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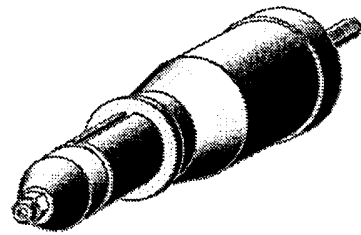
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ANDREA

GB *Operating Instructions*
Instrucciones de uso
Bedienungsanleitung
Notice d'utilisation
Istruzioni d'uso

RiveDrill

E95H



Blind Riveting Attachment
Dispositivo para remachar
Blindniet-Vorsatzgerät
Adaptateur riveteuse pour rivets aveugles
Adattatore per rivetti ciechi

According to the square of capacity for materials of the figure C1.

The size of blind rivet must be agreed with the minimum length 4mm (5/32") and maximum length 10 mm (3/8"), figure C2 and C3. This size is needed more than the length of the thickness is wished to be rivetted correctly, if not the rivetting will be worse and RiveDrill will be able to be worse too.

Figure D. Rivetting. Prepare the drill to turn to the right. Introduce the head of the blind rivet completely in the hole of the parts have to be joined, figure D1. While the drill is started to the right, Rivedrill must hold strongly with the hand on the telescopic body 5, figure D2. Stop the drill when the rivet has been fixed and the mandrel of the blind rivet has been broken. Caution The reaction in the hand that hold the RiveDrill can be increased depending on the material and the size of the blind rivets is been used.

Figure E. Expel the mandrel of the RiveDrill. Turning to the left and incline the RiveDrill to left the mandrel of the rivet falls while the RiveDrill is hold with the hand so that do not turn. Keep the drills turning to the left until the clack, clack, is listened that indicates the initial position with the hole control 4 closed to be prepared for the next blind rivet. Before inserting a new blind rivet make sure that the previous mandrel has been expelled.

MAINTENANCE AND CLEANING.

Figure F. The jaws must be cleaned and lubricated from time to time and remove the dusty material that could be deposit.

If the machine should happen to fail despite an authorized customer services agent for MAQUINAS ANDREA power tools should carry out the care taken in manufacture and testing, repair. For spar parts requirement you may use the piece number of the Figure F.

BREAKDOWN, CAUSES AND SOLUTIONS

☛ If the rivet doesn't enter. Possible solution, the nosepieces 14, 15 or 16, Figure F is not chose correctly. Change the nosepiece. Possible mandrel of the blind rivet inside of RiveDrill. Before to be continued, dismount RiveDrill and expel the mandrel. Possible jaw 5, figure F with defect. Disassemble and change it.

☛ The blind rivet is in but it doesn't work. Possible mechanism in position as figure B3. Act to work as position B2. Possible that the mandrel of the blind rivet is too short. Check the sizes as C4. Possible that the jaws are wearing or break. Clean or change it.

☛ RiveDrill set the rivet but does not expel the mandrel. Possible solution, the nosepieces 14, 15 or 16, Figure F is not chose correctly. Change the nosepiece. