

TAURUS 1-2-3

Repair Instructions



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in Blind Riveting*

This document shows the chronology of the disassembling of the Taurus tool series, illustrated by corresponding pictures. This operation necessitates the use of special tools which are separately listed. Special procedures which must be followed are described in details and pictured. Reference is also made to the operating instructions booklet as well as to the illustrated parts price list.

- Disconnect the tool from the air pressure supply
- Unscrew head (24)
- Unscrew jaw housing (16)
- Unscrew rest mandrel container (103/104)
- Unscrew pressure pipe screw (43a,43) with spring washer (49)

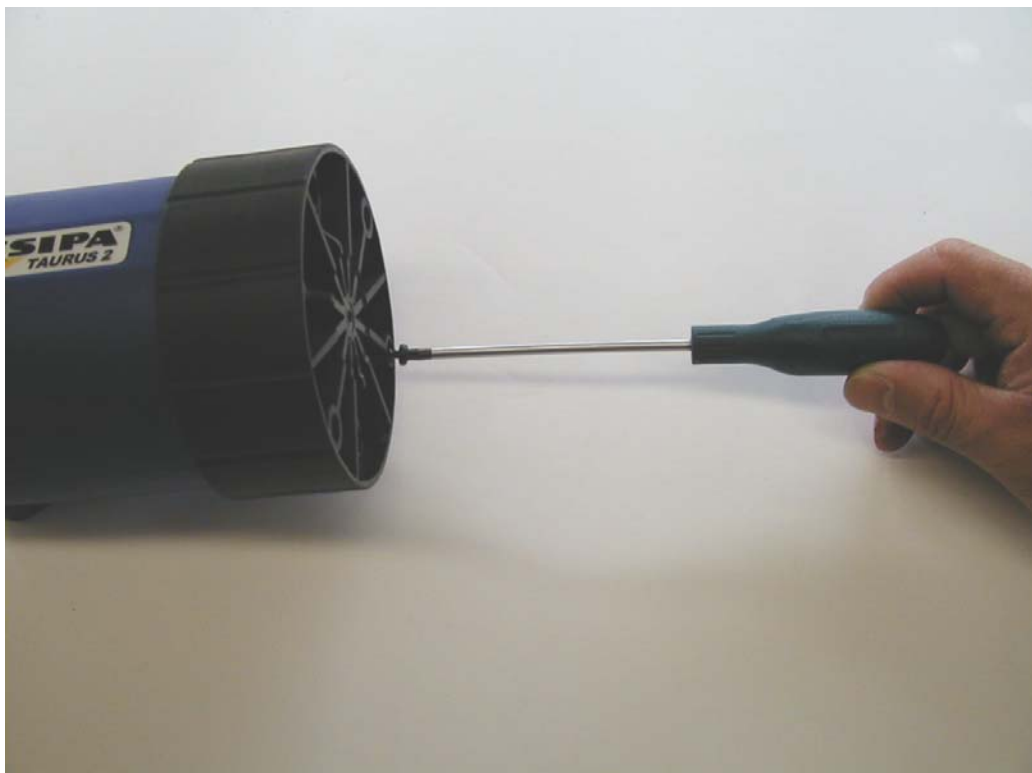


- Re-install the rest mandrel container (103/104)

- Pull-off adapters (42) with lock (41) and retaining spring (48) using the rest mandrel container itself



- **Important:** Remove the housing screw from tool bottom. This screw is maintaining the tool bottom in place and prevents its separation from the tool.



- Carefully install the main cylinder in a vice.
- Unscrew tool bottom (76,77,78) using a wrench for twin holed nuts according to DIN 3116.



- Install the tool into the clamping jig (Special tool P/N 756 0007)
- Extract the aluminium cylinder(69,70,71)



Extract the air piston (72,73,74) using a plier



- Unscrew Alu nut (57) using the special wrench P/N: 756 2005



- Carefully remove the complete air cylinder housing (58,59,60) from the aluminium tube
- Take great care of not damaging O- Ring (56) !



- Unscrew the rear screw plug (40) using special wrench P/N 756 2006



- Remove the tool head from the clamping jig
- Remove the complete grip section



- Empty the hydraulic fluid into an adequate container



- Push traction rod (25) backwards out of the tool head
- Remove reset plunger (36) from the traction rod



- Use a 17mm dia. Alu or plastic stamp for removal of the sealing ring holder (32)
- Plug the stamp into front of tool head and eject carefully the sealing ring holder using a light hammer.



