

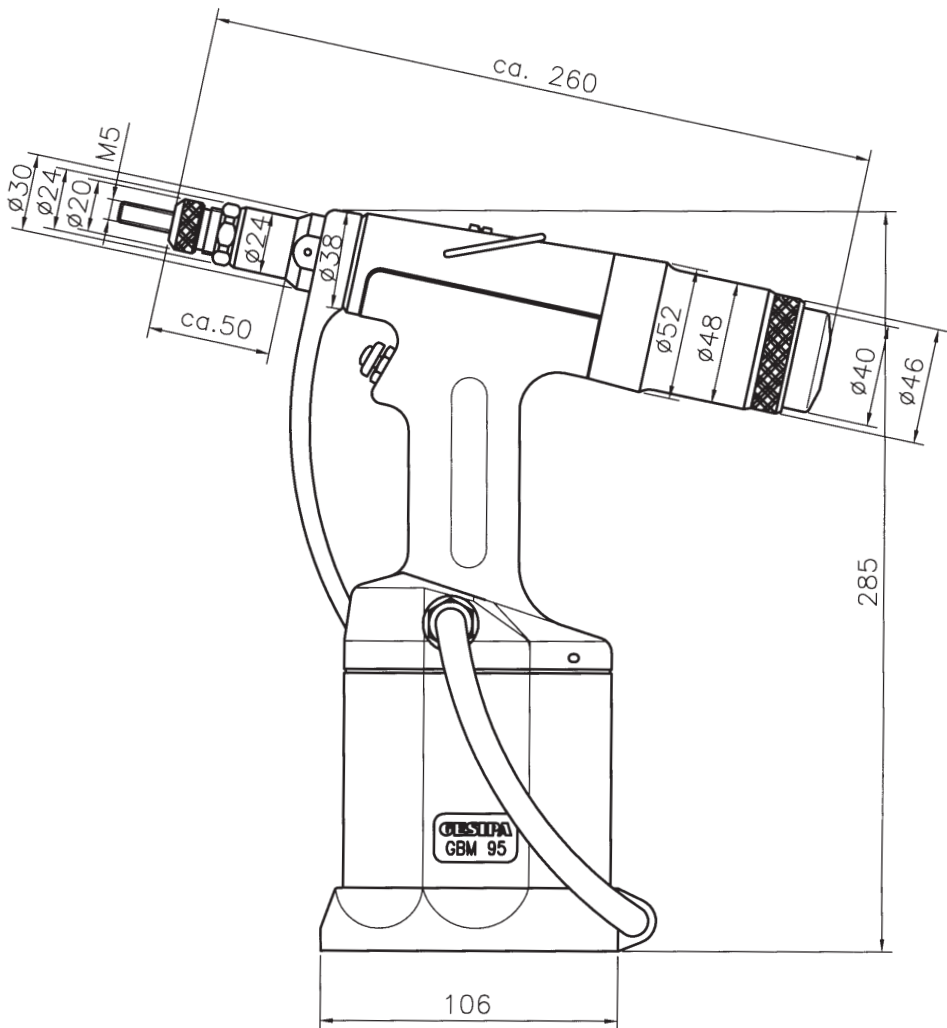
GBM 95

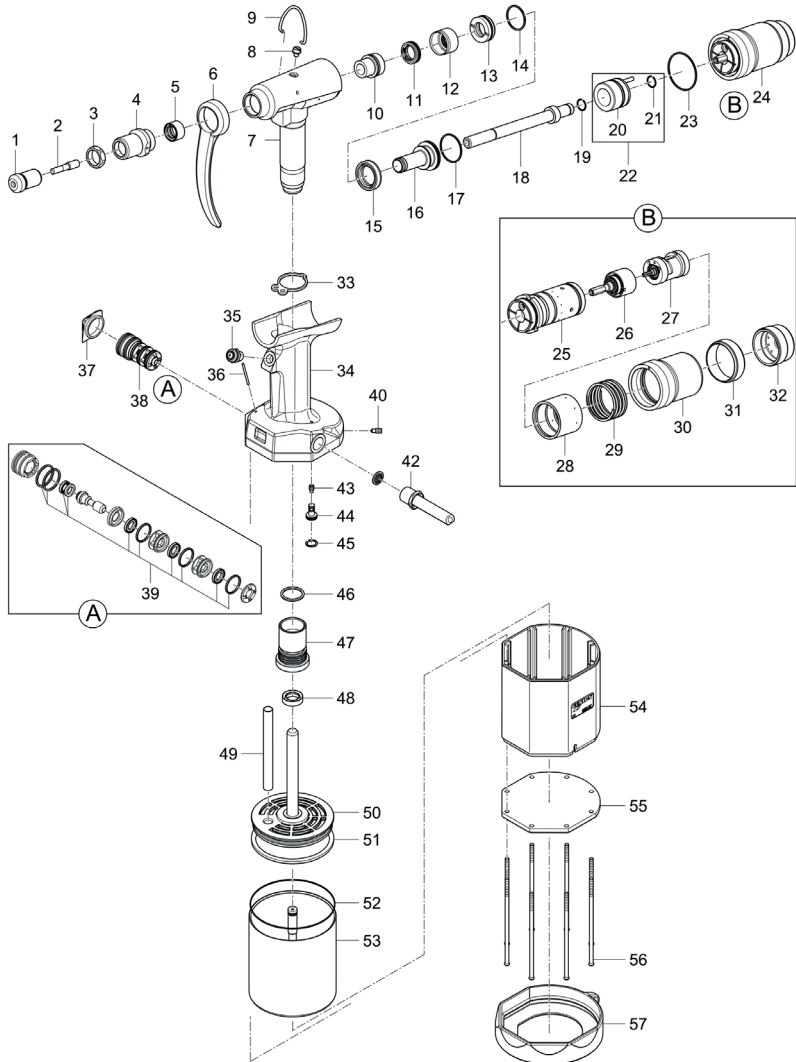


GESIPA Blindniettechnik GmbH
Nordendstraße 13-39
64546 Mörfelden-Walldorf
Germany

T +49 (0) 6105 962 0
F +49 (0) 6105 962 287
info@gesipa.com
www.gesipa.com

GESIPA[®]





1	143 5213	M3
	143 5214	M4 & 8-32"
	143 5215	M5 & 10-32"
	143 5216	M6
	143 5217	M8 & 5/16-18"
	143 5218	M10 & 3/8-16"
	143 5148	1/4-20"
2	143 5207	M3
	143 5208	M4
	143 5209	M5
	143 5210	M6
	143 5211	M8
	143 5212	M10
	143 5149	8-32"
	143 5143	10-32"
	143 5144	1/4-20"
	143 5150	5/16-18"
	143 5145	3/8-16"
3	143 5185	
4	143 5220	
5	145 7574	
6	143 4232	
7	145 7560	
8	145 6754	
9	144 5265	
10	145 7551	
11	145 6749	
12	145 7575	
13	145 6752	
14	143 4227	
15	145 6757	
16	145 7572	
17	143 4226	
18	145 7571	
19	143 5237	
20	143 5236	
21	144 5823	
22	145 7573	

23	143 5243
24	145 7556
25	145 7553
26	145 7576
27	145 7577
28	145 7554
29	144 5813
30	145 7552
31	143 5160
32	143 5161
33	143 4221
34	145 7563
35	145 7567
36	143 4219
37	143 4216
38	145 6756
39	145 6758
40	143 5247
42	143 4220
43	144 5819
44	145 7559
45	144 5826
46	145 7555
47	145 7550
48	143 5179
49	143 4217
50	145 7549
51	143 5201
52	143 4224
53	145 7557
54	143 5204
55	143 4236
56	144 5292
57	143 4237

Table of Contents

1. Use in accordance with the operating instructions	16
2. Safety instructions	16
3. Working range	16
4. Technical data	16
5. Equipment and accessories	17
6. Starting procedure	17
6.1 Adjustment of mandrel length "X"	17
6.2 Adjustment of stroke "Y"	18
6.3 Threading-on and setting of a blind rivet nut	19
6.4 Change of threaded mandrel	20
6.5 Change of unthreading time	20
7. Maintenance and service	20
8. Repairs	21
9. Environmental notes	21
10. Troubleshooting	21
10.1 Rivet nut is not threading on	21
10.2 Set rivet nut is loose	21
10.3 Threaded mandrel is not unthreading	21
11. Warranty	22
12. Conformity declaration	22

1. Use in accordance with the operating instructions

The tool should be used only in accordance with these operating instructions for setting blind rivet nuts.

The safety instructions must be followed!

