

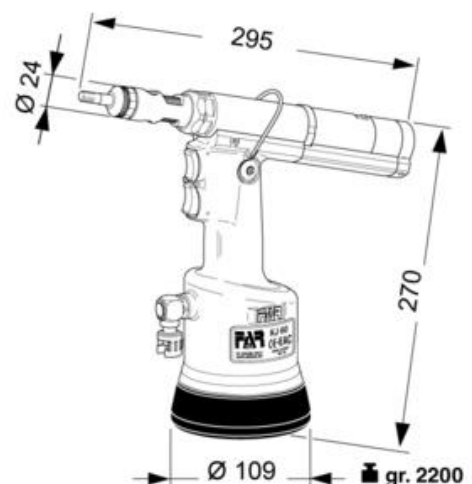
## NUTSERT TOOL – FAR KJ60

### Air nutsert setting tool for sizes from M3-M8\*

The Far KJ60 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-KJ60 Specifications	
Weight	2.2Kg
Pull Force	13.6kN
Stroke	7.5mm
Cycle Time	2.5 seconds
Air Pressure	6 bar
Fastener Capacity	M3-M8* threaded inserts in all material. * Not recommended for M8 in stainless steel



## Technical Data

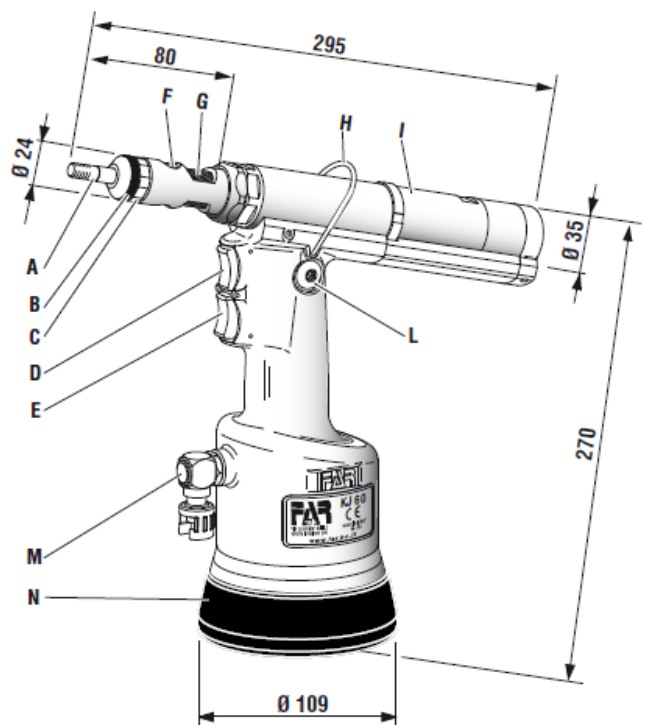
Working pressure.....	6 BAR
Min. int. diam. of the compressed air feeding hose .....	min. diam = 8 mm
Air consumption per cycle.....	9 NI
Max power.....	6 BAR -13656 N
Weight.....	2,200 Kg
Working temperature.....	-5°/+50°C
Root mean square in total acceleration frequency (Ac) to which the arms are subjected.....	< 2.5 m/s <sup>2</sup>
A-weighted emission sound pressure level .....	70 dBA
Peak C-weighted instantaneous sound pressure .....	<130 dBC
A-weighted sound power .....	88 dBA

## General Notes and Use

The tool can be employed only for blind rivet nuts with thread of M3 - M8 diameter. The KJ 60 oil pneumatic 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, for these reasons, make it very handy. 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) Tensile strength push button
- E) Unscrewing push button
- F) Insertion Pin Hole Dechucking clutch
- G) Regulation stroke ring nut
- H) Balancer connection
- I) Pneumatic motor
- L) Oil tank plug
- M) Compressed air connection
- N) Protection bottom

