

Hydraulic Pressing Tool for cordless screwdrivers

Assembly- / Operating Instruction GB



US





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1.1 Notes regarding this manual

Notice

Legislation stipulates that workers handling hydraulic driven riveting tools must be trained and instructed. The training and instruction must be carried out by a Wieländer+Schill instructor or an officially authorized W+S representative.

State-of-the-art technology

This riveting tool represents state-of-the art technology. To ensure the functionality of the equipment, it must be operated in a proper and safe manner.

Handling

All handling necessary to ensure correct operation is described in the instruction manual. No work method other than that expressly approved by the manufacturer may be used.

Faults

In the event of a fault, the user may only carry out repair work for the faults for which the relevant maintenance process is described in this manual.

Read the instruction manual

Read the instruction manual carefully before using the riveting tool

1.2 Explanation of symbols

There are some sections of this manual that use internationally known warning symbols, warning notes and general instructional symbols.





1.3 Marking

Marking on the XPac



- **A** Type designation
- B Serial number and manufacturing date
- C Verification code
- **D** Force range
- E recommended rpm cordless screwdriver

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2.1 Operating mode

The **XPac** is a mechanically and hydraulically driven pressing device for a wide range of applications that require a high pressing force of up to 80 kN or 8t.

A commercially available cordless screwdriver of medium power class serves as drive unit.

The rotation energy of the cordless screwdriver activates a high-pressure pump, which activates a high-pressure cylinder via a pressure control valve.

A full stroke pressure control valve switches off the tool at a preset pressure when the preset end force is reached.

A manually operated relief valve moves the high pressure cylinder back into its Return to original position.





The **pressure control knob** of the *XPac* allows for the setting of the operating pressure and therefore the working pressure.

Before each working operation, please check the pressure setting at the *XPac*.

The pressing force of the device is directly adjustable with the rotary knob. The display means:







2.2 Technical Specifications

Permissible hydraulic OIL	Hydraulic OIL according to DIN 51524AFT-OILaccording to DIN 51562-2Type HLP 22 - HLP 36
Viscosity of the OIL	ca. 22 - 36 mm²/s bei 40°C
OIL filling capacity	60 ccm
Ambient temperature	5 - 50 C° / 41 - 122°F
Prescribed safety clothing	Protective gloves, face mask

2.3 Technical data XPac riveting system



Length	230 mm
Wide	63 mm
Height	130 mm
Height comp.	295 mm
Weight compl.	3,41 Kg
OIL capacity	60 ccm
Pressing force	25 kN - 80 kN
Cylinder stroke	25mm
Required speed	1250 - 1500 rpm
Required torque	12,5 Nm

2.4 Safety instructions



The hydraulic tool kit is strictly approved only for the purpose intended by the manufacturer.



Only genuine accessories may be used. Use of non-genuine tools or accessories represents a major safety hazard.



Ensure that only trained and instructed personnel use this equipment. Use of the equipment by personnel that have not been trained and instructed is prohibited.



Ensure that the instruction manual is made available to operating personnel.



Observe the applicable national regulations for accident prevention.



Because metallic parts can break up and fly off with high energy if the tool is faulty or operated incorrectly, protective gloves and face mask must strictly be worn for all applications of the equipment.



As a result there is a risk of severe physical injury.



Never throw the tool or allow it to fall. Never misuse the tool or let untrained personnel use it.



The tool must only be used in ambient temperature of above 5 °C (41°F) and up to maximum 50 °C (122°F).



The tool must never be used in potentially explosive areas.



Before starting work, always ensure that the pressure regulator is set according to the work requirements!



The manufacturer accepts no liability for damage or injury caused by improper repair or the use of replacement parts made by other manufacturers..



2.5 Maintenance

The tool's hydraulic system must be kept free of dirt and other contamination.



Foreign materials in the hydraulic oil can cause the tool system to malfunction of the unit and can therefore also cause injuries.



During maintenance and service work, the instructions of the tool must be observed.



Basically this tool system is maintenance free.



All service and maintenance work may only be performed by trained and instructed technicians or by the manufacturer. If you should have technical problems or need a service technician please contact the service number below:

Wieländer+Schill

Professionelle Karosserie-Spezialwerkzeuge Neue Wiesen 8 D-78609 Tuningen Telefon: +49 (0)7464 / 9898-0 Telefax: +49 (0)7464 / 9898-289 E-Mail: info@wielanderschill.com

2.6 Warranty

The hydraulic tools of Wielander + Schill come with a 12 month warranty against material and manufacturing defects. This does not cover normal wearing parts of the actuator and adapters.

The warranty period begins from the date of delivery, as specified on the invoice or delivery note.

