

Preparation

Mandrel Change

Operation

- a** Establish material thickness the rivet nut will be installed in



Confirm the rivet nut grip range is suitable for the material thickness

- c** Prepare the hole to the diameter specified for the rivet nut size that is being installed (hole size is critical)

- d** Prepare a test plate that is the same thickness as the material you are installing the rivet nut in and carry out a test install



1 To install the correct size mandrel and nosepiece in the tool, remove the nosepiece



3 Remove the mandrel by pushing and lifting. Replace with the correct size mandrel

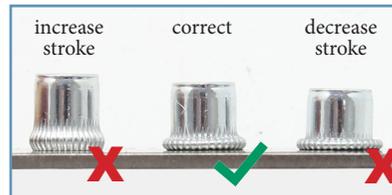


2 Remove the front sleeve by pulling the sleeve from the tool

4 Reverse Step 2 to install the front sleeve, until a positive 'click' is heard

5 Reverse Step 1 to install the correct size nosepiece

Fig. 12



WARNING:
Oversetting the rivet nut **WILL** damage the tool and rivet nut!



6 Adjust the stroke of the mandrel at the head of the tool (up to M5 thread size start at 3mm; M6-M8 thread size start at 4mm; M10-M12 start at 5mm)



7 Wind on the rivet nut with the levers fully extended.



8 Adjust the nosepiece so that the mandrel thread just protrudes through the end of the rivet nut



9 Insert the rivet nut installed on the mandrel in the prepared hole. Bring the levers fully together in one motion



10 You may need to increase the stroke to achieve the correct clamping force. (Refer to Fig. 12)



11 Remove the mandrel for the rivet nut by rotating the mandrel holder knob anti-clockwise

OPERATING INSTRUCTIONS FOR POP PNT410 Rivet Nut Tool

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