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RIVET**
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VVG Befestigungstechnik

Ein Unternehmen der  HONSEL-Gruppe



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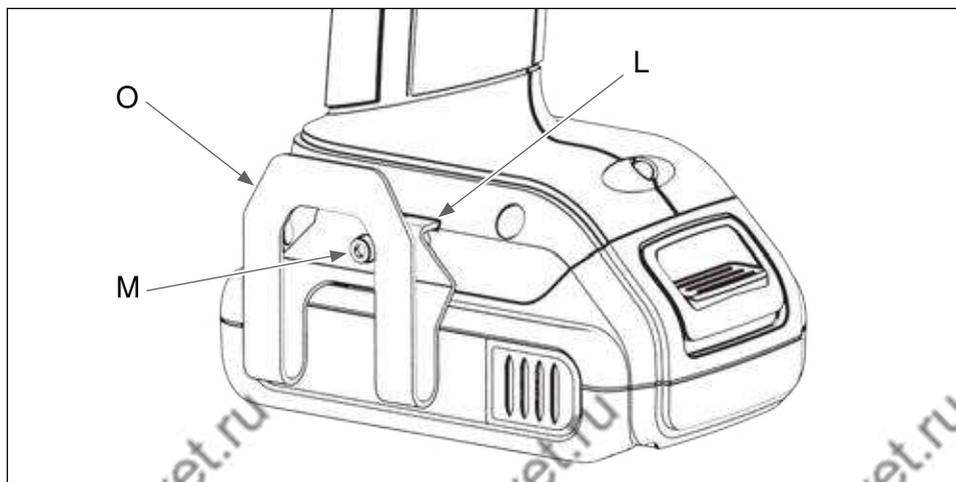
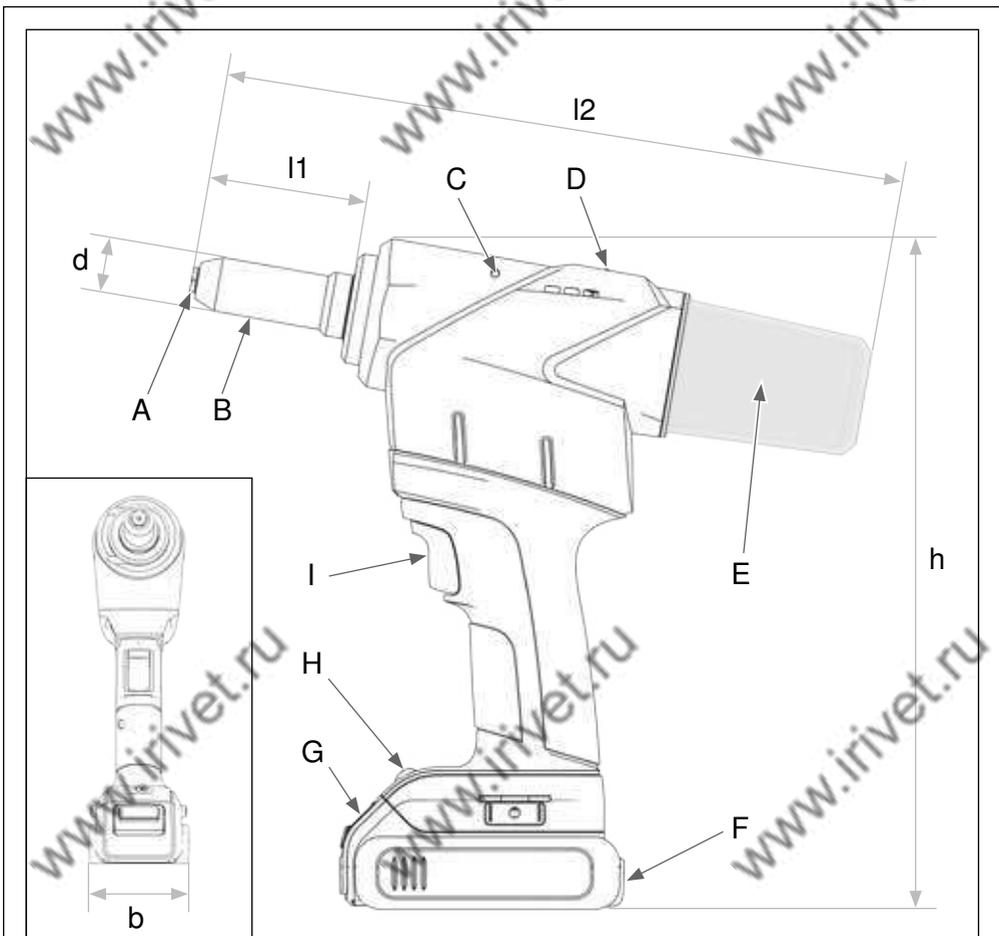
Rivdom