The warranty is valid for the user / buyer provided that the tool is obtained from an authorized sales outlet and is used as described in the instruction manual and for the purpose for which it was designed.

The warranty becomes invalid if the tool is used for purposes other than those for which it was designed.

In addition, the warranty becomes invalid if the tool is not used as described in the instruction manual.

In the event of defect or fault, Wielander & Schill will only repair or replace faulty parts at its own discretion..

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3.1 Connecting and adjusting the XPac

The *XPac* is delivered as standard without a cordless screwdriver. Use a commercially available cordless screwdriver to work with the *XPac*. However, the device should have a minimum torque of 12.5 Nm.



Before using the *XPac*, check the condition of the tool for any damage – for example oil leakage or loose components. Such damage could cause severe physical injuries during use.



Defective components or other damage must be repaired or replaced by qualified personnel.



Make sure that the XPac is always placed on a non-slip surface, stored safely and cannot fall down



Make sure that the Power Pack *XPac* is set up in a work area that is free from heat sources (max. 50 °C/ 120 °F), and free from corrosive liquids, greases and oils.



ATTENTION! The drill chuck must never be opened or closed with the driven cordless screwdriver!



Pre-mount the torque arm on the XPac.





ATTENTION! To avoid injury, lock the cordless screwdriver before connecting the *XPac*.



Insert the cordless screwdriver into the locking ring of the *XPac*.



Tighten the drill chuck by hand.







Push the locking ring backwards over the drill chuck.

Tighten the locking ring with left thread firmly.



Position the torque arm of the *XPac* on the cordless screwdriver.



Position the support elements on the battery without play and tighten the knurled screws.



Also tighten the knurled screw of the torque arm at the top of the *XPac*.



Setting on the cordless screwdriver.



Select second gear for all applications. (fast forward)

Torque adjustment to maximum.

GB US



Set the required force on the pressure control knob.



The relief lever can be turned 360° in both directions.



To release the XPac, push the release lever up . Not more than 60°.



Or press down. Not more than 60°.





After mounting the C-arm (chapter 3.2) and the inserts, loosen the lock on the cordless screwdriver.

The *XPac* is now ready for operation.



3.2 Connecting C-arm



1. Press the safety button at the locking mechanism.



3. To make it easier to slide the C-frame onto the *XPac*, use Molycote Dx paste (50g) Item no. 700144.



2. Turn clockwise the locking lever while pressing the safety button.



4. Locate the C-Arm in the centre of the intake of the **XPac**. The index pin must engage in the corresponding slot.

Push the C-arm onto the intake of the XPac.



5. Close the locking lever clockwise to close



6. The C-arm is correctly mounted when the safety button jumps out completely and a green mark is visible. This action is accompanied by an audible click.



Attention!

The mounting hole of the C-arm must be free from contamination and damage. The locking mechanism must engage smoothly. It should not be possible to move the locking lever once the mechanism is engaged.

Damaged or defective components can cause physically injuries and must not be used under any circumstances!



3.3 Example: Mounting the mandrel and die





Hold the side plate with your finger. Screw the required mandrel into the Carm.





Hand-tighten the riveting head provided. **Apply no excessive force!**





Screw the corresponding counterpart into the insert on the opposite side of the C-arm (plunger rod) with the included spacing adapter – hand tighten.





Do not use any tools for tightening. Only tighten by hand!





Before each assembly of the rivet inserts, the correct choice of the setting head and closing head to the rivet must be taken from the repair instructions.





Check that the riveting heads are firmly seated after each riveting process. Rivet inserts that have become loose present a hazard and can lead to equipment damage or injuries.

4.1 Put out of operation and storage



Open the locking lever on the C-arm - with the safety button pressed down - clockwise.



Remove the C-arm from the *XPac*.







Loosen knurled screws on the support elements.

Abb. 4.1.c



Open the support elements on the torque arm.



Un-screw the locking ring.



Push the locking ring forward.



Open the drill chuck on the cordless screwdriver.



Disconnect the cordless screwdriver from the *XPac.*



ATTENTION! The drill chuck must never be opened or closed with the driven cordless screwdriver!



4.2 Cleaning and maintenance



Check the system at regular intervals for possible oil leakage. A loss of oil indicates a fault in the system. In this case, interrupt work and return the unit to an authorized dealer for repair.





Foreign objects or contamination in the area of the locking ring can cause the equipment to malfunction. Remove foreign objects or contamination in this area with a clean cloth.





To protect the metallic surface from corrosion you can use a standard corrosion protection product such as Caramba, Ballistol or WD40.



5.1 International service and repair partners

https://www.wielanderschill.com/service/vertretungen-weltweit/ https://www.wielanderschill.com/en/service/distributors-worldwide/







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