

PLEASE SPEND 5 MINUTES READING THESE INSTRUCTIONS BEFORE USING YOUR NEW RIVNUT TOOL.

TRUST US, IT WILL SAVE YOU TIME AND INCONVENIENCE IN THE LONG RUN.

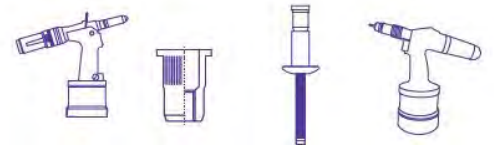


READ THIS MANUAL CAREFULLY BEFORE USING THE TOOL !

It is **IMPORTANT** to follow the safety instructions for adequate protection against injuries.

- This tool should be used **ONLY** to set blind rivets within the **TOOL'S CAPACITY**. It **MUST NOT** be used for other purposes, such as hammer, etc.
- This tool should be always operated with compressed air supply within the air pressure range 0.5Mpa ~ 0.7Mpa.
- Always **DISCONNECT** the air supply from the tool before changing the tool parts, such as jaws, etc.
- **DO NOT** use the tool in the environment described as below:
 - fuel and combustion air.
 - temperature rapidly rising.
 - humidity, rain, water, storm and thunder, lightning.
- When the tool is suspended by the operation hook during use, be sure the tool will not fall.
- When using the tool, always carry protective goggles, protective gloves, safety helmet, and other necessary protections. It is highly recommended for safety reasons.
- Only use genuine spare parts for maintenance and repairs.
- All repair work must be carried out by skilled personnel, when in doubt, always return the tool to the distributor.

DNPB328 Operation Manual



TOOL CAPACITY

Blind rivnuts M3 – M4 – M5 – M6 – M8 all materials and styles.

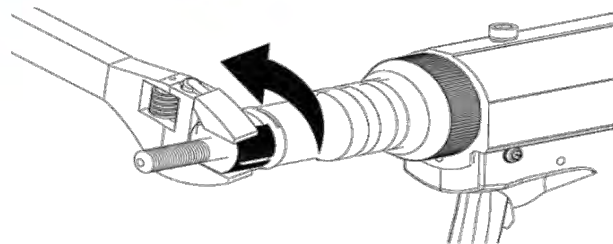
TOOL SPECIFICATIONS

Air supply pressure:	0.5Mpa ~ 0.7Mpa
Output traction power:	14,000N ~ 19,600N
Stroke:	1mm ~ 7mm adjustable
Net weight:	1.70kgs

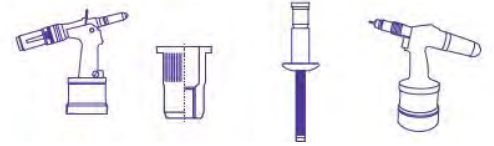
GETTING STARTED

Please refer to the **TOOL EXPLOSIVE ILLUSTRATION** and the **PARTS LIST** in this manual in order to have a good understanding of the tool parts described. The descriptions of the tool parts appear in this manual are in *italics* with the parts position *numbers* corresponding to the tool explosive illustration.

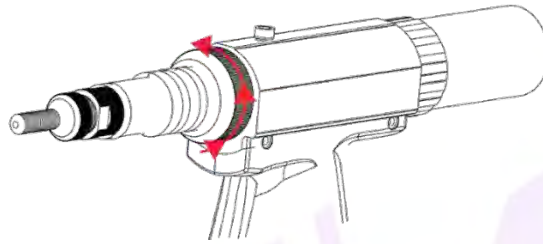
1. This pneumatic powered tool should be used with a compressed air supply. It is recommended to use an air hose with a diameter bigger than 8 mm.
2. Before connecting the tool to the compressed air supply, check that the compressed air pressure is within the specified range of between 0.5Mpa ~ 0.7Mpa. Once the air pressure has been confirmed, connect the air hose adaptor onto the tool *air adaptor* (#58). The air adaptor comes in different versions in different countries. Normally the tools are equipped with the correct version for your country as default, however, if the air adaptor you have received does is incorrect, please contact the tool distributor(s).
3. Before using the tool, ensure that you are using the correct *mandrel* (#1) and *anvil* (#2) according to the size of the rivnut to be set. This tool is equipped with mandrels and anvils from M3 to M8 in the kit. For convenience, 5 identical *locknuts* (#65) are provided in the tool kit for each size *mandrel* (#1) and *anvil* (#2) in pairs.
 - a) Remove the *anvil* (#2) and the *locknut* (#65) from the tool:



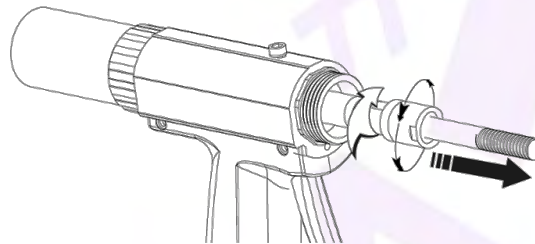
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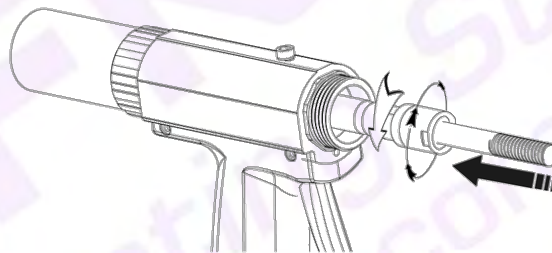
b) Remove the *knurled cover* (#12) and *nose pedestal* (#10):



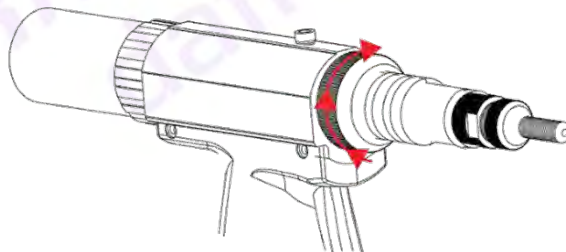
c) Use a spanner to loosen the *connect sleeve* (#3) from the *spring house* (#5), take out the *mandrel* (#1), *transfer bar washer* (#63), *connect sleeve* (#3), *transfer bar* (#4) and *spring* (#6):



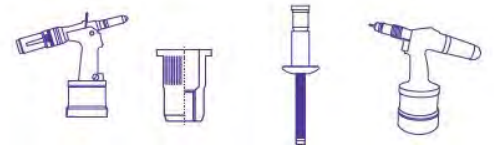
d) Take the *transfer bar washer* (#63) out and insert the required *mandrel* (#1) from the tool accessories pack as per rivnut size, then mount into the *connect sleeve* (#3), *transfer bar* (#4), together with *spring* (#6) install into the *spring house* (#5). Screw the *connect sleeve* (#3) tight with *spring house* (#5) using a spanner:



e) Screw the *knurled cover* (#12) and *nose pedestal* (#10) back to the tool, then replace the *locknut* (#65), and *anvil* (#2):

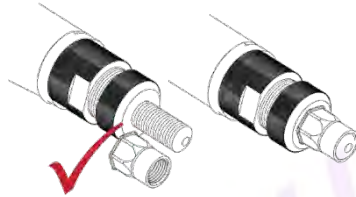


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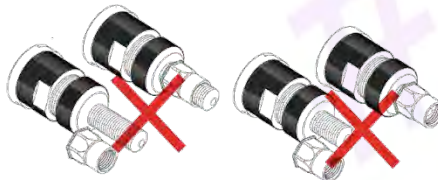


MANDREL PROTRUDING SET FOR BLIND NUT

- 1) Adjust the length of the *mandrel* (#1) that protrudes from the *anvil* (#2) according to the length of the rivnut to be set by adjusting the position of the *locknut* (#65), and *anvil* (#2) screwed on the *mandrel* (#1):

