

1742A Operation Manual

Heavy duty & professional hand rivet nut with Quick-Drill Unit

This Illustrated Operation Manual includes the FEATURES, SPECIFICATIONS, PARTS LIST, OPERATION INSTRUCTIONS, MAINTENANCE and TROUBLESHOOTING.

Before operating this tool, make sure you read this Illustrated OPERATION MANUAL carefully to ensure a safe, correct and satisfactory use.



A. FEATURES

- **1742A RIVET NUT TOOL** is designed to fasten RIVET NUTS with THREADED MANDRELS, from M5 x 0.8 up to M10 x 1.5 or from 10-24/32 up to 3/8-16, in all materials (Aluminium, Steel and Stainless Steel/Inox) and to firmly and securely forge Female Threads in thin base metals and pipes with weldless, tapping-free and one-side work in order to fasten them to bolts.

- **1742A** is equipped with a QUICK-DRILL UNIT, simply "Push & Pull" the DRILL UNIT KNOB to drive the THREADED MANDREL or THREADED SOCKET to engage with and be released from the RIVET NUT or RIVET BOLT/STUD quickly!

- **1742A** is equipped with a FIXING-HOLE DEVICE, simply inserting the FIXING-HOLE PIN not only to solve the problem of RIVET NUT stuck on the working THREADED MANDREL that might happen when fastening RIVET NUT, but also to assist THREADED MANDREL to mount or dismount the TOOL easily just with a single SERVICE WRENCH.

B. SPECIFICATIONS

1742A Tool Dimensions and Net Weight:

Dimensions (Closed type): L 530 x W 130 mm. Net Weight: 2.15 kgs.

- Working Capacity:

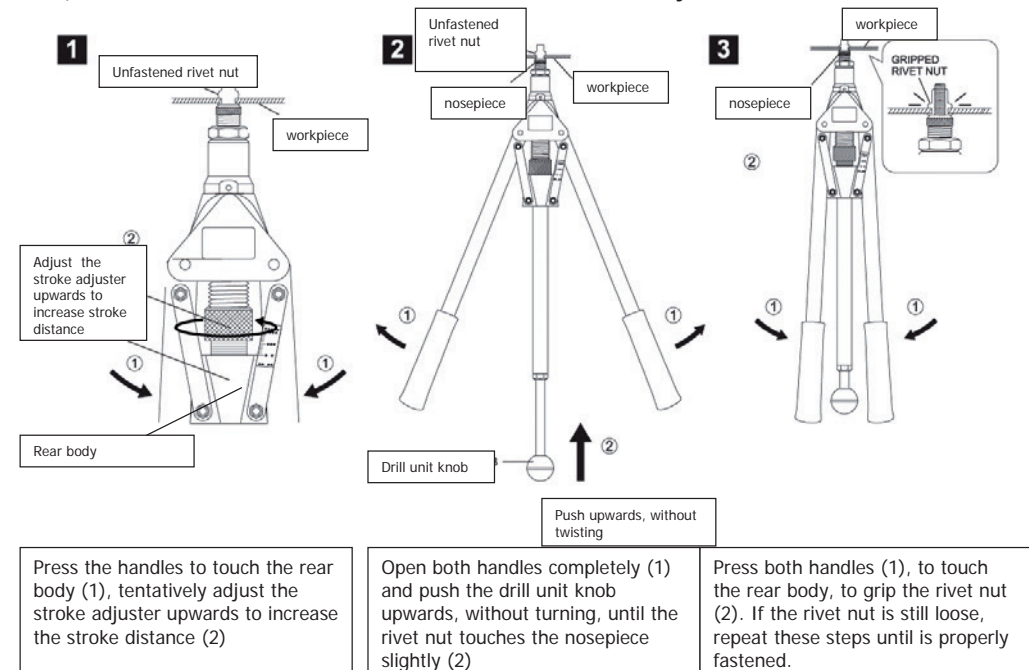
- 1) RIVET NUTS/THREADED INSERTS (Aluminium, Steel, Stainless Steel) ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25, M10x1.5 or UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16.

