

Processes

Self-Piercing Rivet Install
SPR Removal
Hole Punch
Flattening



Self-Piercing Riveter



OPERATOR'S MANUAL

IMPORTANT: Read this Owner's Manual Completely before attempting to use this equipment. Save this manual and keep it handy for quick reference. Pay particular attention to the safety instructions we have provided for your protection. Contact your distributor if you do not fully understand this manual.

Technology Parameters

Parameters	Models	UNI-6700
Piston Force		60Kn (6-Ton) (13,500 pounds)
QCS Coupling Type		6T QCS
Duty Cycle		3 Cycles Per Minute
Arm Throat Depth		5.25"
Motor		Voltage 18V DC; Amperage 18 Amp Power 324 Watts
Battery		18V Li-Ion Rechargeable Battery
Ingress Protection		IP32
Allowable Humidity		0-80%
Operating Temperature Range		15°F to 122°F (-10°C to 50°C)
Storage Temperature Range		32°F to 113°F (0°C to 45°C)
Service Interval		32,000 Cycles

Note: The above parameters are subject to change with the improvement of machines.

Pre-Operation Inspection

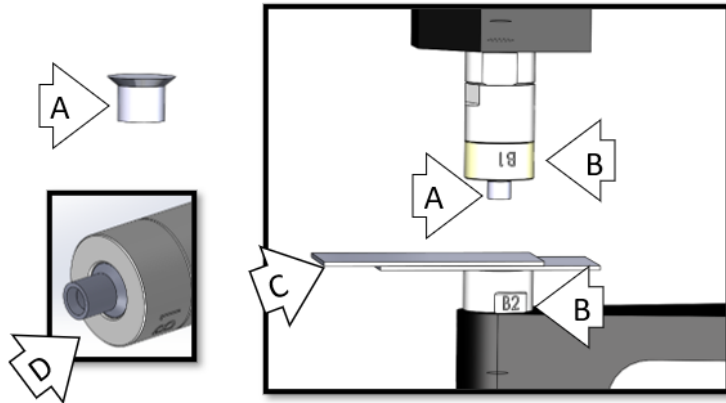
Daily before use, inspect your electrical tool and correct any problems to reduce the risk of serious injury from electric shock, crushing injuries, equipment failure and other causes, and prevent tool damage.

1. Remove battery from tool.
2. Clean any oil, grease or dirt from the tool and head, including handles and controls. This aids inspection and helps prevent the tool or control from slipping from your grip.
3. Inspect the electrical tool for:
 - Proper assembly, maintenance and completeness.
 - Any broken, worn, missing, misaligned or binding parts.
 - Presence and readability of the tool and battery warning labels.
 - Any other condition which may prevent safe and normal operation.

If equipped with the QCS Coupling, inspect for:

- Foreign material in the QCS coupling
- Confirm that all retaining balls are present and that there is no damage.
- When inspecting the mating QCS coupling on interchangeable heads, dimples in the grooves of the QCS coupling are normal with use and are not considered damage.

Operation



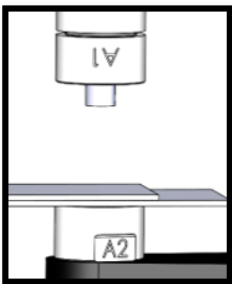
IMPORTANT SEVERE TOOL DAMAGE OR UNSAFE JOINT UNLESS PROPER STEPS FOLLOWED!!

- A) USE CORRECT LENGTH AND SIZE OF RIVET FOR MATERIAL AND TOOLING. **FOLLOW AUTO REPAIR GUIDELINES.**
- B) UPPER AND LOWER TOOLING MUST MATCH. (A1+A2, B1+B2, T1+T2 ETC) TOOLING IS NOT INTERCHANGEABLE WITH OTHER MACHINERY. **DO NOT OPERATE WITHOUT TOOLING.**
- C) FOLLOW AUTO REPAIR GUIDELINES. FOR RIVET AND DIE COMBINATIONS. **DO NOT OPERATE WITHOUT MATERIAL.**
- D) RIVET MUST SIT INSIDE PUNCH RING. **DO NOT OPERATE WITH RIVET OFFSET OR MISALIGNED.**

