VOLKSWAGEN
GROUP

Operating instructions
Premium Booster VAS 843 007

manufactured by: WS Wieländer+Schill GmbH & Co.KG
Professionelle Karosserie-Spezialwerkzeug



Wieländer+Schill

Manufacturer:

WS Wieländer+Schill GmbH & Co.KG
Professionelle Karosserie-Spezialwerkzeug
Neue Wiesen 8
D-78609 Tuningen
info@wielanderschill.com
www.wielanderschill.com

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Safety instructions

1.1 Notes on instructions

Notice
The law stipulates that the user must be trained in the use of hydraulically driven punching and riveting tools. The instruction/training must be carried out by a W+S field representative or by a person authorized by Wieländer+Schill.

State of the art
This work tool corresponds to the current state of the art. For the device to function safely, professional and safety-conscious operation is required.

Handling
All actions necessary for correct operation are described in the operating instructions. No other working methods that are not expressly approved by the manufacturer may be practiced.

Disturbances
If malfunctions occur, you may only repair malfunctions yourself if the corresponding maintenance processes are marked.

1.2 Symbol explanation



Safety notice/danger
This information is used to ensure safe operation. If this is not observed, the safety of the operator cannot be guaranteed.



Danger!
Risk of crushing hands



Danger!
Risk of crushing fingers



Danger!
Danger of environmental pollution

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Danger!
System is under pressure



Compressed air supply
Before working on the machine, interrupt the compressed air supply.

Always disconnect the hydraulic tool from the pressure when leaving the workplace.



Information
This information serves to provide a good understanding of the function of the product. This allows the full performance of the product to be exploited.



Operating manual
Be sure to read the operating instructions before using the product.
Make sure that the operating instructions are made accessible to the operating personnel.
The guarantee is void in the event of damage caused by operating errors!



Wear face protection

Use protective gloves

1.3 General safety information



This operating manual only applies to the
VAS 843 007 punch riveting device.

Make sure that the user has read the operating instructions before putting the machine into operation, understands the information and follows it.



Only original accessories may be used. There is a high safety risk if original tools or accessories are not used.

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WARNING



It is essential to wear protective gloves and face protection when using the device, as incorrect operation or errors in the tool can cause metal parts to burst with high energy and fly away.

WARNING



The tool must never be used in potentially explosive areas.

NOTICE



Never throw or drop the tool. Never misuse the tool or lend it to untrained personnel.

The tool may only be used at ambient temperatures above 5 °C and up to a maximum of 50 °C.

NOTICE



Please observe the accident prevention regulations applicable in the respective countries.

CAUTION



Lay the compressed air lines so that there is no risk of tripping. Supply hoses lying around are a source of danger and can cause injuries.

For higher workplaces, only use approved and tested climbing aids (ladders).

When using the tool, ensure that it has a firm, secure footing.

The work area must be sufficiently lit, dimensioned and freely accessible.

Always store tools and machine parts in the designated place after use. Make sure the surface is clean.

NOTICE



Before starting work, always make sure that the air pressure is set according to the work requirements!

To operate the VAS 843 007/1 punch riveting device, only clean compressed air that corresponds to at least compressed air class 2 according to ISO 8573-1 may be used. Contaminants in the compressed air or the compressed air supply lines can cause damage to the device.

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1.4 Intended use / functionality



The modular technology of the device allows the adaptation of many functional tools for different applications. The VAS 843 007/1 punch riveting device is the basic unit for a range of different hydraulic cylinders and the C-brackets provided for them that can be combined.

Blind rivet and blind rivet nut adapters with a setting force of 22-101 kN are also available.

The device system is supplemented by a variety of special tools for customer-specific applications. The innovative riveting tools cover all areas of the riveting and punching technology covered.

The VAS 843 007/1 punch riveting device is a pneumatic-hydraulic driven pressure intensifier with tandem pistons and a single-stage high-pressure pump, precise pressure control and integrated safety valve.

With a primary air pressure of 6 bar, a maximum hydraulic pressure of 800 bar can be generated.

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VAS 843 007 punch riveting device - Smart Control Function.
1. Accurate pre-positioning
2. Trigger after precise positioning, punching or riveting process.



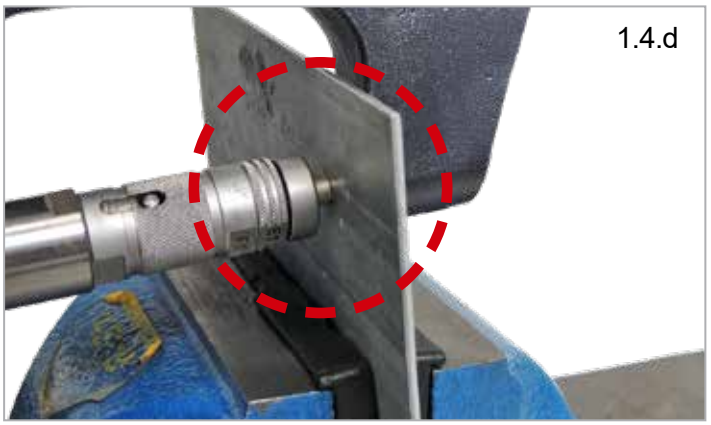
Starting position



Attach the C-arm to the workpiece using dies and rivets.



Trigger the 1st stage using the control button.



The rivet can be pre-positioned precisely on the sheet metal.
The force during prepositioning is 100-200 N.



Is the rivet positioned correctly? Press the actuating button all the way down and thus trigger the 2nd stage.



This triggers the desired work process.

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1.5 Improper use

WARNING

The hydraulic tool set is generally only approved for the applications intended by the manufacturer.

All uses other than those described under point 1.4 are considered improper use and are therefore not permitted.