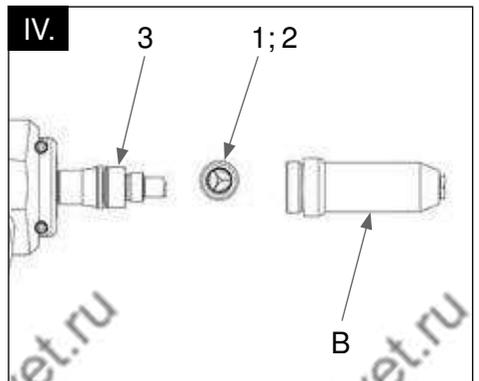
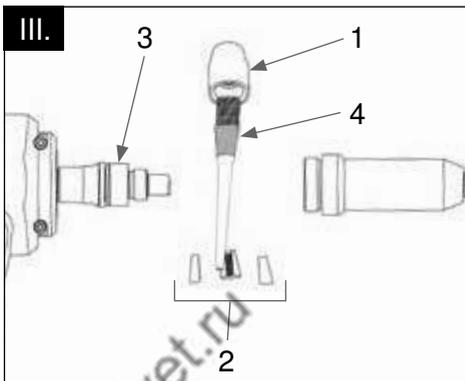
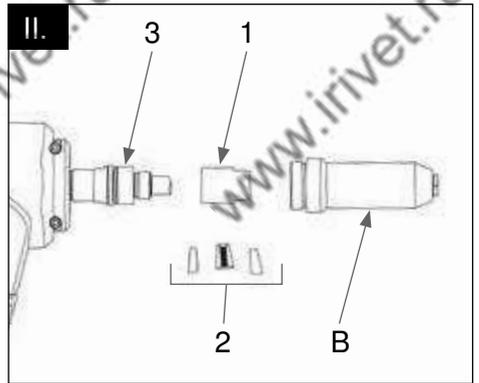
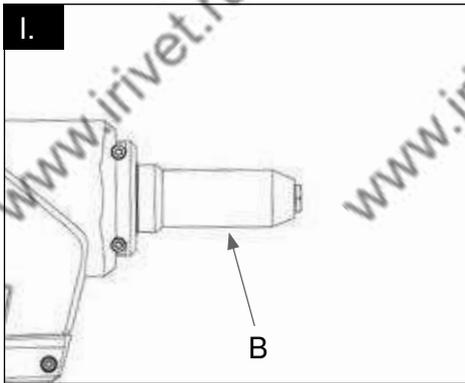
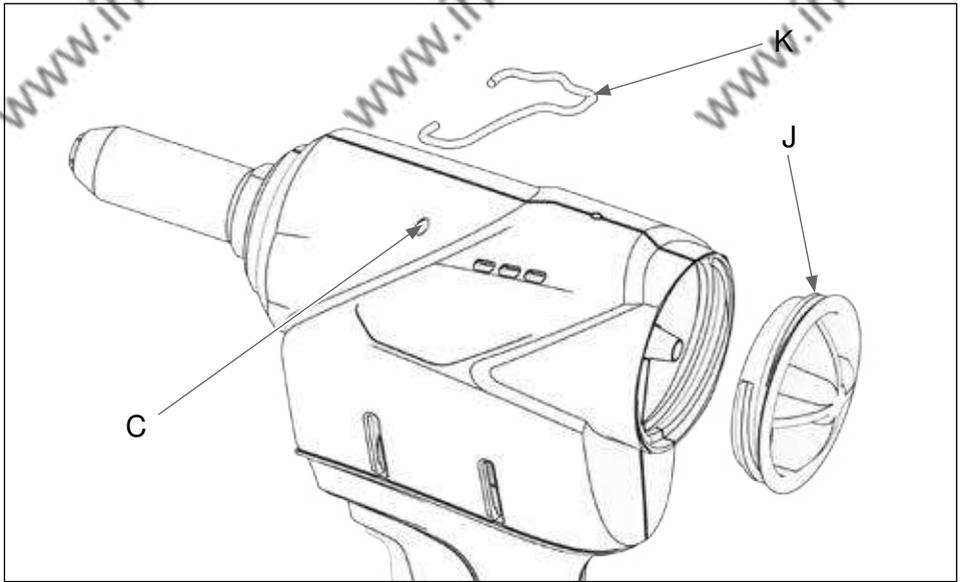
CORDLESS RIVETING TOOLS