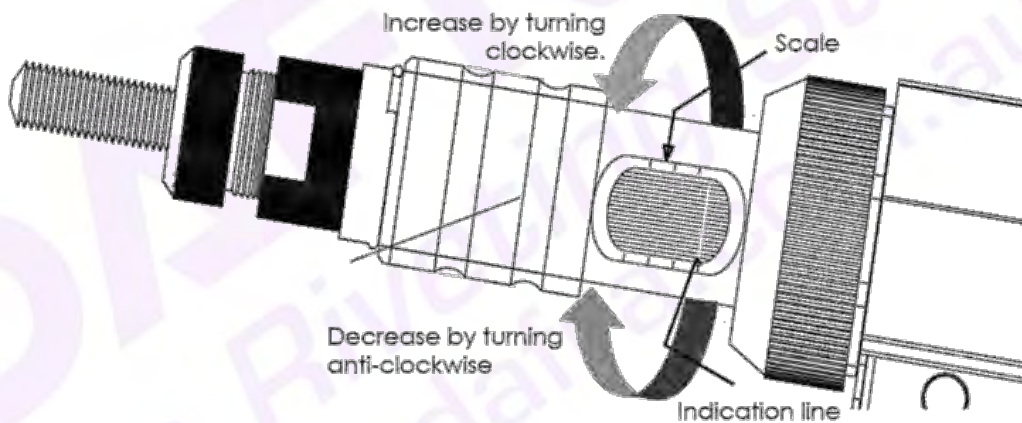


- 2) Never set the mandrel protruding length too long or too short for the rivnut to be set:

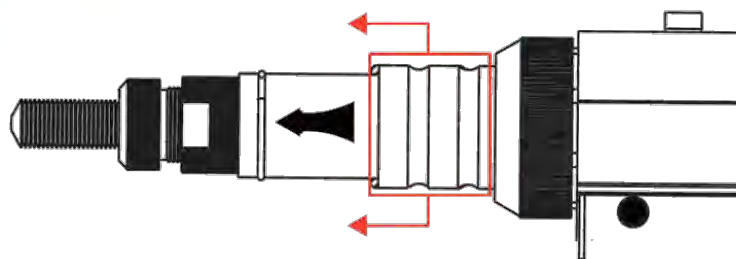


STROKE SETTING

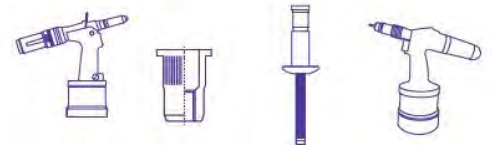
- 1) Tool stroke should be set according to the work piece where the rivnut is to be set. This tool's stroke can be adjusted between 1mm and 7mm.
- 2) To set the stroke:



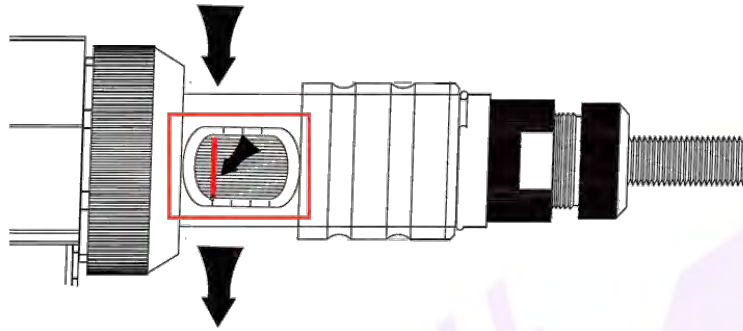
- a) Push the *sleeve* (#56) to the tool mandrel side, as shown:



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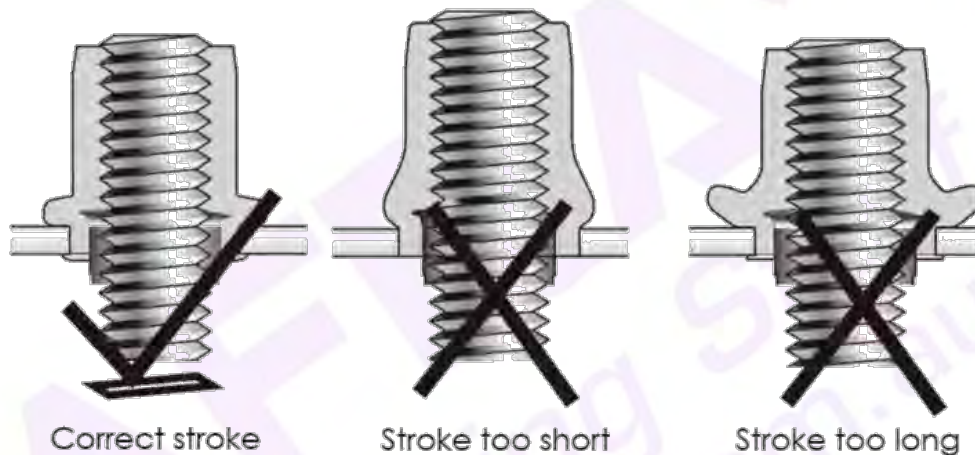
b) Adjust the tool stroke by turning the knurled wheel on the tool as shown:



The scales along with the stroke setting window are indications for stroke.