2. Safety instructions

- The tool is to be used only for setting blind rivet nuts.
- Do not overload the tool. Work only within the indicated capability range.
- Do not operate the tool without installing a rivet nut.
- Regularly check compressed air connections with respect to tightness and leakage.
- Always disconnect the tool from compressed air supply when tool is not in use or when servicing.
- When working with the tool, always wear protective safety glasses. Personal safety equipment such as protective clothing, protective gloves, helmet, nonslip shoes and hearing protection are recommended in order to safeguard against accidents.
- Keep long hair or loose clothing away from the tool during operation or when servicing.
- Repairs should be carried out by trained personnel only. If in doubt, return the tool to the supplier.
- Used hydraulic oil must be disposed of in accordance with environmental regulations.

3. Working range

Blind rivet nuts from M3 to M10, all materials.

4. Technical data

Weight:	2.3 kg
Operating air pressure:	6 bar
Air connection:	6 mm Ø (1/4")
Air consumption:	approx. 8 NI per cycle
Compressed air quality:	filtered and dried
Traction power:	15,700 N (1,600 kp)
Hydraulic oil:	approx. 30 ml ISO VG 46
Noise emission:	L_{pa} 82.5 dB, Measurement uncertainty K=3dB
Vibration:	<2.5 m/s ² , Measurement uncertainty K=1.5 m/s ²

5. Equipment and accessories

Threaded mandrel and nosepieces: M6 in working position
 Alternatively also M3, M4, M5, M8 and M10

Tools: Universal maintenance wrench MSU
 Pin spanner $\varnothing 42$
 Hexagon screw driver SW 4 mm
 Hexagon ball-end driver SW 2.5 mm

Other: Assembly rod
 Hydraulic oil refill bottle
 Operating manual with spare part list

6. Starting procedure

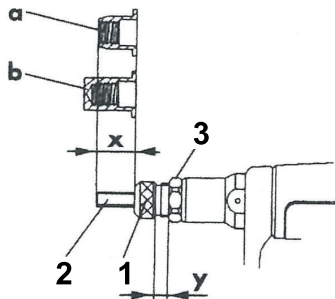


Before starting, carefully read and follow operating instructions!

6.1 Adjustment of mandrel length "X"

- Disconnect tool from compressed air to unlock the threaded mandrel.
- In case of standard blind rivets nuts «a» the protruding part of the threaded mandrel (2) must be as long as the whole blind rivet nut (see drawing 1) and is hand adjusted by turning the mandrel either in or out.
- In case of closed-end rivet nuts «b» use entire threaded depth.
- To lock the length adjustment connect tool to compressed air and the locking device is engaged automatically.

Drawing 1



6.2 Adjustment of stroke "Y"

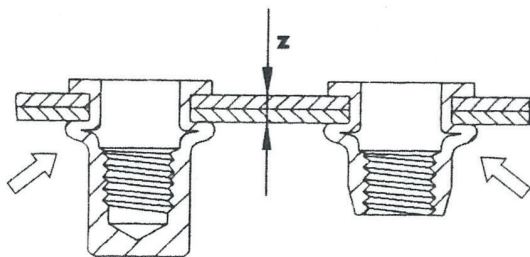
The stroke «Y» (see chart) depends on the blind rivet nut size (M3 to M10, 6-32 to 3/8-16) and the material thickness «Z» (drawing 2).

Stroke chart for GBM 95:

Thread size	Stroke min.	"Y"	mm max.
M3	0.5	-	1
M4	1	-	2
M5	1.5	-	2.5
M6	2.5	-	3.5
M8	3.5	-	4.5
M10	3.5	-	4.5

- Loosen lock nut (3) (drawing 1).
- Adjust stroke «Y» by turning in or out the nosepiece (1).
- Stroke «Y» has to be adjusted to «min», to be locked (tightened) and then the rivet nut has to be set.
- If the blind rivet nut does not form a proper sealing head (as shown in drawing 2) the stroke «Y» must be increased step by step. After stroke adjustment, the lock nut (3) has to be tightened.

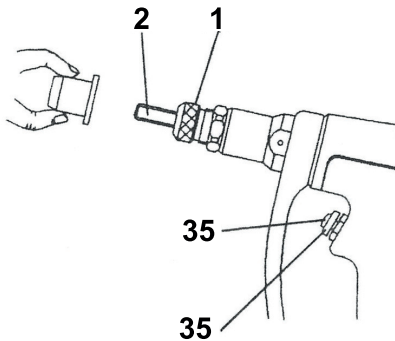
Drawing 2



6.3 Threading-on and setting of a blind rivet nut

- Place the rivet nut in front of the threaded mandrel (2) (see drawing 3) without tilting and push the thread-on button (35).
- Hold the blind rivet nut during the entire threading process until it fits tightly against the nosepiece (1).
- Insert the blind rivet nut into the workpiece, ensuring that the fastener's head is fully seated. Next set the blind rivet nut by pressing the stroke button (35).
- Hold button (35) until blind rivet nut is set completely.
- Release button (35). The threaded mandrel (2) is threaded off automatically.

