LOBSTER®

NUT RIVETING HAND TOOL

Heavy Duty Use **HN-010**

"LOBSTER" BLIND NUT RIVETING PROGRAM

5M 6M 8M & 10M FOR ALUMINUM STEEL AND STAINLESS NUT-RIVETS

NEW

SIMPLE STROKE ADJUSTMENT BY MEANS OF AN ADJUSTER RING WITH MEMORY STROKE SCALE.

SPECIFICATIONS

STROKE : 0 - 8 mm (.315")
LENGTH : 460 mm (18-1/8")
WEIGHT : 1.8 kgs (4 lbs)

Aerofast Aust P/L
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Fax: +61 7 3299 4566
lobster@aerofast.com.au
for all Lobster Rivet Tools inquiries

THREAD CONVERSION KIT FOR SETTING UNC THREADED NUT RIVETS ARE AVAILABLE ON SPECIAL ORDER.

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HEAVY DUTY LEVER

RUGGEDLY BUILT, LONG LASTING TOOL SPECIALLY D
"ONE-OFF" JOBS, CAN HELP CUT YOUR PRODUCTI
COMPLETE INSTALLATION OF NUT RIVETS SIZES U

HN-010 WILL GIVE LONG SERVICE WITH MINIMUM CARE WHEN KEPT CLEAN AND IN PROPER ADJUSTMENTS ACCORDING TO THE INSTRUCTIONS WHICH FOLLOW. FAILURE TO FOLLOW THESE INSTRUCTIONS CAN RESULT IN REJECTED WORK AND/OR DAMAGE TO THE TOOL.

SELECTION OF PROPER NUT-RIVET

• DETERMINING THE 'GRIP RANGE'

Grip range is the calculated material thickness best suited to install the specific nut rivet. Each nut rivet will accomodate thickness of material between the minimum and maximum grip limits, as shown on the nut rivet engineering data

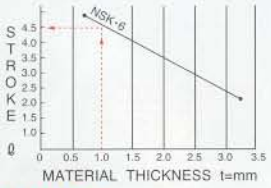
• MEASURING 'GRIP'=tmm

Measure with micrometer over all thickness of materials in which nut-rivets will be installed. These measurements must include air gaps, paints and any burrs that can't be removed.

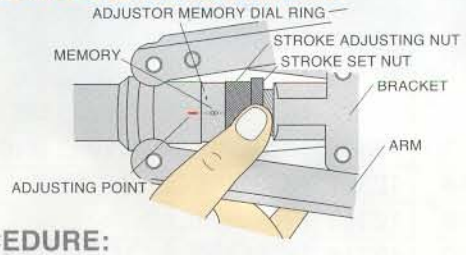
• DETERMINING THE AMOUNT OF STROKE REQUIRED

After knowing the nut-rivet size and material thickness t=mm, in which nut-rivet will be installed, find out the stroke (pull-up) length 'ℓ'=mm from the graph as shown:

EXAMPLE:
Suppose the nut-rivet used is 'LOBSTER' NSK-6M (steel) for the given material t=1.0mm, then the required stroke length will be 4.5mm.



TOOL STROKE ADJUSTMENT



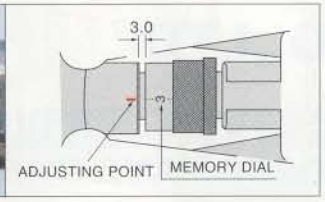
●SIMPLE STROKE ADJUSTMENT BY MEANS OF AN ADJUSTER RING WITH MEMORY STROKE SCALE.

PROCEDURE:

1. Loosen the stroke set nut by turning it in the counter clockwise direction.
2. Grip the two arms fully so that it touches the brackets.

GRIP THE TWO ARMS UNTIL THE FINAL STROKE ADJUSTMENT IS MADE.

3. Turn the stroke adjusting nut in the clockwise direction so that the '0' memory on the stroke adjusting ring coincide with the adjusting point. By doing so the stroke of the tool will become zero.



4. Further adjust the stroke adjusting ring from'0' position to the required stroke length. By turning it in the counter clockwise direction to adjust the memory dial.

Memory dial of HN-010 in one complete rotation has a stroke length of 1.0mm. In the first complete rotation follow the first memory line, in the second rotation follow the second memory line and so on.

EXCESSIVE STROKE MAY BREAK SCREW-MANDREL (PULL-UP STUD), STRIP RIVET THREADS OR BOTH. INADEQUATE STROKE MAY RESULT IN LOOSE INSTALLATIONS OR REJECTED WORK.

5. Tighten the stroke set nut and release the two arms and your tool is adjusted for the required stroke. And, is ready for upsetting the desired nut-rivet.

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HAND TOOL HN-010

ESIGNED WITH ALL THE "MIRACLE" TO CATER FOR
)N OVERHEADS ASSURES FAST, ACCURATE &
PTO M10 OR EQUIVALENT.

