Pneumatic blind rivet setting tools

Hydro-pneumatic blind rivet setting tools

1. TAURUS® 1-6
2. TAURUS® 1-4 with counter device
3. TAURUS® 1-4 with counter device eco
4. TAURUS® 1-4 Axial eco
5. TAURUS® 1-4 Axial
6. TAUREX 1-4 Axial compact
7. TAUREX 1-4 Axial
8. TAUERX 1-4 C
9. TAUERX 1-4 with counter device
10. TAUERX 1-4 with counter device eco
11. TAURUS® WinTech
12. TAURUS® 1 Speed Rivet
13. TAURUS® 2 Speed Rivet
14. TAUERX 1 and 2 Speed Rivet Axial eco
15. PH 1
16. PH 2
17. PH 2000
18. PH 2-VK
19. PH Axial
20. GAV 8000
21. GAV HF

Multi-window technology with up to three assessment windows
# What rivets what?

<table>
<thead>
<tr>
<th>Tools</th>
<th>Energy</th>
<th>Blind rivet Ø mm</th>
<th>PolyGrip®</th>
<th>G-Bulb</th>
<th>MEGA GRIP®</th>
<th>BULB-TITE®</th>
<th>TRI-FOLD®</th>
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</thead>
<tbody>
<tr>
<td>PH1</td>
<td>P</td>
<td>2.4 3.0 3.2 4.0 4.8 5.0 6.0 6.4 8.0 10.0</td>
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<td>PH2</td>
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<td>PH Axial</td>
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<td>TAUROUS® 1 / TAUREX 1</td>
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<td></td>
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<td>TAUROUS® 2 / TAUREX 2</td>
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<td>TAUROUS® 3 / TAUREX 3</td>
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<tr>
<td>TAUROUS® 4 / TAUREX 4</td>
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<td>TAUROUS® 6 / TAUREX 6</td>
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<td></td>
<td></td>
<td></td>
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</table>

<table>
<thead>
<tr>
<th>Tools</th>
<th>Energy</th>
<th>Speed rivets Ø mm</th>
<th>Speed rivets Ø mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>TAUROUS® 1 Speed Rivet</td>
<td>P</td>
<td>2.4 3.0 3.2 4.0 4.8 5.0 6.0 6.4</td>
<td>AS</td>
</tr>
<tr>
<td>TAUROUS® 2 Speed Rivet</td>
<td>P</td>
<td>2.4 3.0 3.2 4.0 4.8 5.0 6.0 6.4</td>
<td>AS</td>
</tr>
<tr>
<td>TAUROUS® 1 Speed Rivet Axial eco</td>
<td>P</td>
<td>2.4 3.0 3.2 4.0 4.8 5.0 6.0 6.4</td>
<td>AS</td>
</tr>
<tr>
<td>TAUROUS® 2 Speed Rivet Axial eco</td>
<td>P</td>
<td>2.4 3.0 3.2 4.0 4.8 5.0 6.0 6.4</td>
<td>AS</td>
</tr>
</tbody>
</table>

- P: Hydro-pneumatic tool
- X: Special accessories required
- A: Alu/Copper
- S: Steel
- E: Stainless Steel / Monel

Blue box: All materials (ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box.

* A special nosepiece is always required when setting MEGA GRIP® blind rivets and BULB-TITE® blind rivets.
The TAURUS® series

Pneumatic-hydraulic blind rivet setting tools made by GESIPA® are ideal in dealing with almost any type of application. The cost-efficient construction, perfect handling properties and practical accessories are what make the TAURUS® series so unique and flexible.
Advantages which simply cannot fail to convince you!

Since the market introduction of the TAURUS® 2 in the year 2002, the TAURUS® series has managed to convince thousand times over in trade and industry. The TAURUS® 2 especially is a true all-rounder.

01 Modular principles
- Widest possible parts commonality – low spare part stocks required and simple maintenance
- Flexible adaption to new applications

02 Power
- High setting forces combined with low weight
- Fast work cycle
- Optimised stroke for the entire series

03 Patented handle mechanism
- With forcibly actuated jaws by pneumatic pressing
- Safe, non-slip gripping of the rivet mandrel
- Just one model of jaws for all tools
- Very long service lives

04 Efficiency
- Little compressed air consumption thanks to dual function: setting the rivets and extracting the spent mandrels use the same air
- Air suction needed only for vertical downwards riveting. Can be permanently switched-off if not needed.

05 Work comfort / safety
- Rubberised, moulded grip
- Balanced center of gravity
- Low-vibration and soundproofed
- Little activation force required
- Spent mandrel container with swivelling air deflector
- Overpressure valve for prevention of overload
- Integrated protection feature prevents the ejection of spent mandrels while the spent mandrel container is removed
The TAURUS® tool series – Unique in the market!

The TAURUS® tool series is equipped with a high-performance, patented grip mechanism and jaw system.

**Patented jaw system**
- The three jaws move in separate channels while being under forced control.
- The jaws are pressed onto the mandrel by using compressed air instead of spring force – the force being ten times higher than usual.
- Due to the high pressure the jaws immediately cling to the mandrels upon triggering the riveting process, only then the pulling movement starts.

**GESIPA®-system – decisive advantages**
- The complete stroke of the tool is used for setting the rivet guaranteeing a reliable setting process.
- The immediate and non-slip grip of the mandrel reduces abrasion and troublesome soiling.
- Since the jaws do not slide along the mandrel, the wear and tear of the jaw profiles is reduced.
- Lower costs due to longer service life and low requirements regarding maintenance and spare parts needed.
Compressed air is used very often in industrial production because of its flexibility. It does, however, cause relatively high costs and its consumption damages the environment. These disadvantages are more than enough reason for GESIPA® to equip the TAURUS® tool series with a special technique that allows to save compressed air and is unique throughout the world.

The GESIPA® System uses the compressed air required for the setting process twice. First, to set the blind rivet and secondly, to extract the spent mandrel. Dual use of the compressed air means no expensive, fresh compressed air is needed which other tools on the market constantly need just to extract the spent mandrel. And, last but not least, noise emission from the TAURUS®-tools is extremely low.

In two-shift operation and with compressed air costs of approximately € 0.03 per m³ this innovative technique allows savings of up to € 720 per year and tool. A TAURUS® 2 can pay for itself in less than one year.
The Taurus® series – unique modular principle. Minimal spare parts stocks, easy maintenance.

Nosepieces
different sizes

Extension units
- Single-piece (different sizes)
- Multi-piece (different sizes)

Spring-loaded trigger system

External trigger system

Air suction function

Nosepiece allocation

Setting process monitoring

GESIPA®-Interface
Versatile accessories complete the range!

The modular concept for the TAURUS® series 1-4 lets the user customise the TAURUS® devices to match his individual requirements. Many identical parts that can be used across all devices reduce the need to stock spare parts and make maintenance easy.

