

**CP-4689 RIVETING HAMMERS**

**UTICA PNEUMATIC 210**

*SIXTH EDITION*

*MAY, 1979*

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*Instruction and Parts Book for*  
**PNEUMATIC HEAVY BOYER®**  
**RIVETING HAMMERS**

**CP-4689 Model "A"**



**TOOL DIVISION**  
**Chicago Pneumatic**

UTICA, NEW YORK 13503

INDEX

Tools covered by this instruction and parts book have catalog numbers starting with CP-4689 followed by catalog code letters such as PUBAR, PUGAR, etc.

The following index indicates the pages on which part information corresponding to catalog code letters are located.

THROTTLE HANDLE			VALVE			CYLINDER *			BUSHING			RETAINER		
Code	Description	Page	Code	Description	Page	Code	Description	Page	Code	Description	Page	Code	Description	Page
<b>P</b>	Pistol Grip Outside Trigger	3	<b>U</b>	Spool	3	<b>B</b>	5 7/16" Stroke	3	<b>A</b>	None		<b>R</b>	Arrow Type	4
						<b>G</b>	9 1/2" Stroke	3						

NOTE: \*  
All cylinders supplied under this code system are straight shank type.

**CAUTION: THIS CODE LETTER INDEX DOES NOT NECESSARILY INDICATE INTERCHANGEABILITY OR SAFE PARTS COMBINATIONS. REFER TO THE LATEST CHICAGO PNEUMATIC CATALOG FOR APPROVED TOOL DESIGNATIONS AND ASSEMBLY COMBINATIONS.**

GENERAL INSTRUCTIONS...  
RECOMMENDED SPARES...  
ADDITIONAL ACCESSORIES.

GENERAL INSTRUCTIONS

Air Supply

For satisfactory performance, 90 psig (6.2 bar) of clean, dry air is required AT THE TOOL, when tool is in operation. LEADER HOSE SHOULD BE AT LEAST 1/2" I.D., but longer runs should be 3/4" hose size or larger, used with couplings of a minimum 7/16" I.D.

The use of a C-104093 CHICAGO PNEUMATIC Air Line Pressure Regulator, and C-132195 Air Line Filter is recommended.

Instructions for Safe Operation

BEFORE PLACING THIS TOOL IN OPERATION, READ THE FOLLOWING SECTIONS EXCERPTED FROM THE COMPRESSED AIR AND GAS INSTITUTE'S "SAFETY CODE FOR PORTABLE AIR TOOLS." (APRIL 1974)

**2.6.2 EYE PROTECTION** Eye and face protection shall be required where there is a reasonable probability of injury that can be prevented by such protection. Suitable eye protectors shall be provided where machines or operations present the hazard of flying objects. Eye protection should be worn at all times while operating power tools.

**7.3 RETAINERS** A retainer shall be integral with or installed on a percussion tool which, without such a retainer, can eject the chisel, rivet set, punch or such equipment, when the tool is operated off a work surface.

**EXCEPTION:** Retainers are not required when proper barriers have been erected to protect persons in surrounding or lower areas from possible ejected tools.

**7.4 QUICK DISCONNECT COUPLINGS** If a quick-disconnect coupling is used on a percussion tool, it shall be separated from the tool by a whip hose.

**7.5 OPERATOR INSTRUCTIONS** A percussion tool shall not be operated unless the chisel, rivet set, scaling tool, or other is in position in the tool and in contact with the work piece. Tools shall not be used in such a manner that ejection of an accessory might endanger adjacent personnel.

**7.6 REMOVE TOOLS** When percussion tools are not in use, the dies and accessories shall be removed, unless they are retained in a positive manner.

Preparing for Operation

Daily before using and before putting tool into operation, disconnect air hose and pour about one tablespoonful of recommended oil into tool air inlet. Blow out air line to clear it of accumulated dirt and moisture, connect tool and operate to allow oil to be carried to the interior.

Lubrication

"The use of synthetic oils is NOT RECOMMENDED due to possible damage to seals, "O" rings, hose, blades and polycarbonate oiler/filter bowls."

Daily before using and after each two hours of service, pour about one tablespoonful of recommended oil into air inlet. In addition, use of a C-132200 CHICAGO PNEUMATIC Air Line Lubricator installed at the end of each air pipe leading to this pneumatic tool is recommended to assure a constant and adequate supply of lubricant to the cylinder.