1.6 Labelling

Nameplate + Description





A Type designation
B max. hydraulic pressure
C Serial no. with production date
D CE marking
E Year of production
F Barcode
G WS Wieländer+Schill with address

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1.7 Scope of delivery

Piece	Description		Item No.
1 Set	Premium Booster	VAS 843 007	932050
	consisting of:		
1 Piece	Riveting and punching tool	VAS 843 007/1	932030
1 Piece	Short stroke cylinder SSC 40/25	VAS 843 007/2	932034
1 Piece	C-arm GC 80/40	VAS 843 007/3	932036
1 Piece	C-arm GC 80/130	VAS 843 007/4	932044
1 Piece	C-arm GC 140/240	VAS 843 007/5	932046
1 Piece	Extension 60 mm for C-arm GC 140/240	VAS 843 007/6	932038
1 Piece	Handle		881341
1 Set	Tool Box Base	VAS 843 007/7	932070
1 Set	Tool Box Flow Form Rivets (FFR)	VAS 843 007/8	932075
1 Piece	Blind rivet adapter BR20	VAS 843 007/9	932032
1 Piece	Blind rivet adapter mouthpiece	VAS 843 007/10	932040
1 Piece	Service kit	VAS 843 007/11	932042
1 Piece	Special grains | 2 functions		703047
1 Piece	Transport case for complete set		960690
1 Piece	Transport case for C-frame		960691
1 Piece	USB stick BA + overview languages		799123

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Technical specifications and data

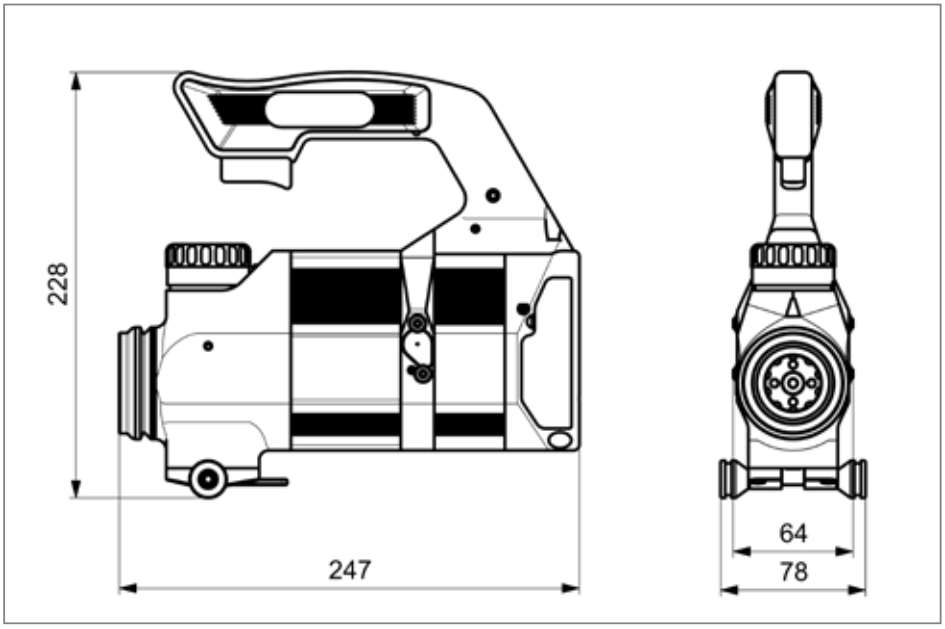


2.1 Technical specifications

Permissible hydraulic OIL	Hydraulic oils according to DIN 51524 AFT oils according to DIN 51562-2 *Type HLP 22 - HLP 36*
Viscosity OIL	approx. 22 - 36 mm^2 /s at 40°C
Filling quantity OIL	120cc
Minimum air pressure	6 bar / 87 psi
Maximum operating pressure hydraulic	800 bar / 11603 psi
Compressed air	Quality class 2 (according to ISO 8573-1)
Temperature (ambient)	5 to 50 C° / 41 to 122°F
Storage temperature	-25 to 40 C° / -13 to 104°F
Required safety clothing	Protective gloves and face protection
Emission sound pressure level	75dB(A) LPAI
Device vibration	< 2.5 m/s^2 (ISO/FDIS 8662-11)
Working speed (under load) at 500 bar	4mm/sec.

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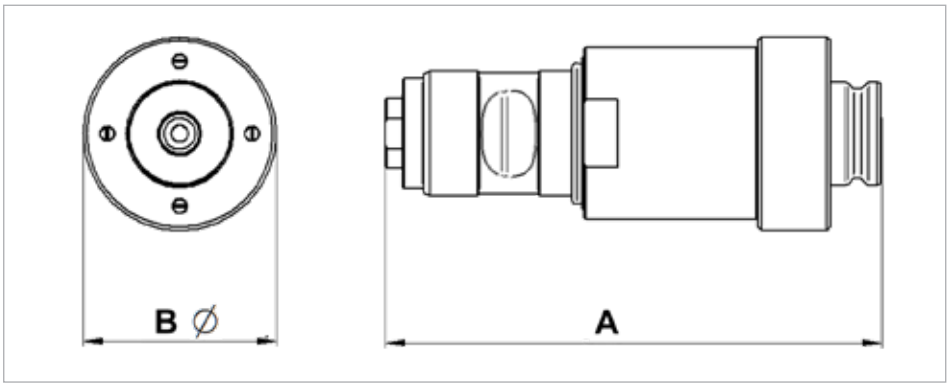
2.2 Technical data for the VAS 843 007/1 punch riveting tool



Length	247 mm
Width	64 (78) mm
Height	228 mm
Weight	3,25 kg
Pressure max.	800 bar
OIL volume	120 ccm

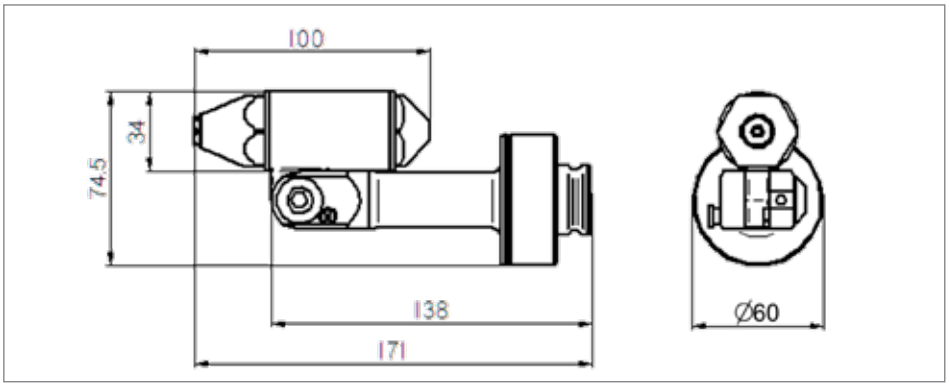
2.3 Power adapters and performance features