This wide range of options provides the user with a high degree of flexibility. Each device in the TAURUS® series 1-4 can be fitted with many different spare parts or refitted according to the application.
**TAURUS® series**

**TAURUS® 1**

Part no. 145 7665

**Working range**
Sets blind rivets from 2.4 up to 3.2 mm Ø all materials and up to 4 mm Ø alu/steel (max. mandrel dia. 2.5 mm)

**Technical data**
- Weight: 1.3 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: approx. 1.0 ltr. per rivet
- Traction power: 5,500 N at 6 bar
- Stroke: 15 mm

**Equipment**
- Nosepieces: 17/18, 17/20 and 17/22, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml, 1 oil refill can,
- Operating instructions with spare parts list

**Dimensions in mm**

**TAURUS® 2**

Part no. 145 7771

**Working range**
Sets blind rivets up to 5 mm Ø all materials and up to 6 mm Ø alu/steel (max. mandrel dia. 3.2 mm)

**Technical data**
- Weight: 1.6 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: approx. 2.3 ltr. per rivet
- Traction power: 11,000 N at 6 bar
- Stroke: 18 mm

**Equipment**
- Nosepieces: 17/24, 17/27, 17/29 and 17/32, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml, 1 oil refill can,
- Operating instructions with spare parts list

**Dimensions in mm**
The experts in riveting technologies

Pneumatic-hydraulic blind rivet setting tools

**Part no. 145 7871**

**TAURUS® 3**

**Working range**
Sets blind rivets up to 6.4 mm Ø all materials (max. mandrel dia. 4.5 mm)

**Technical data**
- Weight: 1.9 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4")
- Air consumption: approx. 4.8 ltr. per rivet
- Traction power: 18,000 N at 6 bar
- Stroke: 25 mm

**Equipment**
- Nosepieces: 17/36, 17/40 and 17/45,
- Maintenance wrench SW12/14, SW14/17,
- 1 hydraulic oil bottle 100 ml,
- 1 oil refill can,
- Operating instructions with spare parts list

**Dimensions in mm**

---

**Part no. 145 7964**

**TAURUS® 4**

**Working range**
Sets blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)

**Technical data**
- Weight: 2.0 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4")
- Air consumption: approx. 4.8 ltr. per rivet
- Traction power: 23,000 N at 6 bar
- Stroke: 19 mm

**Equipment**
- Nosepieces: 17/36, 17/40 and 17/45,
- Maintenance wrench SW12/14, SW14/17,
- 1 hydraulic oil bottle 100 ml,
- 1 oil refill can,
- Operating instructions with spare parts list

**Dimensions in mm**
The experts in riveting technologies

TAURUS® 5

Basic tool
Part no. 145 8002

Working range
Blind rivets above 6.4 mm Ø all materials and lockbolts up to 10 mm Ø with corresponding pulling heads (look on page 144).

Technical data
- Weight: 3.4 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: approx. 6.9 ltr. per rivet
- Traction power: 42,000 N at 7 bar
- Stroke: 17 mm

Equipment
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- Operating instructions with spare parts list

TAURUS® 6

Basic tool
Part no. 145 8022

Working range
Blind rivets above 6.4 mm Ø all materials and lockbolts up to 10 mm Ø with corresponding pulling heads (look on page 144).

Technical data
- Weight: 3.4 kg
- Operating air pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: approx. 6.9 ltr. per rivet
- Traction power: 50,000 N at 7 bar
- Stroke: 15 mm

Equipment
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- Operating instructions with spare parts list

TAURUS® 5 and 6 need to be fitted with nosepieces to match the application. Will be produced on request.
The comprehensive range of accessories allows you to adapt your tool to virtually any challenge – whether trade, construction or industrial applications.

Nosepieces

For long mandrels, special blind rivets and other challenges

The use of the correct nosepiece is essential for ensuring reliable riveting and a neat riveted joint. A large selection of standard and special nosepieces makes it possible to quickly adapt to various types of blind rivet. Even special versions are generally available on request. All nosepiece allocation data relate to DIN and GESIPA® blind rivets.

Nosepiece assignment

<table>
<thead>
<tr>
<th>Rivet</th>
<th>Rivet Ø mm</th>
<th>Rivet material</th>
<th>Nosepiece</th>
<th>Part no.</th>
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<tbody>
<tr>
<td>Standard</td>
<td>2.4</td>
<td>Alu</td>
<td>17/18</td>
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<td>3.2</td>
<td>CAP®-Alu, CAP®-Cu</td>
<td>17/18</td>
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<td>3</td>
<td>Alu/Cu</td>
<td>17/20</td>
<td>143 4994</td>
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<td></td>
<td>3</td>
<td>Alu, Cu, Steel, Stainless steel, Stinox, Alu/alu</td>
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<td>143 5018</td>
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<td>Alu, Cu, CAP®-Alu, CAP®-Cu</td>
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<td>Stainless steel, Stinox, PG-Steel, PG-Stainless steel</td>
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<td>4.8 and 5</td>
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<td>17/29</td>
<td>143 4974</td>
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<td>4.8 and 5</td>
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<td>17/32</td>
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<tr>
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<td>4.8 and 5</td>
<td>Stainless steel, Stinox, PG-Steel, PG-Stainless steel, G-Bulb</td>
<td>17/36</td>
<td>143 4977</td>
</tr>
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<td></td>
<td>6</td>
<td>Alu</td>
<td>17/36</td>
<td>143 4977</td>
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<tr>
<td></td>
<td>6</td>
<td>Steel</td>
<td>17/40</td>
<td>143 4999</td>
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<tr>
<td></td>
<td>6.4</td>
<td>Alu</td>
<td>17/40</td>
<td>143 4999</td>
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<td>6.4</td>
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<td>8</td>
<td>Alu</td>
<td>17/45</td>
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<tr>
<td>BULB-TITE®</td>
<td>4</td>
<td>Alu</td>
<td>17/26 BT</td>
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<td>5.2</td>
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<td>143 4986</td>
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<td>6.3</td>
<td>Alu, Steel, Monel</td>
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<td>7.7</td>
<td>Alu</td>
<td>17/48 BT</td>
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<td>MEGA GRIP®</td>
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<td>6.4</td>
<td>Alu, Steel, Stainless steel</td>
<td>17/41 MG</td>
<td>143 4865</td>
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</tbody>
</table>
**Accessories – Taurus® series 1-4**

**Swivel air connector**

For the complete Taurus® series in 1/8"

Part no. 143 5479

**Set of jaws (3 pcs.)**

Patented jaw system for the complete Taurus® series

Part no. 143 5568

**Flexible base for Taurus® 1 and 2**

With the flexible base made from MBR and the larger surface area, the Taurus® tools are standing even more stably.

For Taurus® 1
Part no. 143 6394

For Taurus® 2
Part no. 143 6371
**Transparent collecting container for Taurus® 1-4**

The classic residual mandrel collecting container in the Taurus® series is also available in a transparent version. The transparent collecting container allows the amount of residual mandrels to be monitored constantly. The transparent collecting container will be available in a small version for the Taurus® devices 1-2 and a large version for the Taurus® devices 3-4.

**For Taurus® 1-2**
Part no. 145 7744

**For Taurus® 3-4**
Part no. 145 7951

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**Taurus® conversion kit**

For conversion to the PH 2000 spent mandrel container (description and full offer on page 150).

**For Taurus® 1**
Part no. 145 7700

**For Taurus® 2-4**
Part no. 145 7703

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**Mandrel extraction tube**

By attaching a special-purpose hose nipple, the spent mandrel container can be replaced by the spent mandrel evacuation hose*. In stationary use, this can be of great advantage as frequent disposal is not required. The spent mandrels are collected in a container so that the work place remains clean and tidy, with no interruption to the work.

*The use of Taurus® tools with a 1.5 m long evacuation hose requires permanent employment of the suction unit.

For the full Taurus® series
Part no. 145 7864
## Accessories – TAURUS® series 1-4

### Extension units

Allows easy access to rivet sites which are difficult to reach.

The extension units are used for riveting sites which are situated low down or are difficult to access. We offer one-piece extension units of 35, 85, 135 and 185 mm length for the TAURUS® 1-4. The extension units consist of three parts.

#### One-piece

The total length of the steel head sleeve for TAURUS® 1 with 35 mm, 85 and 135 mm is 106 mm, 156 mm and 206 mm respectively.

TAURUS® 2 with 35 mm, 85 mm, 135 mm and 185 mm is 106 mm, 156 mm, 206 mm and 256 mm respectively.