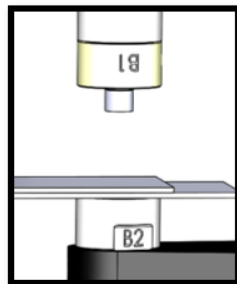
TOOLING CONFIGURATIONS

DO NOT MIX AND MATCH OR USE OTHER BRANDS

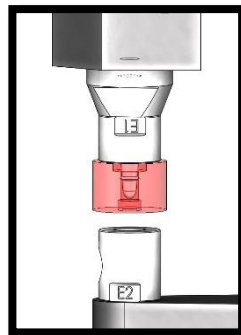
3mm Rivet Driver



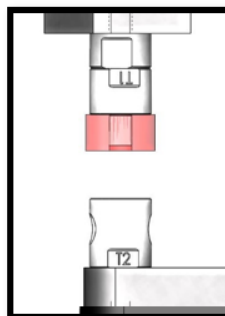
5mm Rivet Driver



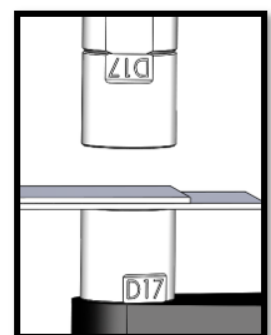
Rivet Extractor



6mm Hole Punch



Flattening Tool



Optional stripper included for formed side center location assistance

Do not use hole punch tooling without stripper

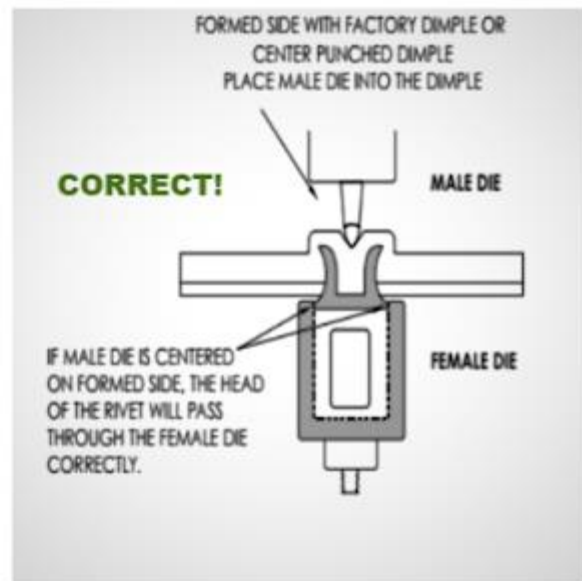
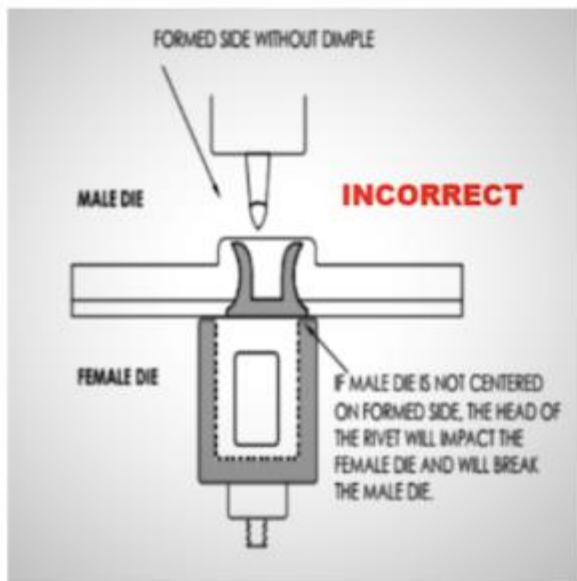
SPR Operating Tips

- This is a precision tool capable of over **13,000 pounds** of clinching force
- On extraction and hole-punch operations, stop the tool once process is complete and manually retract the ram with the red trigger
- Take your time when using this tool...**GO SLOW** on any of the applications
- Always ensure the proper dies are installed and **tightened with the included wrench!!**
- Do not dry fire the tool without material.**

EXTRACTION SPECIAL NOTES

-When using the extraction dies, **ALWAYS** ensure you are pushing out the dimple side (sample diagram below) and are centered on the dimple.

-Extractor die (E1) includes a polyurethane stripper that has an opening to center on both 5mm and 3mm rivets (one on each side). Please ensure stripper is installed with 3mm or 5mm pilot over rivet head and stays on during extraction process. Pilot ensures proper alignment.



RECAP

The tool puts out over 13,000 pounds of force.

The dies are made of hardened tool steel.

If the tool is not set-up and aligned over the rivet head properly, the die can and will break.

Included Items and Accessories



UNI-PUNCH 6700 SELF PIERCING RIVETER ACCESSORIES

H&S Part #	Parts List Description	H&S Part #	Parts List Description
			
UNI-6720	SPR Rivet Kit 3-5mm 300 Pk (included)	UNI-6770	SPR Die, Tool Kit 8T Standard (included)
UNI-6733	SPR Rivet 3.3-3.5 mm 100 Pk	UNI-6771	SPR Die 3.3 Rivet (A1 Upper)
UNI-6734	SPR Rivet 3.3-4.0 mm 100 Pk	UNI-6772	SPR Die 3.3 Rivet (A2 Lower)
UNI-6754	SPR Rivet 5.3-4.0 mm 100 Pk	UNI-6773	SPR Die 5.3 Rivet (B1 Upper)
UNI-6755	SPR Rivet 5.3-5.0 mm 100 Pk	UNI-6774	SPR Die 5.3 Rivet (B2 Lower)
UNI-6756	SPR Rivet 5.3-6.0 mm 100 Pk	UNI-6775	SPR Die Flattening (D17)
UNI-6757	SPR Rivet 5.3-7.0 mm 100 Pk	UNI-6776	SPR Die 3-5 Extractor (E1 Upper)
UNI-6710	SPR Battery Pack 18V/2.0Ah	UNI-6777	SPR Die 3-5 Extractor (E2 Lower)
UNI-6711	SPR Battery Charger (115VAC)	UNI-6778	SPR Die 6.0 Hole Punch (T1 Upper)
		UNI-6779	SPR Die 6.0 Hole Punch (T2 Lower)

TECH SUPPORT: 704-935-5242