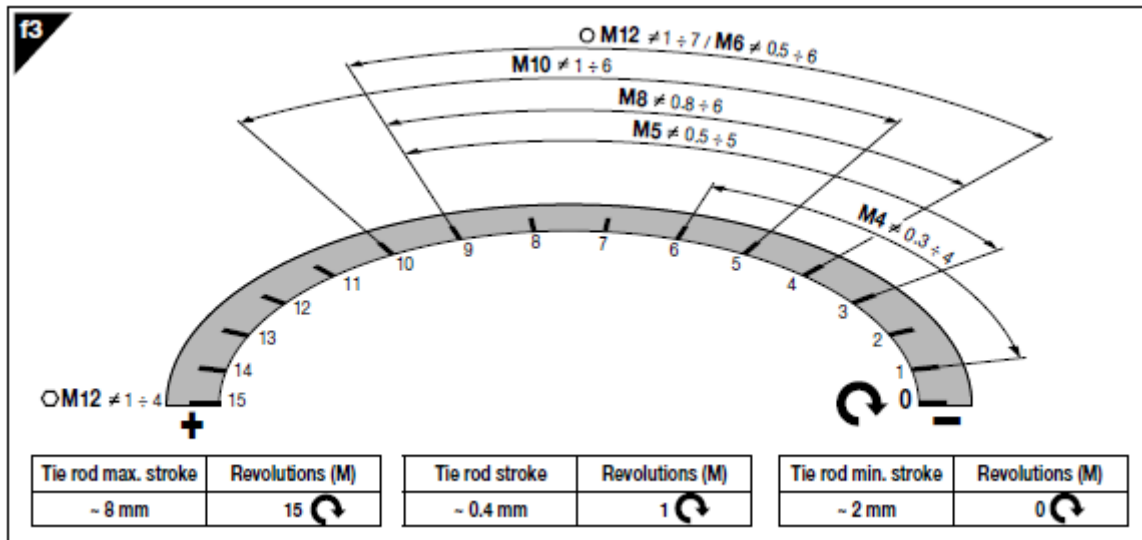


Preliminary Operations (fig. f2-f3)

Check that the threaded tie rod (A) and head (B) couple assembled on the riveting tool is suitable to the size of the insert to clamp; otherwise change the size (page 17). The couple tie rod (A) + head (B) assembled on this riveting tool, corresponds to a M10 thread. Before using the riveting tool and after each change of size, the stroke should be adjusted according to the dimensions, type of the insert and thickness of the material to clamp. Before carrying out this operation rotate the knob (M) according to the direction of the arrow, (+) for increasing the stroke and (-) for decreasing it. Increasing the stroke - rotation of knob (M) - in the direction indicated with the symbol (+), the distance "h" (page 15) decreases increasing the clamping action. To verify that the stroke is correctly adjusted check the indicator (N) comparing it with the values of the table (fig. f3).

NOTE: Before the definitive placing of the insert, its clamping on the thicknesses involved should be checked, carrying out other adjustments, as shown at page 18 (the specified adjustments are just an indication, it is advisable to see the technical data of the inserts used).





Placing Nutserts (fig. f4-f5-f6)