2.3.1 Short stroke cylinder SSC 40/25 VAS 843 007/2



A - Length	150 mm
B - Ø Diameter	60 mm
Stroke	25 mm
Pressure max.	Kapitel 2.4
Weight	1,7 kg

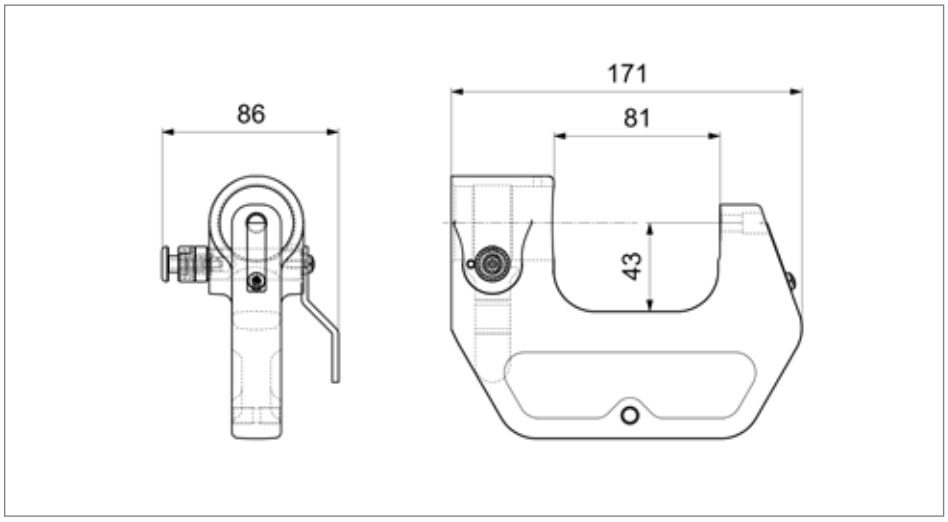
2.3.2 Blind rivet adapter BR 20 VAS 843 007/9



Length	171 mm
Wide	60 mm
Pressure max.	22 kN +/- 15% tolerance
Stroke	22 mm
Radius/Angle	120°
Interlock steps	30°
Weight	1 kg

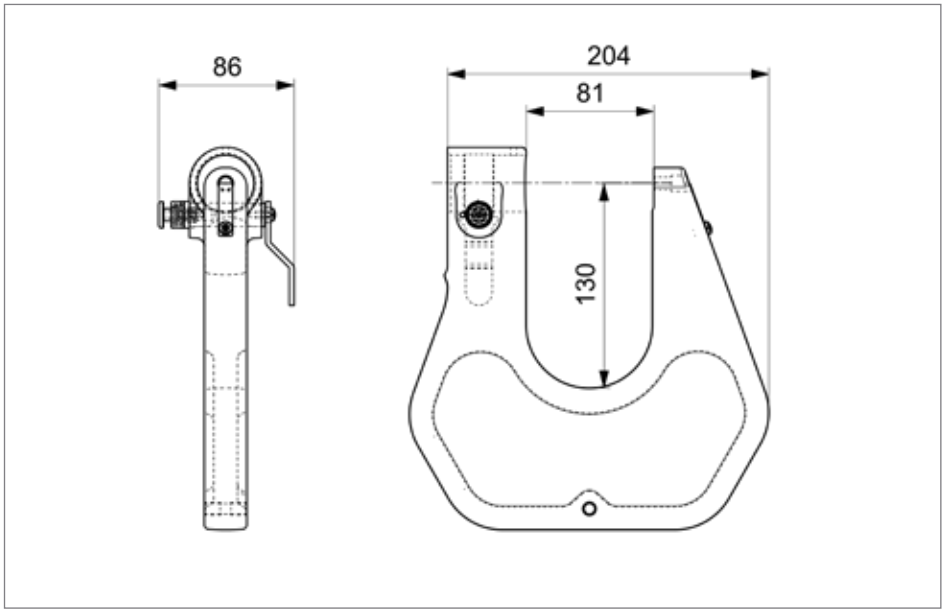
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2.3.3 C-Arm GC 80/40 VAS 843 007/3



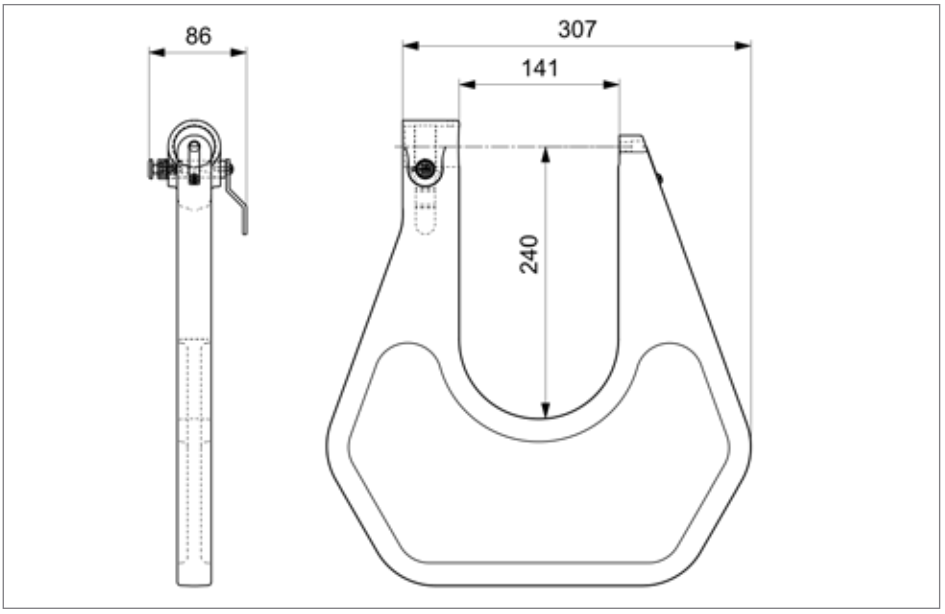
Wide	80 mm
Length	40 mm
Weight	2,3 kg
Safety locking	
additionally Hand grip	

