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1. Conditions of Use

This blind rivet setting tool may be used only to set blind rivets, as described in the operating instructions.
The safety instructions MUST be followed!

2. Safety Notes ⚠

- Use the tool ONLY to set blind rivets
- Never overload the tool: Work within the stated performance parameters
- Never operate the tool without placing the blind rivet in the hole of the workpiece or the rivet could come off the tool! Do not point the tool head towards yourself or anyone else!
- The spent-mandrel container should always be screwed tightly on to the tool whilst in operation.
- Regularly empty the spent mandrel container: Overloading may cause damage to the tool.
- Do not use the tool as a hammer.
- Regularly check the compressed air connections for 'play' and leakage.
- Prior to maintenance and when not in use, always disconnect the tool from the compressed air supply.
- Safety glasses should always be worn when using the riveting tool. The use of any personal protective clothing is always recommended.
- Do not exceed the air pressure limit of the tool.
- When not in use, make sure that the tool cannot fall to the floor.
- Repairs should be carried out only by qualified staff. When in doubt, the tool should be sent back (not dismantled) to the supplier or to Gesipa.

3. Working Range

Type of tool		TAURUS 1	TAURUS 2	TAURUS 3
Standard blind rivet Ø	(mm)	2,4 – 3,2 all materials	up to 5 all materials	up to 6,4 all materials
		up to 4 Alu	up to 6 Alu	up to 8 Alu

4. Technical Data

Type of tool		TAURUS 1	TAURUS 2	TAURUS 3
Weight	(kg)	1,3	1,6	1,9
Operating pressure	(bar)	5-7	5-7	5-7
Stroke	(mm)	15	18	25
Air connecting hose Ø	(mm)	6	6	6
Spent mandrel container capacity	(spent mandrels)	approx. 100 to 200 acc. to size		
Air consumption	(Liter/rivet)	ca.1,2	ca.1,8	ca.2,3
Setting Power at 5 bar	(N)	4.200	9.000	14.000
Hydraulic fluid ISO VG 32 up to 46	(ml)	ca.30	ca.30	ca.30
Noise emission L_{pa}	(dB)	77	78	79
Vibration	(m/s^2)	< 2,5	< 2,5	< 2,5
Compressed air requirement	(filtered)	✔	✔	✔
Integrated spent mandrel ejection		✔	✔	✔
Integrated rivet retention		✔	✔	✔

5. Equipment/Accessories

Type of tool	(Part-N°.)	TAURUS 1	TAURUS 2	TAURUS 3
Nosepiece in working position		17/18	17/27	17/36
Nosepieces in tool base		17/24 17/27	17/29 17/32 17/36	17/40 17/45
1 wrench SW12/14	(756 2195)	✔	✔	✔
1 wrench SW14/17	(756 2187)	✔	✔	✔
1 bottle of Hydr. fluid 100 ml	(715 8955)	✔	✔	✔
1 oil filling container	(756 2179)	✔	✔	✔

6. Nosepiece table

Rivet Ø (mm)	Rivet Material	Nosepiece	Part-N°.
2,4	Alu	17/18	725 2075
3,2	CAP-Alu, CAP-CU	17/18	725 2075
3 and 3,2	Alu, CU, Steel, Stainl. Steel, Stinox, Alu/Alu, PG- Alu, PG-Steel	17/24	725 1583
4	Alu, CU, CAP-Alu, CAP-Cu	17/24	725 1583
4	Steel, Alu/Alu, PG-Alu	17/27	725 2040
4	Stainl. Steel, Stinox, PG-Steel	17/29	725 2059
5 and 4,8	Alu, CAP-Alu, CAP-CU, PG-Alu	17/29	725 2059
5 and 4,8	Steel, Alu/Alu	17/32	725 2067
5 and 4,8	Stainl. Steel, Stinox, PG-Steel	17/36	725 2083
6	Alu	17/36	725 2083
6	Steel	17/40	725 2560
6,4	Alu	17/40	725 2560
6,4	Steel, Alu/Alu	17/45	724 3065
8	Alu	17/45	724 3065

BULB-TITE Ø (mm)	Rivet Material	Nosepiece	Part-N°.
4	Alu/Alu	17/26 BT*	725 2202
5,2	Alu/Alu	17/32 BT*	725 2210
6,3	Alu/Alu, Steel/Steel, Monel/Stainl. Steel	17/42 BT*	725 2229
7,7	Alu/Alu	17/48 BT*	725 2237

MEGA-GRIP Ø (mm)	Rivet Material	Nosepiece	Part-N°.
4,8	Alu/Alu, Steel/Steel, Stainl. Steel	17/31 MG*	725 2250
6,4	Alu/Alu, Steel/Steel, Stainl. Steel	17/41 MG*	724 3146

* Available as a special accessory
Elongated nosepieces and further special nosepieces available on request.

7. Starting Procedure

Before use, read, pay attention to and carefully keep both the operating and safety instructions.

Ensure a specialist.connects the compressed air supply to the riveting tool

7.1 Installation of the spent mandrel

Screw the spent mandrel container on to the tool by turning it clockwise.