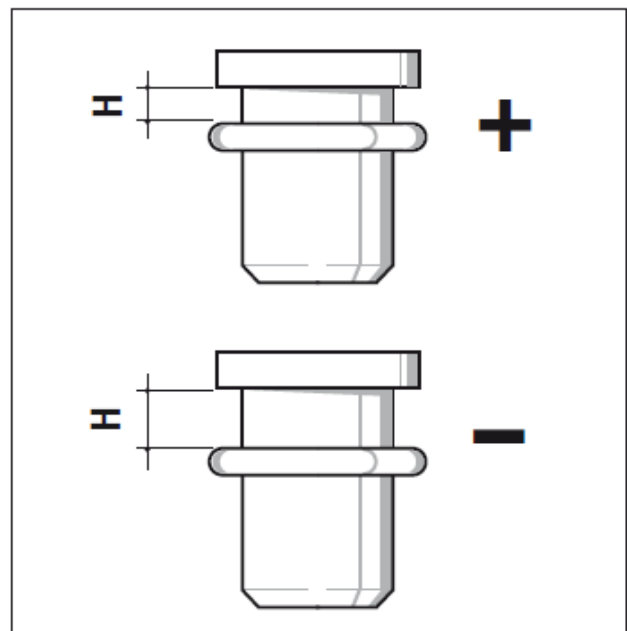
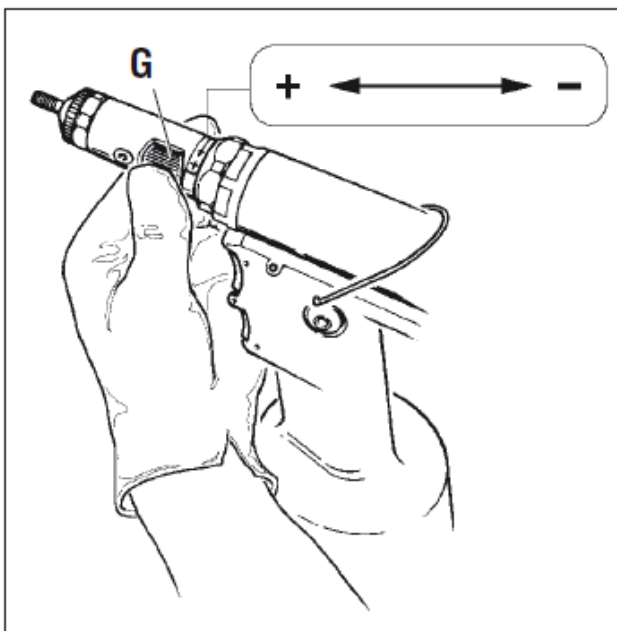
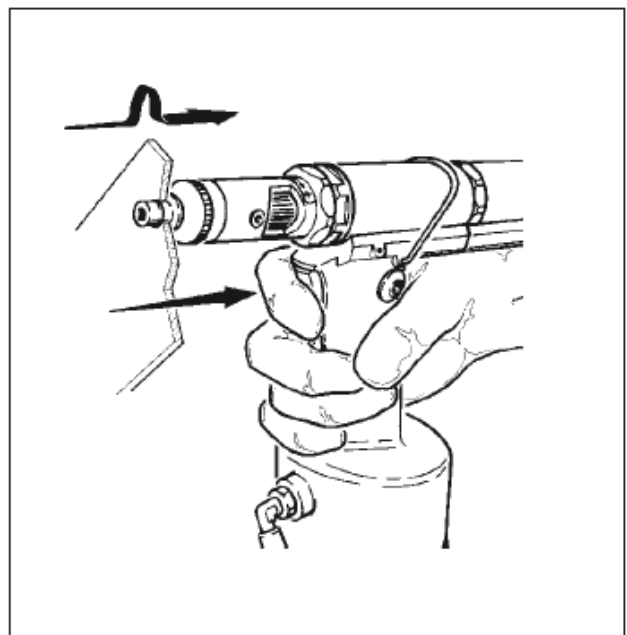
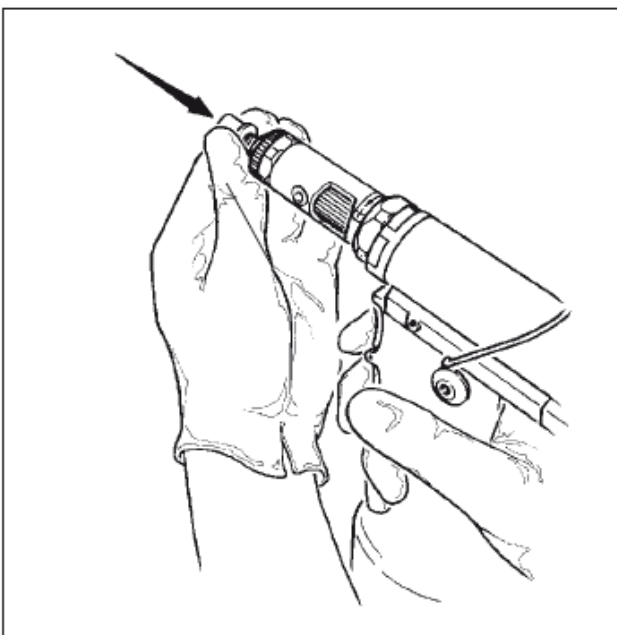


## Placing Nutserts

Make sure that the couple tie-rod/head mounted on your riveting tool is suitable for the insert to clamp; otherwise, change size accordingly. Usually the riveting tool is supplied with the couple tie-rod/head corresponding to a M8 thread. Before using the riveting tool and after any change of size, perform the following operations according to the size and thickness of the part to clamp. Adjust the riveting tool stroke to the minimum by turning the ring nut "G" to "-" marked on the tool. Place the insert on the tie rod and push slightly on it so as to make it clamp automatically. Make sure the insert head touches the riveting tool head properly. Fasten the insert and in order to ensure a proper clamping of the material, adjust the riveting tool stroke by turning the ring nut "G" accordingly. By increasing stroke, i.e. by turning the ring nut "G" to "+", the distance "h" between head and insert deformation will decrease and clamping will result more effective.



**WARNING!!! A WRONG ADJUSTMENT OF THE RIVETING TOOL STROKE  
MAY CAUSE A FAULTY CLAMPING OF INSERTS AND MAY BRAKE THE TIE ROD!**



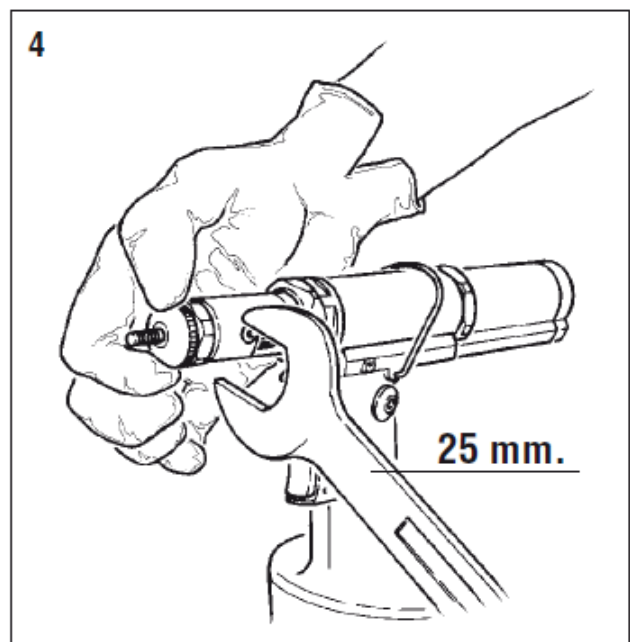
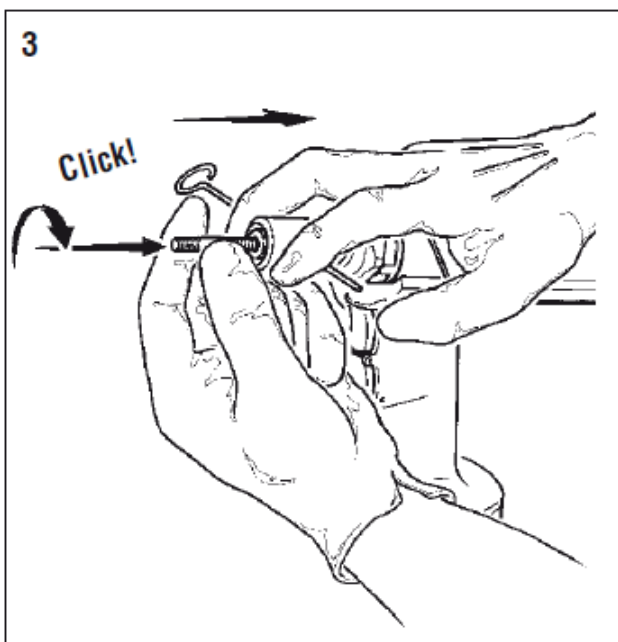
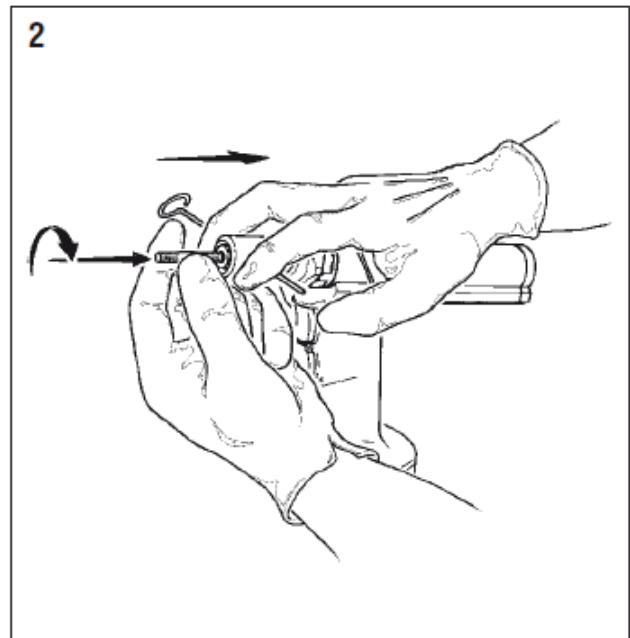
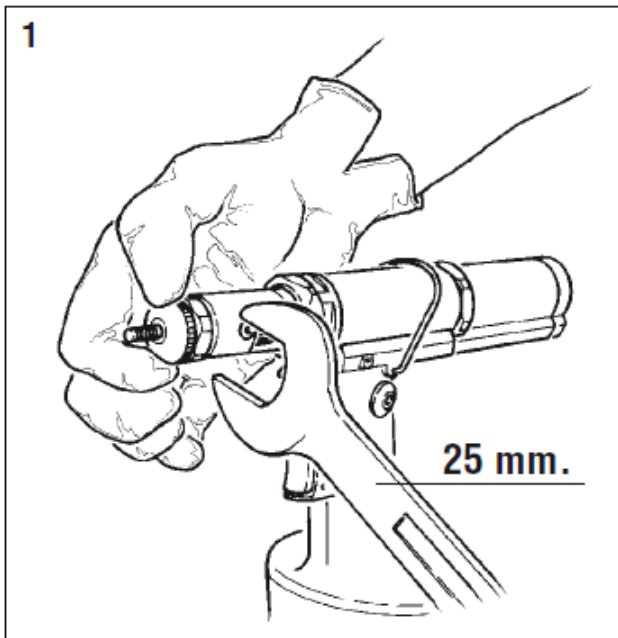
## Changing Sizes

Depending on insert thread, it is necessary to replace the couple “tie-rod/head” as follows:

**PICTURE 1.** Loosen the ring nut by means of a 25-mm standard spanner and remove the riveting tool head.

**PICTURE 2.** Make the pin supplied pass through the pertinent service hole located on the cone carrying head and apply a light pressure on the head inwards, in order to dechuck the tie rod clutch., at the same time, unscrew the tie rod and extract it.

**PICTURE 3-4.** Keep the clutch dechucked and screw the tie rod size desired. When the replacement of the tie rod has been performed, swing it until you hear a click. Then assembly the proper head and lock it with the corresponding ring nut loosen before. Each time you carry out any change of size, repeat the adjustment operations as specified in the previous pages.



