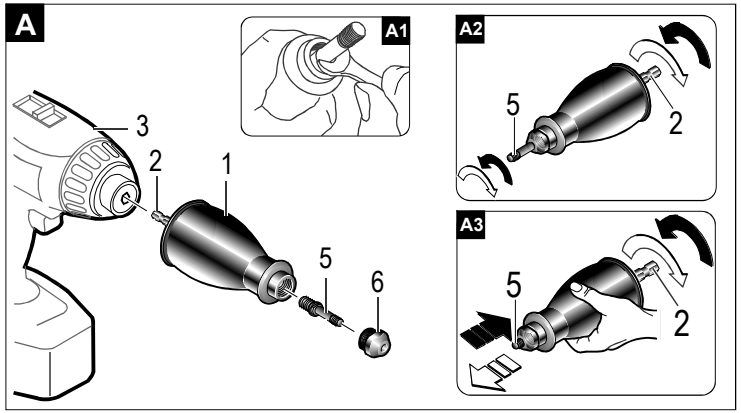

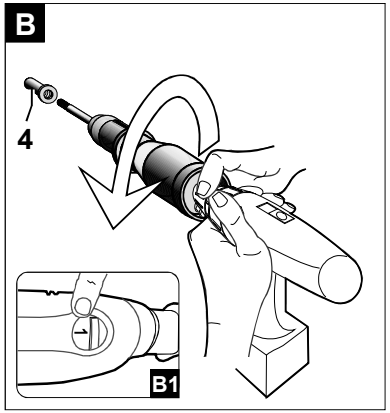

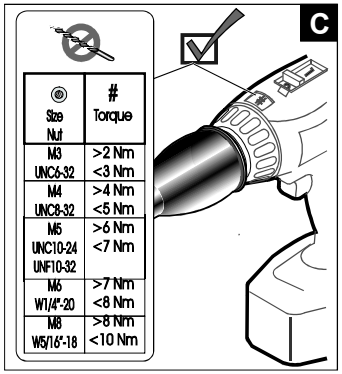

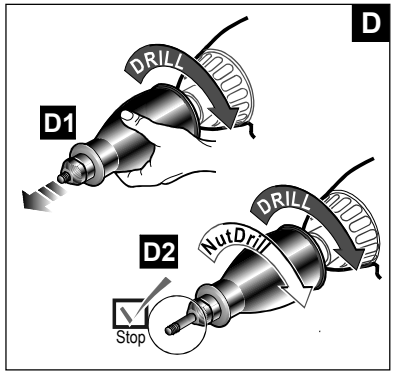

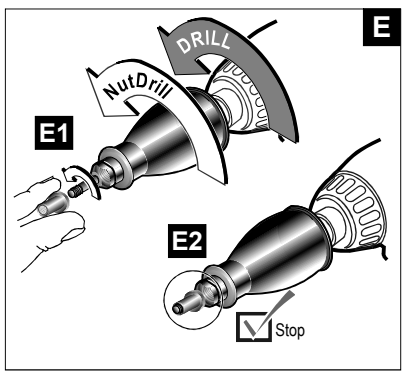

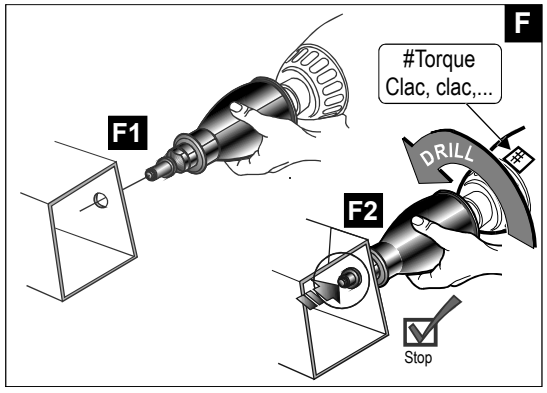

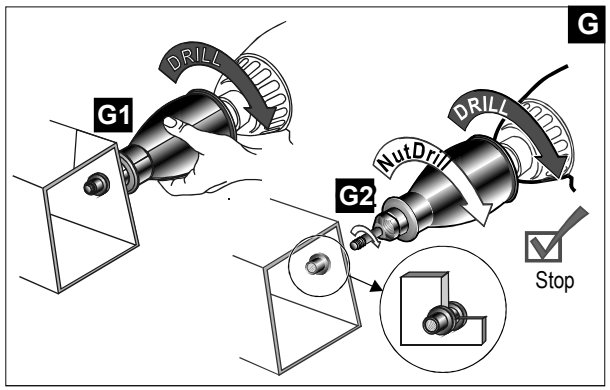

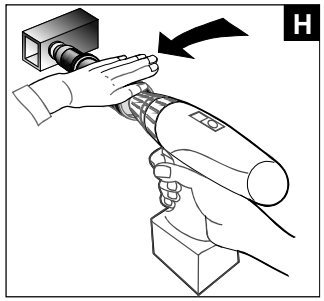

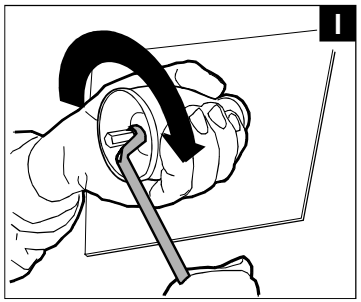

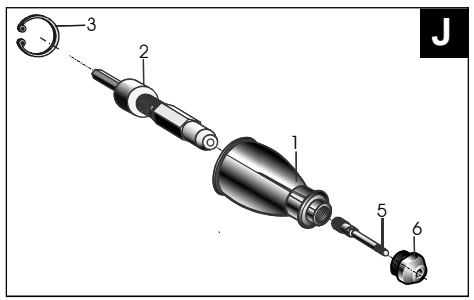

GB NutDrill

FOR YOUR SAFETY

Working safely with this machine is possible only when the operating and safely information are read completely and the instructions contained there in are strictly followed.

·The safety instructions must be observed for the respective driving tool that is used.

·To ensure the secure function of the unit, only the rivet nuts mentioned in the technical data may be used with the specified nosepiece / threaded mandrel for them.

·High forces can occur during the working procedure, use grooves and therefore, hold the NutDrill tool firmly. Do not use bracelets or other objects that can be hooked.

Use only original ANDREA accessories.

TOOL SPECIFICATION.

Stroke (run) 9 mm (3/8")
Maximum indoor torque control allowed; 12 Nm (110Lbf.in)
Weight approx. 360 grs.
Length; 141 mm
Diameter; 60 mm
Drive shank hex 5/18" (8mm)
Guide and mandrels available sizes, (not always included with the unit) with European thread sizes M3, M4, M5, M6 y M8 with thread in American measures UNC6-32, UNC8-32, UNC10-24, UNF10-32, W1/4"-20 y W5/16"-18.

USE AS INTENDED

The device is intended to be as an attachment with cordless drilling machines of 12 V or more, as well as with reversible turn and torque control to set rivet-nuts.

Never apply to NutDrill a Torque higher than 12 Nm. When the rivet-nut has been setting, the resistance is increased immediately and all the power in this case produces an overload and wears the mechanism of the tool.

The user must try previously with its rivet-nuts and its drilling machine the necessary torque, setting in air first with a small torque and increasing it till get what it needs to set the rivet-nut.

For damage caused by usage other than intended, the user is responsible.

OPERATING CONTROLS