TAURUS® 3 and 4 with 35 mm, 85 mm and 135 mm is 106 mm, 156 mm and 206 mm respectively.

<table>
<thead>
<tr>
<th>Tool</th>
<th>+35 mm</th>
<th>+85 mm</th>
<th>+135 mm</th>
<th>+185 mm</th>
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<tr>
<td>TAURUS® 1*</td>
<td>146 4345</td>
<td>146 4346</td>
<td>146 4347</td>
<td>-</td>
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<tr>
<td>TAURUS® 2*</td>
<td>145 8042</td>
<td>146 4350</td>
<td>146 4351</td>
<td>146 4352</td>
</tr>
<tr>
<td>TAURUS® 3 and 4</td>
<td>145 7932</td>
<td>145 7933</td>
<td>145 7937</td>
<td>-</td>
</tr>
</tbody>
</table>

#### Multi-piece

Total length of the steel head sleeve including the extension unit. On TAURUS® 1-4 the steel head sleeve can be extended variably in steps of 100 mm.

<table>
<thead>
<tr>
<th>Tool</th>
<th>50 mm</th>
<th>100 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>TAURUS® 1 with spring loaded trigger system</td>
<td>145 0880</td>
<td>145 7727</td>
</tr>
<tr>
<td>TAURUS® 2 with spring loaded trigger system</td>
<td>145 7857</td>
<td>145 7858</td>
</tr>
<tr>
<td>TAURUS® 3 and 4 with spring loaded trigger system</td>
<td>145 7959</td>
<td>145 7960</td>
</tr>
</tbody>
</table>

* Valid for tools manufactured after October 2015

For older models see page 305

### Small jaw assembly TAURUS® 1-2

The small jaw assembly is particularly suitable where rivet sites are difficult to access. The TAURUS® 1 with the small jaw assembly handles aluminium/steel blind rivets up to Ø 4 mm and steel/steel blind rivets up to Ø 3.2 mm. The small jaw assembly for the TAURUS® 2 handles aluminium/steel blind rivets up to Ø 5 mm and steel/steel blind rivets up to Ø 4 mm. The jaw assembly is 100 mm long and the diameter of the steel head sleeve is 18 mm.

For TAURUS® 1: Part no. 145 7705
For TAURUS® 2: Part no. 145 7846
Angle head 90° and Angle head 90° compact

The angle head 90° and the angle head 90° compact are designed for use in tight spaces. Its sturdy design allows it to apply large setting forces when setting blind rivets even in difficult of access work areas. The angle head 90° for TAUrus® 1-4 allows to set all Types of standard blind rivets up to Ø 6.4 mm all materials and Ø 8 mm alu, depending on the tool type. The minimum edge clearance is 15 mm, the head length is 110 mm.

The angle head 90° compact for the TAUrus® 1 and 2 allows to set standard blind rivets of all Types of material up to 5 mm in diameter and alu/steel blind rivets up to 6 mm in diameter, depending on the tool Type. The minimum edge clearance is 12 mm, the head length is 90 mm. Both angle heads can be freely fixed in any position around the TAUrus® tensile axis (360° free rotation).

Angle head 90° for TAUrus® 1-4

Technical data
- Weight: 1.1 kg
- Stroke: 23 mm
- Traction power: up to 20 kN

Equipment
- Nosepiece 17/45 WK
- Jaws up to rivet Ø 4 mm (Nosepiece 17/24)

Part no. 145 7920

Angle head 90° compact for TAUrus® 1-2

Technical data
- Weight: 0.7 kg
- Stroke: 20 mm
- Traction power: up to 10 kN

Equipment
- Nosepieces: 16/36

Part no. 145 7921

Jaws (3 parts) for

Angle head 90° for TAUrus® 1-4
- Up to rivet Ø 4 mm (Nosepiece 17/24)
  Part no. 143 4173
- Up to Ø 6.4 mm of all materials,
  Ø 8.0 mm Alu
  Part no. 143 4958

Angle head 90° for TAUrus® 1-2
  Part no. 143 4104
A wide variety of options means higher flexibility. All of the TAURUS® varieties are customized and designed and made to fit the application. Please contact our team from the Technical Sales department should you require individual advice or have any further queries or need information on prices.
TAURUS® 2/K

The TAURUS® 2/K has been designed for setting plastic rivets. In its functionality the TAURUS® 2/K is identical to the standard tool, however has a stroke of 24 mm instead of 18 mm. Plastic rivets only need a low setting force, however, normally require large setting strokes due to the toughness of the plastic material.

The TAURUS® 2/K allows to safely set plastic rivets with only one setting stroke! The TAURUS® 2/K comes with 3 nose pieces for plastic rivets 17/30 K, 17/35 K and 17/40 K included.

**Technical data**

| Strength: | 24 mm |
| Tensile strength: | 8,400 N |

**Part no. 145 7804**

**Working range**
Blind rivets plastic from 4 up to 6 mm Ø.

**Nosepieces**
17/30K; 17/35K; 17/40K

**TAURUS® 2/AS**

The TAURUS® 2/AS is a special version of the TAURUS® 2 with a VAS slide switch which does not engage when in its highest position, thus achieving that vacuum absorption is automatically deactivated once the tool is not in use. This way, unintentional activation of the vacuum absorption with unnecessary air consumption can be effectively avoided.

Other TAURUS® sizes upon request.

**Part no. 145 7794**

**TAURUS® 2/24**

As far as technology and functionality are concerned, the TAURUS® 2/24 is identical to the standard tool, however has a stroke of 24 mm instead of 18 mm. This tool provides the advantage of being able to safely set critical rivet Types requiring a large setting stroke with only one setting stroke without re-engagement. This applies, for example, to our BULB-TITE® or similar rivets.

**Part no. 145 7803**

**Working range**
Blind rivets up to Ø4 mm all materials, Ø5 mm steel; Ø 6 mm alu.

**Technical data**

| Strength: | 24 mm |
| Tensile strength: | 8,400 N |

Further info
The experts in riveting technologies

TAURUS® versions

TAURUS® 1-4 with counter device

The tools are equipped with a sensor which detects and counts the spent mandrels after the setting process has been finished. The sensor is positioned on the tool head in front of the spent mandrel container.

For a completely independent workstation, the amplifier GRivAmp or the counter and display unit GRivCount can be used for processing and analysing the signals.

The TAURUS® series 1-4 with counter device – detects and counts the spent mandrels

For retrofitting existing tools a conversion kit suitable for all TAURUS® Types (except TAURUS® with PH 2000 spent mandrel container) is available:

Conversion kit TAURUS® 1 with sensor
Part no. 145 7698

Conversion kit TAURUS® 2-4 with sensor
Part no. 151 6858

GRiv-Count
Part no. 146 3062

GRiv-Amp
Part no. 145 7699

Power supply (24 V) is to be provided on site.
TAURUS® versions

TAURUS® 1-4 with counter eco

TAURUS® 1-4 with counter – the cost-effective variant for monitoring the number of setting strokes

In contrast to the TAURUS® with counter, the eco counter only counts the number of setting strokes and not the spent mandrels. The sensor is fitted on the air cylinder. The counter is not available on its own. It is supplied mounted on a new tool or it can be retrofitted at the Walldorf factory.

Retrofit kit for the eco counting device

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>TAURUS® 1</td>
<td>145 0892</td>
</tr>
<tr>
<td>TAURUS® 2</td>
<td>145 0933</td>
</tr>
<tr>
<td>TAURUS® 3</td>
<td>145 0963</td>
</tr>
<tr>
<td>TAURUS® 4</td>
<td>145 0993</td>
</tr>
</tbody>
</table>

Can only be mounted by GESIPA®.
The TAURUS® 4 can be equipped with an „RT 100” C-Frame tool for processing semitubular and solid rivets. Further application options include press-fitting, hole punching and caulking as well as pressing out lockbolts.