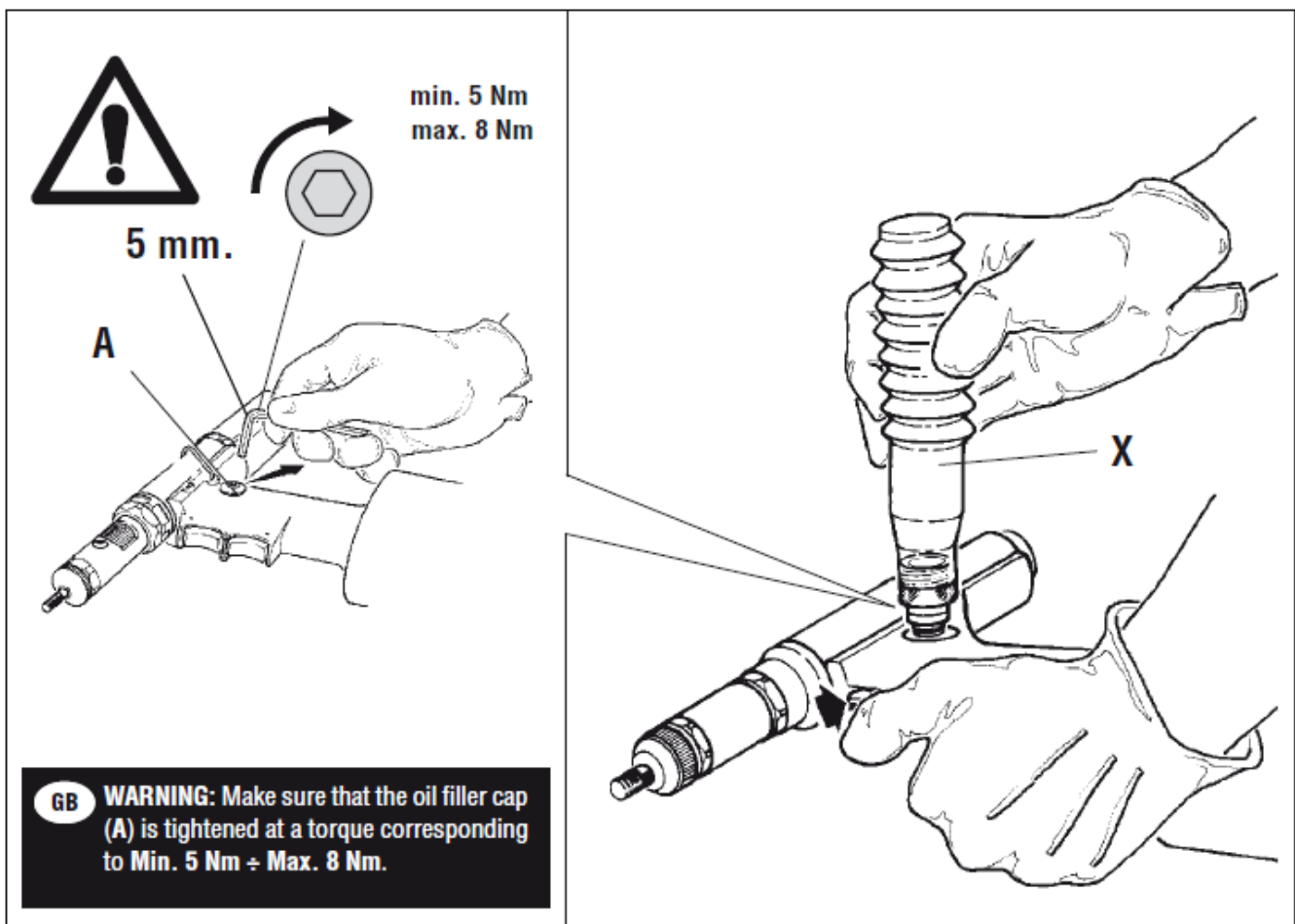
## Topping Up The Oil-Dynamic Circuit

You need to top up the oil-dynamic circuit after a long period of work, when you note a power loss. Put the riveting tool (**DWELL AND NOT FED**) in a horizontal position and remove the plug (**A**), by means of a 5 mm Allen wrench (equipped with the riveting tool); during this operation, check the oil level in order to avoid any overflowing. Then, slowly pour the oil **HLP 32 cSt** into the bellows container (**X**) which shall be screwed to its seat on the plug (**A**). While keeping the riveting tool in a horizontal position and starting air feeding, push the tensile strength button and make the riveting tool carry out some cycles until air bubbles inside the container (**X**) stop coming out. This condition indicates that the topping up of the oil has fully been achieved. At this point stop the air feeding and, while keeping the riveting tool in a horizontal position, unscrew and close up the container (**X**) and the plug (**A**).