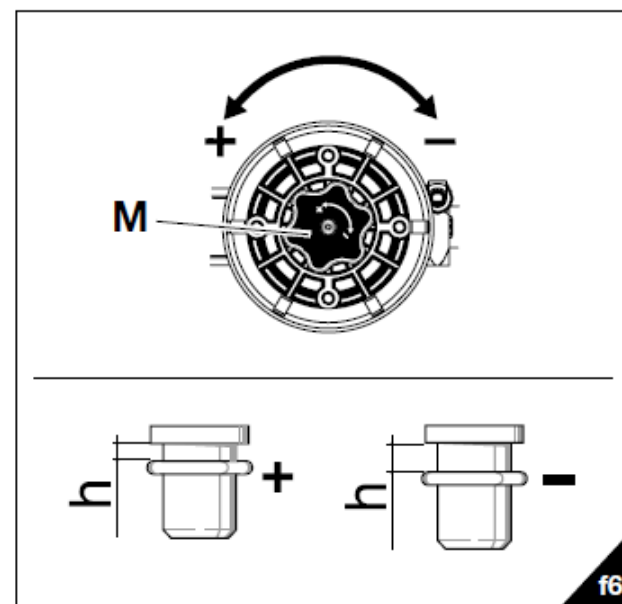
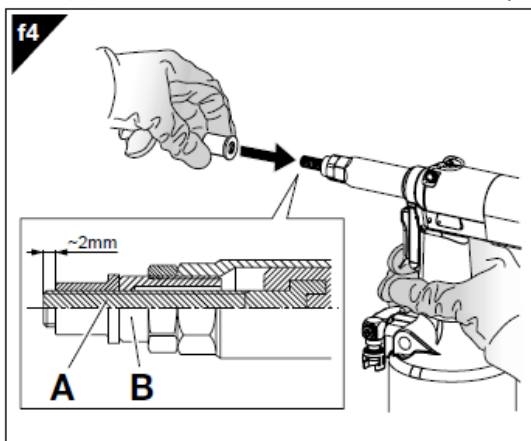
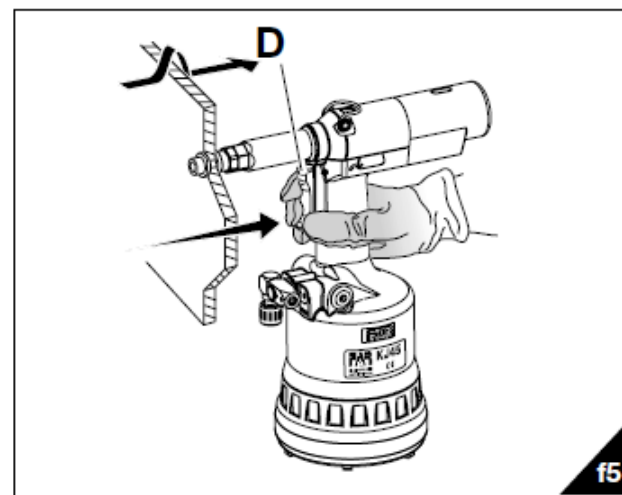
Check that the threaded tie rod (A) and head (B) couple assembled on the riveting tool is suitable to the size of the insert to be used. Adjust the stroke as indicated (fig. f2-f3). Introduce the insert on the tie rod (A) and push slightly on it as indicated in figure f4, so as to make it clamp automatically on the threaded tie rod. Make sure that the insert head touches the head (B) checking that the tie rod (A) comes out of 2mm from the insert. In case of further adjustments of the tie rod (A) follow the instructions of page **CHANGE TO PAGE NO.**

It is possible to place the insert pushing the button (D) and keeping it pushed up to the complete release of the tie rod (fig. f5). For a correct placing and right working of the machine, the inserts to be used should be properly cleaned.

Note: According to the desired clamping, carry out other adjustments of the riveting tool stroke, rotating the knob (M) (fig. f2-f3-f6), if necessary.

Insufficient deformation = the insert could rotate inside the housing compromising its use and resistance.

Excessive deformation = possible damages of the insert and tie rod (A) with eventual breaks of both components.



Changing Sizes (fig. f10-f11-f12-f13)

The riveting tool is supplied with 6 pairs of threaded tie rods (A) and heads (B), for tightening a range of threaded inserts from M4 to M12. Depending on the insert thread, it is necessary to replace the threaded tie rod (A) and head (B) group, as follows: loosen the ring nut (C) with a 22 mm. standard spanner and remove the riveting tool head (B), and spacer (Q) if it ranges from M4 to M8. With the same spanner, unscrew the tube carrying head (O). Use two 20 mm. standard spanners for disassembling the ring nut (K) and extract the threaded tie rod (A).