1742A Standard Accessories:

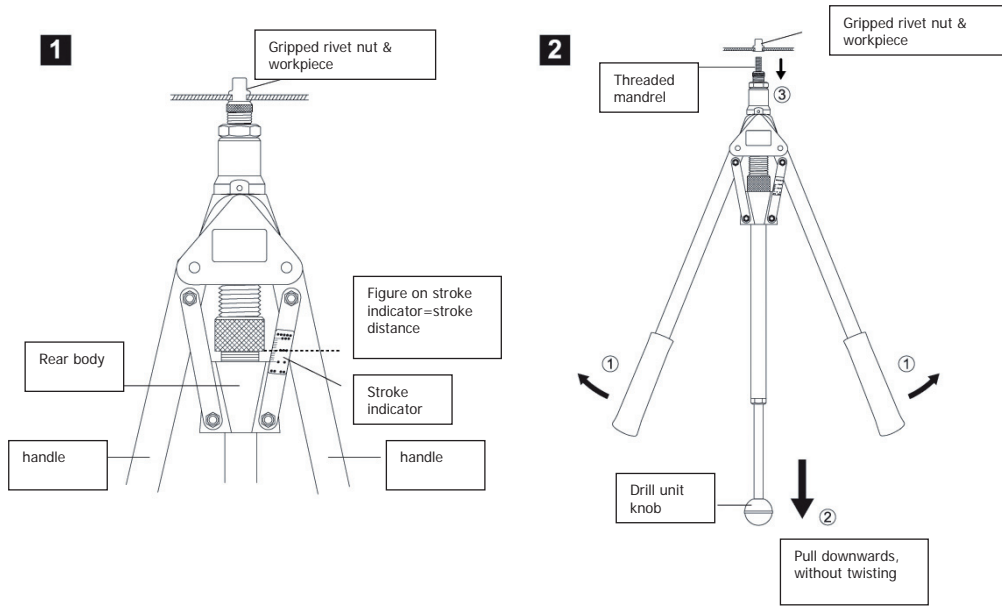
- 1) THREADED MANDRELS: ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25, M10x1.5 : 1 pc of each. or UN Inch Thread Size: 10-24, 10-32, 1/4-20, 5/16-18, 3/8-16 : 1 pc of each.
- 2) NOSEPIECES: ISO Metric Size: M5, M6, M8, M10 : 1 pc of each. or UN Inch Size: #10, 1/4, 5/16, 3/8 : 1 pc of each.
- 3) NOSEPIECE LOCK NUT, SERVICE WRENCH, SMALL RULE, FIXING-HOLE PIN, PIN RETAINER, PARTS PLASTIC BOX, TRAY, STEEL CARRY CASE, OPERATION MANUAL: 1 pc of each.

J. TROUBLESHOOTING

J-1) How to reset the rivet nut if, at the first use, it is not set firmly.



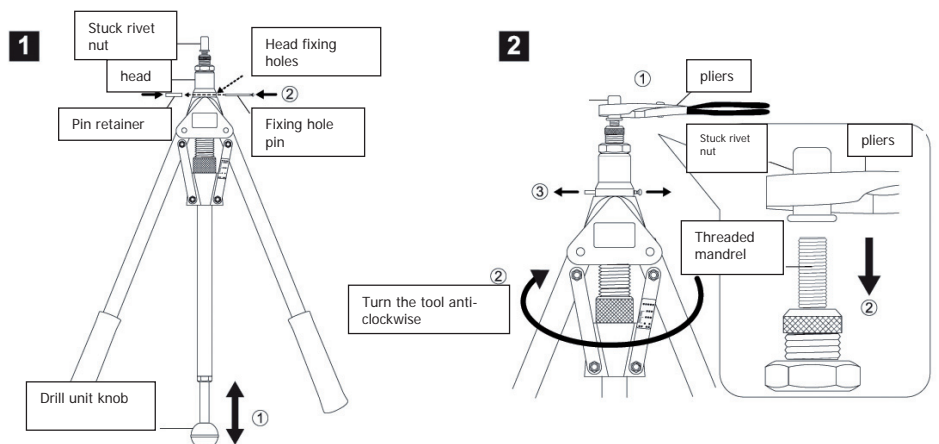
J-2) How to readjust the correct stroke distance to protect the tool and the rivet nut threads from damage, should you not manage to manually press the handles to touch the rear body:



WARNING: do not insist in pressing the handles.
Holding both handles, check and memorise the figure on the stroke indicator.

