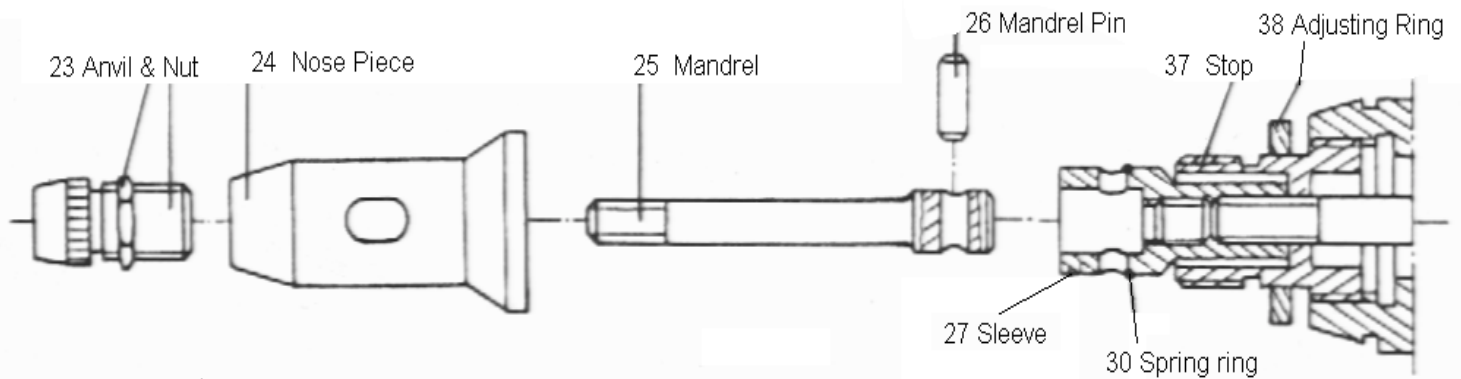




TROUBLESHOOTING (continued)

PROBLEM	POSSIBLE CAUSE	REMEDY
RIVKLE spins after installation	RIVKLE being used is not compatible with material thickness	Check the grip range of the RIVKLE
	The head of the RIVKLE is not in contact with the anvil during installation	Ensure the anvil is properly set
	Insufficient stroke setting	Reset stroke distance
	Insufficient air pressure	Check air pressure
	Lack of hydraulic fluid	Add hydraulic fluid
Mandrel becomes jammed in threads of installed RIVKLE **	Incorrect size RIVKLE being used	Use correct size RIVKLE
	Stroke setting incorrect	Reset stroke Distance
	Operator did not have RIVKLE fully inserted into the work piece during installation	Ensure RIVKLE is fully inserted in the hole with its head resting on the surface of the material

