



MODEL:

1450

PRODUCT TYPE:

13" PLUSNUT AND EXTRA-LONG RIVET NUT SETTER KIT METRIC & SAENT



WARNING



Study, understand and follow all instructions provided with this product. Read these instructions carefully before installing, operating, servicing or repairing this tool. Keep these instructions in a safe accessible place.

INTENDED USE OF THE TOOL

The tool is designed to set bulb style PlusNut, extra long rivet nut and standard rivet nut hardware. Do not use this tool outside of the designed intent. Never modify the tool for any other purpose or use.



WARNING



Caution: To help prevent personal injury

- Use of this product can expose you to chemicals including ethylene glycol, gasoline vapors and engine exhaust, which are known to the State of California to cause cancer, birth defects, or reproductive harm. Always wear ANSI approved safety equipment, safety glasses and clothing when using this product. Study, understand, and follow all instructions provided with this product. Failure to read and follow all warnings and operating instructions may result in damages and serious injury or death.
- Always wear ANSI approved goggles when using this product. (Users and Bystanders).
- Never use this tool for any application other than for which it was designed.
- Only use accessories designed for this tool.
- Never alter or modify this tool in any way.
- Improper operation and/or maintenance of the tool, modification of the tool, or use of the tool with accessories not designed for it could result in serious injury or death.
- Always select the correct accessories of the correct size and design for the job that you are attempting to perform.
- Always work in a clean, safe, well-lit, organized and adequately equipped area.
- Do not begin repairs without assurance that vehicle is in secure position, and will not move during repair.

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MADE IN CHINA



Astro Pneumatic Tool Company

Unpacking

When unpacking, check the parts diagram and part number listing on page 4 to make sure all parts are included. If any parts are missing or damaged, please call your distributor.

PRODUCT INFORMATION:

- For setting bulbed PlusNut's, longer than standard rivet nuts and even standard rivet nuts
- Includes 9 SAE and Metric sizes: 10-32, 10-24, 1/4-20, 5/16-18, 3/8-16, M5, M6, M8 & M10
- Features the market's most popular rivet nut setting tool (1442) adapted for PlusNut and long rivet nut use

SPECIFICATIONS:

- Extra long mandrels in 10-32, 10-24, 1/4-20, 5/16-18, 3/8-16, M5 x 0.8, M6 x 1, M8 x 1.25, M10 x 1.5
- Quick-change 13" rivet nut setter and storage case

DO NOT DISCARD – GIVE TO USER



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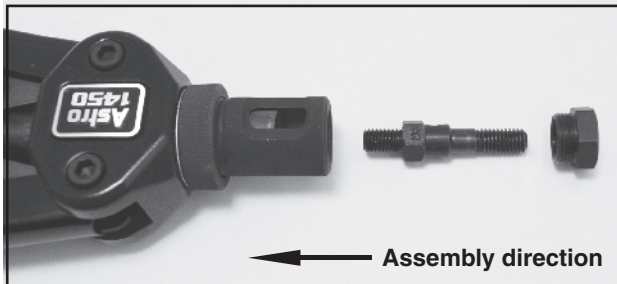
WARNING



Always wear ANSI approved safety goggles when using this product (Users and Bystanders). Failure to read and follow all warnings and operating instructions may result in damages and serious injuries or death.

OPERATING INSTRUCTIONS:

1. Choose the rivet nut size to be installed.
2. Install the correct size mandrel/nosepiece for the rivet nut to be installed. See photos and instructions for changing the mandrel/nosepiece and adjustment.
3. Drill a hole in the work product the same size or slightly larger than the outside diameter of the rivet nut to be installed.
4. To install the rivet nut, open the handles outward as far as possible and thread the rivet nut clockwise onto the mandrel until reaching the nosepiece.
5. Insert the rivet nut fastened to the riveter into the pre-drilled hole until flush with the work product, and pull handles inward to secure the rivet nut into the hole. If the rivet nut is loose in the hole, open the handles outward, turn #12 knob clockwise, and pull handles inward until the rivet nut is secure in the hole. Repeat as necessary until the rivet nut is secure in the hole. See adjustment instructions if necessary.
6. Turn the #12 knob counterclockwise until the mandrel is removed from the rivet nut. The rivet nut installation is complete if the rivet nut is secure from movement in the hole.