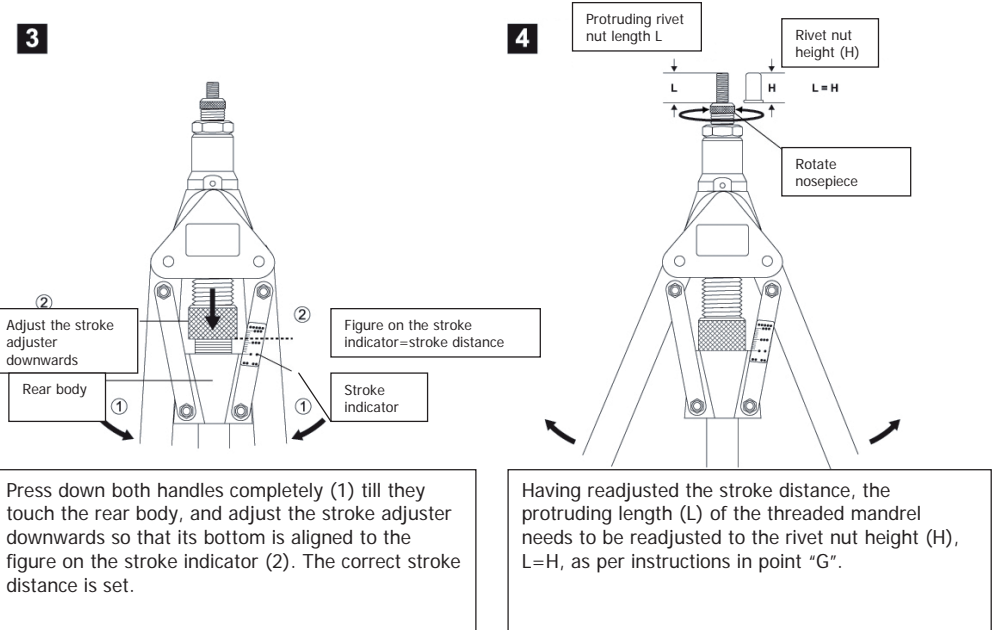
Open both handles completely (1) and pull the drill unit knob downwards, without twisting (2), to unscrew the threaded mandrel from the gripped rivet nut and Workpiece (3)

J-3) What to do should a rivet nut be stuck on the threaded mandrel.

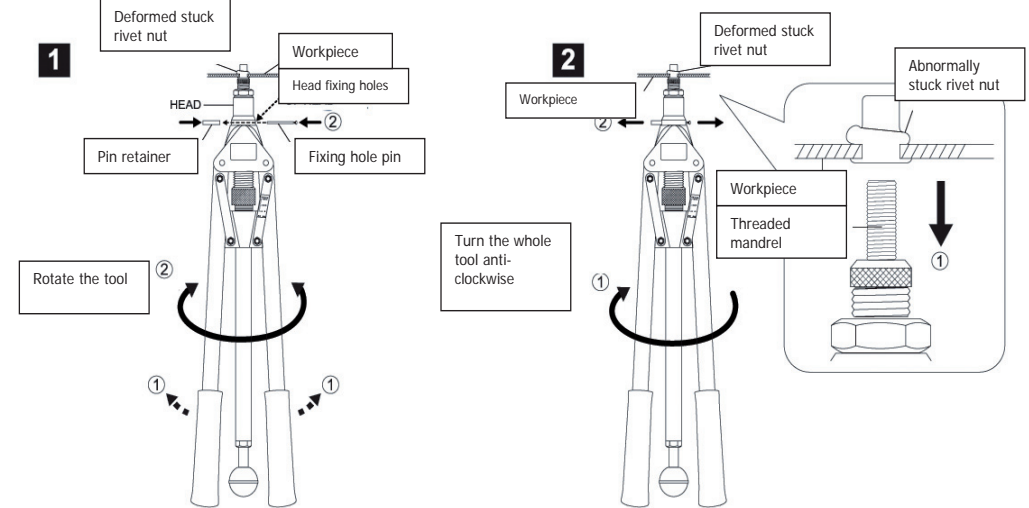


Pull the drill unit knob downwards then push it upwards to align the head fixing holes and the long fixing hole of the mandrel seat (1); fit the fixing hole pin into the holes and fasten it with the pin retainer (2). The threaded mandrel free rotation should cease.

It is recommended two people do this job: while one holds the rivet nut with pliers, the other turns the tool anti-clockwise to unscrew the threaded mandrel from the rivet nut (2). Remove the pin retainer and the fixing hole pin. (3)