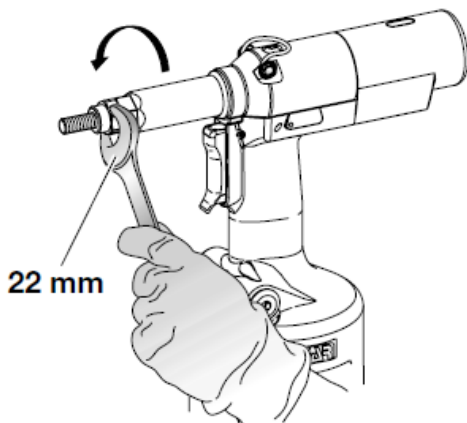
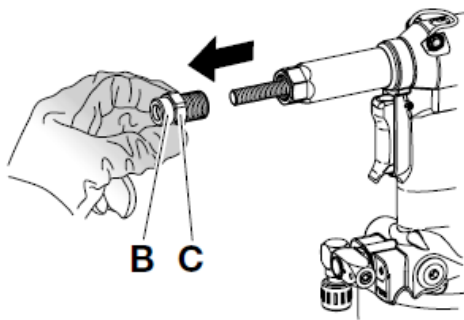
Note: Use two spanners for unblocking the ring nut (K) as indicated in figure (f9); the inobservance of this procedure can damage the riveting tool.

After having replaced the threaded tie rod (A) with that one of the right size, assemble the ring nut (K) again and carry out the above-mentioned operations in reverse order, being sure that the component (R) is the right one. Every time you carry out any change of size, repeat the adjustment operations as indicated at page 18.

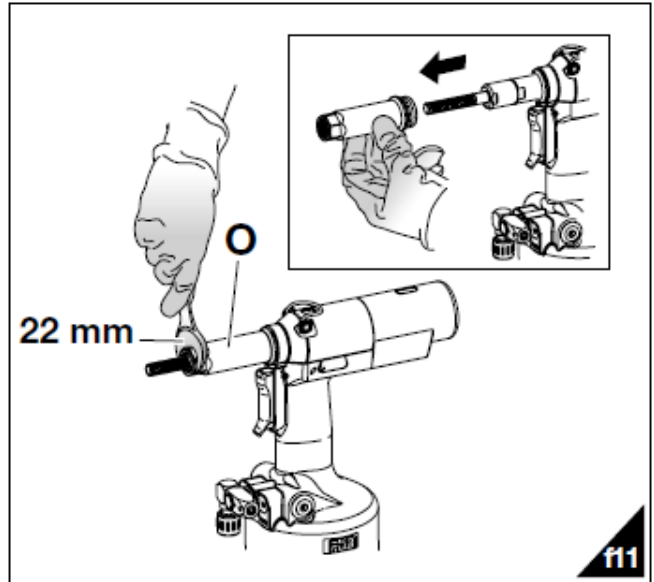


ATTENTION!

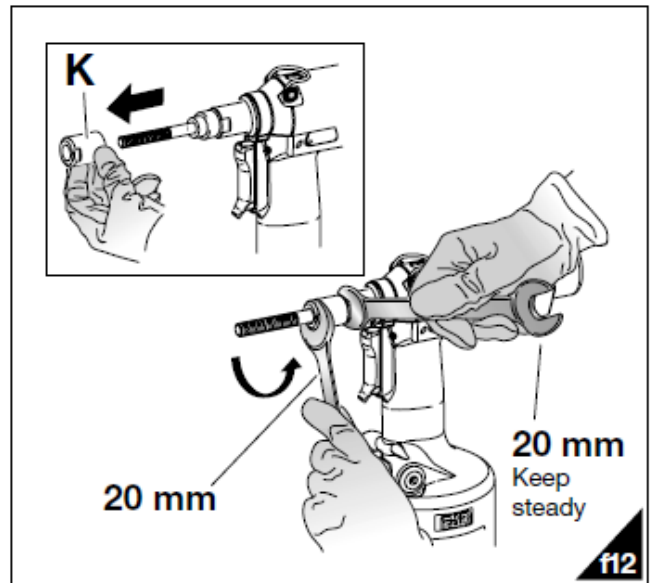
Disconnect the machine before carrying out the above-mentioned operations.