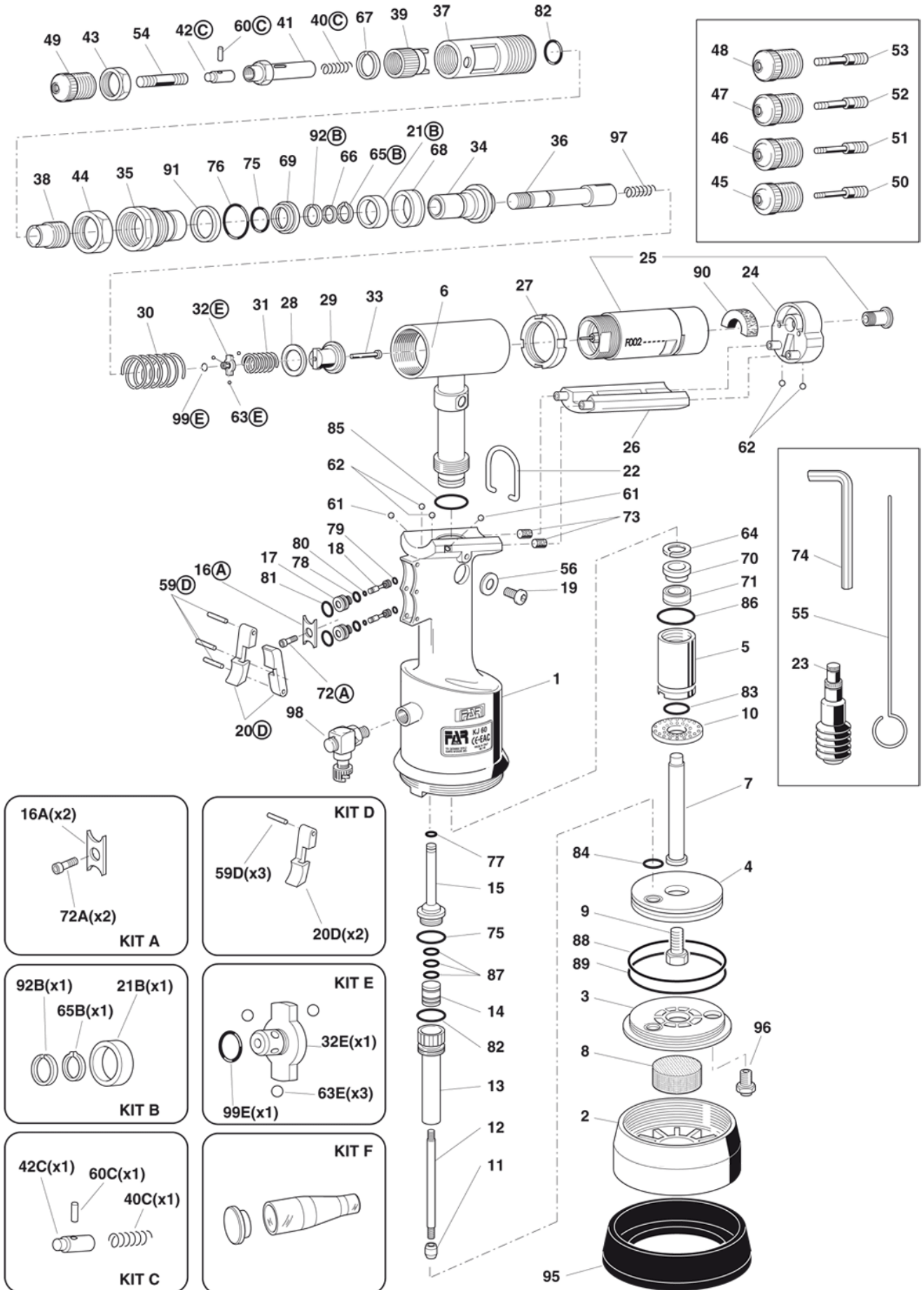
**WARNING:** it is very important to follow the about mentioned instructions and use gloves. If you need to empty fully the hydraulic circuit, you must put the oil in a suitable container and contact a Company that is authorized to discharge any waste



**WARNING! Before disconnecting the compressed air hose, make sure that it is not under pressure!**  
We recommend to use oil HLP 32 cSt or similars.



