III. OPERATION GUIDE:

WARNING: WEAR WORK GLOVES (RUBBER COATED PREFERRED) FOR GRIPPING THE ADAPTER

IMPORTANT: Ensure the threads on mandrels are clean and the loaded rivet nut has full thread engagement with threaded mandrel during riveting. It is strongly recommended to clean and lubricate (ex. silicone spray, dry lube) the threads on mandrels before and after use.

CRITICAL: Before using the tool on your intended work piece, it is REQUIRED that you test the tool with a rivet nut on a test piece to determine the adequate torque needed for your rivet nut size, rivet nut material, and sheet metal thickness and material.

- Ensure drill is in "driver" mode and not drill mode. Different drills will require different torque limiting settings for the same material.
- On the test piece, set your drill to a low clutch setting and work up to higher settings until the torque level is enough to fully set the rivet nut but not over set - WARNING: Over setting rivet nuts may permanently damage the mandrel or tool.
- Once the torque level is determined, test again on a new hole at your intended setting to confirm. The knurled part of the rivet nut should look mushroomed and starting to become flat on the other side of the work piece and should not rotate when you install a bolt.

1. Tool Installation:

Install a new mandrel and nosepiece to match your intended rivet nut thread size. Use the included wrench to install the new mandrel into the #2 Plunger Tube. Ensure that the mandrel and other components are tightly fixed in position. After installing the front bushing cover and lock bushing, lightly tighten the new nosepiece onto the end of the tool. Install the hex shank drive end of the tool into your drill and affix tightly into its chuck.

2. Riveting:

2.1 While holding the adapter with your hand **(WEAR GLOVES)**, operate the drill in the REV direction until you hear the adapter start to click. This means it has fully exposed the mandrel.

2.2 Switch the drill to the FWD setting.

2.3 Manually thread the selected rivet nut onto threaded mandrel; or hold the rivet nut in one hand and use another hand to pull the drill trigger slightly to have the nut threaded on by the tool.

2.4 Ensure the rivet nut has adequate thread engaged and that there is no cross threading. Check and confirm the objects to be riveted are SECURE.

2.5 Some small amount of clearance between nose piece and the flange of rivet nut may be beneficial to operation, but keep adequate thread engagement on the nut.

2.6 Refer to Section III. for determining the proper drill torque settings. (REQUIRED).

2.7 Put the rivet nut now threaded onto the tool's mandrel fully into the proper size hole (see Sizing Chart on page 2).

2.8 Align the adapter with the hole angle as best you can. While gripping the adapter firmly with one hand (wear work gloves), operate the drill in the FWD direction until you feel or hear the drill's torque clutch catching. The adapter should not rotate while the drill works. Release your grip on the adapter and reverse the drill out of the rivet nut. Depending on the material, you may need to manually help the adapter thread out of the rivet nut with your off hand.

Tip 1: If setting M10 or 3/8" and especially on stainless, high grip strength is required. Not all rivet nuts are the same, some require more force.

Tip 2: Make a note of the torque setting matching your application for future use.

IV. MAINTENANCE:

1. The nut riveting adapter is lubricated before shipping. Recommended: cleaning the components of plunger tube, and using lubricant grease to re-lubricate its parts on a yearly basis or earlier.
2. Threaded mandrel replacement:
   Life span of threaded mandrel varies with usage frequency and the uses of different rivet nut sizes/types. Recommended: replacing the threaded mandrel with new spare and its nosepiece before worn-out.

I. Product Technical Data:

Dimensions: 8.5" x 5.5" x 2.4"

Weight: 2.5 lbs

Hex Shank Size: 6.35mm (1/4")

Riveting Capability:

Rivet Nut Size		SAE 10-24	SAE 1/4-20	SAE 5/16-18	SAE 3/8-16	M5	M6	M8	M10
Nut Material	Aluminum	✓	✓	✓	✓	✓	✓	✓	✓
	Steel/Copper	✓	✓	✓	✓	✓	✓	✓	✓
	Stainless Steel	✓	✓	✓	✓*	✓	✓	✓	✓*

* Tool is capable but may require very high grip strength

Rivet Type: Rivet Nut

Stroke Limit: Maximum 0.7 inch

Working Torque: Refer to section **III. Operation Guide**

Recommended RPM: Low speed, driver setting (<240 RPM)

Requirements of Driving Tools: *Requirements of cordless driving tool:*

- Adjustable torque setting.
- Chuck capacity of 6.35 mm (1/4") shank.
- Min 12V for aluminum, or M5 and 10-24 steel rivet nuts.
- Min 14.4V for steel rivet nuts in M6, M8, 1/4" & 5/16" or stainless in M5 or 10-24.
- Min Full-size 18V+ for M10 and 3/8" rivet nuts and all other sizes in stainless steel. **WEAR GLOVES**
- Clutch provides a felt and/or audible indication of reaching max setting.

Requirements of elctric or pneumatic driving tool:

- Adjustable torque setting.
- Chuck capacity of 6.35 mm (1/4") shank.
- With maximum torque > 190 in/lbs for aluminum and steel rivet nuts in smaller sizes.
- With maximum torque > 400 in/lbs for stainless steel rivet nuts.

Common Sizes Chart:

Rivet Nut	Rivet Nut Diameter	Drill Hole Size	Grip Range
M5	6.9mm OD	7mm (9/32")	26 – 16ga
M6	8.9mm OD	9mm (3/8")	26 – 13ga
M8	10.9mm OD	11mm (7/16")	26 – 11ga
M10	12.9mm OD	13mm (17/32")	26 – 11ga
10-24	6.9mm OD	7mm (9/32")	26 – 16ga
1/4-20	8.9mm OD	9mm (3/8")	26 – 13ga
5/16-18	10.9mm OD	11mm (7/16")	26 – 11ga
3/18-16	12.9mm OD	13mm (17/36")	26 – 11ga

II. SAFETY GUIDE:

1. Wear adequate protective gear including ANSI approved goggles and **THICK WORK GLOVES (RUBBER COATED)**
2. Only use the nut riveting adapter with driving tool that matches with requirements specified on **Product Technical Data**.
3. Switch off the driving tool before installing or uninstalling the nut riveting adapter.
4. The objects to be riveted **MUST BE SECURELY FIXED BEFORE** riveting in order to avoid possible injury. Unsecured objects may rotate with the driving tool if not secured.
5. The driving tool MUST be stopped if user releases the adapter's body during riveting.
6. During disassembly for mandrel changing or **Maintenance**, take care as there are pre-loaded springs within the tool.