f10

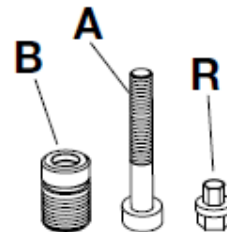


f11

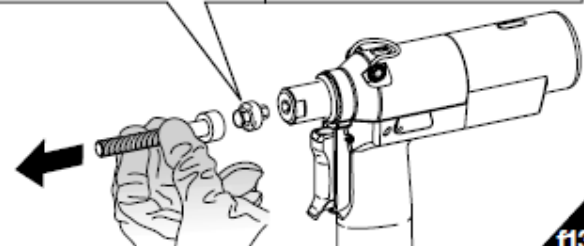
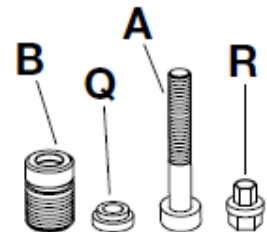


f12

M10 - M12



M4 ÷ M8



f13

Adjustment of the Couple Tie Rod/Head (fig. f14-f15-f16)

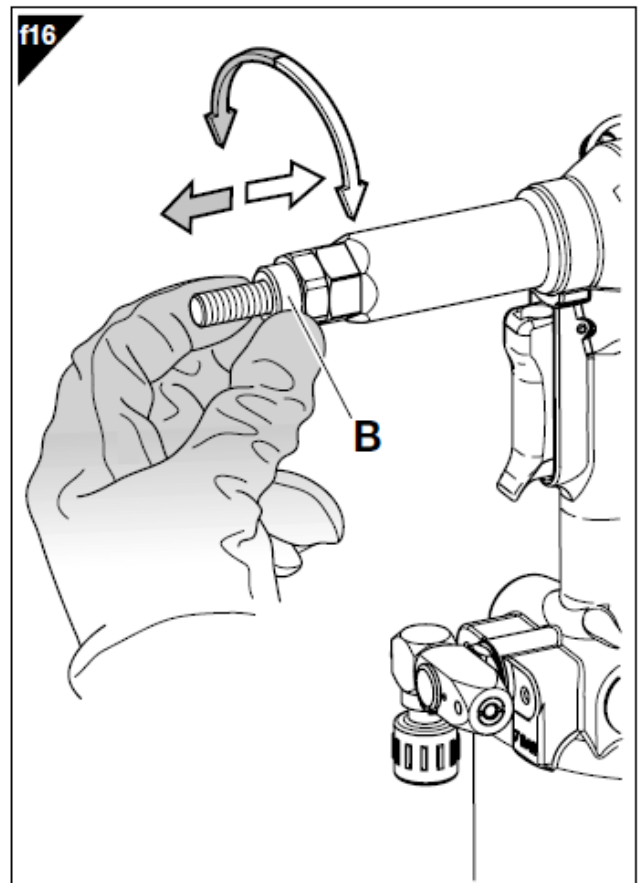
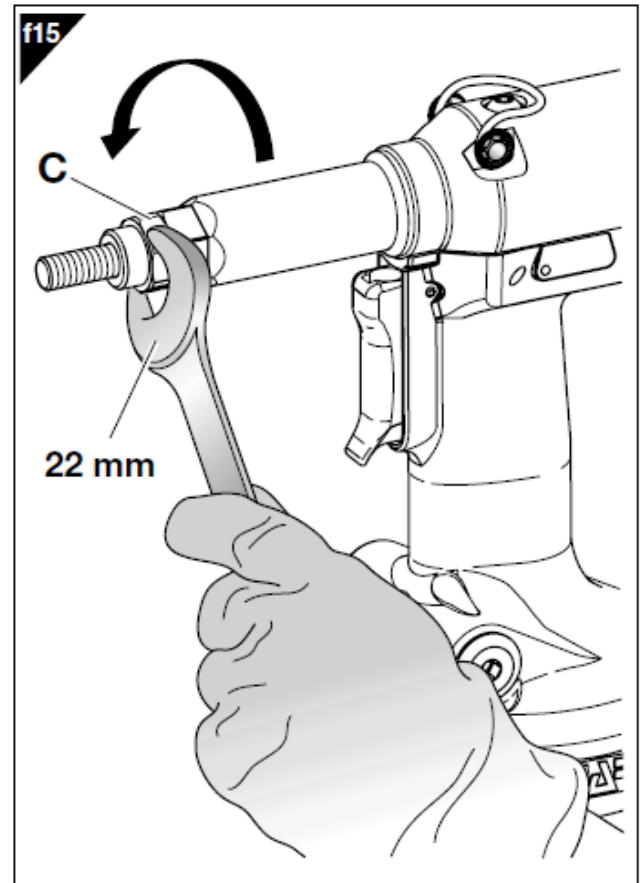
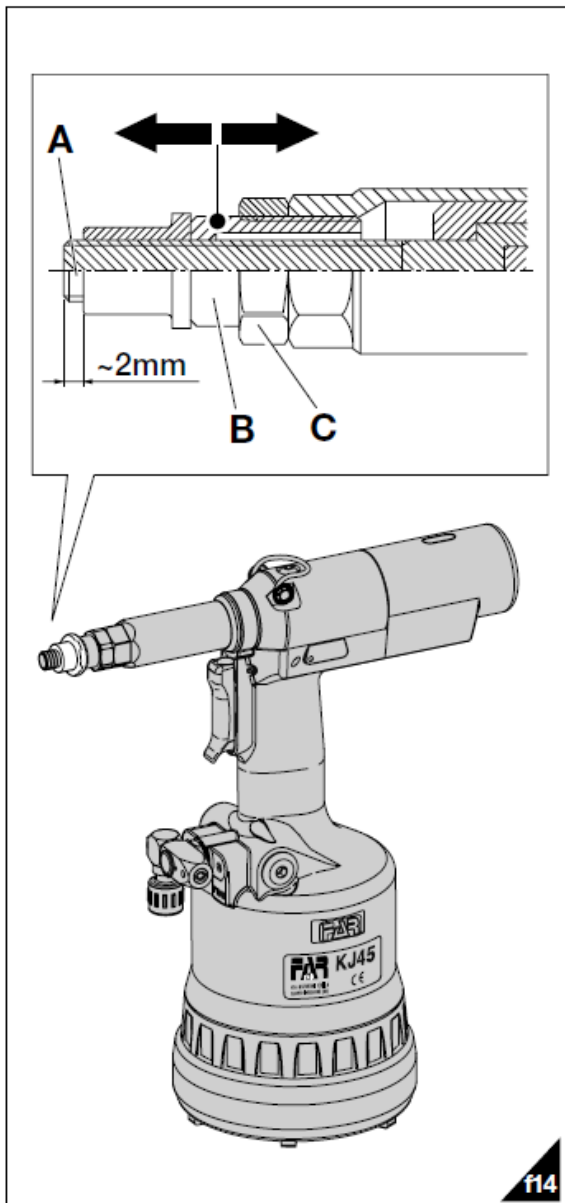
Changing the length of the insert to clamp, the position of the head (B) compared to the threaded tie rod (A) should be adjusted.

Disconnect the riveting tool from the compressed-air supply. Screw an insert of the desired length on the threaded tie rod manually until the insert head touches the riveting tool head (B). The head is adjusted correctly if the threaded tie rod comes out of the insert screwed on it of about **2 mm**. Otherwise unblock the ring nut (C) with a **22 mm** standard spanner then screw or unscrew the head (B) up to the right position, and block the ring nut (C).