**Refer to instructions on previous pages to free the jammed mandrel



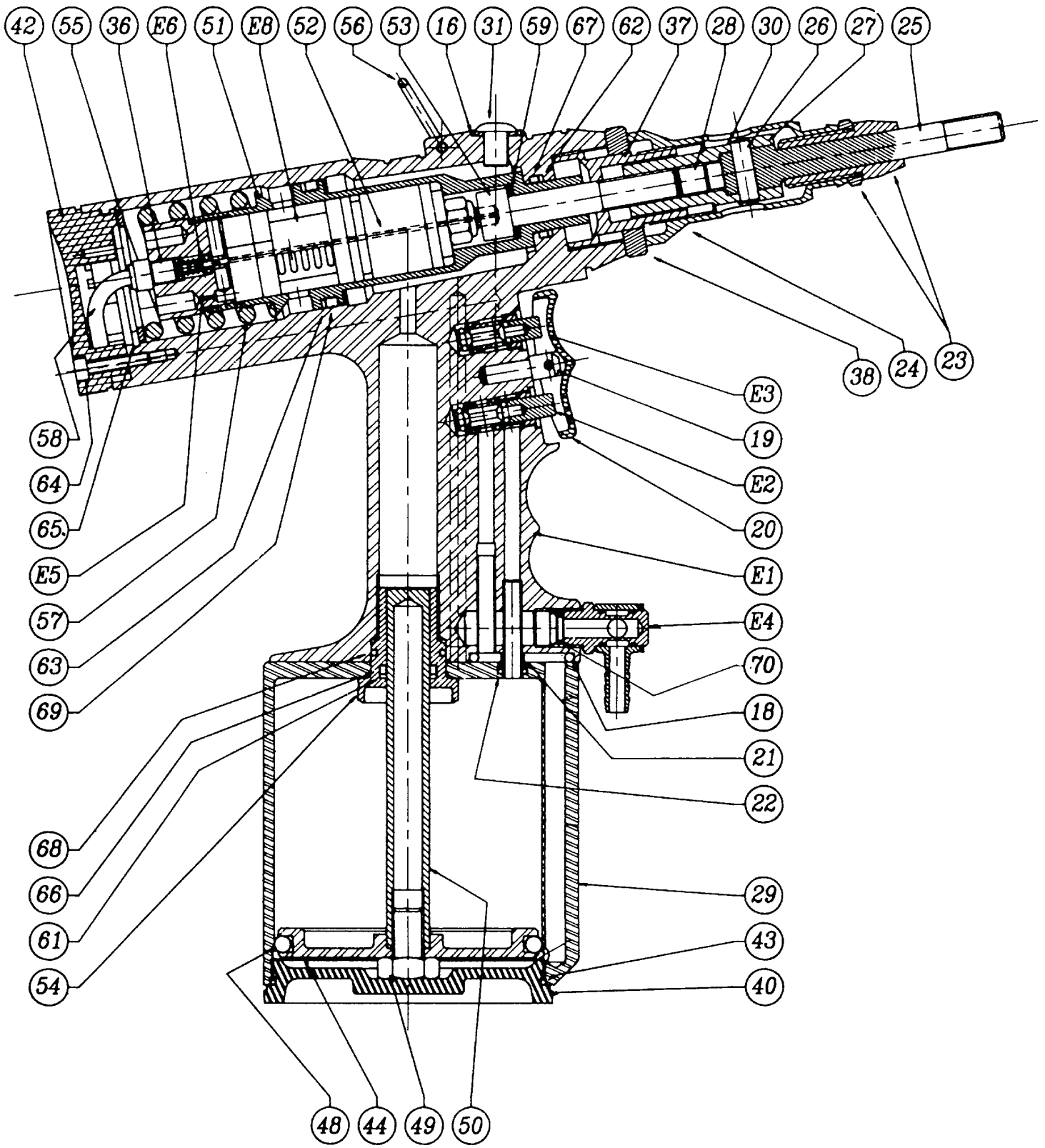
FRONT END COMPONENT REFERENCE

INSERT SIZE	ANVIL PART #	MANDREL PART #
M3	4068/4069-4074-M3	4068/4069-4075-M3
M4	4068/4069-4074-M4	4068/4069-4075-M4
M5	4068/4069-4074-M5	4068/4069-4075-M5
M6	4068/4069-4074-M6	4068/4069-4075-M6
M8	4068/4069-4074-M8	4068/4069-4075-M8
M10	4068/4069-4074-M10	4068/4069-4075-M10
M12	4068/4069-4074-M12	4068/4069-4075-M12
6-32	4068/4069-4074-632	4068/4069-4075-632
8-32	4068/4069-4074-832	4068/4069-4075-832
10-24	4068/4069-4074-1024	4068/4069-4075-1024
10-32	4068/4069-4074-1032	4068/4069-4075-1032
1/4x20	4068/4069-4074-2520	4068/4069-4075-2520
5/16x18	4068/4069-4074-3118	4068/4069-4075-3118
5/16x24	4068/4069-4074-3124	4068/4069-4075-3124
3/8x16	4068/4069-4074-3716	4068/4069-4075-3716
3/8x24	4068/4069-4074-3724	4068/4069-4075-3724
1/2x13	4068/4069-4074-5013	4068/4069-4075-5013
COMPONENT	DESCRIPTION	PART NUMBER
# 24	Nose piece	4068 4076 9
# 26	Mandrel pin	4068/4069-4099
# 27	Sleeve	4068 4076 11
# 30	Spring ring	4068 4076 14
# 37	Stop	4068 4076 17
# 38	Adjusting ring	4068 4076 18

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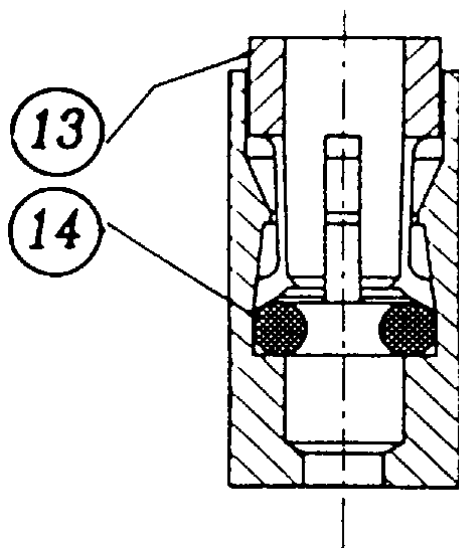
See following page for detailed views.