Recommended Lubricants

CHICAGO PNEUMATIC Airoilene Oil, which contains moisture absorbent, rust inhibiting additives and will not separate while the tool is idle, is recommended for use in the lubricator and may be purchased under the following symbols:

- 1 gal. can -----P-089507
- 5 gal. can -----P-089508

If recommended oil is not available, use a turbine or spindle grade oil with a viscosity of 100-150 SUS at 100°F. which contains a rust inhibitor.

Loss of Power/Erratic Action

Tool failure, loss of power or erratic action may be caused by factors outside the tool. Make the following checks.

1. Check air pressure. For rated performance, 90 psig (6.2 bar) air pressure is required AT THE TOOL with tool operating. A drop in air pressure may be caused by lowered compressor output, excessive drain on the air line or by use of hose or connections of improper size or in poor condition.
2. Check for wet or dirty air. Wet air tends to wash lubricant away from cylinder and to rust and corrode the tool. Dirt and foreign matter in the air supply will impede action of the piston and cause damage to the tool.

If above are in order, check mechanical parts of tool. Disassemble tool, thoroughly clean and inspect all parts. Replace worn parts, relubricate and reassemble tool.

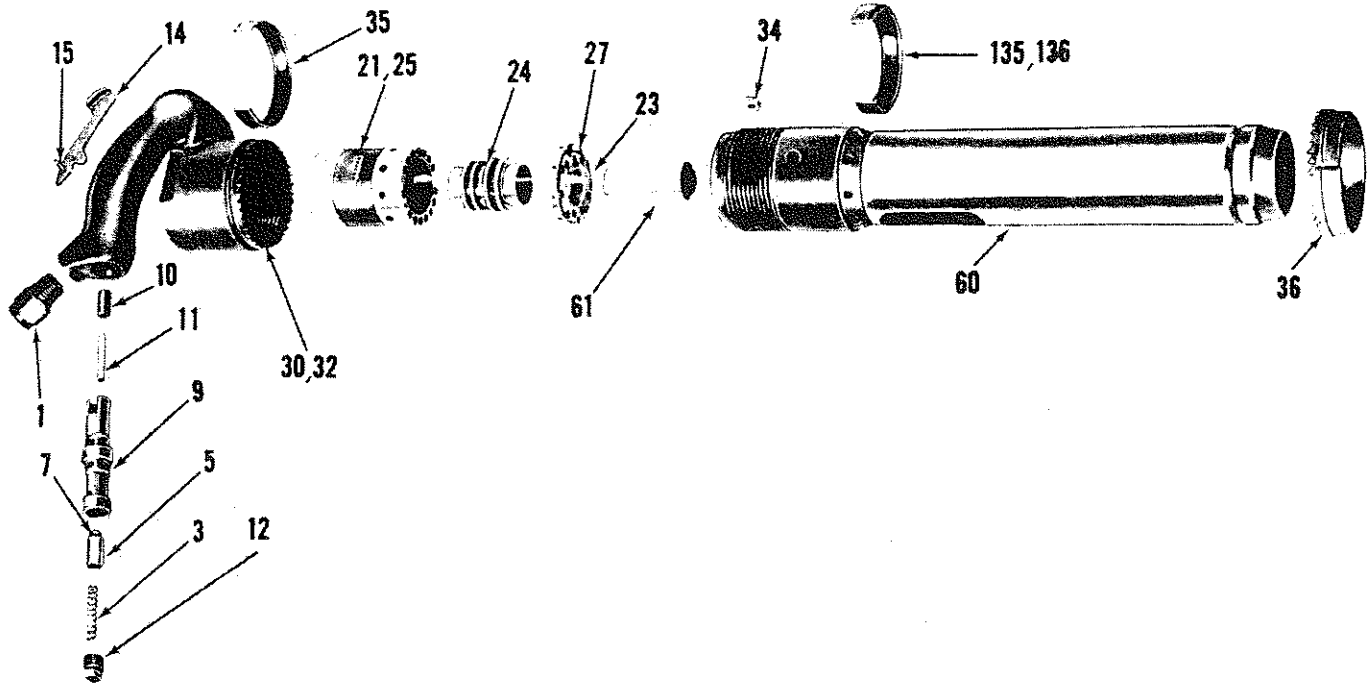
Maintenance

Do not penalize the operator by requiring him to use a tool which is not in first class condition. A regularly scheduled inspection and repair program will correct minor faults, avoid later extensive repairs, and maintain the tool at its highest efficiency.