# Spare Parts Diagram



## Parts List

Pos.	Code	Description	Qty
01	721779	Riveting tool body	1
02	712269	Body cover	1
03	711684	Cylinder bottom plate	1
04	721685	Pneumatic piston	1
05	711780	Connector	1
06	721689	Hydraulic cylinder	1
07	711781	Rod	1
08	711691	Silencer	1
09	711692	Screw TE M7 x 18	1
10	711782	Shock absorber	1
11	711694	Lower valve	1
12	711695	Threaded sleeve	1
13	721698	Valve body	1
14	711700	Upper valve	1
15	711701	Upper valve body	1
16A	711702	Plate	1
17	711703	Valve body	2
18	711704	Valve piston	2
19	710839	Oil tank plug	1
20D	711705	Push-button	2
21B	711713	Spacer	1
22	710854	Balancer hook	1
23	721387	Oil container	1
24	711783	Motor cover	1
25	72A00126	Pneumatic Motor F002	1
26	711785	Motor protection sector	1
27	711786	Ring nut	1
28	711787	Stop ring	1
29	712670	Clutch	1
30	711790	Spring	1
31	711791	Spring	1
32E	711792	Ball bushing	1
33	712270	Rod	1
34	711794	Hydraulic piston	1
35	711795	Front connector	1
36	711796	Shaft	1
37	711797	Milled sleeve	1
38	711798	Stroke adjusting ring nut	1
39	711799	Stroke-adjusting knob	1
40C	711800	Spring	1
41	711801	Sleeve carrying tie rod	1

42C	711802	Tie rod clutch	1
43	711803	Ring nut	1
44	711804	Ring nut	1
45	711805	Head M 3	1
46	711806	Head M 4	1
47	711807	Head M 5	1
48	711808	Head M 6	1
49	711809	Head M 8	1
50	711810	Tie rod M 3	1
51	711811	Tie rod M 4	1
52	711812	Tie rod M 5	1
53	711813	Tie rod M 6	1
54	711814	Tie rod M 8	1
55	710876	Tie rod release pin	1
56	710906	Washer 400-020-4490	1
59D	711726	Dowel pin $\varnothing$ 2 x 20 UNI 1707	3
60C	710537	Spring pin $\varnothing$ 4 x 12 UNI 6873	1
61	711815	Ball $\varnothing$ 3,5	2
62	710911	Ball $\varnothing$ 4	4
63E	711816	Ball $\varnothing$ 2,5	3
64	711817	Seeger ring 18 UNI 7437	1
65B	710902	Seeger ring 16 UNI 7435	1
66	711818	Seeger ring SW 11	1
67	711821	Seeger ring JV 20	1
68	711721	Gasket B-110078-B / NEO	1
69	711722	Gasket B-094063-B / NEI	1
70	711819	Gasket B-070039 / 1	1
71	711820	Gasket TS-10-18-5,8 / L	1
72A	711727	Screw TSCE M4 x 8 UNI 5933	1
73	712037	Inox filter $\varnothing$ 6 x 4	2
74	711092	Wrench 5 mm	1
75	711728	Gasket OR 2-016	2
76	711730	Gasket OR 2-119	1
77	710367	Gasket OR 2-008	1
78	710376	Gasket OR 2-009	2
79	710918	Gasket OR 2-005	2
80	710919	Gasket OR 2-004	2
81	710003	Gasket OR 5-052	2
82	710342	Gasket OR 2-017	2
83	710594	Gasket OR 2-012	1
84	711061	Gasket OR 5-614	1
85	711731	Gasket OR 2-018	1
86	711732	Gasket OR 2-118	1
87	710258	Gasket OR 5-612	3