Figure A: **Devices elements:**
- 1- NutDrill
- 2- Drive shank
- 3- Drive Machine (drilling machine)
- 4- (figure B) Rivet-nut (nut-insert)
- 5- Mandrel
- 6- Guide Nosepiece.

·Not all the accessories described are included as standard delivery.

Caution. The mandrel 5 and the guide nosepiece are screwed to the left and unscrewed to the right. Mounting the mandrel 5 and the guide nosepiece that is going to be set tighten strongly with a 7mm wrench (Fig. A1)

WORKING PROCEDURE

NutDrill transform the circular movement that comes into the drive shank (figure A2) in four different movements that goes out by the mandrel 5. When the drive shank 2 turns to the right or to the left, the mandrel 5 turns also to the right or to the left. But if you hold NutDrill with your hand to not turn (figure A3) the mandrel 5 come in or go out when the drive shank 2 turns to the right or to the left respectively, like indicate the black or white arrows in the figure A3.

Try the four movement of NutDrill, without rivet-nuts:

Drilling machine turning to the left holding NutDrill with the hand to not turn; *look how the mandrel goes out and how NutDrill start to turns sliding from the hand when it comes to the beginning of the run.*

Drilling machine turning to the right holding NutDrill with the hand to not turn; *look how the mandrel comes in 9 mm (3/8") and how NutDrill start to turns sliding from the hand when it comes to the end of the run.*

Caution, when the mandrel comes to the end or the beginning of the run, NutDrill has to turns necessarily. If then NutDrill is tightened strongly with the hand **NutDrill is blocked.**

Unblocked of the NutDrill. To unblocked the NutDrill, you must turn the drive shank 2 (figure A3) while you are holding strongly the NutDrill with the hand to not turn, to the right or to the left, depending on if we want to come in or go out the mandrel 5 respectively. If the blockade is too strong, hold the NutDrill by both planes 7 with a wrench of 22mm to not turn while with another key of 8 mm in the drive shank 2, fig. I, we unblocks. Be sure to make the strength in the right way in each case following the arrows white or black that indicate in figure A3.