CHANGING MANDREL/NOSEPIECE INSTRUCTIONS:

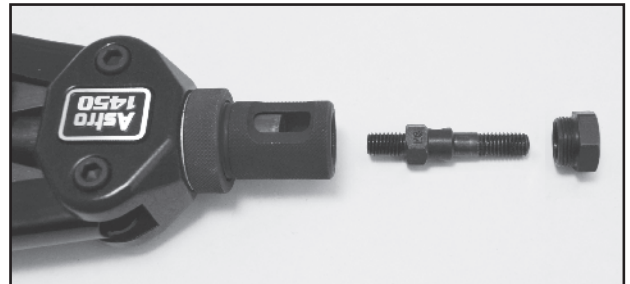
1. Remove and install the mandrel and nosepieces. Always keep the matched mandrel/nosepiece sets together.
2. Remove nosepiece from #20 sleeve by unthreading the nose piece counterclockwise. This can be done either by hand or with the provided wrench if too tight to do so.



3. Using your thumbnail or tool, press down to depress the #18 inner hexagonal sleeve that sits within the #20 outer sleeve. This should expose the lower hex portion of the mandrel.



4. Unthread the mandrel by hand to remove it from the sleeve. Once the mandrel has been threaded out far enough to clear the #18 hex sleeve you may release tension on this sleeve collar.
5. Choose the correct mandrel/nosepiece to be installed.



6. Thread the new mandrel into the tool by hand until it approaches the #18 hex sleeve and fully depress this sleeve to allow the mandrel to be threaded further until it stops. **The mandrel does not need to be torqued.** Release the hex sleeve and allow it to fully reengage the mandrel. If the mandrel and hex sleeve do not initially align, rotate the #12 knob while holding onto the mandrel until it clicks up and reengages.
7. Thread the matching nose piece into the #20 by hand. Torqueing the nose piece is optional.



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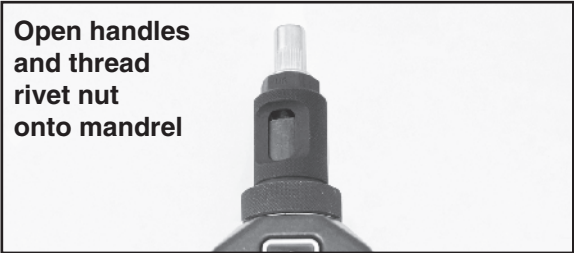
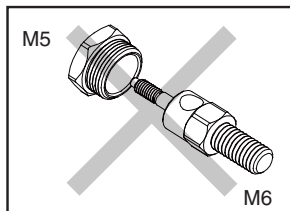
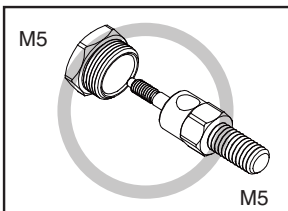
ADJUSTMENT INSTRUCTIONS:

1. Proper adjustment of the riveter is necessary for efficient and easy operation.
2. The adjustment of the riveter will vary, depending on the size and type of rivet nut being used and the hole size.
3. Adjust the riveter by opening the handles outward as far as possible loosening the #19 adjusting nut and turning the #20 outer sleeve clockwise to increase the number of threads on the mandrel protruding beyond the nosepiece for larger rivet nuts, and by turning the #20 outer sleeve counterclockwise for smaller rivet nuts. Once adjustment is set tighten the #19 adjusting nut by hand. Fine adjustment can be made by turning the rivet nut on the mandrel to position the rivet nut closer or further away from the nosepiece, as long as the mandrel is threaded all the way through the rivet nut.
4. Always assure that the mandrel is threaded into all threads of the rivet nut to prevent damage to the threads on the mandrel and/or the rivet nut.
5. If the handles are extended too far outward to provide enough leverage to pull the handles inward to set the rivet nut, turn the #20 outer sleeve clockwise or turn the rivet nut counterclockwise slightly to change the handle angle to provide the proper leverage.