Rivdom ONE 16V

Rivdom TWO 20V

Rivdom TWO 2.8 20V





English

SCOPE OF DELIVERY

1. Riveter
2. Nose piece box with nose pieces
3. Combination wrench for changing the nose pieces
4. Collecting container
5. Cover cap
6. Hanging clip
7. Belt clip
8. Battery with state-of-charge indicator (optionally with two batteries)
9. Universal quick charger 220 V ~ 12/16/20 V
10. Connecting cable with IEC power connector
11. Operating instructions
12. L-Boxx (optionally in cardboard package) with inlay

SAFETY PRECAUTIONS

EXPLANATION OF THE SYMBOLS / PICTOGRAMS IN THE SAFETY PRECAUTIONS

	This symbol draws attention to the fact that hazards exist for the life and health of persons.
	Caution! Important safety precaution or directive that must be strictly observed in order to avoid the risk of personal injury or machine damage!
	Wear protective goggles!
	Before commissioning, read and observe the operating instructions and safety precautions!
	Remove the main plug
	General points to be observed

GENERAL SAFETY PRECAUTIONS



Read all the safety precautions and instructions. Store all safety precautions and instructions in a safe place for future reference.



Failure to observe safety precautions and instructions can result in electric shock, fire and/or serious injuries.

SAFETY AT THE PLACE OF WORK



Keep your place of work clean and well illuminated. Untidiness or inadequately illuminated places of work can result in accidents.

Do not work with the riveter in potentially explosive atmospheres where they may be inflammable liquids, gases or dusts. Riveters generate sparks that could ignite the dusts or vapours.

Keep children and other persons away when working with the riveter. If distracted, you may lose control over the riveter.

ELECTRICAL SAFETY



The plug of the fast charger must fit properly into the plug socket. The plug must not be modified in any way. Do not use adapter plugs in conjunction with earthed fast chargers. Non-modified plugs and matching plug sockets reduce the risk of an electric shock.

Avoid physical contact with earthed surfaces such as those of pipes, heaters, cookers and refrigerators. There is an increased risk of electric shock if your body is earthed.

Keep riveters away from water or rain. The ingress of water into a riveter increases the risk of an electric shock.

Do not misuse the cable, e.g. for carrying or hanging up the fast charger or for pulling the plug out of the plug socket. Keep the cable away from heat, oil, sharp edges or moving equipment parts. Damaged or twisted cables increase the risk of an electric shock.

When using a riveter outdoors, use for the fast charger only extension lead that are also suitable for outdoor use. The use of an extension lead that

is suitable for outdoor use reduces the risk of an electric shock.
If the use of the riveter in a damp environment is unavoidable, use for the fast charger a residual current circuit breaker. Use of a residual current circuit breaker reduces the risk of an electric shock.

PERSONAL SAFETY



Be careful, pay attention to what you are doing and work sensibly when using a riveter.

Do not use a riveter when you are tired or under the influence of drugs, alcohol or medication. One moment of inattention when working with the riveter can result in serious injuries.



Wear personal protective equipment and use protective goggles at all times. The wearing of personal protective equipment such as a dust mask, non-slip safety shoes, a helmet or ear protectors, depending on the type and application of the riveter, reduces the risk of injuries.

Avoid inadvertent starting of the riveter. Ensure that the riveter is switched off before attaching the battery (F), picking it up or carrying it. Having your finger on the trigger when carrying the riveter can lead to accidents.

Remove the setting tools or wrenches before switching on the riveter. A tool or wrench connected to a rotating part of the riveter can result in injuries.

Avoid abnormal body postures.

Ensure a secure footing and maintain your balance at all times. This will enable you to control the riveter in unexpected situations.

Wear suitable clothing. Do not wear loose clothing or jewellery. Keep hair, clothing and gloves away from moving parts. Loose clothing, jewellery or long hair can become entangled in moving parts.