2.3.4 C-Arm GC 80/130 VAS 843 007/4



Wide	80 mm
Length	130 mm
Weight	5,7 kg
Safety locking	
additionally Hand grip	

2.3.5 C-Arm GC 140/240 VAS 843 007/5



Wide	140 mm
Length	240 mm
Weight	13,6 kg
Safety locking	
additionally Hand grip	

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2.4 Pressure regulation

The **pressure control valve** on the VAS 843 007/1 punch riveting tool allows the operating pressure and thus the size of the available workforce on the tools to be adjusted. The pressure regulator is limited to a maximum working pressure of 6 bar on the output side, regardless of how high the input air pressure is.

2.4.a

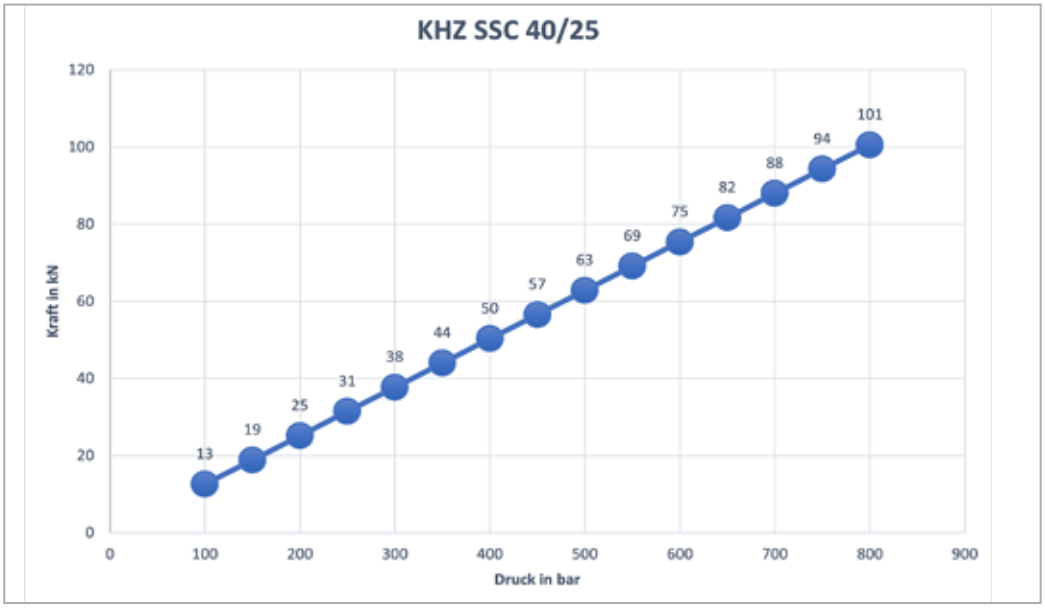


ATTENTION! The performance diagram is only valid for the adapter listed.

Pressure in bar	Force in kN
100	13
150	19
200	25
250	31
300	38
350	44
400	50
450	57
500	63
550	69
600	75
650	82
700	88
750	94
800	101

* Specified values +/- 15% tolerance

Power diagram for punch riveting device VAS 843 007/1 with short-stroke cylinder SSC 40/25 VAS 843 007/2



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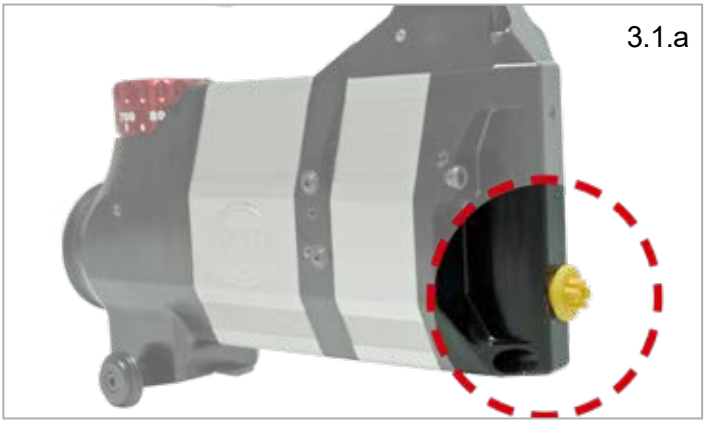
3

Installation

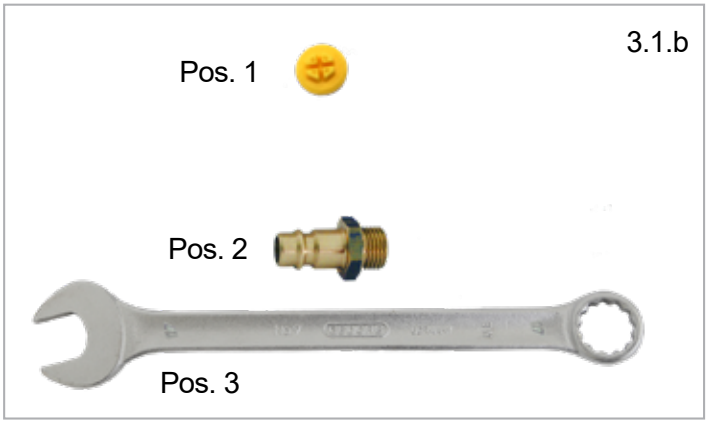
3.1 Compressed air connection

The VAS 843 007/1 punch riveting device is delivered without a compressed air connection as standard.

Remove the cap before use.


3.1.a

Remove the yellow cap (item 1).
Install the appropriate compressed air connection (item 2) in the G1/4“ thread using a size 17 open-end wrench (item 3).