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SCREWMANDRELS & NOSEPIECES

(PULL-UP STUDS) (ANVILS)

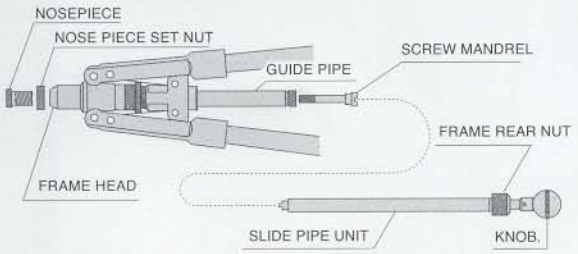
HN-010 is provided with 3-sets of screw mandrels (pull-up studs) and nose pieces (anvils) for sizes: M6, M8, M10, as standard accessories. However for M5 available on special order.

Check that the correct size screw mandrel and nosepiece are installed in the tool. If the screw mandrel and nosepiece are the wrong size or screw mandrel threads are torn or if it is desired to change to a different nut rivet size, proceed as follows:

• CHANGING SCREWMANDREL

Loosen the frame rear nut and drawout the slide pipe unit from the guide pipe. And, as you tilt the tool, the screw mandrel will drop out and change to conformed size.

To reassemble, position the slide pipe after changing the screw mandrel and tighten the frame rear nut.

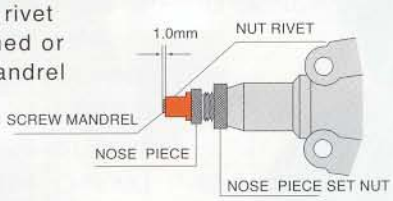


• CHANGING THE NOSEPIECE

Loosen the nosepiece set nut and nosepiece by turning it in the clockwise direction and change to conformed size.

NOSEPIECE ADJUSTMENT

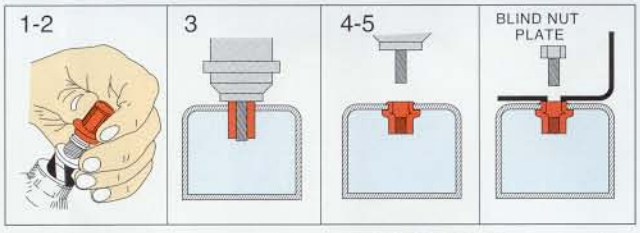
Loosen the nosepiece set nut and adjust the nosepiece so that the screw mandrel should extend 1.0mm more than the overall length of the nut rivet, this will engage all the threads of nut rivet. Nut rivet threads may be deformed or stripped if the screw mandrel does not engage all the threads in the nut rivet.



CHECK POINTS:

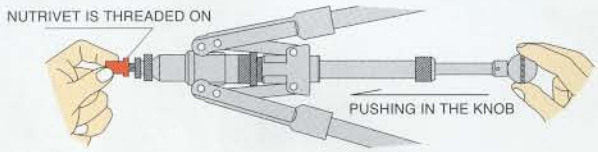
- Oil all the movable joints and parts.
- Check the threads of the screw mandrel. if torn, change to new one.
- If any dust on the threads of the screw mandrel, clean the threads with brush.
- Before using, must not forget to oil the threads of the screw mandrel, as this will increase the life of the screw-mandrel.
- In case, adjusting point does not coincide '0' position of the stroke adjusting memory dial ring, then adjust the collar (having marked adjusting point) with the help of plier.

OPERATION PROCEDURE

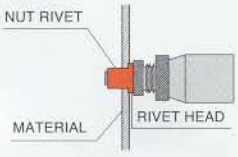


HN-010 is designed with new "QUICK-DRILL" mechanism for threading on and unthreading the nut rivets simply by pulling and pushing in the round knob grip.

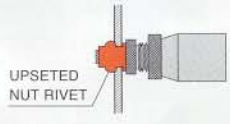
1. Just pull the round knob grip to its maximum, this rotates the screw mandrel in the counterclockwise and the nut rivet will not be threaded onto the mandrel.
2. Nut rivet is threaded onto screw mandrel of the tool for installation by simply pushing in the round knob.



3. Nut rivet on the tool mandrel is then inserted into the pre-drilled hole in the material for installation.



4. Just grip the two arms fully so that it touches the brackets. By doing so, the screw mandrel retracts and the threaded portion is pulled, forming a bulge in the unthreaded shank area of the nut rivet on the blind side.



5. And, pull back the round knob grip, the screw mandrel will rotate in the counterclockwise, unthreading itself from the upsetted nut rivet.

THE TOOL MUST BE HELD AT RIGHT ANGLE TO THE WORK UNTIL THE ENTIRE UPSET RETRACT CYCLE IS COMPLETED. FAILURE TO DO THIS RESULT IN EXCESSIVE SCREWMANDREL BREAKAGE AND/OR DAMAGED NUT RIVET THREADS.

DAMAGED NUT RIVET REMOVAL

Drill through the damaged nut-rivet head with the same size drill that drilled the original hole. The counter bore will act as a drill guide. A new fastener of the same size may now be installed in the hole.