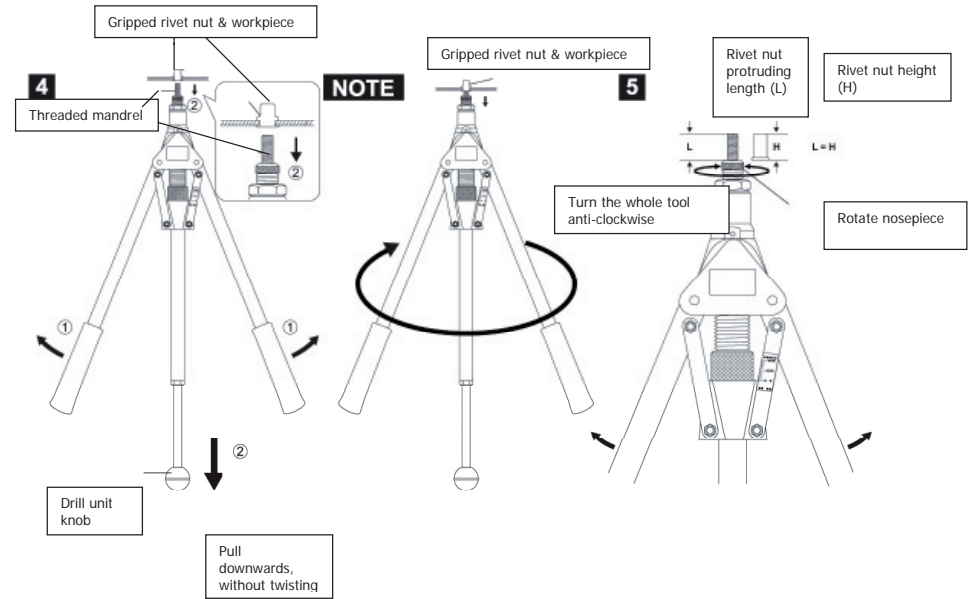
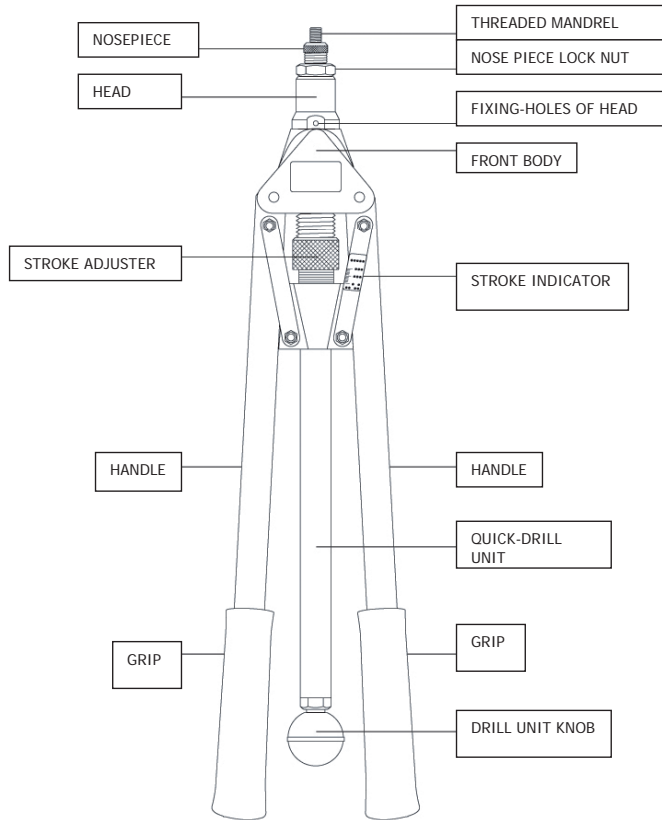
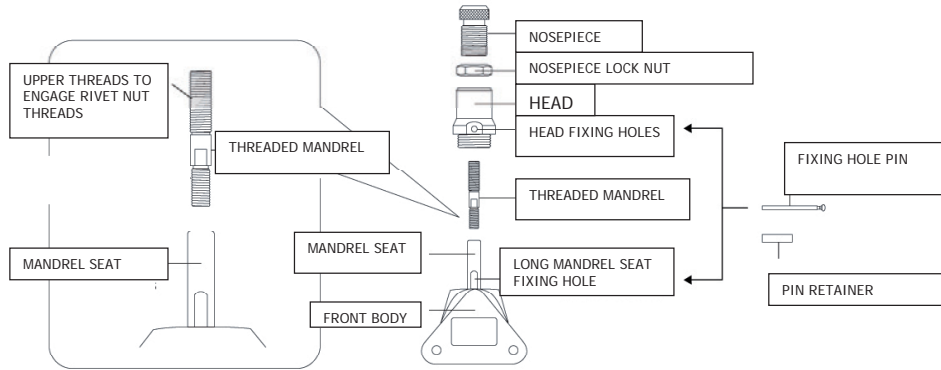
J-4) what to do should the rivet nut be abnormally deformed when pressing both handles.



Slightly open both handles (1), rotate the tool the align the head fixing holes and the long mandrel seat fixing hole, then insert the fixing hole pin into the holes and fasten with the pin retainer (2). The threaded mandrel free rotation should cease.