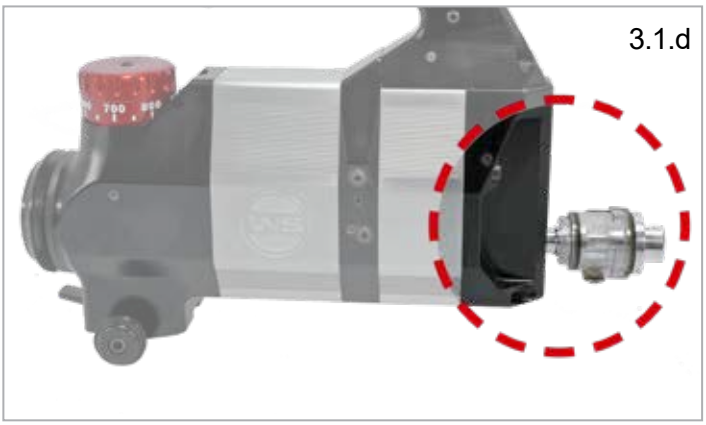


3.1.b

Mounted compressed air connection.


3.1.c

When operating with dry compressed air, use the miniature oiler with item no. 637103 from the accessories range. The oiler is screwed in between the device and the compressed air connection. The oiler must always be filled with pneumatic oil. The pneumatic oil is available under item no. 698001 available in the accessories range.


3.1.d

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3.2 Connecting the VAS 843 007/1 punch riveting device

WARNING

The VAS 843 007/1 punch riveter must be checked for any damage, oil leaks or loose components before each use. Such defects in the device can lead to serious injuries during operation.
Defective components or any defects must be replaced or repaired by qualified personnel.

NOTICE

The air pressure in the supplying compressed air network must not exceed 10 bar / 145 psi exceed.

The compressed air hose must be laid in such a way that people cannot trip!

NOTICE

The VAS 843 007/1 punch riveter must be connected to the compressed air hose. The release lever must point forward.



Always place the VAS 843 007/1 punch riveter on a non-slip surface. The compressed air hose must be laid in such a way that the device is stored safely and cannot be torn off.

NOTICE

The VAS 843 007/1 punch riveter may only be used in work areas that are free from heat sources (max. 50 °C/ 120 °F), as well as corrosive liquids, greases and oils.

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3.3 Connecting the SSC 40/25 short-stroke cylinder VAS 843 007/2



1. Fold the relief lever on the punch riveting tool VAS 843 007/1 forward.



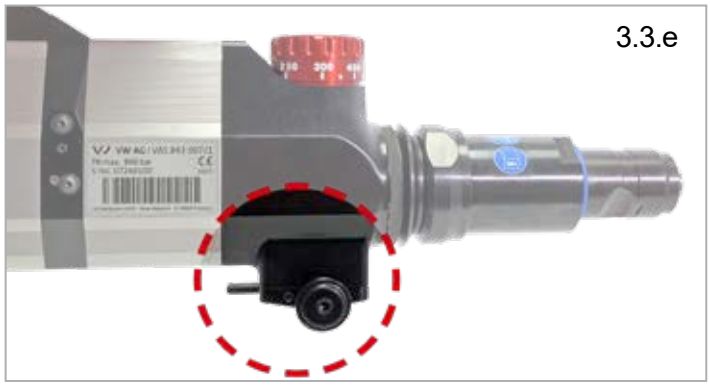
2. Pull/press locking ring backwards.
The inner red marking ring becomes visible.



3. Place the short-stroke cylinder with quick coupling in the middle.
With the locking ring pressed backwards, push the short-stroke cylinder with the quick coupling into the coupling receptacle under pressure.



4. Release the locking ring on the coupling holder.



5. Fold the relief lever backwards.

Danger!
The quick coupling on the punch riveting tool VAS 843 007/1 as well as the coupling connection on the respective adapter must be clean and free of dirt and damage!

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3.4 Correct and incorrect connection/handling of the VAS 843 007/2 short-stroke cylinder



1. Wrong !
If the red marking ring on the quick coupling is still visible, the adapter is not properly engaged.



2. Correct
Press the adapter firmly into the holder. The locking ring must snap into place and lie flat all around, otherwise the lock will not be closed.



3. Wrong !
When working, never hold the riveting tool by the coupling, otherwise the module may come loose from the riveting tool.



4. Correct
Example short-stroke cylinder with C-arm.

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3.5 Install the C-arm



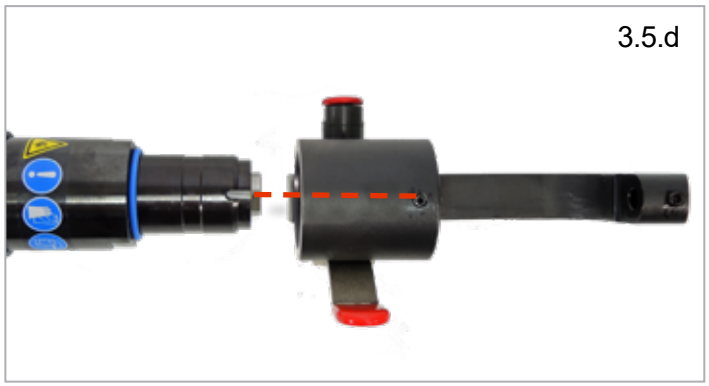
1.Press in the locking button on the locking mechanism.



2. Open the locking lever with the safety button pressed.



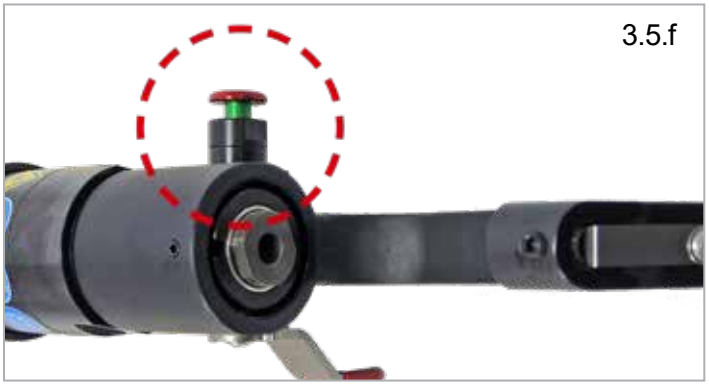
3. To make it easier to slide the C-arm onto the short-stroke cylinder, grease the inside.