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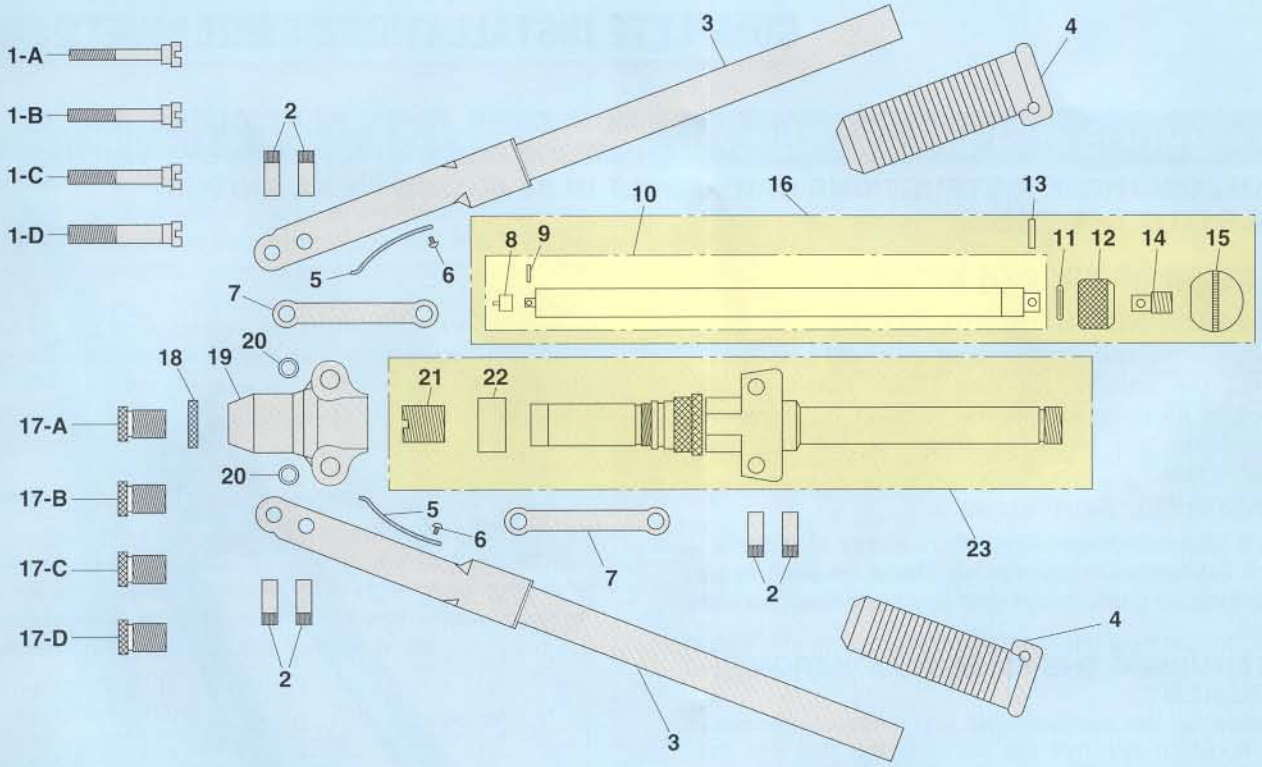
HN-010(B) PARTS LIST & EXPLODED VIEW



INDEX NO.	CODE	DESCRIPTION
HN10-01A	12806	SCREW MANDREL M5
HN10-01B	12326	SCREW MANDREL M6
HN10-01C	12330	SCREW MANDREL M8
HN10-01D	12331	SCREW MANDREL M10
HN10-02	12313	PIN
HN10-03	14521	ARM UNIT
HN10-04	12319	CUSHION GRIP
HN10-05	12316	ARM SPRING
HN10-06	11926	ARM SPRING SCREW(M3 X 6)
HN10-07	12312	LINK
HN10-08	11931	CONNECTOR
HN10-09	11932	SPRING PIN(2 X 8)
HN10-10	14528	SLIDE PIPE UNIT
HN10-11	10274	O-RING P-10
HN10-12	11938	FRAME REAR NUT

INDEX NO.	CODE	DESCRIPTION
HN10-13	10787	SPRING PIN (3 X 10)
HN10-14	11939	KNOB CONNECTOR
HN10-15	11945	KNOB GRIP
HN10-16	14532	SLIDE PIPE ASSEMBLY
HN10-17A	12805	NOSEPIECE (ANVIL) M5
HN10-17B	12320	NOSEPIECE (ANVIL) M6
HN10-17C	12327	NOSEPIECE (ANVIL) M8
HN10-17D	12328	NOSEPIECE (ANVIL) M10
HN10-18	14560	NOSEPIECE SET NUT
HN10-19	12342	FRAMEHEAD
HN10-20	12314	COLLAR
HN10-21	12340	FRAME FRONT PIECE
HN10-22	12338	SET SLEEVE
HN10-23	14529	BRACKET UNIT

(TOOL LEAVES THE FACTORY FITTED WITH M6 NOSEPIECE AND SCREW MANDREL)

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