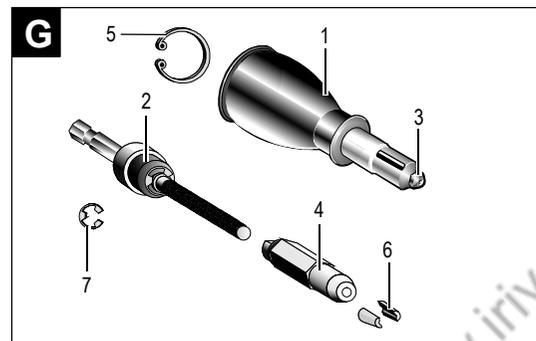
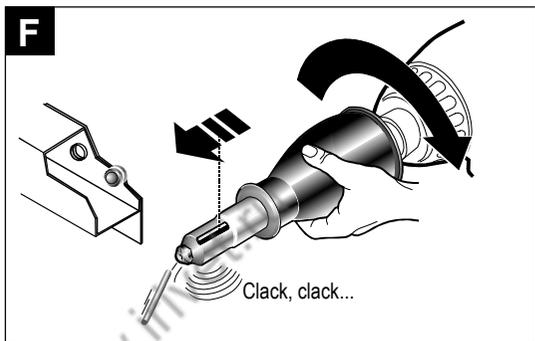
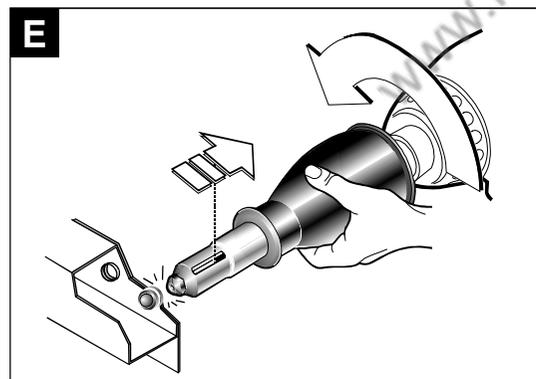
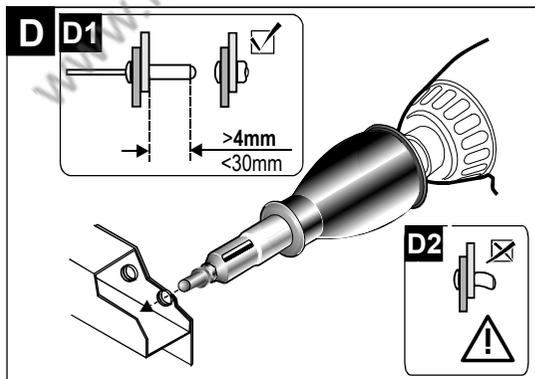


C1

Blind Rivet Diameter (D mm)	3,2	4,0	4,8	6,4	7,5
Blind Rivet Diameter (D inches)	1/8"	5/32"	3/16"	1/4"	5/16"
Material : Aluminium	Yes	Yes	Yes	Yes	Yes
Material : Steel	Yes	Yes	Yes	Yes	
Material : Stainless steel	Yes	Yes	Yes	Yes	

C2

Ø D	Ø M	L
3,2mm	>1,8mm	>26mm
1/8"	<2,4mm	<31mm
4,0mm	>2,0mm	>26mm
5/32"	<2,2mm	<33mm
4,8mm	>2,7mm	>29mm
3/16"	<2,8mm	<34mm
6,4mm	>3,7mm	>30mm
1/4"	<3,9mm	<34mm
7,5mm	>4,2mm	>30mm
5/16"	<4,4mm	<34mm



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FOR YOUR SAFETY.

Working safely with this machines is possible only when the operating and safety 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.
- ☐ In order to ensure that the machine functions safely, only use the blind rivets listed in the specifications together with the correctly matching nosepiece (nozzle) and with size are showed in figure C.
- ☐ High forces can occur during the working procedures, use grooves in the hand that the RiveDrill is hold, and therefore hold RiveDrill tool firmly. Do not use bracelets or other object that can be hooked.
- ☐ Use only original ANDREA parts and accessories

TOOL SPECIFICATIONS.

Stroke (run) (without rivetting), 44mm (7/4").
 Maximum Stroke (run) (rivetting), 30mm (5/4").
 Maximum torque of entrance allowed , 15 Nm (135 Lbf.in).
 Approx. Weight 600 g.
 Approx. Longitude 180mm (7")
 Diameter, 60 mm (2 1/2")
 Hex drive shank 8 mm (5/16") between faces.
 Included nosepiece (nozzles); 5 units
 Capacity to rivet: The safety sizes for blind rivets must be observed in the graphic figure C1, about diameter and material of blind rivets aluminum, steel or stainless steel.

USEAS INTENDED

The device has been designed to be attached to a reversible drilling machine, cordless drill (12 volt. Or more), to set blind rivets.

- ☞ The rivet is fixed in a single action.
- ☞ The mandrel of the rivet should be inserted completely in the RiveDrill.
- ☞ Before insert the blind rivet be sure to expel the mandrel of the rivet before.
- ☞ For damage caused by usage other than intended, the user is responsible.

OPERATING CONTROLS

Figure A. The accessories described in the book instructions are not always included in the given unit. There are some of them optional.