Each C-Frame can be optionally operated stationary and equipped with a foot-operated switch.

The C-Frame tools are characterised by a swivel range of 360°, efficient operating sequence and a precisely adjustable setting stroke.

**Technical Data**
- Setting force: 23,000 N (at 6 bar)
- Tool stroke: 19 mm
- Operating pressure: 5-7 bar
- Hose connection: Ø 6 mm (1/4”)
- Weight: approx. 2.0 kg (without C-Frame)

**Advantages**
- Flexibility
- Simple and safe pneumatic force control
- Easy tool change

Contact our Technical Sales department.
TAURUS® versions

TAUREX 1-6

The whole TAURUS® series with remote pressure transducer – for even more flexibility, versatility and ergonomy

Working range
- All blind rivets and lockbolts up to a mandrel breaking force of 50 kN
- Same performance and technical characteristics as the respective individual units in the TAURUS® series 1-4, 5-6 with different stroke
- 3 metres hose length between pressure transducer and setting pistol

Common technical data
Operating air pressure: 5 to 7 bar
Air hose connection: 6 mm (1/4”)
Noise emission: max. 79 dB
Vibrations: < 2.9 m/s²

Advantages
- Low weight of the hand held tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side: No oil leak and no air bleeding
- Ideally suited for setting of blind rivets and lockbolts in poorly accessible locations
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Can be combined with almost all supplements and options of the TAURUS® series: head extensions, mandrel containers, rivet counting units, process control, pressure trigger and remote control

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>TAUREX 1</td>
<td>145 8025</td>
</tr>
<tr>
<td>TAUREX 2</td>
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<td>TAUREX 3</td>
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<td>145 8058</td>
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<tr>
<td>TAUREX 5</td>
<td>145 8060</td>
</tr>
<tr>
<td>TAUREX 6</td>
<td>145 8062</td>
</tr>
</tbody>
</table>
Parallel head for TAURUS® 1-4

The parallel head for the TAURUS® series 1-4 was specially developed for use in areas that are difficult to access. The compact and sturdy design makes it possible to set blind rivets with a high setting force even in working areas that are difficult to access. Depending on the Type of tool, the parallel head for the TAURUS® series 1-4 can set standard blind rivets up to Ø 6.4 mm all materials with a setting force of up to 20 kN. The smallest edge spacing is 13 mm.

Technical data
- Weight: 1.0 kg
- Stroke: up to 25 mm
- Setting force:
  - up to 20 kN

Equipment
- Nosepiece 16/36

Advantages
- Minimal edge spacing (13 mm)
- High setting force in restricted space
- Compact and sturdy design
- Easy jaw maintenance
- Low vibration even at high break-off forces
- Mandrel disposal into the spent mandrel container by tilting back or to the front through the nose-piece.

Head modules for TAURUS® 5-6 and TAUREX 5-6

Adaption takes priority
The TAURUS® 5 and 6 riveting tools must be adapted to the different kinds of rivets and lockbolts through specific pulling head modules.

- Head module for 7.8 mm Titgemeyer TIBULB*
  Part no. 145 8008

- Head module for 9.8 mm Huck Magna-Lok®*
  Part no. 145 8009

* partly registered trademarks of TITGEMEYER GmbH & Co. KG or Alcoa Fastening Systems

Other head modules on request.
Balancer for all TAURUS® 1-4-Axial- and TAUREX 1-4-Axial-tools

To cover various requirements, two balancer models for suspending the TAURUS® Axial tools are available. If the tube for evacuating the spent mandrel can be kept very short, no external mandrel evacuation assistance is necessary which means a balancer without valve is sufficient. However, if due to the tube length external evacuation assistance of the mandrel becomes necessary it can be switched on and off by means of the valve balancer in order to save cost-intensive compressed air.

- Balancer without valve
  - Part no. 143 4734

The balancer with disconnecting valve is used when the blind rivet is to be inserted into the tool. In this case the valve interrupts the compressed air necessary to generate negative pressure when in its highest position.

- Balancer with disconnecting valve
  - Part no. 145 7733

The time delay valve on the other hand is used when the blind rivet is to be inserted into the part. During the rivet setting procedure, the valve activates the compressed air required to create a vacuum and shuts it off after a set time.

- Time delay valve
  - Part no. 145 0893
The TAURUS®-series 1-4 in axial version – the cost-efficient introductory version for special applications

Applications
The special pistols of TAURUS® Axial eco offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action.

In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAURUS® Axial eco can be additionally supplied with a spring-loaded trigger system.

A compressed air supply is additionally required for reliable mandrel evacuation. Depending on the application, this is preferably achieved via the balancer with valve or the time delay valve (see Page 145).

Working range
• Blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia 4.5 mm)
• Same performance and technical data as the respective individual units in the TAURUS® series

Technical data
Operating air pressure: 5 to 7 bar
Air hose connection: 6 mm (1/4”)
Noise emission: max. 79 dB
Vibrations: < 2.9 m/s²
Weight:
TAURUS® 1 Axial eco 2.0 kg
TAURUS® 2 Axial eco 2.3 kg
TAURUS® 3 Axial eco 2.6 kg
TAURUS® 4 Axial eco 3.0 kg

Advantages
• Cost-efficient basic version
• Perfectly designed for fixed installations on production lines or semi-automatic workstations
• Very practical for processing blind rivets in positions that require a vertical rivet setting process
• The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, setting process monitoring, spring loaded trigger system and remote control
• Can be suspended on a balancer
• Integrated mandrel evacuation for disposal of the spent mandrel

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>TAURUS® 1 Axial eco</td>
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<td>TAURUS® 2 Axial eco</td>
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<td>TAURUS® 4 Axial eco</td>
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<td>145 7899</td>
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<tr>
<td>TAURUS® 4 Axial eco</td>
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</tbody>
</table>
Applications
The special pistols of TAUROS® Axial offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action.

In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAUROS® Axial can be additionally supplied with a spring loaded-trigger system.

A compressed air supply is additionally required for reliable mandrel evacuation. Depending on the application, this is preferably achieved via the balancer with valve or the time delay valve (see page 145).

Working range
• Processing blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
• Same performance and technical data as the respective individual units in the TAUROS® series 1-4

Technical data
<table>
<thead>
<tr>
<th>Tool</th>
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</tr>
</thead>
<tbody>
<tr>
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<td>145 7796</td>
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<tr>
<td>TAUROS® 3 Axial</td>
<td>145 7894</td>
</tr>
<tr>
<td>TAUROS® 4 Axial</td>
<td>145 0982</td>
</tr>
</tbody>
</table>

Advantages
• Pressure transducer attached in a space-saving manner directly to the device, i.e. also for applications in tight spaces
• Technical design close to the TAUREX Axial
• Also perfectly designed for fixed installation in production lines or semi-automatic workstations
• Very practical for processing blind rivets in positions that require a vertical rivet setting process
• The tool can be equipped with almost all TAUROS® series options; e.g. extension units, blind rivet counter, spring loaded trigger system and remote control
• The handle in the rivet axis allows ergonomic work – especially in vertical applications
• Can be suspended on a balancer
Applications
The TAUREX Axial compact is a particular advantage in enclosed spaces due to the pressure transducer mounted close and parallel to the tool’s axis. The special pistols of TAUREX Axial compact offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action. In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAUREX Axial compact can be additionally supplied with a spring-loaded trigger system (see page 145).