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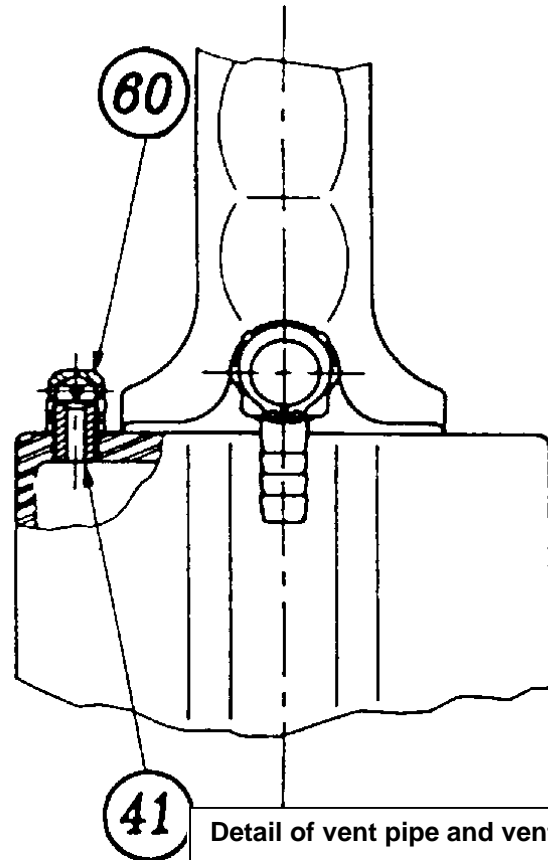
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CHECK OIL DAILY



Detail of push / pull valve



Detail of vent pipe and vent cap

4068 Pneumatic/Hydraulic Tool Checking Hydraulic Oil Level

To ensure proper operation of the 4068 tool, the hydraulic oil level must be checked periodically. This is a simple task, following the steps below.

1. Disconnect air hose from the tool.
2. Place the tool upright on a bench or other level surface.
3. Remove the oil fill plug using a 5mm allen wrench.
4. Remove the vent cap from the air chamber.
5. Using Bollhoff special tool #2361 5301 034 (or a section of heavy wire such as a straightened coat hanger), depress the air piston fully downward until it stops.
6. Inspect oil level at the fill plug hole. Add oil as needed until the oil level reaches the base of the hole. **Use Mobil DTE ISO VG68 or equivalent.**
7. Reinstall oil fill plug and vent cap.
8. Connect air hose, cycle the tool several times to force any air bubbles out of the oil.
9. Recheck steps 1-7 to verify that oil level is stable.

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Hydro- Pneumatic installation tool 4068

Spare part list

No.	Part No.	Description	Qty
13	4068 4076 1	Fast inside connecting tongs	4
14*	4068 4076 2	Fast connecting joint	4
16*	4068 4076 3	BS ring, ID 8 mm	1
18*	4068 4076 4	Feed tank joint	1
19	4068 4076 5	Trigger axle	1
20	4068 4076 6	Trigger	1
21	4068 4076 7	Tank spacer	1
22*	4068 4076 8	Tank return joint	1
23	Varies	Anvil and locknut (see 2.1)	1
24	4068 4076 9	Nose piece	1
25	Varies	Mandrel	1
26*	4068/4069-4099	Mandrel drive pin	1
27	4068 4076 11	Sleeve	1
28	4068 4076 12	Bolt M 10x10	1
29	4068 4076 13	Pneumatic	1
30*	4068 4076 14	Spring ring	1
31	4068 4076 15	Bolt M 8x10 ISO 7380	1
36	4068 4076 16	Bolt M 8x8	1
37	4068 4076 17	Travel/Stroke stop	1
38	4068 4076 18	Adjusting ring	1
40	4068 4076 19	Jointless tank plug	1
41	4068 4076 20	Vent	1
42	4068 4076 21	Rear plug	1
43*	4068 4076 22	Tank plug joint	1
44	4068 4076 23	Jointless pneumatic piston	1
48*	4068 4076 24	Pneumatic piston joint	1
49	4068 4076 25	Bolt M 10 DIN 933, galvanized	1
50	4068 4076 26	Emitter piston	1
51	4068 4076 27	Receiver piston	1
52	4068 4076 28	Push-pull rod	1
53	4068 4076 29	Drive shaft	1
54	4068 4076 30	Steady bush	1
55	4068 4076 31	Spring washer	1
56	4068 4076 32	Hook	1
57	4068 4076 33	Spring	1
58*	4068 4076 34	Flexible pipe	2
59*	4068 4076 35	Thrust washer	1
60	4068 4076 36	Vent plug	1
61*	4068 4076 37	Back-up ring	1
62*	4068 4076 38	Back-up ring	1
63*	4068 4076 39	Back-up ring	1
64	4068 4076 40	Bolt M4 x 20	1
65	4068 4076 41	Rear inside circlip	1
66*	4068 4076 42	Dynamic bearing joint	1
67*	4068 4076 43	Front Dynamic joint	1
68*	4068 4076 44	Static bearing joint	1
69*	4068 4076 45	Rear dynamic joint	1
70	4068 4076 46	Air inlet hose	1
E1	4068 4076 47	Body sub-assembly	1
E2*	4068 4076 48	Crimping valve (piston, sleeve, joints)	1
E3*	4068 4076 49	Unscrewing valve (piston, sleeve, joints)	1
E4	4068 4076 50	Complete banjo	1
E5	4068 4076 51	Distributor motor	1
E6*	4068 4076 52	Push-pull valve (piston, sleeve, joints)	1
E8	4068 4076 53	Compressed air motor	1

*Repair case comprised of the parts marked with **

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