"LOBSTER" BLIND NUT RIVETING PROGRAM

LIGHT DUTY LEVER HAND TOOL HND-005

LOBSTER®

SIMPLE TO USE AND RELIABLE, COMPACT LIGHT WEIGHT TOOL ESPECIALLY DESIGNED FOR PROTO-TYPE DEVELOPMENT USE ___. ALUMINUM DIE-CAST FRAME, HARDENED CHROME-VANADIUM STEEL HANDLE, PLASTIC GRIP WITH FINGER STOPS FOR A GOOD HAND-HOLD COMBINE PROFESSIONAL QUALITY, IN ADDITION THE PULL-OFF SLEEVE MAKE IT SIMPLE TO SPIN A RIVET ON TO THE MANDREL, WITHDRAWL OF THE TOOL AFTER SETTING IS DONE BY FLICKING THE PULL-OFF SLEEVE ANTI-CLOCKWISE. THIS BALANCED SPINNING MECHANISM MAKE THE HND-005 SUITABLE FOR DOWNWARD, HORIZONTAL AND OVERHEAD INSTALLATION OF NUTRIVET SIZES UP TO 6M OR EQUIVALENT IN ALUM-ALLOY.

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HND-005 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

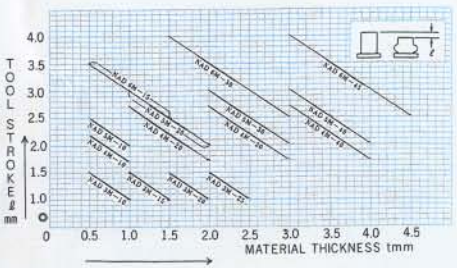
Grip range is the calculated material thickness best suited to install the specific nut rivet. Each nut rivet will accomodate thickness of material between the minimum and maximum grip limits, as shown on the nut rivet engineering data.

• MEASURING 'GRIP' = tmm

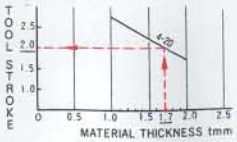
Measure with micrometer over all thickness of materials in which nut-rivets will be installed. These measurements must include air gaps, paints and any burrs that can't be removed.

• 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 4M-20 (aluminum) for the given material thickness 't' = 1.7mm, then the required stroke (pull-up) length 'ℓ' will be 2.0mm.
Thus 'ℓ' = 2.0mm is the amount of stroke required to set aluminum 4M-20 nut rivet in the material thickness of 't' = 1.7mm.



SCREWMANDRELS & NOSEPIECES

(PULL-UP STUDS) (ANVILS)

HND-005 is provided with 4-sets of screwmandrels and nose pieces of sizes: 3M, 4M, 5M and 6M as an standard accessory, along with spanner mounted on the handle plastic grip. Spare screwmandrels are housed in the cap on the pull-off sleeve, where as nosepiece are screwed on the tool body. Check that the correct size screwmandrel & nosepiece are installed in the tool and proceed as follows:

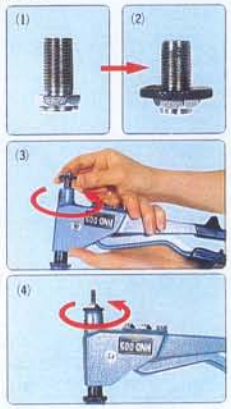
• INSTALLING SCREWMANDREL

1. Remove the cap on the pull-off Sleeve and Select the correct size Screwmandrel.
2. Open the Handles Fully and Grip the pull-off Sleeve Knob Hard.
3. Screw in the Screwmandrel Anticlockwise into the Piston through the nose of the Tool and Tighten with the Spanner.

N.B: The Spanner Flats on the Screw Mandrel Grooves lie outside the nose when the Handles are fully open, so that the Spanner may be used for unscrewing and tightening the Screwmandrel in the Piston, only after the Nose piece is removed.

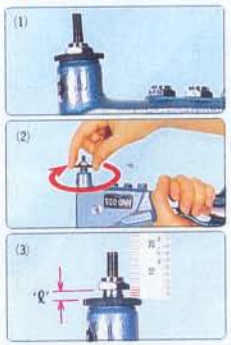
• INSTALLING NOSEPIECE

1. Select the correct Nosepiece.
2. Screw on the Stroke Set Nut over the Nosepiece and Check until fully Screwed.
3. Close the Tool Handle. Screw in the Nosepiece (Having Stroke Set Nut Screwed on) into the Nose Anti-Clock Wise, until Stroke Set Nut and Nosepiece Seats the Nose fully.
4. By doing so the Tools Stroke will become zero'0' The instruction on Tool Stroke control should be read at this point.



TOOL STROKE ADJUSTMENT

1. First set the Tool Stroke to zero as described in the "Installing Nosepiece" instructions.
2. After having Set the Tool Stroke to zero '0', turn the Stroke Set Nut Clockwise to Adjust the Stroke length 'ℓ'.
3. Hold firmly the Nosepiece and tighten the Stroke Set Nut Anti-Clockwise and your Tool is ready for use.



PRIOR TO INSTALL RIVETS, IT IS IMPORTANT TO CHECK TO SEE THAT THE STROKE SET NUT IS TIGHTENED AGAINST THE FRAME.

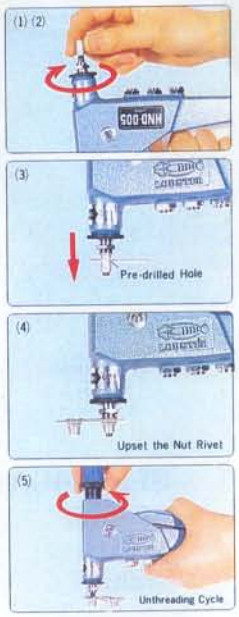
CHECK POINTS:

- Ensure that the correct Nosepiece and Screwmandrel is fitted to the Tool.
- Check the threads of the Screwmandrel, if turn, change to new one.
- If any dust on the threads of the Screwmandrel, Clean the threads with brush.
- Before using, must not forget to oil the threads of the Screwmandrel, as this will increase the life of the Screwmandrel.

OPERATION PROCEDURE

HND-005 is so designed that the pull-off Sleeve make it simple to spin a Nut Rivet on the Screwmandrel, withdrawl of the Tool after setting is done by flicking the pull-off Sleeve Anti-Clockwise.

1. Open handle fully and place the flange of the Nut Rivet over the Screwmandrel.
2. Nut Rivet is threaded onto Screwmandrel of the Tool by spinning the pull-off Sleeve knob Clockwise or as simple as screwing the nut rivet over the mandrel directly.
3. Nut Rivet on the Tool Mandrel is then inserted into the pre-drilled hole in the material for installation.
4. Just squeeze the handle fully and the Screwmandrel 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 flick the pull-off Sleeve anti-clockwise for unthreading 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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