Drawing 3



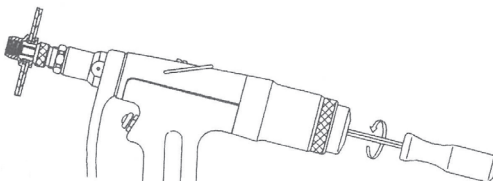
Attention! 

In order to avoid upsetting smaller or thin-wall type blind rivet nuts during the threading process, disconnect tool and increase the threaded mandrel protrusion to a length such that the rivet nut does not thread on flush against the nosepiece. Adjust setting stroke (see paragraph 6.2)

Important: 

- If the threaded mandrel (2) is not threaded out of the blind rivet nut completely, a short quick touch of the stroke button (35) will induce threading-out procedure.
- If the threaded mandrel is stuck in the blind rivet nut, it may be loosened by means of the enclosed hexagon wrench SW4 (see drawing 4).

Drawing 4



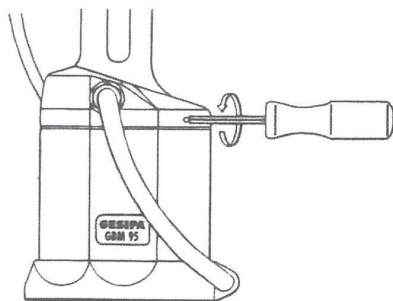
6.4 Change of threaded mandrel

- Disconnect tool from compressed air supply.
- Loosen lock nut (3) (drawing 1).
- Unscrew nosepiece (1).
- Unscrew threaded mandrel (2) by turning backward and forward until mandrel releases.
- Screw in new threaded mandrel.
- Screw in corresponding nosepiece (1) with lock nut (3).
- Adjust setting stroke «Y» and length of threaded mandrel «X» (see paragraphs 6.1 and 6.2).

6.5 Change of unthreading time

- The adjusting screw at the edge of the handle near the air connection can be reached with enclosed ball-headed screw driver SW 2.5 mm (see drawing 5).
- A slight turn to the right increases the unthreading time.
- A slight turn to the left reduces the unthreading time.

Drawing 5



7. Maintenance and service

Special maintenance is not necessary. If applicable, exchange worn threaded mandrels according to paragraph 6.4. When not in use the tool should be kept in a dry room.

8. Repairs

Repairs under warranty are carried out by the manufacturer. Repairs outside the warranty period should only be carried out by skilled technical personnel. Failure to observe the assembly and setting procedures and operation by non-skilled personnel may result in serious damage to the blind rivet setting tool. In case of doubt, always send the blind rivet setting tool back to the supplier or to GESIPA®.

9. Environmental notes

Used hydraulic oil must be disposed of in accordance with recycling regulations.

10. Troubleshooting

10.1 Rivet nut is not threading on

Cause	Solution
Faulty rivet nut thread	Use new rivet nut
Faulty mandrel thread	Exchange threaded mandrel (see paragraph 6.4) Hold rivet nut tightly when threading out

10.2 Set rivet nut is loose

Cause	Solution
Setting stroke „Y“ too short	Adjust to larger stroke (see paragraph 6.2)

10.3 Threaded mandrel is not unthreading

Cause	Solution
Setting stroke „Y“ too long	Reduce stroke (see paragraph 6.2) If necessary, unscrew with hexagon screw driver (see drawing 4)
Threading-on time too short	Increase threading-on period (see paragraph 6.5)

11. Warranty

The applicable terms and conditions of warranty shall apply and can be viewed under following link: www.gesipa.com/agb

12. Conformity declaration

We hereby declare that the design and construction of the tool named below, as well as the version that we have put on the market, complies with applicable fundamental health and safety requirements stipulated in EU directives. Tool modifications made without our authorisation shall render this declaration void. The safety information in the product documentation provided must be observed. This document must be retained.

GBM 95

- DIN EN ISO 12100:2011
- DIN EN ISO 11148-1:2012
- DIN EN 82079-1:2013



ppa. Dr. Richard Gärtner

Authorised documentation representative:

GESIPA Blindniettechnik GmbH
Nordendstraße 13-39
D-64546 Mörfelden-Walldorf