Proceed as follows in case the control valve (see cut A-A in operating instructions) has to be removed from the air cylinder housing (58,59,60):

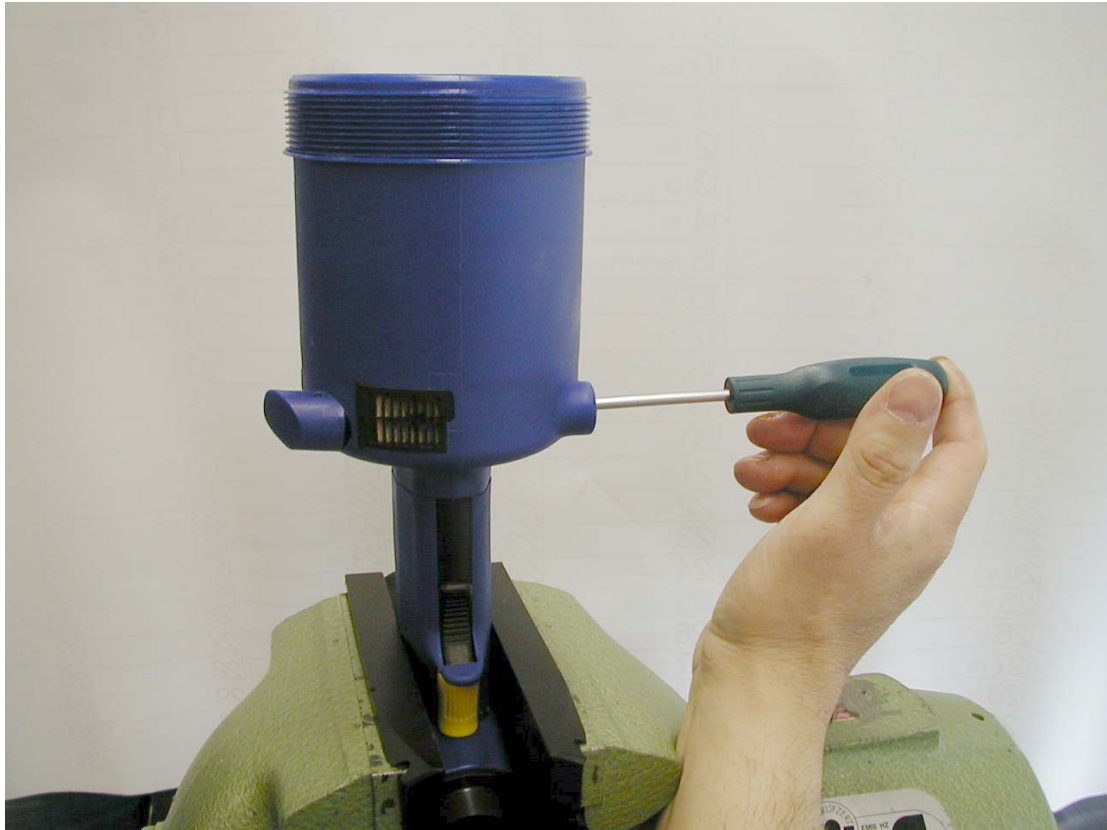
- Remove screw (75) using a T20 Torx screw driver



- Unscrew the safety valve (90) using an adequate screw driver



- Use an adequate tool to push out the control piston (92) and the plug (96,97,98) from the side of the safety valve
- Push the airzet rod sealings (93) and spacer cage (91) out of the air cylinder housing.



- Order of sequence of the different components of the control valve.



- **Re-installation** of the control valve into the tool requires the use of the spezial Mounting tool for airzet ring, P/N 756 2008.
- Use this tool as follows :
 1. Insert introduction help into base body
 2. Drop Airzet ring into side slit.
 3. Insert stamp from above and carefully push down until you feel the airzet ring engaging into the introduction help.
 4. Pull the introduction help down



- Push the introduction help sideways into the air cylinder housing.
- Push with your thumb on the base of the introduction help and then pull back with your fingers until Stop.
- Grease the Airzet-Ring
- Mount all parts following the drawings shown in the operating instruction booklet or on the spare parts price list.
- **Warning : Important notice:**
Take good care of correct installation of the distance cage (91) into the control valve of the Taurus 2 and 3 tools. The distance cage carries a slot on one side. Insert the distance cage with the slotted side first in such a way that the slot connects with the nose inside the control valve bore. Installation of the 3 following distance cages is indifferent.
The first distance cage is not present in the Taurus 1. Installation of the 3 distance cages is indifferent.



Re-assembling the tool is done in reversed sequence