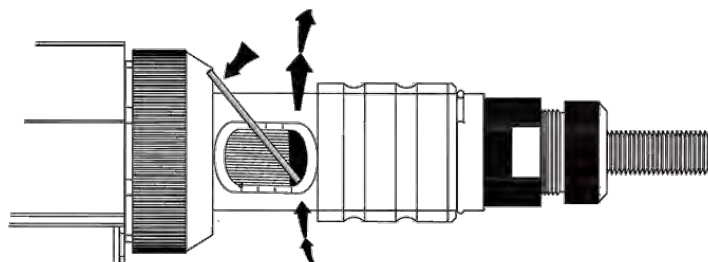
c) Replace the *sleeve* (#56) back to its initial position after setting the stroke.

It is recommended to set a trial rivnut to ensure the correct stroke setting. The illustration below shows the results of correctly and incorrectly set stroke.

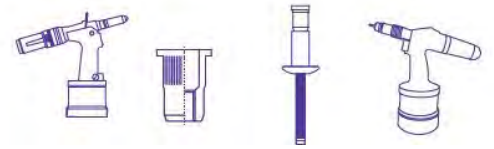


If the stroke is set too long or there is a fault with the rivnut itself, it's possible that the rivnut may not be released from the tool *mandrel* (#1) after setting.

To release the tool from the damaged rivnut, first loosen the *knurled cover* (#12), slide away the *sleeve* (#56), then insert a 2.5mm diameter Allen-key through the stroke adjusting window into the gap along the flat side of the *nose pedestal* (#10) and *spring house* (#5) which is positioned to the side in the stroke adjusting window. Be sure that the *nose pedestal* (#10) and *spring house* (#5) are secure with each other, then hold on to the *nose pedestal* (#10) and the Allen-key clockwise. This will also turn the *mandrel* (#1) clockwise therefore releasing the rivnut as shown:



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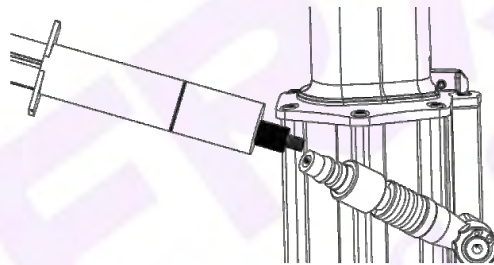


TOOL OPERATION FOR SETTING RIVNUTS

- 1) After completing your start-up preparations and setting your stroke correctly, turn your rivnut once onto the tool *mandrel* (#1) then apply light pressure to the end of the rivnut - the *mandrel* (#1) will automatically thread itself into the rivnut. Place the *mandrel* (#1) with rivnut attached into your pre-drilled work piece hole.
- 2) Pull the tool *trigger* (#53) to set the rivnut in its position on work piece.
- 3) After setting the rivnut, release the *trigger* (#53). The *mandrel* (#1) will turn anti-lock wise and release the tool from the set rivnut. If the tool is still not released from the set rivnut, press the button at the back of *compressed spring pedestal* (#21), then the tool will be released.

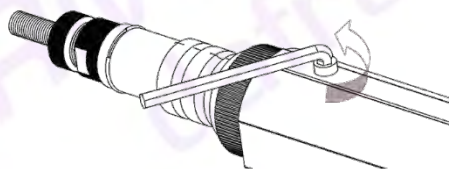
TOOL MAINTAINANCE

In order to maintain optimum performance after several weeks of regular use, add a few drops of hydraulic oil to the inlet of the *air adaptor* (#58) of the tool in order to reduce the friction of the tool parts since the oil will be blown inside the tool when tool is in operation.