4. Place the C-arm in the middle of the holder of the short-stroke cylinder. Make sure that the guide groove points in the direction of the guide pin in the C-bracket.



5. Slide the C-arm completely onto the cylinder holder. Close the locking lever.



6. The C-arm is correctly installed when the safety button pops out completely. (Green marked area visible). This process is indicated by an audible click.

Attention!
The hole in the C-arm must be free of dirt and damage. The locking mechanism must engage smoothly into the locking position.
The locking lever on the C-arm must no longer be able to be swiveled once it has snapped into place!
Damaged or defective components can cause serious injuries during operation and must not be used under any circumstances!

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3.6 Assembly of the rivet adapters


3.6.a

1. Hold the side sheet metal with your finger to screw in the riveting tool.


3.6.b

2. Screw the riveting tool required for the work process into the holder of the C-arm. Tighten the rivet head hand-tight.
Do not use force!


3.6.c

3. Screw in the extension on the opposite side and tighten it hand-tight.


3.6.d

4. Screw the corresponding counterpart to the rivet insert into the extension and tighten it hand-tight.
Do not use any tools to tighten. Hand tighten only!


3.6.e

5. Before each assembly of the rivet inserts, the correct affiliation of the setting head and closing head to the rivet must be found in the repair instructions.

After each riveting operation, the tightness of the rivet heads must be checked. Rivet inserts that have come loose pose a danger and can lead to serious injuries during operation.

NOTICE

Before each operation, the operating pressure setting on the VAS 843 007/1 punch riveting device should be checked.
If the pressure setting is too low, the rivet will not be pressed in completely!
If the pressure setting is too high, the pressing forces are so high that the sheet metal composite is deformed to an unacceptable extent.

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3.7 Connecting the BR20 VAS 843 007/9 blind rivet adapter



1. Fold the relief lever on the punch riveting tool VAS 843 007/1 forward.



2. Pull/press locking ring backwards.
The inner red marking ring becomes visible.



3. Place BR20 with quick coupling in the middle. With the locking ring pressed backwards, push the BR20 with the quick coupling into the coupling receptacle under pressure.



4. Release the locking ring on the coupling holder.



5. Fold the relief lever backwards.

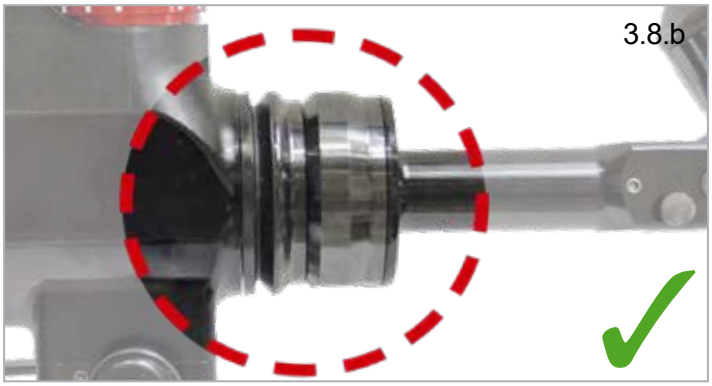
Attention!
The quick coupling on the punch riveting tool VAS 843 007/1 as well as the coupling connection on the respective adapter must be clean and free of dirt and damage!

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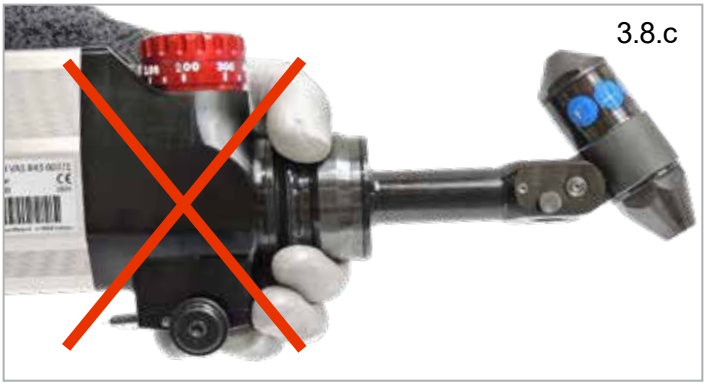
3.8 Correct and incorrect connection/handling of the BR20 VAS 843 007/9



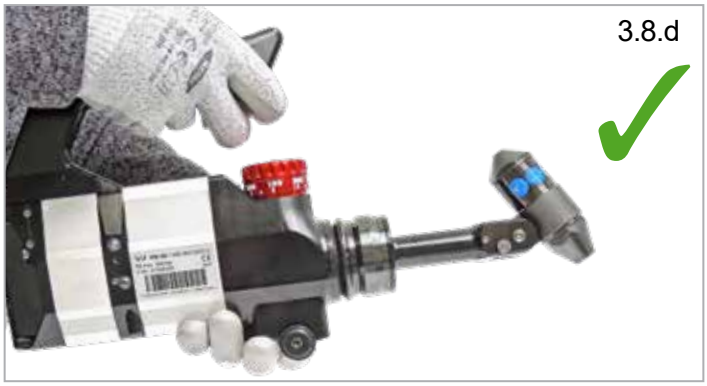
1. Wrong !
If the red marking ring on the quick coupling is still visible, the adapter is not properly engaged.



2. Correct
Press the adapter firmly into the holder. The locking ring must snap into place and lie flat all around, otherwise the lock will not be closed.



3. Wrong !
When working, never hold the riveting tool by the coupling, otherwise the module may come loose from the riveting tool.



4. Correct
Example power adapter BR20

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4

Things to note before working with the BR20 VAS 843 007/9

4.a





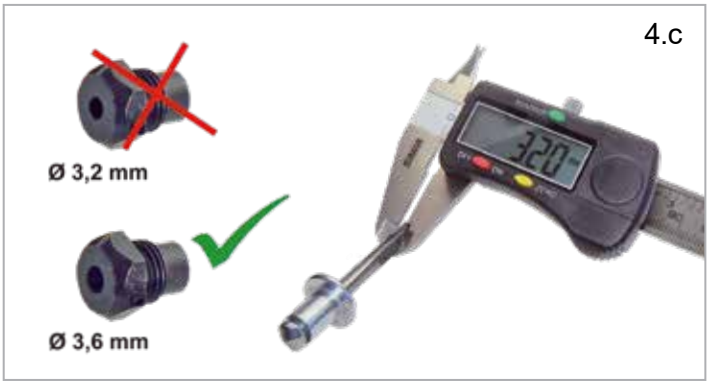
ATTENTION!
Only use blind rivet systems with a maximum shaft length of up to 40 mm.