ATTENTION!

Disconnect the machine before carrying out the above-mentioned operations.



Maintenance

Daily maintenance

- Check that the threaded tie rod is not damaged.
- Check the supply system of the compressed air.
- Check that the stroke of the tool is suitable for the selected insert to clamp (see the pertaining instructions for adjusting the stroke, indicated on page 3).
- Check that there are neither air nor oil leakages. In this case replace possible damaged connectors or seals.
- Check that the supply pressure of the compressed air does not exceed 7 bar.

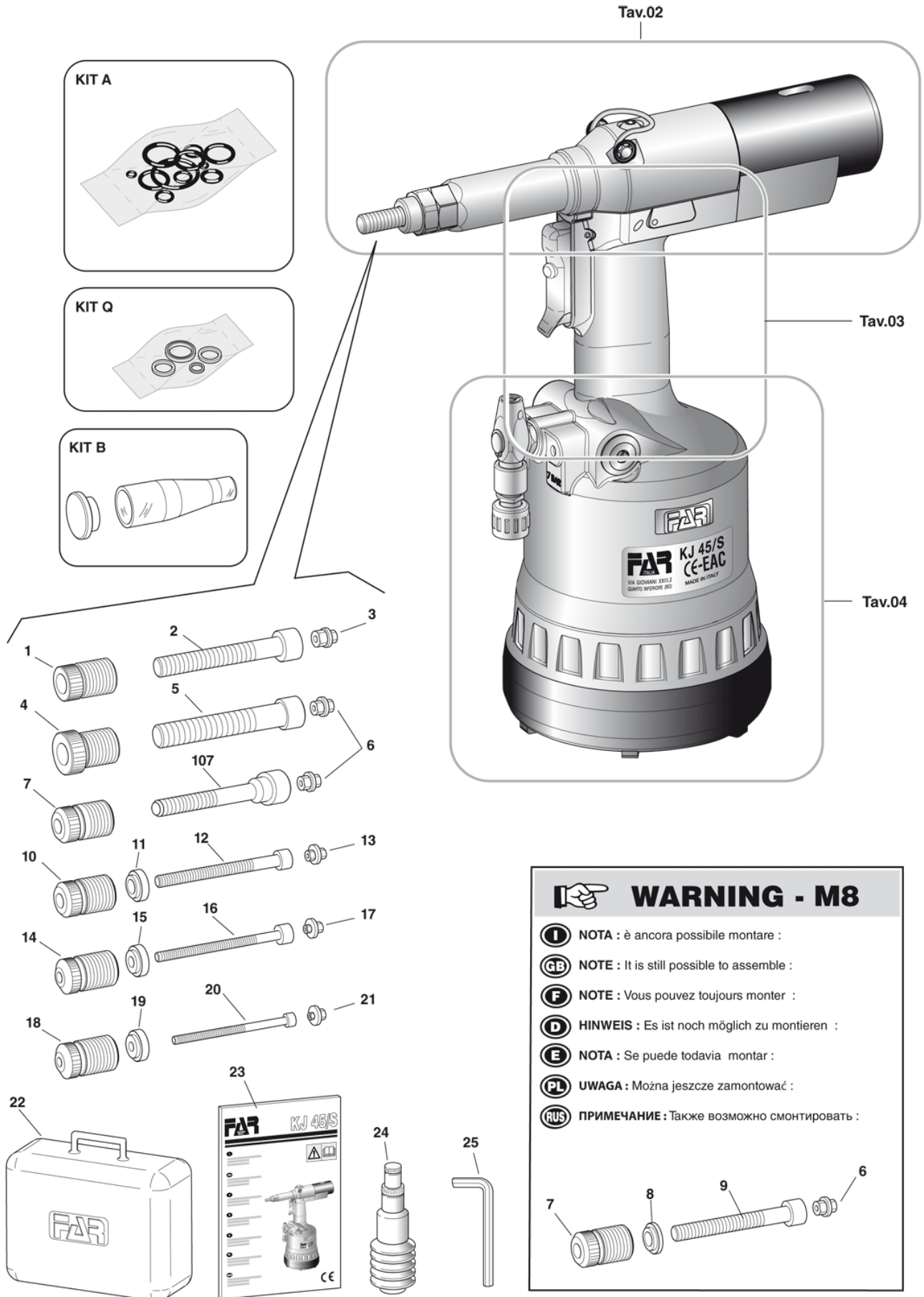
Weekly maintenance

- Check the oil level controlling the stroke of the riveting tool. If necessary fill up for preventing failures of the riveting tool.

Overhaul of the riveting tool

- It is advisable to carry out a complete overhaul of the riveting tool after 600,000 cycles or every year. In this case apply only to centres authorized by FAR S.r.l.

Spare Parts Diagram



Spare Parts List

Pos.	Code	Description	Qty
001	713291	Head M 10	1
002	71C00281	Screw TCCE M10 x 70 UNI 5931 - 12,9	1
003	72A00105	Hexagonal unit for tie-rod M 10	1
004	713292	Head M 12	1
005	713177	Tie rod M 12	1
006	72A00104	Hexagonal unit for tie-rod M 8 - M 12	2
007	713290	Head M 8	1
008	71345529	Spacer for screw M 8	1
009	71C00514	Screw TCCE M8 x 70 UNI 5931 - 12,9	1
010	713289	Head M 6	1
011	71345276	Spacer for screw M 6	1
012	71C00279	Screw TCCE M6 x 70 UNI 5931 - 12,9	1