Turn the tool anti-clockwise to unscrew the threaded mandrel from the stuck rivet nut (1). Remove the pin retainer and the fixing hole pin. (2)

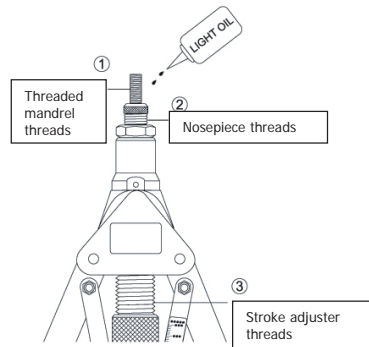
C. MAIN PARTS



<p>Open both handles completely (1), pull the drill unit knob downwards, without twisting, to unscrew the threaded mandrel from the gripped rivet nut and Workpiece (2).</p>	<p>NB. If the threaded mandrel still does not unscrew from the rivet nut and Workpiece, turn the whole tool anti-clockwise to unscrew the mandrel completely.</p>	<p>As the stroke distance has been readjusted, the protruding length (L) of the threaded mandrel has to be readjusted to fit the rivet nut height (H). L=H, as per point "G".</p>
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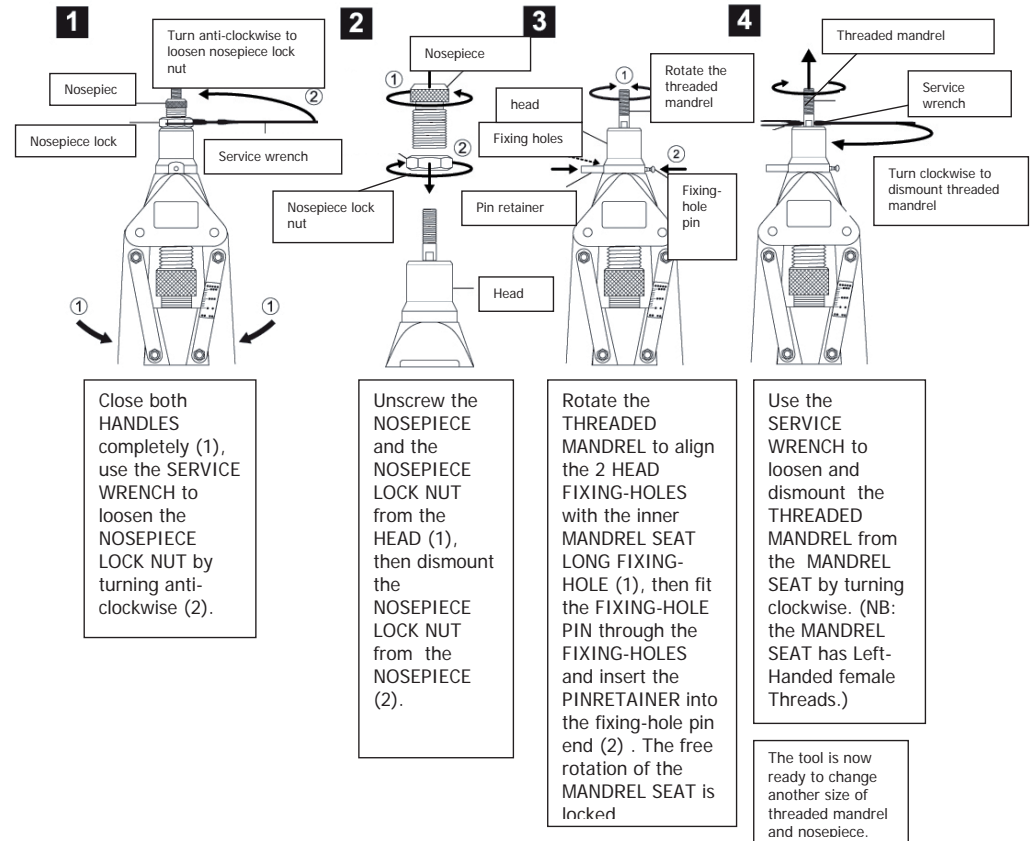
I. MAINTENANCE