If the mandrel collecting containers can be fitted, ensure that they are properly connected and used correctly. By-passing of the safety switch is prohibited.

DIMENSIONS AND DESCRIPTION OF THE TOOLS

- A Nose piece
- B Front sleeve
- C Hole for hanger clip
- D Fault indicator (red/yellow LED)
- E Mandrel collecting container
- F Battery with charging status indication
- G Battery lock/release (latch)
- H Riveting point light (white LED)
- I Trigger

	Rivdom ONE 16 V	Rivdom TWO 20 V	Rivdom TWO 2.8 20 V
d	23 mm	23 mm	23 mm
l1	66 mm	79 mm	79 mm
l2	281 mm	310 mm	310 mm
h	275 mm	283 mm	283 mm
b	76 mm	76 mm	76 mm

*Rivdom TWO 2.8: Front sleeve (B) may differ from the standard, depending on the configuration!

TECHNICAL DATA

	Rivdom ONE 16 V	Rivdom TWO 20 V	Rivdom TWO 2.8 20 V
Nom. blind rivet working range [Ø mm]	2.4 - 5.0	4.8 - 6.4	6.4 - 9.8
Max. stud diameter [mm]	3.4	4.8	4.0 to 6.15
Riveter weight incl. battery [kg]	1.8	2.0	2.1
Total stroke [mm]	21	30	
Drive (DC / BLDC)	DC	BLDC	BLDC
Tensile force [N]	10,000	20,000	24,000
Sound emissions LpA / K // LWA / K [dB]	<65 / 3 // <76 / 3		
Vibrations ah / K [m/s ²]	< 2.5 / 1.5		
Service interval [number of rivets]	100,000	300,000	
Battery [V]	16	20	20
Battery [Ah]	2.0		
Battery cells [number]	4	5	
Battery weight [kg]	0.32	0.37	
Battery working temperature [°C]	-5 to 45		
Charger input voltage [V AC / Hz]	100 to 240 / 50 to 60		
Charger output voltage [V DC]	7.0 to 21.0		
Charger output current [Ah]	4		
Charger working temperature [°C]	0 to 40		
Charger charging time to 90 % / 100 % [min]	22 / 30		
Charger weight without cable [kg]	0.55		

OPERATION AND HANDLING OF THE RIVETER



Do not overload the tool. Use the proper riveter for your work. You will work better and safer in the specified performance range by using the appropriate riveter.

Do not use a riveter whose switch is defective. A riveter that can no longer be switched on or off is dangerous and must be repaired.



Remove the battery (F) before making adjustments to the tool, changing accessories or putting the tool away. This precautionary measure prevents any unintentional starting of the riveter.

Keep the riveter out of the reach of children when

not in use. Do not allow persons to use the tool who are not familiar with it or who have not read these instructions. Riveters are dangerous if they are used by inexperienced persons.

Maintain riveters with care. Check that moving parts function correctly and do not jam, and that parts are not broken or damaged in such a way that the function of the riveter is impaired.

Have damaged parts repaired before using the tool. Many accidents are caused by poorly serviced riveters.

Use riveter, accessories, attachments, etc. only as described in these instructions. Give consideration to the working conditions and the work to be carried out. The use of riveters for other than the intended applications can lead to dangerous situations.

OPERATION AND HANDLING OF THE BATTERY



Charge the batteries (F) only in chargers recommended by the manufacturer.

There is a risk of fire if a charger designed for a given type of battery is used with other batteries.

Use only the specified batteries in the riveters. The use of other batteries can lead to injuries and the risk of fire.

Keep battery (F) not in use away from paper clips, coins, keys, nails, screws or other small metal objects that could cause bridging of the contacts. A short circuit between the battery contact can cause burns or a fire.

If improperly used or damaged, liquid can escape from the battery (F).

Avoid contact with this liquid. In the event of accidental contact, wash off with water. If the liquid gets into the eyes, obtain additional medical assistance. Escaping battery liquid can cause skin irritation or burns.

SERVICE



Have your riveter repaired only by qualified specialist personnel and only with original spare parts. This will ensure that the safety of the riveter is maintained.

COMMISSIONING

CHARGING THE BATTERY

Note: The battery (F) is partially charged on delivery. In order to ensure the full performance of the battery (F), charge the battery (F) completely in the charger before the first use. Observe the notes on the state of charge on the charger. The Li-Ion battery (F) can be recharged at any time without shortening its service life. Interruption of the charging cycle does not damage the battery (F). The charger is equipped with a temperature monitoring device that permits charging only in the temperature range between 0 °C and 40 °C.