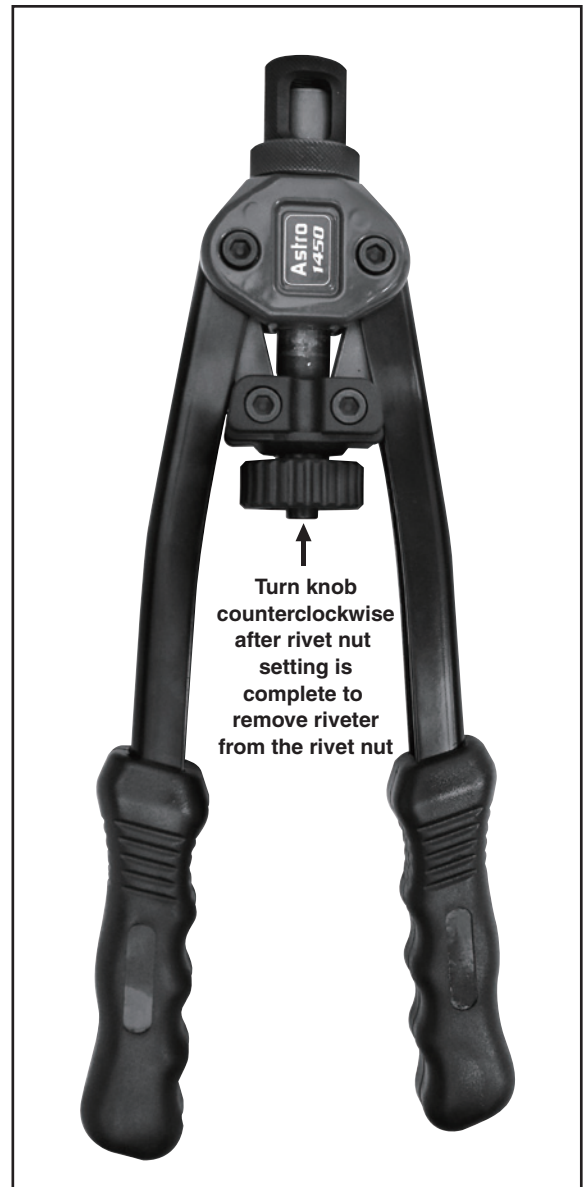


Riveter properly prepared for setting rivet nuts

⚠ Store matching nosepieces and mandrels together when not in use to prevent mismatching the sizes and for convenience.