PUT IN SERVICE

Figure B. **Mounting of NutDrill.** Insert the drive shank 2 of the NutDrill into the chuck of the drilling machine 3 and tighten strongly. Select the minimum speed in the drilling machine (figure B1)

Figure C. **Selection of the Torque.** Select the torque depending on the size of the rivet- nut and the material of it. Figure C indicates the minimum and maximum torque necessarily (in Newton per meter) to set the steel rivet-nut of the sizes are indicated. Generally the number # of the drilling machine does not correspond with the Torque in Nm. The user must try previously with its rivet-nuts and its drilling machine the necessary torque, setting in air first with a small torque and increasing the torque till get what it needs to set the rivet-nut.

Figure D. **Initial preparation.** Holding NutDrill, only lightly with the hand to not turn (figure D1), avoiding the blockade, make the drilling machine turns to the left until the mandrel goes out completely and the NutDrill start to turns (figure D2) sliding in the hand. Get free NutDrill and stop the drilling machine.

Figure E. **Screwing.** Make the drilling machine turns to the right and get free the NutDrill to turns also while the rivet-nut is been screwing completely the rivet-nut (Figure E1). Stop the drilling machine (Figure E2) while the rivet-nut is screwed completely till makes stop in the guide nosepiece 6 and the mandrel 5 is showed through the rivet-nut.

Figure F. **Riveting.** Insert the rivet-nut in the hole and hold NutDrill strongly with the hand (Figure F1). In this moment if the rivet-nut is very hard the reaction in the hand is higher, thus why NutDrill has to be hold strongly with the hand while it is turning the drilling machine to the right while set the rivet-nut, till the torque control of the drilling machine act producing a characteristic sound, clack, clack, (Figure F2). Stop the drilling machine.

Figure G. **Unscrewing.** Change the way of turn of the drilling machine and turns it to the left while the NutDrill is holding with the hand strongly just a second to slacken the strength in the rivet-nut, and then go on holding lightly with the hand till the mandrel goes out completely and the NutDrill start to slide lightly in the hand, figure G1. Go on with the turn of the drilling machine to the left leaving the NutDrill to turn freedom; while it is completely unscrewed from the rivet-nut, figure G2. So the rivet-nut was riveted and NutDrill with the mandrel out ready to set the next rivet-nut. Repeat the cycle from Figure E for the next rivet-nut. If in the first experience NutDrill is blocked, try the four movement described in the point: PUT IN SERVICE / Unblock of NutDrill.

Figure H. **Manual unscrews.** If it is necessary, with the drilling machine stopped (for instance battery finish), it is possible to unscrew manually.

Figure I. **Manual work.** Also it is possible to use NutDrill manually, without drilling machine, using a wrench of 8 mm in the drive shank while NutDrill is holding with the hand to not turn.

MAINTENANCE AND CLEANING

Lubricate the thread of the mandrel to clean the rest of material that can be added.
If the machine should happen to fail despite the care taken in manufacture and testing, repair should be carried out by an authorized customer services ANDREA agent. It is necessarily to indicate the number of the figure J to require spare parts.

BREAKDOWN, CAUSES, AND SOLUTIONS

Broken mandrels or the rivet-nut. Torque too high. *Change the mandrel and reduce the torque control.*

It is not possible to hold NutDrill with the hand. Wear produced probably because have been used torques higher than 12 Nm. *Change the mechanism 2 figures J.*

GUARANTEE

NutDrill has a guarantee of 6 months against material defects or manufactures faults, from the purchase order (enclosing the invoice or the delivery note). In case of defect, it will be change or repair the device if it is convenient.

It isn't covert by the guarantee the damage produced by the natural wear, overload or bad use. The claim can only be proceed if the damage device is sent without dismounting to an Andrea warehouse or Technical service Authorized.

There is also a RiveDrill to set blind rivets. Please do not doubt in ask for further information to your supplier.

DECLARATION OF CONFORMITY

Declaration of the manufacturer according to 98/37/EC.
This product has been designed exclusively for being built into another machine, or mounted onto another machine or other machines. It is forbidden to put this product into operation before the conformity of the final product with the provisions of the regulations 98/37/EC has been fulfilled.

There is conformity for instance, if NutDrill is applied with an electric or Pneumatic ANDREA tool according with the manual user instructions or the draws in this instruction.

CE09
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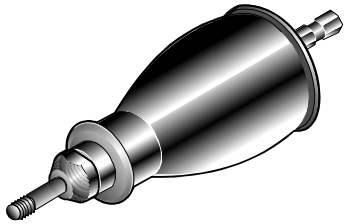
www.rivedrill.com

ANDREA

GB

Operating Instructions
Instrucciones de uso
Bedienungsanleitung
Notice d'utilisation
Istruzioni d'uso

NutDrill



Rivet Nutter Attachment
Dispositivo para remachar tuercas
Einnietmuttervorsatz-Gerät
Adaptateur riveteuse pour rivets
Testa rivettatrice