PREPARING THE RIVETER – RIVDOM ONE 16 V

Fit the mandrel collecting container (E) by turning to the right. Push the battery (F) into the foot of the riveter from the front and ensure that the battery (F) is properly engaged. Press the trigger (I) and hold it depressed. Fit the appropriate nose piece (A) for the rivet you wish to set using the combination wrench supplied. After changing the nose piece, release the trigger.

PREPARING THE RIVETER – RIVDOM TWO 20 V AND TWO 2.8 20 V

Fit the stud collector by turning to the right. Push the battery (F) into the foot of the riveter from the front and ensure that the battery (F) is properly engaged. Press the trigger for 5 seconds (until the white LED on the tool starts to flash 1/sec) and release again. The riveter remains in the rear-most position. Fit the appropriate mouthpiece (A) for the rivet you wish to set using the open-jaw wrench supplied. After changing the mouthpiece, press the trigger again briefly and the tool moves to its starting position again.

WORKING WITH THE RIVETER

RIVETING

Insert the mandrel of the rivet into the nose piece (A). Now insert the rivet into the parts to be riveted. For a good riveting result, ensure that the parts and the head of the rivet are resting on one another without a gap. Press the trigger until the mandrel is sheared. Hold the riveter so that the mandrel collecting container is facing downwards to ensure that the sheared mandrel drops into the mandrel collecting container.

When working with cover cap, hold the riveter with the nose piece (A) facing downwards after each set rivet to ensure that the sheared mandrel drops out of the riveter to the front. Do not use fixed or retainer nose pieces together with the cover cap. This would result in damage to the riveter!

EXTENDED TRIGGER FUNCTIONS (RIVDOM TWO 20 V AND TWO 2.8 20 V ONLY)

Rivdom TWO and TWO 2.8 have two further functions that are controlled with the trigger.

1. Service position: Press the trigger for 5 seconds (until the white LED on the tool

starts to flash 1/sec) and release again. The riveter remains in the rearmost position. The mouthpiece (A) can now be easily changed or the clamping mechanism serviced. Press the trigger briefly and the tool moves to its starting position again.

2. Auto and Manual mode: In Manual mode, hold the trigger depressed during setting of the rivet until the mandrel is sheared off. In Auto mode you only have to press the trigger briefly and the riveter controls the riveting process automatically. To change from one mode to the other, hold the trigger pressed for 10 seconds (until the white LED on the tools starts to flash 2/sec) and release again. Press the trigger briefly and the tool moves to its starting position again.

MALFUNCTION

If rivets are used beyond the specified performance capability of the riveter, the riveter stops and the red LED (D) comes on. Wait until the LED (D) goes out and press the trigger briefly again. The tool then moves to its starting position again. When the battery (F) is discharged, the riveter is protected by a protection circuit. The riveter completes the cycle and then stops. The LED (D) lights up yellow. Replace the discharged battery with a charged battery (F). The yellow LED (D) goes out and you can continue to work.

STUD HOLDER

All Rivdom riveters are equipped with a safety switch, the "stud holder", and thus conform also to the Machinery Directive. This prevents the riveter being used without stud collector (E). Never operate the riveter without stud collector (E) or stud securing cap (J). Never bypass the safety switch. If you have to work in confined spaces, the stud securing cap (J) can be fitted instead of the stud collector (E). When working with stud securing cap (J), hold the riveter with the mouthpiece (A) facing downwards after each set rivet to ensure that the sheared mandrel drops out of the riveter to the front. Do not use fixed or retainer mouthpieces together with the stud securing cap (J). This would result in damage to the riveter!

HANGER CLIP

If you wish to use the riveter on a balancer, you can attach the hanger clip supplied (K) to the two bores (C) provided. Take care not to stretch the hanger clip (K) too far apart so that it does not lose

its tension. Check that the hanger clip (K) is fitted securely before using the riveter.

BELT CLIP

Attach the belt clip (O) to the foot of the riveter using the screw (M). A corresponding thread and two slots (L) are recessed in the foot of the housing on both sides of the riveter. Check at regular intervals that the clip (O) is still securely attached, otherwise retighten the screw (M).