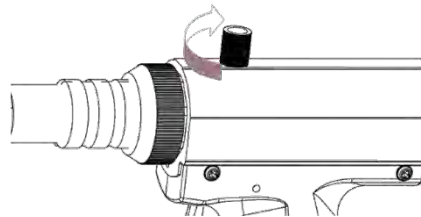


After a period of use, the tool stroke may be reduced which indicated that the hydraulic oil in the pneumatic tool needs to be refilled or changed;

- 1) Remove the *screw* (#17) with a hexagon wrench:



- 2) Connect the air supply and to place a cloth over the hole where the *screw* (#17) was removed, then to pull the *trigger* (#53) and the oil will be forced out from the tool



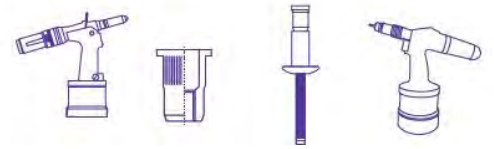
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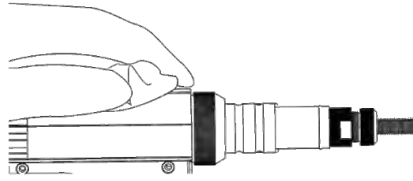
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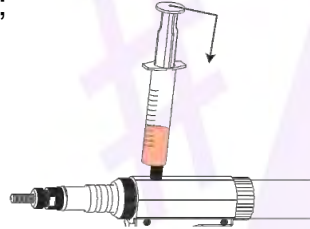
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- 3) Screw the *oil inject adaptor* (in *oil injector set in the accessories pack*) into the hole where *screw (#17)* was removed;

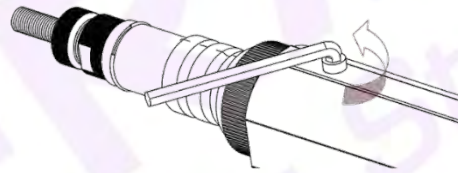


- 4) Use the *oil injector* (in the *accessories pack*) to slowly inject the oil until full (approx. 15ml). Remove the injector and its adaptor, then clean off any excess oil on the tool and tightly screw the *screw (#17)* back into the tool;

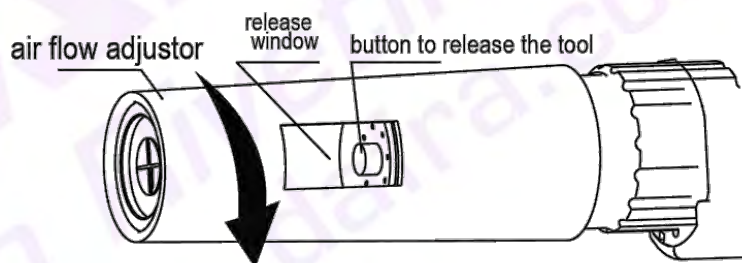


- 5) Test the tool stroke. If the stroke is still not what it should be, some air could have entered the *oil cylinder (#15)* while refilling the oil in the tool.

To release this extra air from the tool, connect the tool to the air supply, pull the tool *trigger (#53)* 6 or 7 times, then loosen the *screw (#9)*, to let the extra air leak out and then tighten the *screw (#17)* again.