4.b



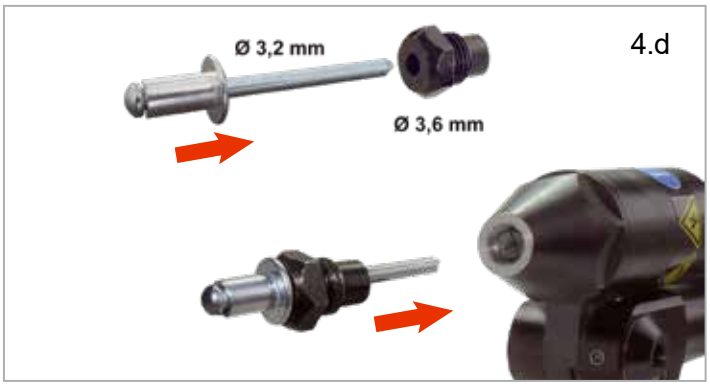
The BR20 can be used to process all blind rivet systems (except high-strength rivets) with a pull shaft Ø of 2 to 4.2 mm (max. shaft length up to 40 mm) and a maximum setting force of 20 kN. The corresponding mouthpieces for the adapter must be changed for the different pull shaft diameters.

4.c



Always mount the mouthpiece with the next larger diameter on the BR 20 if the diameter of the pull shaft and mouthpiece are identical!
If in doubt, always first determine the pull shaft diameter of the blind rivet!

4.d



During initial assembly and changing the mouthpiece - always mount the mouthpiece together with the appropriate blind rivet on the BR 20. Remove blind rivet. Press the actuation button so that the gripping cone (chuck jaws) is positioned on the mouthpiece.

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The rivet head of the BR20 blind rivet adapter can be swiveled through 120° and can be locked in 30° increments.



Press the locking button on the adapter until the head can be swiveled freely.



After releasing the button, swivel the adapter until the locking is active again at the next grid point.

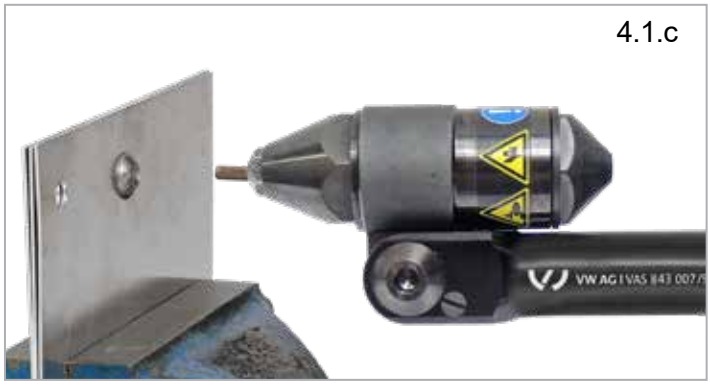
4.1 Processing blind rivets with the BR20 VAS 843 007/9



The BR20 has a single ejection for the torn-off drawstocks. When inserting the respective rivet, the ejector spring must be pressed in completely.



When the VAS 843 007/1 punch riveting tool is operated, a piston pulls the rivet's pull shaft until the tear-off force is reached.



The locking head has formed and the torn pull shaft is released again by the ejector of the BR20 and can be removed.

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5

Maintenance

CAUTION

The entire hydraulic system, including the quick-release couplings and the air supply lines, must be free of dirt.

Contamination in the hydraulic fluid and in the compressed air will cause the appliance to malfunction and can therefore also cause injuries.

The relevant adapter/tool instructions must be observed during servicing and maintenance work.

All maintenance and servicing work may only be carried out by trained specialist personnel or by the manufacturer.

If you have any queries regarding technical problems or maintenance requirements, please contact our service address:

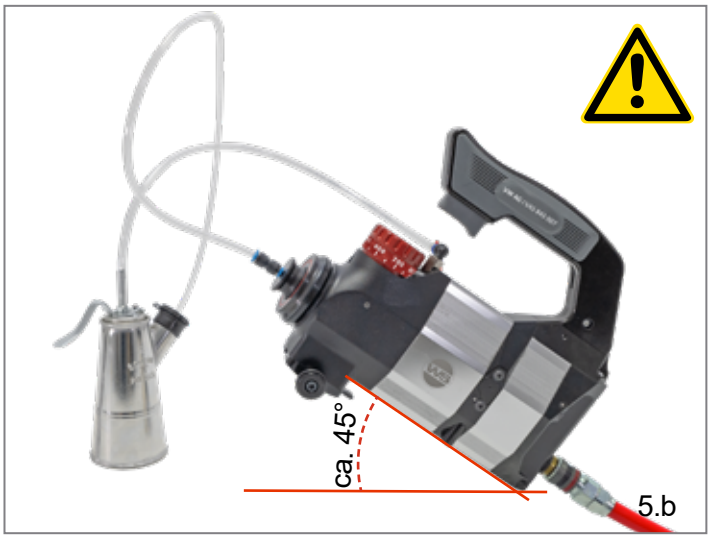
WS Wieländer+Schill
Professionelle Karosserie-Spezialwerkzeuge
Neue Wiesen 8
D-78609 Tuningen
Telefon: +49 (0)7464 / 9898-0
Telefax: +49 (0)7464 / 9898-289
E-Mail: info@wielanderschill.com

The device system is basically maintenance-free. It may be necessary to top up the oil due to normal use of the device or losses when disconnecting tools. Please observe the relevant oil specifications.
See chapter 2.1



5.a

Unscrew the sealing plug from the VAS 843 007/1 punch riveting device using a 5 mm Allen key.



5.b

Connect the venting and filling device for the tool holder system of the VAS 843 007/1 punch riveting device.
To vent, place the device at an angle of approx. 45°.
Pump the oil can until no more air bubbles are visible in the vent hose.