- 1 RiveDrill.
- 2 Drive Shank
- 3 Nosepiece (nozzle)

- 4 Hole control
- 5 Drilling machine
- 7 (Figure C) Blind rivets

INITIAL OPERATION.

Figure A. Mounting of RiveDrill. Insert the drive shank 2 into the chuck of the drill 5 and tighten it strongly, figure A1.

Figure B. Working procedure. RiveDrill is hold with the hand to not turn, figure B, and transform the rotatory movement that comes into by the drive shank 2, in a lineal movement that open or close the hole control 4, figure B. When the drive shank 2, turns to the right or to the left the inside mechanism of RiveDrill advances towards the drilling machine setting the rivet or expelling the mandrel of the rivet respectively. The black arrows open the hole control 4 and the white arrows close it, figure B. In the beginning and the end of the interior run of RiveDrill, 44mm, it sounds "clack, clack..."

Try the movement without rivets:

☞ Drilling machine to the left, figure B, looking at how the hole is closed 4 and it sounds clack, clack.
 ☞ Drilling machine to the right, figure B, looking at how the hole 4 is opened. When the inside mechanism of RiveDrill finish the run of 44 mm (7/4") it sounds clack, clack.

Initial position to set the rivet. The hole control 4 must be closed as in figure B. If the hole 4 is open, close it, turning the drilling machine to the left till it sounds clack, clack.

USE

Figure C. Insert the blind rivet. Insert the blind rivet 7, figure C, completely, with the drilling machine stopped.
Caution: Do not use blind rivets with different sizes and materials that are indicated in figure C. Select the nosepiece adequate for the diameter of the rivet which you are going to set. The use of an inadequate nosepiece can produce a deficient work. The measures of the rivets must be between the maximum and minimum indicated on the chart C2.

Figure D. Sizes of the blind rivets. The longitude of the rivetting must be agreed with the minimum of 4 mm (5/32") and maximum than 30 mm (5/4"), figure D1 . If the longitude rivetting is more than 30 mm (5/4"), figure D2, the blind rivet is default and the RiveDrill can be damage.

Figure E. Rivetting. Prepare the drilling machine to turn to the right. Insert the rivet completely, in the hole of the units to be assembled. Turns the drilling machine to the right while RiveDrill is hold with the hand, strongly to

not turn while it is rivetting. Stopped the drilling machine when the mandrel is broken. **Caution**, the reaction of the hand which is hold the RiveDrill is increased with the hardness of the material and the size of the blind rivet.

Figure F. Expel the mandrel of the rivet . Turning to the left the drilling machine, incline the RiveDrill to left the mandrel of the rivet falls while the RiveDrill is hold with the hand to not turn. Keep the drill turning to the left till it sounds; clack, clack, that indicate the initial position with the hole 4 close to set the next rivet. For the following blind rivet repeat the process from figure D. Before inserting a new blind rivet make sure that the previous mandrel has been expelled.

MAINTENANCE AND CLEANING .

The jaws must be cleaned and lubricated from time to time and remove the dusty material that could be deposit. If the machine should happen to fail despite an authorized customer services agent for MAQUINAS ANDREA power tools should carry out the care taken in manufacture and testing, repair. For spare parts requirement you may use the piece number of the Figure G.

BREAKDOWN, CAUSES AND SOLUTIONS

■ **If the rivet does not enter.** Possible nosepiece 3 figure G, incorrect or damage. *Change it .* Possible mandrel of the rivet does not expelled or jammed. *Dismounting and take away the mandrel .* Possible that the jaws 6, figure G, damages . *Changed the jaws .*

■ **The blind rivet is in but it doesn't work.** Possible hole 4 open . *Close the hole 4.* Possible mandrel of the rivet is too short. *Check the measures of the blind rivet as chart C2.* Possible that the jaws are wearing or break. *Clean it or change it.*

■ **RiveDrill set the rivet but it doesn't expel the mandrel.** Possible nosepiece 3 Figure G, inadequate or damage. *Change it .* Possible that the jaws, are damage. *Change it .* Possible that the mandrel of the rivet is too thick. *Check the measures as chart C2.*

SUITECASE.(Optional)

An optional suitcase, sizes 400mm (16") x 350mm (14") x 100 mm (4"), can keep the RiveDrill, and accessories together with the drilling machine, charger of batteries, etc. Ask to your supplier about NutDril information.

GUARANTEE

RiveDrill has a guarantee of 2 years against materials and workmanship defects from the date of purchase (verified by invoice or delivery document). Damage that has happen by normal wear, overloading or improper handling is excluded from the guarantee. Claims can only be accepted if the devices is sent without having been disassembled, to MAQUINAS ANDREA, or a workshop authorized.

DECLARATION OF CONFORMITY

Declaration of the manufacture according to: 98/37/CE. This product has been designed exclusively for being built into another machine, or mounted onto another machine. It is forbidden to put this product into operation before the conformity of the final product with the provisions of the regulation 98/37/CE has been fulfilled. The conformity is fulfilled, for example, if is this accessory driven by a MAQUINAS ANDREA power tool according to the operating instructions or the pictogram instructions on the packing.

CE09

Máquinas Andrea, S.A.

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ANDREA

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

RiveDrill HP

High Power



Blind Riveting Attachment
Dispositivo para remachar
Blindniet-Vorsatzgerät
Adaptateur riveteuse pour rivets aveugles
Adattatore per rivetti ciechi