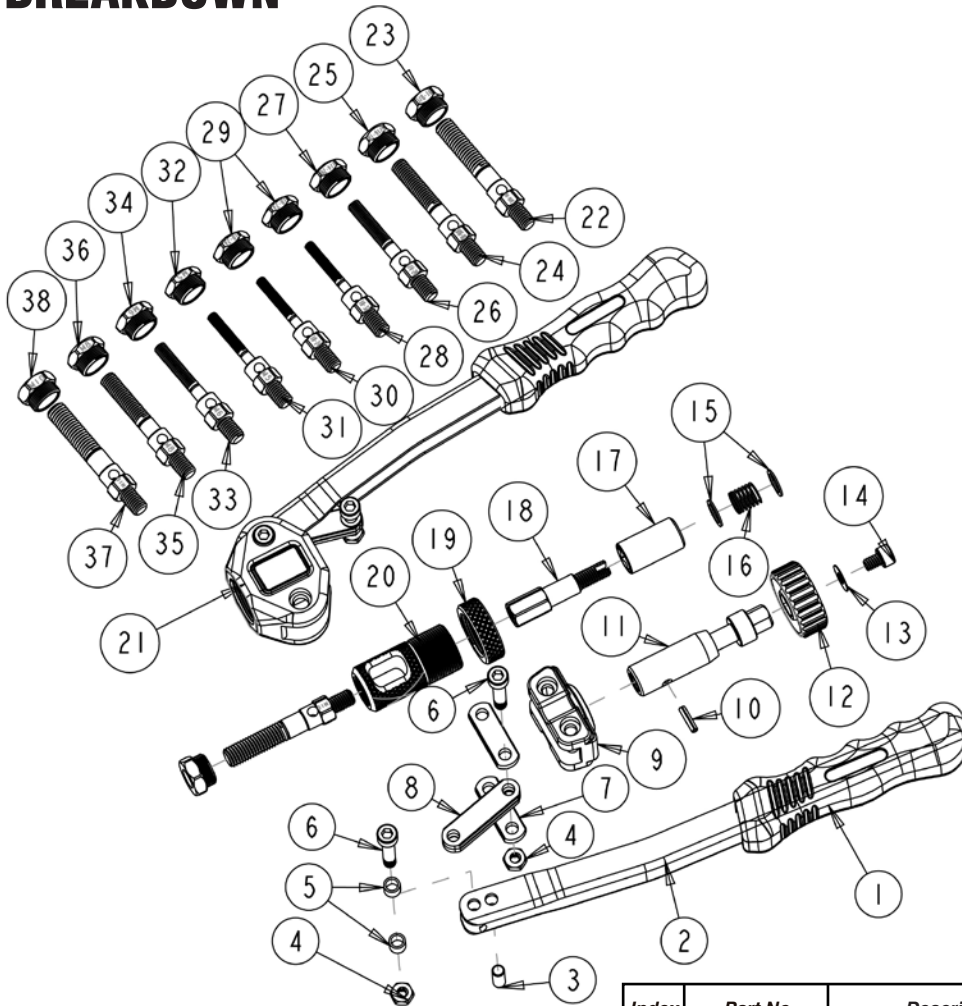


Open handles and thread rivet nut onto mandrel



Turn knob counterclockwise after rivet nut setting is complete to remove riveter from the rivet nut

PARTS BREAKDOWN



Parts List

Index	Part No.	Description	Qty
1	1442-01	Grip	2
2	1442-02	Handle	2
3	1440-10	Bushing	2
4	1442-A20	Spacer	5
5	1442-04	Bushing	4
6	1442-06	Screw	4
7	1442-09	Connecting Bar	2
8	1442-08	Screw	4
9	1442-15	Main Shaft Drive	1
10	1442-A14	Opening Spring Pins	1
11	1442-A15	Pulling Bar	1
12	1442-13	Knob	1
13	1442-A20	Spacer	5
14	1442-11	Screw	1
15	1442-A08	Spacer	2
16	1442-A09	Spring	1
17	1442-A07	Riveting Bar	1
18	1442-A06	Hexagonal Sleeve	1

Index	Part No.	Description	Qty
19	1442-A04	Adjusting Nut	1
20	1442-A03	Sleeve	1
21	1442-16	Main Body	1
22	LM3/8-16	3/8-16 Long Mandrel	1
23	1452-31	3/8-16 Nosepiece	1
24	LM5/16-18	5/16-18 Long Mandrel	1
25	1442-A27	5/16-18 Nosepiece	1
26	LM1/4-20	1/4-20 Long Mandrel	1
27	1442-A33	1/4-20 Nosepiece	1
28	LM10-32	10-32 Long Mandrel	1
29	1450-29	10-32 / 10-24 Nosepiece	1
30	LM10-24	10-24 Long Mandrel	1
31	LM5M	M5 Mandrel 5mmx0.8	1
32	1442-A31	M5 Nosepiece	1
33	LM6M	M6 Mandrel 6mmx1.0	1
34	1442-A29	M6 Nosepiece	1
35	LM8M	M8 Mandrel 8mmx1.25	1
36	1442-A01	M8 Nosepiece	1
37	LM10M	M10 Mandrel 10mmx1.5	1
38	1452-27	M10 Nosepiece	1