MAINTENANCE AND SERVICE

SERVICING AND CHANGING THE CLAMPING JAWS

Depending on the mandrel material, shear force and surface finish, the clamping jaws have to be cleaned and replaced at regular intervals.

- I Loosen and remove front sleeve (B) using a SW 27 combination wrench.
- II Loosen and remove clamping sleeve (1) from adapter (3) using two SW 17 combination wrenches and remove the 3-piece clamping jaws (2) from clamping sleeve (1). Clean clamping jaws (2) and inspect for wear. Replace clamping jaws (2), if necessary.
- III Clean the inside and outside of clamping sleeve (1). Grease the inside of clamping sleeve (1) lightly with graphite grease using a brush (4).
- IV Place clamping jaws (2) into clamping sleeve (1).
Install clamping sleeve (1) with clamping jaws (2) on adapter (3) again and finally fit front sleeve (B).

Important: Tighten the clamping sleeve using two SW 17 combination wrenches to ~22 Nm, otherwise the gearing may be destroyed!

RIVETER SERVICE

In order to ensure proper and safe operation of the riveter, it should be sent to a service centre either directly or via your dealer.

What?	Rivdom ONE 16 V	Rivdom TWO 20 V	Rivdom TWO 2.8 20 V	Who?
Visual inspection of the riveter	Daily			Operator
Battery charge state	Daily			Operator
Cleaning and greasing the clamping mechanism	Between 1,000 and 10,000, depending on the rivet type			Operator
Changing the clamping jaws	When the rivet can no longer be set in one stroke			Operator
Changing the mouth-piece	Every 25,000 to 50,000 rivets			Operator
Inspection*	100,000 or once a year	300,000 or once a year	300,000 or once a year	VVG Service

* The inspection includes the examination, maintenance and possibly repair or replacement of all riveter components, such as gearing, motor and electronics

UNIVERSAL FAST CHARGER

Connect the charger to a plug socket using the cable supplied. Push the battery (F) carefully and without force into the holder. Remove the battery (F) in the same way. The universal fast charger charges the battery (F) in 30 minutes; the battery is 90 % charged after approx. 22 minutes. Observe the corresponding indicators on your charger.

The cells used for the Li ion batteries (F) of the Rivdom riveters are high quality and state-of-the-art. The optimum charging and discharging temperature for Li-Ion cells is 25 °C. No complete charging or discharging capacity can be reached above and below 25 °C.

Use only the connecting cable supplied (with IEC power connector). Different national versions are available.

Charge only Rivdom PLUS batteries (F).

Charge only in a temperature range between 0 and 40 °C.

BATTERY

The battery (F) has a latch (G) on the front side. To insert or remove the battery, press the latch downwards and push the battery (F) into the riveter foot or pull it out.

Use the battery (F) in the riveter only in the specified temperature range between -5 and 45 °C. Charge the battery (F) only in a temperature range between 0 and 40 °C.

Use only the approved charger.

Never short-circuit the battery (F).

If the battery (F) shows signs of visible damage, do not use it any longer.

Keep the battery (F) away from moisture and liquids.

Dispose of the battery (F) in the proper manner.

BATTERY STORAGE

Protect the battery (F) from moisture and liquids. Store the battery (F) only in the optimum temperature range between -30 °C and 25 °C. The batteries (F) can be stored as follows without recharging: Storage period between -30 ~ 25°C – 1.5 years
Storage period between -30 ~ 45 °C – 3 months
Storage period between -30 ~ 60 °C – 1 month
Do not leave the battery (F) in the car, e.g. in the summer.

A significantly shorter operating time after recharging indicates that the battery (F) is worn out and has to be replaced.

Observe the instructions on disposal.

BATTERY DISPOSAL

Li ion: Do not throw the battery (F) into the domestic waste, fire or water. Batteries/rechargeable batteries (F) are collected and recycled or disposed of in an eco-friendly manner.

For EU countries only:

In accordance with Directive 91/157/EEC, defective or old batteries (F) must be recycled.

Batteries (F) that can no longer be used can be returned to your dealer or directly to VVG.

DISPOSAL OF RIVETER AND FAST CHARGER

Riveters, chargers, accessories and packagings should be recycled in an eco-friendly manner.

For EU countries only:

Do not throw riveters into the domestic waste!

In accordance with European Directive 2002/96/EC on Waste Electrical and Electronic Equipment and its implementation in national law, riveters must be collected separately and recycled in an eco-friendly manner at the end of their useful life.