Operating range
- Processing blind rivets up to 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the TAURUS® series 1-4

Technical data
Operating pressure: 5 to 7 bar
Air hose connection: 6 mm (1/4”)
Noise emission: max. 79 dB
Vibrations: < 2.9 m/s²
Weight:
- TAUREX 1 Axial compact: 3.1 kg
- TAUREX 2 Axial compact: 3.4 kg
- TAUREX 3 Axial compact: 3.7 kg
- TAUREX 4 Axial compact: 4.1 kg

Advantages
- Pressure transducer attached in a space-saving manner directly to the device, i.e. also for applications in tight spaces
- Technical design close to the TAUREX Axial
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, spring-loaded trigger system and remote control
- The handle in the rivet axis allows ergonomic work – especially in vertical applications.
- Can be suspended on a balancer
The experts in riveting technologies
Pneumatic blind rivet setting tools

TAURUS® versions

TAUREX Axial 1-4

The TAURUS® series 1-4 with remote mounted pressure transducer in axial version – making it more flexible, versatile and ergonomic

Applications
The TAUREX Axial is a particular advantage in restricted spaces due to the separate pressure transducer mounted in the working direction. The special pistols of TAUREX Axial offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action. In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAUREX Axial can be additionally supplied with a spring-loaded trigger system.

It is essential to use an external suction system with the TAUREX Axial!

A compressed air supply is additionally required for reliable mandrel evacuation. Depending on the application, this is preferably achieved via the balancer with valve or the time delay valve (see page 145).

Working range
- Sets blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia 4.5 mm)
- Same performance and technical data as the respective TAURUS® series 1-4
- 3 metre hose length between pressure transducer and setting pistol

Technical data
Operating air pressure: 5 to 7 bar
Air hose connection: 6 mm (1/4”)
Noise emission: max. 79 dB
Vibrations: < 2.9 m/s²
Weight:
TAUREX 1 Axial 2.4 kg
TAUREX 2 Axial 2.7 kg
TAUREX 3 Axial 3.0 kg
TAUREX 4 Axial 3.1 kg

Advantages
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Low weight of the hand held tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side: No oil leak and no air bleeding
- The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, spring loaded trigger system and remote control
- The handle in the rivet axle allows ergonomic work – especially in vertical applications
- Can be suspended on a balancer

<table>
<thead>
<tr>
<th>Tool</th>
<th>Part no.</th>
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</thead>
<tbody>
<tr>
<td>TAUREX 1 Axial</td>
<td>145 8026</td>
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<tr>
<td>TAUREX 2 Axial</td>
<td>145 8032</td>
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<tr>
<td>TAUREX 3 Axial</td>
<td>145 8047</td>
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<tr>
<td>TAUREX 4 Axial</td>
<td>145 1019</td>
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<tr>
<td>TAUREX 1 Axial 145 1002</td>
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<tr>
<td>TAUREX 2 Axial 145 8033</td>
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<tr>
<td>TAUREX 3 Axial 145 1016</td>
<td></td>
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<tr>
<td>TAUREX 4 Axial 145 1020</td>
<td></td>
</tr>
</tbody>
</table>
**TAURUS® versions**

**TAURUS® 1-4 with spring-loaded trigger system**

The spring-loaded trigger system ensures that the components which are to be riveted are reliably placed one on top of the other gapfree prior to the riveting process. Furthermore, this ensures that the blind rivet reaches its end position in the bore prior to the setting process and that the setting head is in the right position. The pressure force can be variably applied depending on the application.

The spring-loaded trigger system cannot be retrofitted but is supplied completely attached.

**New features:**
Adjustable range from 15 to 75 N / Guaranteed easy-to-apply contact / force by use of springs

**TAURUS® 1-4 with PH 2000 spent mandrel container**

The fixed mounted, large PH 2000 mandrel container is very sturdy and particularly suited to long mandrels from 50 to 70 mm in length. The container fits all TAURUS® versions 1 to 4.

**TAURUS® versions**

**TAURUS® 1** with PH 2000 spent mandrel container
Part no. 145 7669

**TAURUS® 2** with PH 2000 spent mandrel container
Part no. 145 7780

**TAURUS® 3** with PH 2000 spent mandrel container
Part no. 145 7878

**TAURUS® 4** with PH 2000 spent mandrel container
Part no. 145 7970

You will find the corresponding conversion kits on page 135.
TAURUS® tools for stationary use in production systems

The TAURUS® tools can be integrated as stationary units in automatic production systems and operated by remote control, if required. As an option, a low-pressure connection can be used to detect the blind rivet in the nosepiece. If required, the spent mandrel can be disposed of by means of an evacuation tube and also monitored by a sensor. In stationary production systems, several tools can be operated automatically and in parallel in order to achieve the highest possible level of efficiency.

Tool mount for TAURUS® 1-4

For integration into automated systems or connection to handling modules.

Part no. 143 5538*

*Device support not available individually. The tool is delivered pre-mounted on a new device or can be retrofitted on an existing device at the GESIPA® Walldorf site.

Can only be mounted by GESIPA®
Setting process monitoring is achieved by direct online analysis of traction force and traction course recorded during the setting of the rivet. All system components necessary for this operation are integrated in the tools. Analysing a setting process takes less than 1 µs. The results are directly shown by a green or red LED installed in the tool base and optionally by an acoustic signal. In addition to this individual analysis, the system also provides collective analysis for the complete workpiece. The tool stores more than 260,000 setting process data which can be retrieved at any time. The system also identifies failure patterns and memorizes them for failure analysis and troubleshooting. The tools can be operated as stand-alone devices or as integrated part of a customer’s production system via the GESIPA® interface.

GESIPA®-Interface
The new interface developed by GESIPA® is based on an embedded PC system and provides 24 digital in and out control system ports, Ethernet connection via a RJ45 connector as well as status LEDs. Connection ports for a protocol converter supporting all common bus systems and for external storage media as well as a USB port for fast data transfer complete the features of the new interface.

In addition, the GESIPA® interface has a process database for storing 250,000 of the most current process data (date, time, rivet position, process curve, analysis, etc.).

Of course, the new interface is backward compatible with its predecessor models.

High-grade GESIPA® blind rivet with minimal scatter:
- Minimal scatter of the graphs
- All graphs end in the break-off window
- 20x OK riveting
The experts in riveting technologies

TAURUS® versions

TAURUS® WinTech

WinTech – multi-window technology with up to three assessment windows

Ideal for demanding joining technology used for safety components such as in the aviation industry.

The basis for monitoring the WinTech setting process is the tried and tested TAURUS® C. The setting process is evaluated with the aid of position and force sensors as well as integrated electronic circuitry. Up to three evaluation windows can be configured with special setup software. A coloured LED on the tool shows the result of setting process monitoring. With a data line, the values can also be recorded and further processed.

Consultation, price and delivery time on request

Application

In the production of critical components as well as in automatic setting processes, the TAURUS® C can facilitate monitoring and documentation of the results.

Advantages

- High process reliability
- Documentation of each individual setting operation
- Less scrap as faults are detected immediately
- Avoidance of additional costs/quality costs due to NOK parts
- The customer can configure how to enter and exit the assessment window
- Flush-break rivets (MEGA GRIP®) can also be monitored

Example of OK process

Window entry and exit at customer-defined positions

Example of not OK process

Material to be joined too thin due to missing compo-
Speed riveting technology, also known as Speed Rivet Technology, is an assembly technique that requires access from one side only and enables high rates thanks to the pre-racked rivets and the automatic feed process. This technology is used in the following industrial areas, for example: electronics, housing manufacture, household appliances, lighting, lightweight constructions, DIN connectors, diecast aluminium housings and aeronautics.