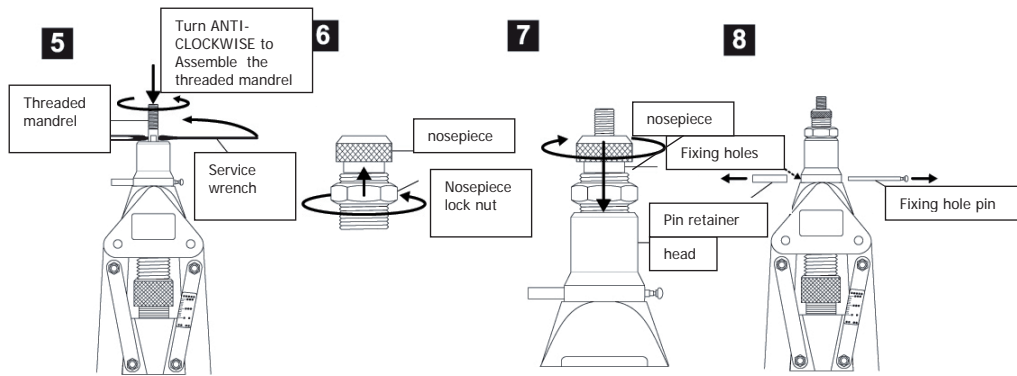
This tool is extremely sturdy and reliable, it only requires an occasional application of Light Oil to the mandrel (1), nosepiece (2) and stroke adjuster (3) threads.



D. HOW TO CHANGE THE THREADED MANDREL AND NOSEPIECE

PRECAUTION : Check the Thread Size of the Fastening BOLT and the WORKPIECE Thickness to determine the Thread Size, Grip Range, Material and Type of RIVET NUT, then drill or punch the correct size of Hole in the WORKPIECE to fasten the RIVET NUT. The Working Size of the THREADED MANDREL and NOSEPIECE should be same as the rivet nut thread size.



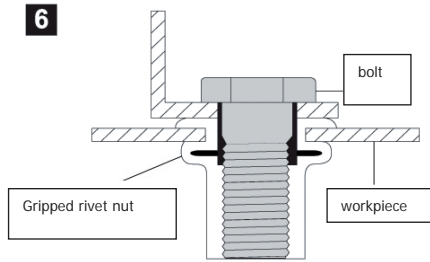
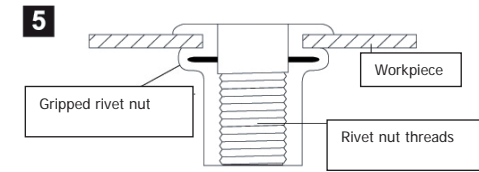


Use the service wrench to assemble the working size of the threaded mandrel into the mandrel seat firmly by turning anti-clockwise. (NB. The mandrel seat has left handed female threads)

Assemble the nosepiece lock nut into the working size of the nosepiece

Screw the nosepiece into the head by turning clockwise

Finally, remove the pin retainer and the fixing pin from the holes.



Complete the fastening by fixing a bolt to the gripped rivet nut

H. HOW TO FASTEN THE SAME SIZE OF RIVET NUT.

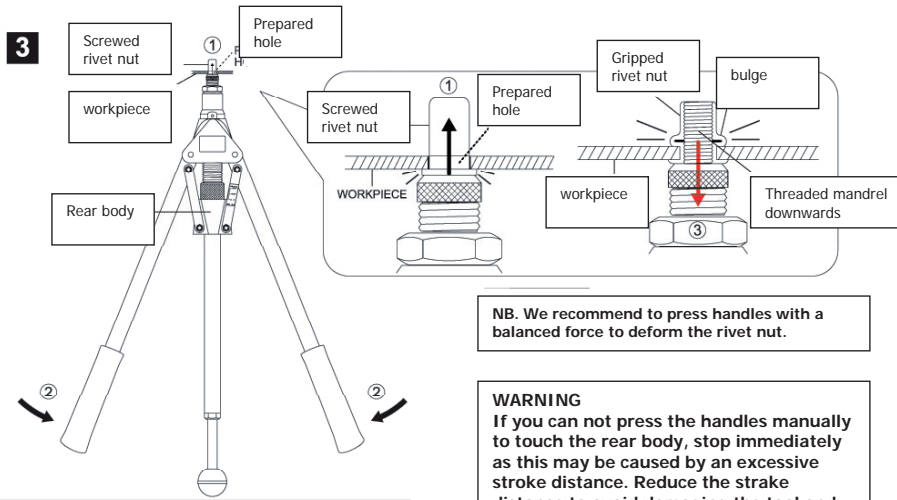
If you are using a rivet nut with the same size as the previous one, simply repeat the steps indicated in H. above.

NB. We recommend you always carry out a pilot test before setting different sizes of rivet nut to ensure correct fastening and to avoid damage to the tool and threads.