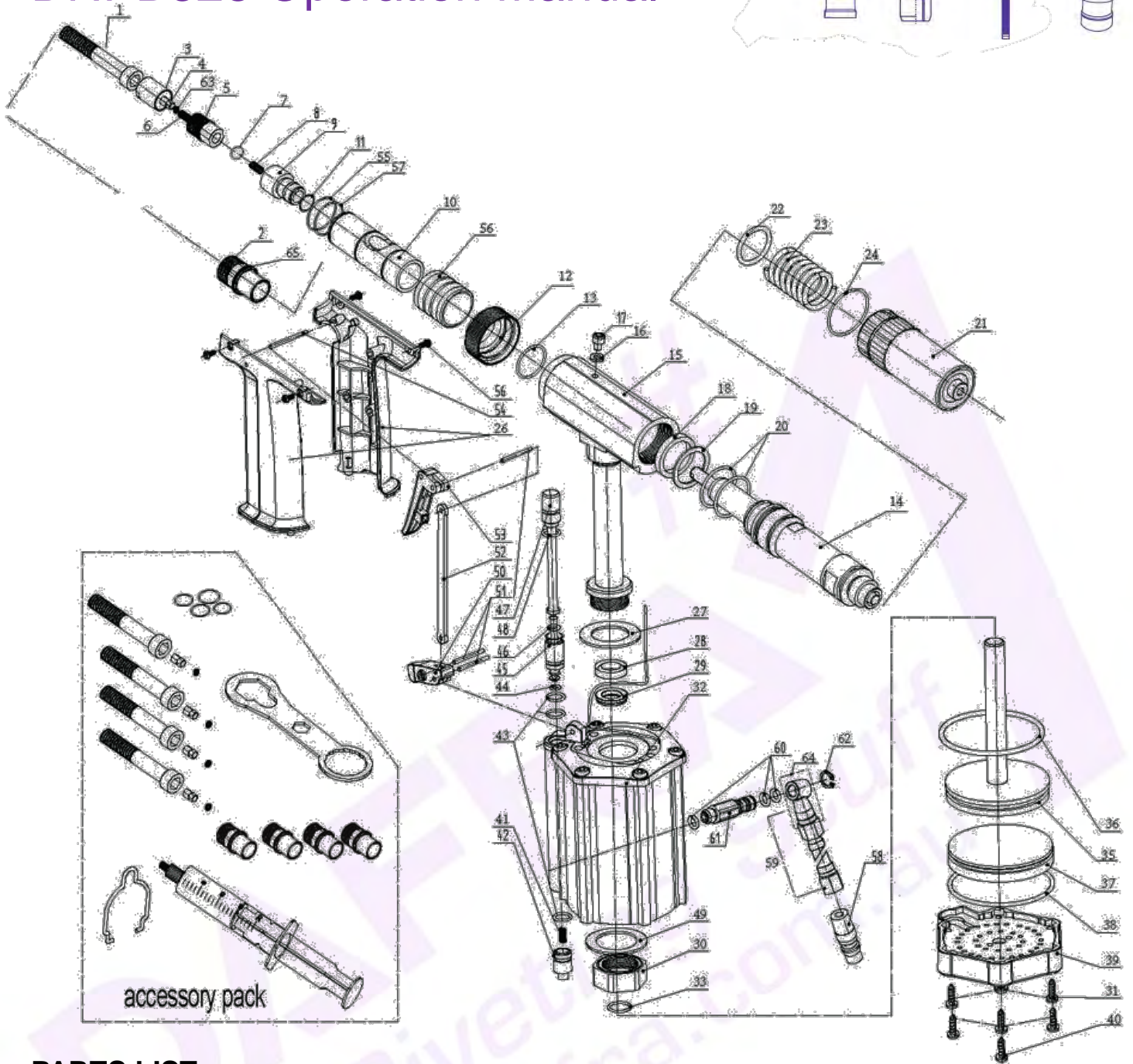
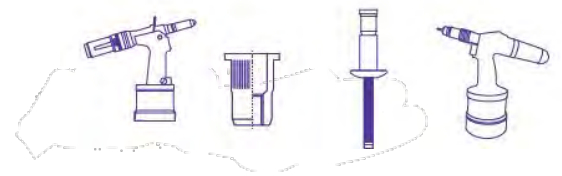
OPTIONAL USE OF AIR FLOW ADJUSTOR



The *air flow adjustor* (in the *tool accessories pack*) allows you to adjust the air flow released from the tool when the tool is operated. It has no effect on the performance of the tool itself but is used based on the tool operator's personal preference.

The operator may feel uncomfortable with the air released from the tool blowing on his / her arm. Once mounted on the back of the *compressed spring pedestal (#21)*, this device allows the operator to direct the air release away from their body, while still providing access to the button at the back of the *compressed spring pedestal (#21)* - via the window in the *air flow adjustor* - to release the tool from a set rivnut when necessary (refer to **TOOL OPERATION FOR SETTING RIVNUT section 3**).

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PARTS LIST

PART POSITION	PART CODE	DESCRIPTION	Quantity in Tool/Kit
1	P03006-00	mandrelM8 metric	1
2	P00306-00	anvil M8	1
3	P00481-00	connect sleeve	1
4	P00494-00	transfer bar M8	1
5	P00482-00	spring house	1
6	P03003-00	spring	1
7	F60074-00	O-ring	1
8	F00101-00	pin	1
9	P00315-00	adjust sleeve	1
10	P00483-00	nose pedestal	1
11	F00011-00	O-ring	1

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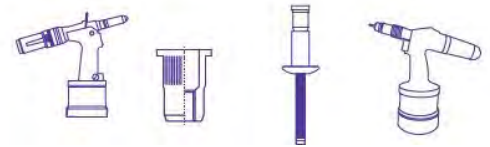
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PARTS LIST - continued