Speed riveting technology completes GESIPA Blindniettechnik GmbH’s product portfolio. The new speed rivet setting tool by GESIPA® is the product of decades of expertise and the unbeatable advantages of the well-known, tried-and-tested TAURUS® series. Our engineers’ main objectives in its development were for the TAURUS® 1 Speed Rivet to be safe, quick and reliable. The very light and ergonomically shaped device will set new standards for the market.
TAURUS® 1 Speed Rivet

The experts in riveting technologies
Pneumatic blind rivet setting tools

The hydro-pneumatic-magazine setting tool with quick setting process and fast rates!

Working range
The rivet setting tool is designed for setting standard speed rivets from 2.4 - 4.8 mm Ø of all materials, as well as up to 4 mm Ø in stainless steel.

Technical data
- Traction power: 3,500 N at 6 bar
- Stroke: 26 mm
- Operating pressure: 5.7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Weight: 1.8 kg

Equipment
- Tag on device head
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- 1 oil press
- Operating instructions with spare parts list

Part no. 145 7684

Advantages
- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAUERUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)

Dimensions in mm

The experts in riveting technologies
**TAURUS® 2 Speed Rivet**

The experts in riveting technologies

---

**Working range**
The rivet setting tool is designed for setting standard speed rivets from 2.4 - 6.4 mm Ø of all materials.

**Technical data**
- Traction power: 6,500 N at 6 bar
- Stroke: 30 mm
- Operating pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4’’)
- Weight: 2.0 kg

**Equipment**
- Tag on device head
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- 1 oil press
- Operating instructions with spare parts list

**Advantages**
- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)

---

Standard tool comes without nosepiece
**TAURUS® 1 Speed Rivet Axial eco**

Axial version of the speed riveting setting tool for special applications

Part no. 145 7692

**Working range**
The rivet setting tool is designed for setting standard speed rivets from 2.4 - 4.8 mm Ø of all materials, as well as up to 4 mm Ø in stainless steel.

**Technical data**
- Traction power: 3,500 N at 6 bar
- Stroke: 26 mm
- Operating pressure: 5.7 bar
- Air hose connection: 6 mm Ø (1/4"")
- Weight: 3.0 kg

**Equipment**
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- 1 oil press
- Operating instructions with spare parts list

**Advantages**
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Can be suspended on a balancer
- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switch off
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)

**Dimensions in mm**

Standard tool comes without nosepiece
TAURUS® 2 Speed Rivet Axial eco

Axial version of the speed riveting setting tool for special applications

Part no. 145 0931

Working range
The rivet setting tool is designed for setting standard speed rivets from 2.4 - 6 mm Ø of all materials.

Technical data
- Traction power: 6,500 N at 6 bar
- Stroke: 30 mm
- Operating pressure: 5-7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Weight: 3.3 kg

Equipment
- 1 hydraulic oil bottle 100 ml
- 1 oil refill can
- 1 oil press
- Operating instructions with spare parts list

Advantages
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Can be suspended on a balancer
- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)

Dimensions in mm
The different nosepieces

- **Standard**: For easy to access riveting points.
- **Standard pointed**: For countersunk head rivets.
- **Extended and extended bent**: For difficult to access riveting points.
- **With opening mechanism**: Makes it easier to open the nosepiece so that speed rivets can be changed more conveniently and quickly.

### Spreader nosepiece without opening mechanism

<table>
<thead>
<tr>
<th>Rivet Ø</th>
<th>Part no.</th>
<th>Ø d (mm)</th>
<th>Ø D (mm)</th>
<th>L1 (mm)</th>
<th>L2 (mm)</th>
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</thead>
<tbody>
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### Spreader nosepiece with opening mechanism

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### Mandrel spring

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<td>4.8</td>
</tr>
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</table>

- **Standard**: For standard spreader nosepiece with or without opening mechanism.
- **Extended**: For extended spreader nosepiece with or without opening mechanism.
**GESIPA® assembly cell**

The new GESIPA® assembly cell guarantees optimum, precise handling with a wide range of GESIPA® processing devices and a workspace tailored perfectly to the customer’s requirements.

The desk is adapted individually to customer requirements and designed ergonomically (e.g. adjustable height). Everything – be it the desk, work piece socket, compressed air supply, electrical supply or processing tools – comes from one source, with process monitoring on request.

The optimised work piece socket allows the desk to be converted for different products and processing tools easily, saving costs.

The GESIPA® assembly cell is produced from high quality materials and components. Needless to say, you also have the option of transferring system components already used at your company.

**Advantages**
- Ergonomic working
- Individually adjustable
- Existing work tools can be integrated
- Easy and time-saving conversion for other products from your portfolio
- Setting process monitoring possible

More information on the individually adjusted assembly cell on request.

Example: Can be individually adjusted for each customer.
The individual work station

Specifcs

Operating status display
The signal light installed on the desk uses different colours to show the process status.

Counting device
The counting device registers and counts the torn off residual rivet mandrels.

GESIPA® setting tool
The setting tool is completely integrated in the assembly cell.

Individual work piece carrier
The optimised work piece carrier allows the desk to be converted for different products and processing tools easily, saving costs.

Foot pedal
The foot pedal allows you to use both hands to join individual parts and fasten the components to be riveted in place.
PH 1

Hydro-pneumatic blind rivet setting tool

Part no. 145 6766

Working range
Blind rivets up to 4 mm Ø all materials.
Not suitable for stainless steel
CAP® blind rivets.

Technical data
- Weight: 1.2 kg
- Operating air pressure: 5 - 7 bar
- Air hose connection: 6 mm Ø (1/4’’)
- Air consumption: 0.8 - 1.2 ltr. per rivet
  (0.2 ltr. compr. air)
- Traction power: 6,200 N at 6 bar
- Stroke: 15 mm

Nosepieces/accessories
- Nosepieces: 16/18, 16/24, 16/27 and 16/29
- 1 set of jaws, 1 spent mandrel bottle,
  1 wrench each of MSU and MSZ,
- Maintenance instructions with spare parts list

Jaws (2 parts) for PH 1

Part no. 143 4071

Features
- Hydraulic head in aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- The piston made of hardened and hard chromium plated steel make the device easy to handle and wear-proof
- Compact seals are wear-proof for a long service life
- Fast venting valve for fast return and high working sequence
- Low-noise pneumatic switching
- Simple, low-interruption valve design
- Hydraulic head can be adjusted by 360°
- Favourable centre of gravity and handle design for fatigue-free handlin

Dimensions in mm
PH 2

Hydro-pneumatic blind rivet setting tool

Part no. 145 6771

Working range
Blind rivets from 3 up to 5 mm Ø all materials and blind rivets with 2.4 mm up to 3.2 mm Ø with small jaws (page 171).

Not suitable for stainless steel CAP® blind rivets.

Technical data
- Weight: 1.3 kg
- Operating air pressure: 5 - 7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: 1.2 - 1.8 ltr. per rivet (0.3 ltr. compr. air)
- Traction power: 8.800 N at 6 bar
- Stroke: 15 mm

Equipment
- Nosepieces: 16/24, 16/27, 16/29, 16/32 and 16/36
- 1 set of jaws, 1 spent mandrel bottle,
- 1 wrench each of MSU and MSZ,
- Maintenance instructions with spare parts list

Features
- Hydraulic head made of aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Pistons: Steel hardened and chrome-plated – smooth operation and wear-proof
- Compact seals are wear-proof for a long service life
- Fast venting valve for fast return and high working sequence
- Low-noise pneumatic switching
- Simple, low-interruption valve design
- Hydraulic head can be adjusted by 360°
- Favourable centre of gravity and handle design for fatigue-free handling

Jaws (3 parts)
for PH 2 and PH 2000

Part no. 143 4103

Dimensions in mm
**PH 2000**

**Hydro-pneumatic blind rivet setting tool**

**Part no. 145 6724**

**Working range**
Blind rivets up to Ø 5.0 mm all materials, Ø 6.0 mm aluminium and blind rivets with Ø 2.4 mm up to 3.2 mm with small jaw assembly (page 171).

**Technical data**
- **Weight:** 2.1 kg
- **Operating air pressure:** 6 bar
- **Air hose connection:** 6 mm Ø (1/4’’)
- **Air consumption:** 2.8-3.6 ltr. per rivet (0.6 ltr. compr. air)
- **Traction power:** 12,000 N at 6 bar
- **Stroke:** 22 mm

**Equipment**
- Nosepieces: 16/24, 16/27, 16/29, 16/32, 16/36, 16/40 and 16/45
- 1 set of jaws, 1 air deflector (no. 896)
- 1 wrench MSU
- 1 ball headed screw driver SW 2.5
- 1 oil refill can with hydraulic oil
- Maintenance instructions with spare parts list
Hydro-pneumatic blind rivet setting tool

Features

- The patented broken mandrel disposal system with the extraction option is an integral part of the tool. No retrofitting required.
- The compressed air used for the setting process is then used to automatically eject the broken mandrel, an efficient and cost-saving solution.
- High setting force with low weight
- Universal use, easy handling
- Large stroke (22 mm) – guarantees setting without re-engagement and increases the oil refilling interval
- Pneumatic piston return – high working sequence

- Hydraulic head: Aluminium with wear-proof cylinder surface
- Pneumatic cylinder: Aluminium with impact-resistant plastic sheath
- Trigger valve: Direct pneumatic triggering – fast and functionally reliable
PH 2000-BT

Hydro-pneumatic blind rivet setting tool

Part no. 145 6729

Working range
BULB-TITE® blind rivets up to 7.7 mm Ø
all materials

Technical data
Weight: 1.9 kg
Operating air pressure: 6 bar
Air hose connection: 6 mm Ø (1/4”)
Air consumption: 2.8 - 3.6 ltr. per rivet
(0.6 ltr. compr. air)
Traction power: 12,000 N at 6 bar
Stroke: 22 mm

Equipment
Nosepieces: 16/26 BT, 16/32 BT, 16/42 BT
and 16/48 BT
1 nozzle tube no. 8080 a (built-in)
1 nozzle tube no. 8080 b (as accessory)
1 wrench MSU
1 ball headed screw driver SW 2.5
1 oil refill can with hydraulic oil
1 air deflector (no. 896)
Maintenance instructions with spare parts list

Jaws (3 parts) for PH 2000-BT

Part no. 143 4173

Universal nosepiece
The universal nosepiece replaces five nosepiece sizes.
The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece.

More information on the universal nosepiece can be found on page 171.

Article numbers for nosepieces
Information about nosepiece allocations are valid for DIN compliant and GESIPA® blind rivets.

<table>
<thead>
<tr>
<th>Article</th>
<th>Part no.</th>
<th>Article</th>
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</table>
**PH 2-VK**

**Hydro-pneumatic blind rivet setting tool**

**Part no. 145 6774**

**VK:** Shorter version of the pistol head for difficult to access rivets

**Working range**
Blind rivets up to 4 mm Ø alu, steel and copper

**Technical data**
- **Weight:** 1.3 kg
- **Operating air pressure:** 5 - 7 bar
- **Air hose connection:** 6 mm Ø (1/4’’)
- **Air consumption:** 1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
- **Traction power:** 6,200 N at 6 bar
- **Stroke:** 14 mm

**Equipment**
- Nosepieces: 10/18, 10/24 and 10/27
- 1 spent mandrel bottle,
- 1 maintenance wrench of MSU and MSZ,
- maintenance instructions with spare parts list

**Jaws (2 parts) for PH 2-VK**

**Part no. 143 4071**

**Dimensions in mm**
PH Axial

Hydro-pneumatic blind rivet setting tool

Part no. 145 8063

Working range
Blind rivets from 4 up to 5 mm Ø steel and 2.4 up to 3.2 mm Ø with small jaw assembly (page 171).

Technical data
- Weight: 1.8 kg
- Operating air pressure: 5 - 7 bar
- Air hose connection: 6 mm Ø (1/4”)
- Air consumption: 1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
- Traction power: 8,800 N at 6 bar
- Stroke: 15 mm

Equipment
- Nosepieces: 16/24, 16/27, 16/29 and 16/32
- Jaw pusher with reducing tube no. 125 for 4 mm Ø blind rivets in alu and copper
- Ejection tube with socket for spent mandrels
- Maintenance instructions and spare parts list

Jaws (3 parts) for PH Axial

Part no. 143 4103

Features
- Pneumatic cylinder and hydraulic head with jaw mechanism arranged axially behind each other: simple and easy handling when used vertically (e.g. desktop assembly points)
- Integrated blind rivet suction and rivet mandrel ejection system: does not need to be retrofitted, secure disposal of the spent mandrels in a central container via a hose
- Hydraulic head in aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Working piston made of hardened and hard chromium plated steel make the device easy to handle and wear-proof
- Compact seals are wear-proof with large scraper effect, long service life
- Fast venting system: faster return; high work sequence
- Low-noise pneumatic switching
- Simple valve structure: interruption free
## Accessories – Hydro-pneumatic blind rivet setting tool

**Nosepiece assignment PH tools.** Information about nosepiece allocations are valid for DIN compliant and GESIPA® blind rivets.

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<th>PH 2</th>
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<th>PH-Axial</th>
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</table>

* Small jaw assembly required (see page 171)

** Conversion kit necessary (145 6762)

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The experts in riveting technologies

GESIPA®
Special accessories for blind rivet setting tools

Transparent spent mandrel container for the TAURUS® and Bird Pro series

The spent mandrel container of the TAURUS® and Bird Pro series is also available in a transparent version.

The transparent collecting container allows the amount of residual mandrels to be monitored constantly.

The transparent spent mandrel container is available in a small version for TAURUS® tools (TAURUS® 1-2) and a large version (TAURUS® 3-4). A version is also available for the Bird Pro series.

Example: TAURUS® 2 with small transparent spent mandrel container and PowerBird® Pro Gold Edition with transparent spent mandrel container

VAS

Vacuum absorption system for PH1 and PH2

Part no. 145 7579

This device absorbs the spent mandrel after the riveting operation and transports it automatically into the mandrel container. A further advantage is offered when the rivet, inserted into the nosepiece, is held in the jaw mechanism even if the tool head is in the vertical downwards position. The vacuum absorption device is available as a complete built-in and can also be retrofitted to existing GESIPA® riveting power tools at any time.

Technical data

Weight of kit: 430 g
Operating air pressure: 4-6 bar

Equipment

1 air deflector (part no. 896)
1 wrench MSU
Maintenance instructions with spare parts list
Special accessories for blind rivet setting tools

Small jaw assembly for PH 1, PH 2, PH 2000 and PH-Axial

With reduced head diameter (18 mm) and 2 part jaws.

Working range
up to 4 mm Ø stainless steel and 5 mm Ø alu

Equipment
Standard: nosepiece 10/24 (optional also with nosepiece 10/18, 10/27, 10/29, 10/32)

PH 1 and PH 2
Part no. 145 6783

PH 2000
Part no. 143 4234

PH Axial
Part no. 145 8075

Universal nosepiece for blind rivet tools
HN 2, PH 1, PH 2, PH 2-KA, PH 2000 and AccuBird®

The universal nosepiece replaces five nosepiece sizes. The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece.

Working range
Blind rivets from 2.4 up to 5 mm Ø alu, copper and steel and up to 4 mm Ø stainless steel.

For HN 2, PH 1, PH 2 and PH 2000
Universal nosepiece — 16
Part no. 145 6776

Für AccuBird®
Universal nosepiece — 17
Part no. 143 4960

Operation
Operate the tool and hold trigger, then push back adjusting ring to end position (1). By turning the rotary star (2).