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6

Taking the appliance out of operation and storing it


6.a

Disconnect the short-stroke cylinder SSC 40/25 VAS 843 007/2. The disconnected adapter or the punch riveting device VAS 843 007/1 must never be contaminated with dirt, dust, chips or aggressive liquids.

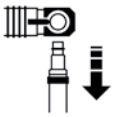

6.b

Close the coupling on the adapter with the protective cap.
Foreign bodies or impurities in the hydraulic system or on the couplings can lead to malfunctions in the system.


6.c

With compressed air connected:
After disconnecting the module, the operating button must be pressed once.
This closes the valve at the front.
CAUTION! Only trigger the 1st stage on the actuating button.


6.d



After the work process or during a work break, always disconnect the compressed air supply from the punch riveting device VAS 843 007/1.


6.e

ATTENTION!
A minimal amount of residual oil on the quick-release couplings of the adapters is normal and does not mean a malfunction. Always remove any residual leakage from the coupling with a clean cleaning cloth.


6.f

Check the system for any major oil loss before and after each use. A loss of oil indicates a fault in the system. In this case, stop work and localise the fault or return the appliance to an authorised specialist dealer for repair.

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The VAS 843 007 punch riveting tool can now be put away without any oil leaking out.


6.g


6.h

Only ever store the tool in the transport case provided. Clean the tool system with clean cleaning cloths after each operation.



6.j

Maintaining metal surfaces with corrosion protection protects the materials from corrosion.

6.1 Reinigung der Nietwerkzeuge


6.1.a

After each completed riveting process, remove any adhesive residue from all contaminated rivet inserts and modules.



6.1.b

All affected tool components must be dismantled for this purpose. Clean them with acetone or other solvents.

⚠ CAUTION

Hardened adhesive residue on the riveting tool leads to malfunction. Affected riveting punches/ mandrels must be replaced with original spare parts before starting work.

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6.2 Disposal



Parts of the appliance are recyclable materials and can be recycled. Authorised and certified recycling companies are available for this purpose. Please contact your local waste disposal authority for environmentally friendly disposal of non-recyclable parts.

7

Warranty

Wieländer+Schill hydraulic tools are guaranteed for 12 months against defects caused by material or manufacturing faults. Excluded are the wearing parts of the actuator and wearing parts of the accessory components.

The warranty period begins on the date of delivery, confirmed on the invoice or delivery note.

The warranty applies to the user/purchaser if the tool was purchased from an authorised sales outlet and was used as intended.

The guarantee is invalidated if the tool has been used for purposes other than its intended use.

The guarantee is also invalidated if the tool is not used in accordance with the operating instructions. the operating instructions.

The manufacturer accepts no liability for damage caused by improper repair and use or by the use of non-original spare parts

In the event of a defect or fault, Wieländer+Schill will only repair or replace faulty parts at its own discretion. repaired or replaced at its own discretion.

8

International service and repair partners

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

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9

EU-Declaration of Conformity

EU-Declaration of Conformity

In accordance with the EU Machinery Directive 2006/42 EC

Manufacturer:	WS Wieländer+Schill GmbH & Co.KG Professionelle Karosserie-Spezialwerkzeug Neue Wiesen 8 D-78609 Tuningen
Type of device: Tool type:	Hand-held hydraulic tool Pneumatic-hydraulic Universal tool for heavy labour
Type designation:	**Riveting and punching tool VAS 843 007/1** has been developed and designed in accordance with the following standards and directives of
Applied harmonised standards:	Equipment Safety Act (GPSG) EN ISO 12100 EN ISO 4413:2010; EN ISO 4414:2010 EN ISO 16092-1 /-3:2018 EN ISO 11148-13:2018 EN ISO 11148-10:2011 EN ISO 11200:2014 + A1:2020 EN ISO 11202:2010 + A1:2021
EU Machinery Directive:	2006/42 EC
Authorised representative for the compilation of the relevant technical documentation	Manfred Bäurer *Managing Director*
We declare as manufacturer:	The products labelled accordingly fulfil the requirements of the listed directives and standards. Tuningen, 29.05.2024



Manfred Bäurer
Managing Director

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10

Troubleshooting

Pos.	Error	Troubleshooting
1.	Power adapter does not work properly or comes loose from the quick coupling	• Adapter is not correctly coupled. • Release lever is not folded backwards. • Chapter 3.3 + 3.4 / 3.7 + 3.8
2.	C-clamp does not engage on the short-stroke cylinder.	• Position and fit the C-bracket correctly. Chapter 3.5
3.	Riveting process is not carried out correctly.	• Remove adhesive residue from the punches and dies. If this is not possible or the rivet punches/mandrels are damaged, replace them. Caution: Only use original spare parts. • Check that the correct dies are inserted.
4.	Rivet is not set correctly	• Check the central air supply. The tool requires an air pressure of at least 6.0 bar. • Observe the specifications in the repair guide.
5.	Riveting process is not completed and the tool does not open after the rivet has been set. (Piston does not return to the home position)	• Disconnect compressed air from the tool. Fold the release lever forwards. The piston moves to the home position and the tool opens.
6.	Machine does not work, does not trigger (Piston remains in the tool)	• Compressed air must be connected • Close the side ventilation holes Hold 1st side closed and release Hold 2nd side closed and release CAUTION! Always wear protective gloves. Fig. 10.a - 10.c
7.	Tool does not open after the pressing process. (Piston remains in the tool)	• Force setting: turn clockwise. Increase the pressure setting (bar) until the tool opens. To continue working, select the required pressure setting again.

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Pos. 6 Troubleshooting


10.a

Ventilation opening





Wear protective gloves.


10.b


10.c

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Volkswagen Aktiengesellschaft
K-AVO-LW
Konzern After Sales – Group Service,
Literatur und Systeme
Werkstattausrüstung
Brieffach 011/4915
38442 Wolfsburg

Volkswagen Aktiengesellschaft
K-AVO-LW
Group After Sales – Group Service,
Literature and Systems
Workshop Equipment
Letter Box 011/4915
38442 Wolfsburg

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