E. HOW TO ADJUST THE STROKE DISTANCE

WARNING

- The correct stroke distance is defined on the basis of the Workpiece thickness and the rivet nut grip range. Each rivet nut has its own grip range, maximum and minimum grip.
- The Workpiece thickness must be within the grip range of the rivet nut or between the maximum and minimum, to ensure a safe and firm fastening.
- If the rivet nut maximum grip is inferior to the Workpiece thickness, the tool and the rivet nut threads might be damaged.
- If the minimum grip of the rivet nut is superior to the Workpiece thickness, the rivet nut will not grip firmly to the Workpiece.
- An excessive stroke distance might result in damage of the tool and the rivet nut threads; the rivet nut will not adjust firmly to the Workpiece.



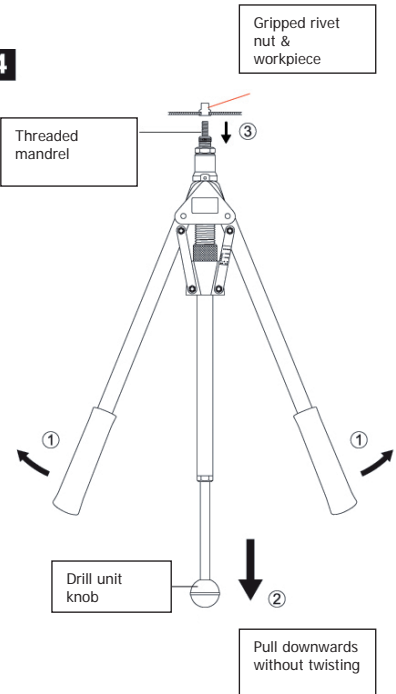
NB. We recommend to press handles with a balanced force to deform the rivet nut.

WARNING

If you can not press the handles manually to touch the rear body, stop immediately as this may be caused by an excessive stroke distance. Reduce the stroke distance to avoid damaging the tool and the rivet nut threads. See Troubleshooting J-2.

Insert the Screwed RIVET NUT into the Prepared Hole of the WORKPIECE completely (1). Press both HANDLES to touch the REAR BODY (2), that drives the THREADED MANDREL to deform the RIVET NUT to fasten the RIVET NUT in the WORKPIECE (3).

4



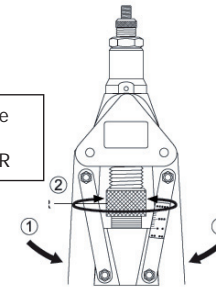
Open both handles completely (1), pull the drill unit knob downwards (without twisting) (2) to unscrew the threaded mandrel from the gripped rivet nut (3).

The rivet nut is therefore gripped in the Workpiece firmly and is secured.

NB. If the rivet nut is not firmly fastened, please refer to Troubleshooting J-1. If handles can not be pressed to touch the rear body, please refer to Troubleshooting J-2.

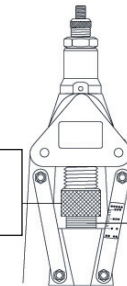
1

Rotate the STROKE ADJUSTER



Close the handles completely (1), rotate the stroke adjuster (2) to adjust the correct stroke distance

Rotate STROKE ADJUSTER



1 black line corresponds to 1mm or 0.04". total of line indicates the stroke distance.

OR) rotate the stroke adjuster to reveal the number of exposed lines: 1 line corresponds to 1mm or 0.04" stroke distance.

2

Rotate the STROKE ADJUSTER

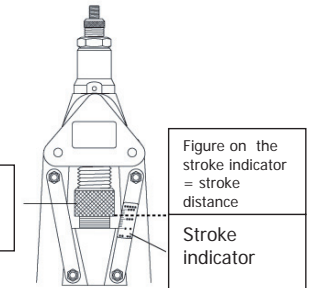
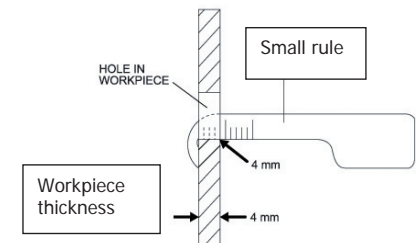


Figure on the stroke indicator = stroke distance
Stroke indicator

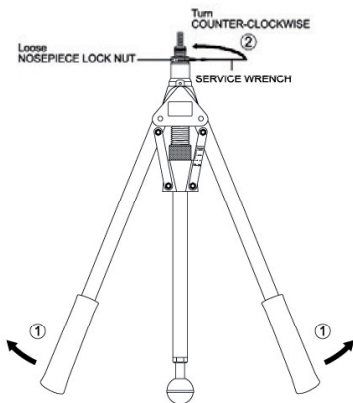
EITHER) rotate the stroke adjuster to reveal the figure on the stroke indicator parallel to the bottom of the stroke adjuster. **Figure on the indicator = stroke distance**



The rule is to measure the Workpiece thickness.