The universal nosepiece includes: Special steel sleeve, complete adjusting ring, rotary star and sealing ring.
Special accessories for blind rivet setting tools

One-piece extension unit
Replaces the steel case, is especially slim and therefore particularly well suited to narrow, hard-to-reach places.

**Overall Length = Steel case + Standard nosepiece**

<table>
<thead>
<tr>
<th>Tool</th>
<th>+35 mm</th>
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<th>+135 mm</th>
<th>+185 mm</th>
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<td>TAUROUS® 1*</td>
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<td>146 4346</td>
<td>146 4347</td>
<td>-</td>
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<tr>
<td>TAUROUS® 2*</td>
<td>145 8042</td>
<td>146 4350</td>
<td>146 4351</td>
<td>146 4352</td>
</tr>
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<td>TAUROUS® 3 and 4</td>
<td>145 7932</td>
<td>145 7933</td>
<td>145 7937</td>
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<table>
<thead>
<tr>
<th>Tool</th>
<th>50 mm</th>
<th>100 mm</th>
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<tbody>
<tr>
<td>TAUROUS® 1 with spring loaded trigger system</td>
<td>145 0880</td>
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<tr>
<td>TAUROUS® 2 with spring loaded trigger system</td>
<td>145 7857</td>
<td>145 7858</td>
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<tr>
<td>TAUROUS® 3 and 4 with spring loaded trigger system</td>
<td>145 7959</td>
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* Valid for tools manufactured after October 2015
For older models see page 305

<table>
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<tr>
<th>Tool</th>
<th>+35 mm</th>
<th>+85 mm</th>
<th>+135 mm</th>
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<td>PowerBird® Pro</td>
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<td>PowerBird® Pro Gold Edition</td>
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</table>

<table>
<thead>
<tr>
<th>Tool</th>
<th>+50 mm</th>
<th>+100 mm</th>
</tr>
</thead>
<tbody>
<tr>
<td>PowerBird® Pro Gold Edition with spring loaded trigger system</td>
<td>145 0821</td>
<td>145 0822</td>
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</table>

The total length of the steel head sleeve for:

**Battery powered tools**
for 50 mm is 117 mm
for 100 mm is 167 mm
for 150 mm is 217 mm

**Battery powered tools (Pro)**
for 35 mm is 106 mm
for 85 mm is 156 mm
for 135 mm is 206 mm

**TAUROUS® tools**
TAUROUS® 1 with 35 mm, 85 mm and 135 mm is 106 mm, 156 mm and 206 mm respectively
TAUROUS® 2 with 35 mm, 85 mm, 135 mm and 185 mm is 106 mm, 156 mm, 206 mm and 256 mm respectively
TAUROUS® 3 and 4 with 35 mm, 85 mm and 135 mm is 106 mm, 156 mm and 206 mm respectively
Special accessories for blind rivet setting tools

Multi-piece extension units
For riveted joints in low-lying places. Screwed in between the device and the existing steel case

Total length = steel head sleeve + extension + standard nosepiece

<table>
<thead>
<tr>
<th>Tool</th>
<th>Length</th>
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<tbody>
<tr>
<td>PH 1 and PH2</td>
<td>100 mm</td>
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<tr>
<td>PH 2000</td>
<td>100 mm</td>
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<tr>
<td>AccuBird®</td>
<td>100 mm</td>
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<tr>
<td>PowerBird®</td>
<td>100 mm</td>
</tr>
<tr>
<td>PowerBird® Gold Edition</td>
<td>100 mm</td>
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<tr>
<td>AccuBird® Pro</td>
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<tr>
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<td>100 mm</td>
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<tr>
<td>TAURUS® 1</td>
<td>100 mm</td>
</tr>
<tr>
<td>TAURUS® 2</td>
<td>100 mm</td>
</tr>
<tr>
<td>TAURUS® 3 and 4</td>
<td>100 mm</td>
</tr>
</tbody>
</table>

PH tools
Total length of the steel head sleeve including the extension unit is 50 mm 117 mm.

Battery powered tools
Variable extension of the steel head sleeve is possible in steps of 100 mm. The total length of the steel head sleeve, including the extension unit, is 167 mm for 100 mm.

Battery powered tools (Pro)
Variable extension of the steel head sleeve is possible in steps of 100 mm. The total length of the steel head sleeve, including the extension unit, is 171 mm for 100 mm.

TAURUS® tools
Total length of the steel head sleeve including the extension unit. On TAURUS® 1-4 the steel head sleeve can be extended variably in steps of 100 mm.

Offset head for PH1 and PH2
For setting rivets in places with difficult access and in corners

<table>
<thead>
<tr>
<th>Offset head for PH1 with 2 part jaws</th>
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<tbody>
<tr>
<td>Part no. 145 6611</td>
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<table>
<thead>
<tr>
<th>Offset head for PH2 with 3 part jaws</th>
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</thead>
<tbody>
<tr>
<td>Part no. 145 6612</td>
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</table>
Special accessories for blind rivet setting tools

Special length nosepieces for blind rivet setting tools
NTS, NTS-K, NTX, NTX-F, Flipper®, SN 1, PH 1-VK, PH 2-VK and PH 1-L

<table>
<thead>
<tr>
<th>Rivet-Ø</th>
<th>Material Description</th>
<th>Ø d</th>
<th>Ø D</th>
<th>Designation</th>
<th>15 mm</th>
<th>20 mm</th>
<th>25 mm</th>
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</thead>
<tbody>
<tr>
<td>3 and 3.2</td>
<td>Alu, Cu, Steel, Stainless steel, Stinox, Alu/alu, PG-Alu, PG-Steel</td>
<td>2.4</td>
<td>6.5</td>
<td>10/24 SL...</td>
<td>145 6630</td>
<td>145 6632</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Alu, Cu</td>
<td>2.4</td>
<td>6.5</td>
<td>10/24 SL...</td>
<td>145 6630</td>
<td>145 6632</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>Steel, CAP®-Alu, CAP®-Cu, Alu/alu, PG-Alu</td>
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<td>7.0</td>
<td>10/27 SL...</td>
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<td>145 6635</td>
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<tr>
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<td>Stainless steel, Stinox, PG-Steel</td>
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<td>8.0</td>
<td>10/29 SL...</td>
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<tr>
<td>4.8</td>
<td>CAP®-Alu, CAP®-Cu</td>
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<tr>
<td>4.8 and 5</td>
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SN 2, HN 2, PH 1, PH 2, PH 2-KA, PH-Axial and PH 2000

<table>
<thead>
<tr>
<th>Rivet-Ø</th>
<th>Material Description</th>
<th>Ø d</th>
<th>Ø D</th>
<th>Designation</th>
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<th>28 mm</th>
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<tbody>
<tr>
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<td>145 6813</td>
<td>145 6814</td>
<td>145 6815</td>
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<td>145 6813</td>
<td>145 6814</td>
<td>145 6815</td>
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<td>145 6817</td>
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<td>145 6819</td>
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<td>145 6821</td>
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<td>145 6825</td>
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<td>145 6827</td>
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## Special accessories for blind rivet setting tools

### AccuBird®, PowerBird® and TAURUS®

<table>
<thead>
<tr>
<th>Rivet-Ø</th>
<th>Material</th>
<th>Ø d</th>
<th>Ø D</th>
<th>Designation</th>
<th>15 mm</th>
<th>20 mm</th>
<th>25 mm</th>
<th>28 mm</th>
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<tbody>
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<td>146 4039</td>
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</tbody>
</table>

### CAUTION! Blind rivets must be ordered as a custom-made product with extended mandrel!