7.2 Selection and exchange of nosepieces

Attention: Always use a nosepiece corresponding to the blind rivet size (selection according to table point 6.)

Exchanging nosepieces

- Disconnect the tool from the compressed air
- Unscrew the nosepiece from the tool head
- Screw in and tighten the replacement nosepiece.

7.3 Setting a blind rivet

- Connect the tool to the compressed air.
- Insert the blind rivet into the nosepiece and place the rivet into the workpiece
- Press the yellow trigger until mandrel breaks.
- Release the yellow trigger
- The mandrel is automatically transported to the mandrel container (see point 7.5)

7.4 Suction and holding of a blind rivet

This feature allows the blind rivet to be held in the tool nosepiece for vertical, downwards riveting.

- Open the ON/OFF valve N° 88 in the tool head by pushing it to the right or left stop with a pin (e.g. a mandrel) to enable the suction feature.
- After Closing the hand on the pistol grip push slider N° 86 upwards to stop to switch on the suction. Pushing slider N° 86 downwards will switch off the suction.
- Pushing back the ON/OFF valve N° 88 will permanently disable the suction feature.

7.5 Emptying the mandrel container

- The mandrel container must be emptied regularly; Overfilling causes the tool to malfunction.
- Unscrew the container counter-clockwise and dispose of spent mandrels according to valid recycling procedures.
- Screw the spent mandrel container back on to the tool.

8. Maintenance and Care

The complete jaw assembly must be regularly maintained.

8.1 Lubricating the jaws

- Disconnect the tool from the compressed air
- Screw off steel head N° 24
- Dip the complete jaw housing into oil as far as N° 17 O-ring, or spray oil on Jaws N° 15
- Reassemble in reverse order.

8.2 Exchanging jaws

- Disconnect the tool from the compressed air
- Screw off steel head N° 24
- Screw off jaw housing N° 16
- Remove jaws N° 15
- Clean jaw housing and grease friction surfaces
- Insert new jaws from the front (grease will hold in position)
- ReasseHydraulic fluid refill

8.3 Hydraulic fluid refill

- Disconnect the tool from the compressed air
- Screw off steel head N° 24
- Unscrew and remove fluid refill screw N° 30 c/w sealing ring N° 31, using a T20 Torx screwdriver
- Screw on included oil filling container with cover
- Reconnect the tool to the air pressure and depress yellow trigger once. Disconnect the tool from compressed air
- Empty old oil from the oil container.
- Fill oil container with new hydraulic fluid, up to mark
- Move traction rod back and forth carefully several times by hand until oil escapes bubble-free. Push traction rod fully back up to stop and leave in this position.
- Remove oil filling container and screw back sealing ring and refill screw
- Reconnect the tool to compressed air and depress trigger twice.
- Carefully loosen oil filling screw by 2 revs; Traction rod will move slowly up to forward stop. Wipe away spilt oil.
- Retighten oil filling screw
- Screw on steel head N° 24

8.4 Storage conditions
Keep tool in a dry, frost-proof area

9. Repair

In principle, warranty repairs should only be carried out by the manufacturer.

When warranty expires, repairs should be carried out by trained personnel. Failure to correctly carry out setting instructions and incorrect handling can lead to serious tool defects. When in doubt, the tool should be returned to the manufacturer.

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10. Troubleshooting

10.1 Blind rivet does not set

Cause	Remedy
– Jaws N° 15 dirty	– Clean and lubricate (point 8.1)
– Jaws N° 15 worn	– Change jaws (point 8.2)
– Low air pressure	– See air pressure requirement (point 4)
– Stroke too small	– Refill hydraulic fluid (point 8.3)

10.2 Spent mandrel is not evacuated

Cause	Remedy
– Spent mandrel container full	– Empty spent mandrel container (point 7.5)
– Wrong nosepiece in use	– Change according to table (Point 6)
– Nosepiece worn	– Change nosepiece
– Spent mandrel jammed in jaw housing	– Clean and oil jaws or change if worn (point 8.2)

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11. Warranty

This riveting tool has a six-month warranty from the date of delivery (to be proven by invoice or delivery note). Damage caused by wear, overload or improper handling is excluded from the warranty.

Damage caused by material or manufacturing defects will be covered by the warranty and will be repaired or replaced free of charge.

Claims can only be accepted if the complete riveting tool **(not dismantled)** is returned to the distributor, or to **GESIPA.**

12. CE Conformity Declaration

We hereby declare that the construction of the pneumatic hydraulic blind riveting tools

TAURUS 1 ***TAURUS 2*** ***TAURUS 3***

when used in accordance with the operating instructions meets the following standards, laws and regulations:

- Machinery Directive 98/37 EEC
  Appendix I, II, III and V
- 91/368 EWG Abl. EU Nr. L 198-16
  91/392 EWG Abl. EU Nr. L 183-9
  PrEN 31200 Edition 06/93
  PrEN 31204 Edition 06/93
  ISO 3744 Edition 1981
- Vibrations according to ENV 28662–1;
  9. GSGV; 91 / 368 EWG
  Plus all cited directives
- Applicable national technical specifications GSG
  (Appliance Safety law ; Accident Prevention regulations)

Harder

H.U. Harder
(Safety Officer)