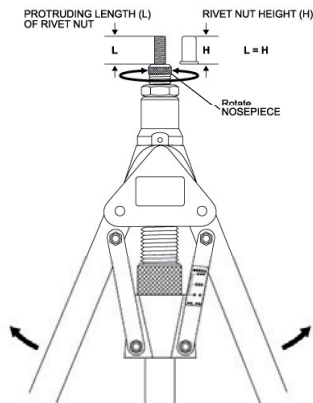
F. HOW TO ADJUST THE PROTRUDING LENGHT (L) OF THREADED MANDREL

1



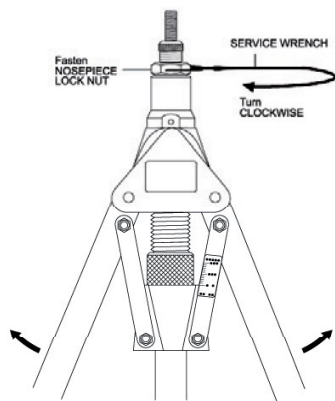
Open 2 HANDLES completely (1), use SERVICE WRENCH to loose NOSEPIECE LOCK NUT by turning Counter-Clockwise (2).

2



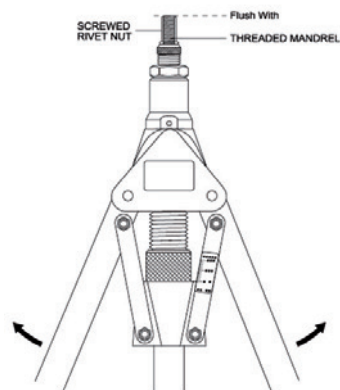
Rotate the NOSEPIECE to adjust the PROTRUDING LENGHT (L) of THREADED MANDREL, it must be the same as the RIVET NUT HEIGHT (H), $L=H$.

3



Use SERVICE WRENCH to fasten NOSEPIECE LOCK NUT by turning CLOCKWISE.

NOTE

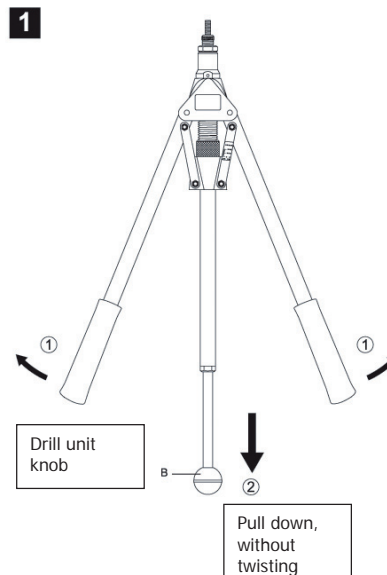


NOTE: after adjusting the protruding lenght (L) of THREADED MANDREL, the Screwed RIVET NUT should be flush with the THREADED MANDREL.

G. HOW TO OPERATE THIS TOOL TO SET RIVET NUT

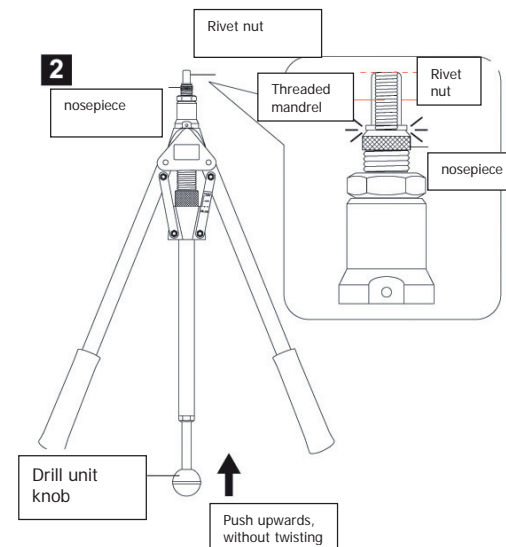
PRECAUTION: Before operating this TOOL, it is strongly requested to follow the above "E" to install the correct size of the THREADED MANDREL and NOSEPIECE, the above "F" to adjust the proper Stroke Distance, and the above "G" to adjust the suitable Protruding Length (L) of THREADED MANDREL to engage with RIVET NUT.

1



Open both handles completely (1), pull the drill unit knob down to the end, without twisting.

2



Screw the rivet nut into the threaded mandrel by pushing the drill unit knob up slowly, without turning, until the rivet nut touches the nosepiece. It is recommended the rivet nut touch the nosepiece only slightly. The screwed rivet nut should be in line with the threaded mandrel.