013	72A00103	Hexagonal unit for tie-rod M 6	1
014	713288	Head M 5	1
015	71345275	Spacer for screw M 5	1
016	71C00278	Screw TCCE M5 x 70 UNI 5931 - 12,9	1
017	72A00102	Hexagonal unit for tie-rod M 5	1
018	713287	Head M 4	1
019	71345274	Spacer for screw M 4	1
020	71C00277	Screw TCCE M4 x 65 UNI 5931 - 12,9	1
021	72A00101	Hexagonal unit for tie-rod M 4	1
022	709033	Plastic case	1
023	75036018	Instructions for use	1
024	72A00053	Oil container assembly	1
025	712225	Wrench 4 mm	1
107	71345831	Tie rod M 8	1

KITA	74000042	Pneumatic kit
Code	Description	Qty
71C00295	Ring Parbak 8-028	1
71C00296	Gasket OR 5-670	1
710925	Gasket OR 027	1
711062	Gasket OR 2-126	1
710244	Gasket OR 2-130	1
713275	Gasket OR 2-122	1
713390	Gasket OR 2-007	2
710258	Gasket OR 5-612	1
710921	Gasket OR 2-115	1
71C00529	Gasket XR 008 PP180 B	1
710528	Gasket OR 008	1

710572	Gasket OR 2-120	1
710385	Gasket OR 2-006	2
713394	Gasket OR 2-106	1
710376	Gasket OR 2-009	2
711338	Gasket OR 2-003	2
710918	Gasket OR 2-005	2
716060	Gasket OR 2-010	5
713400	Gasket OR 5-616	7
71C00355	Gasket OR 1,78 x 8,73	1
71C00356	Gasket OR 1,78 x 7,66	1
71C00522	Gasket OR 5-615	1
710914	Gasket OR 2-116	1
71C00297	Gasket OR 6-700	2
713398	Gasket OR 2-340	1
710350	Gasket OR 2-109	1
713192	Cage	5
713271	Gasket OR 2-014	2

KITB

74000027

Tie rod containier kit

KITQ

74000037

Oil-dynamic kit

Code	Description	Qty
711722	Gasket B-094063-B / NEI	1
713389	Gasket 157118-B / NEO	1
711827	Gasket TTS-12-19-5,7 / L	1
710390	Gasket B-075047	1