1. Keep tool properly lubricated.
2. Provide 90 psig (6.2 bar) of clean, dry air AT THE TOOL.
3. Use hose and connections of proper size and in good condition.
4. Set up and maintain a repair and replacement program scheduled at regular intervals.

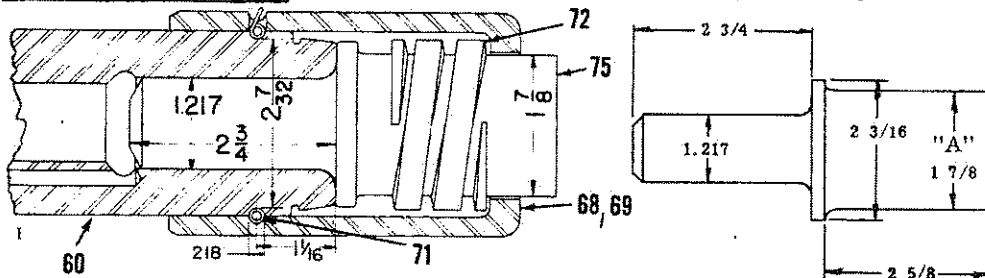
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CP-4689 HEAVY RIVETING HAMMERS Model "A"



Flush Face Sets	"A"
P-015632	3/4 1 1/4
P-012606	7/8 1 1/2

Type S-1 Button Head Rivet Sets use with P-122232 Retainer and straight shank cylinders

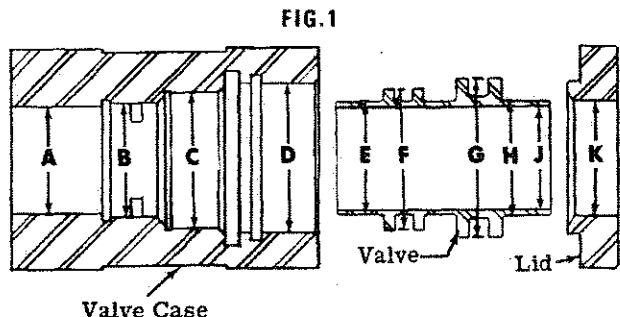


Rivet Body Diameter in. (mm)	Part No.
3/8 ( 9.5)	P-008804
1/2 (12.7)	P-008806
5/8 (15.9)	P-008808
11/16(17.5)	P-008809
3/4 (19.1)	P-008810
13/16(20.6)	P-008811
7/8 (22.2)	P-008812
15/16(23.8)	P-008813
1 (25.4)	P-008814

Index No.	CP Part No.	Description	No. Req'd.	Index No.	CP Part No.	Description	No. Req'd.
1	P-001983	Bushing-Air Inlet (Incl:Screen) (3/8" NPTF)	1	30	P-007155	Handle Complete (Incl: Index No's. 1, 3, 5, 11, 12, 14, 15 & 32)	1
3	P-001853	Spring-Throttle Valve	1	32	P-007348	Handle (Incl: Index No. 9)	1
5	P-001799	Valve-Throttle (Incl: Index No. 7)	1	34	P-001419	Key-Lock Collar	1
7	P-083071	"O" Ring (-011)	1	35	P-001373	Clip-Lock Collar Spring	1
9	P-007198	Tube-Throttle Valve (Incl: Index No. 10)	1	36	P-001398	Collar-Lock	1
10	P-004839	Bushing-Push Pin	1	60	P-001137	Cylinder (5 7/16" Stroke)	1
11	P-004834	Pin-Push	1		P-001004	Cylinder (9 1/2" Stroke)	1
12	P-001873	Plug-Throttle Tube	1	61	P-001212	Piston	1
14	P001982	Lever-Throttle	1	68	P-122232	Retainer-A. T. Rivet Set (Incl: Index No's 69, 71 & 72)	1
15	P-001915	Pin-Throttle Lever	1	69	P-071534	Sleeve-Retainer	1
21	P-007180	Case-Valve Complete (Incl: Index No's. 23 thru 27)	1	71	P-070006	Spring-Lock	1
23	P-006584	Lid-Valve Case	1	72	P-002494	Spring-Set Retainer	1
24	P-001535	Valve-Cycling	1	75	*	Set-Rivet (St raight Shank)	1
25	P-006583	Case-Valve	1	135	P-001386	Deflector-Exhaust (Incl: Index No. 136)	1
27	P-001631	Dowel-Valve Case	1	136	P001386	Deflector-Exhaust Rivet	1