PART POSITION	PART CODE	DESCRIPTION	Quantity in Tool/Kit
12	P00317-00	knurled cover	1
13	P00318-00	wire circlip	1
14	A00100-00	assembly air motor	1
15	A00101-00	assembly oil cylinder with DAFRA logo DNPB328	1
16	F00002-00	washer	1
17	P00009-00	screw	1
18	F00103-00	U-ring	1
19	P00319-00	piston pin washer	1
20	F00027-00	O-ring	2
21	A00102-00	compressed spring pedestal	1
22	F00104-00	O-ring	1
23	P00323-00	return spring	1
24	F00105-00	O-ring	1
25	P00039-00	screw	4
26	A00008-00	assembly grips	1
27	P00017-00	oil cylinder washer	1
28	F00039-00	U-ring	1
29	P00325-00	piston shaft washer	1
30	P00326-00	assembly oil cylinder locknut	1
31	P00021-00	screw	12
32	A00104-00	assembly air cylinder	1
33	F00040-00	O-ring	1
35	A00105-00	assembly piston	1
36	F00008-00	O-ring	1
37	P00027-00	piston pedestal	1
38	F00009-00	O-ring	1
39	P00028-00	air cylinder pedestal	1
40	P00029-00	screw	1
41	P00314-00	spring	1
42	P00373-00	switch lower base	1
43	F00011-00	O-ring	3
44	F00010-00	O-ring	1
45	P00330-00	switch upper base	1
46	F00106-00	O-ring	1
47	A00103-00	assembly trigger shaft	1
48	F00012-00	O-ring	1
49	P00334-00	oil cylinder gasket	1
50	P00034-00	lever	1
51	F00013-00	pin	3
52	P00035-00	connecting rod	1
53	P00058-77	short trigger red	1
54	F00014-00	pin	1
55	P00336-00	wire circlip	1
56	P00337-00	sleeve	1
57	F00005-00	O-ring	1
58	F00015-00	air adaptor standard	1
59	A00117-00	assembly air adaptor with hose w/o switch	1

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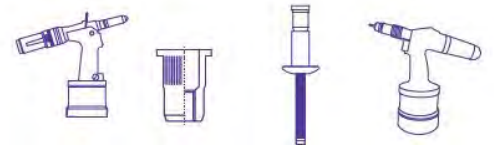
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PARTS LIST - continued

PART POSITION	PART CODE	DESCRIPTION	Quantity in Tool/Kit
60	F00016-00	O-ring	3
61	P00164-00	assembly air adaptor joint	1
62	F00048-00	A-circlip	1
63	P00488-00	M8 transfer bar washer	1
64	P00150-00	swivel joint - optional supply, part of A00117-00	0
65	P00311-00	locknut	1
Accessories Pack	P03010-00	mandrelM3 metric	1
Accessories Pack	P03009-00	mandrelM4 metric	1
Accessories Pack	P03008-00	mandrelM5 metric	1
Accessories Pack	P03007-00	mandrelM6 metric	1
Accessories Pack	P00492-00	transfer bar M3	1
Accessories Pack	P00490-00	transfer bar M4	1
Accessories Pack	P00491-00	transfer bar M5	1
Accessories Pack	P00493-00	transfer bar M6	1
Accessories Pack	P00484-00	M3 transfer bar washer	1
Accessories Pack	P00485-00	M4 transfer bar washer	1
Accessories Pack	P00486-00	M5 transfer bar washer	1
Accessories Pack	P00487-00	M6 transfer bar washer	1
Accessories Pack	P00310-00	anvil M3	1
Accessories Pack	P00309-00	anvil M4	1
Accessories Pack	P00308-00	anvil M5	1
Accessories Pack	P00307-00	anvil M6	1
Accessories Pack	P00311-00	locknut	4
Accessories Pack	P00393-00	air flow adjuster	1
Accessories Pack	F00010-00	O-ring	1
Accessories Pack	F00011-00	O-ring	3
Accessories Pack	F00012-00	O-ring	1
Accessories Pack	F00106-00	O-ring	1
Accessories Pack	A00009-00	oil injector set	1
Accessories Pack	P09051-00	hook	1
Accessories Pack	P09052-00	wrench	1

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