When ordering spare parts, give Name, Speed or Size, Model and Serial Number of the tool and Part Number and Description of each part desired.

5. Check valve mechanism by disassembling tool and checking for plugged air porting and for worn parts. As the parts of the tool wear, power will slowly decrease. Depending on the requirements of the particular application, tolerable wear can vary. As a guide for maintaining maximum power output, the parts shown below should not be worn in excess of the dimensions shown below.



Dimension A	1.0631 max.	Dimension F	1.3739 min.
Dimension B	1.1251 max.	Dimension G	1.4989 min.
Dimension C	1.3756 max.	Dimension H	1.1242 min.
Dimension D	1.5004 max.	Dimension J	1.0655 max.

As a guide in maintaining maximum power output, parts listed below should not be worn in excess of listed dimensions.

Part	Max. I.D. (Inches)	Part	Min. O.D. (Inches)
Cylinder (Index #60)	1.065	Piston (Index #61)	1.0603

Replace piston (61) if cracked or worn hollow on striking end.

Check wear on throttle valve by cracking valve slowly. If tool accelerates rapidly, or throttling is poor, replace "O" ring (7).

Repair tools for handle (P-007348)  
P-005237 tap for P-007198 throttle valve tube  
P-005242 two step reamer for P-007198 tube

### SPARE PARTS SERVICE CHART

THIS SERVICE CHART IS PUBLISHED AS A GUIDE TO EXPECTANT LIFE OF COMPONENT PARTS. THE REPLACEMENT LEVELS ARE BASED ON AVERAGE TOOL USAGE OVER A ONE YEAR PERIOD

EXAMPLE: For 10 tools in use: 10 high wear items will be required per year, 7 medium wear items, etc.

NOTE: Quantities must be increased where tool is subjected to more severe and/or continuous usage.

#### LEGEND

- X—Type of wear, if no other comments apply.
- L—Easily lost. Carefully reserve during disassembly.
- D—Easily damaged during disassembly and assembly.

Index No.	CP Part No.	Description	No. Req'd.	High Wear 100%	Medium Wear 70%	Low Wear 30%	Non Wear 10%
1	P-001983	Bushing-Air Inlet	1				X
3	P-001853	Spring-Throttle Valve	1	L			
5	P-001799	Valve-Throttle	1			D	
7	P-083071	"O" Ring	1			X	
9	P-007198	Tube-Throttle Valve	1	X			
10	P-004839	Bushing-Push Pin	1	X			
11	P-004834	Pin-Push	1			X	
12	P-001873	Plug-Throttle Tube	1				X
14	P001982	Lever-Throttle	1	X			
15	P-001915	Pin-Throttle Lever	1	X			
23	P-006584	Case-Valve Lid	1			X	
24	P-001535	Valve	1	X			
25	P-006583	Case-Valve	1			X	
27	P-001631	Dowel-Valve Case	1				X
32	P-007348	Handle	1				X
34	P-001419	Key-Lock Collar	1				L
35	P-001373	Clip-Lock Collar Spring	1			X	
36	P-001398	Collar-Lock	1			X	
60	P-001137	Cylinder (5 7/16")	1			D	
	P-001004	Cylinder (9 1/2")	1			D	
61	P-001212	Piston	1			D	
135	P-001386	Deflector-Exhaust	1	X			
136	P001386	Rivet-Exhaust Deflector	1	X			
ARROW TYPE RIVET SET RETAINER							
69	P-071534	Sleeve-Retainer	1				X
71	P-070006	Spring-Lock	1				X
72	P-002494	Spring-Set Retainer	1	X			

When ordering spare parts, give Name, Speed or Size, Model and Serial Number of the tool and Part Number and Description of each part desired.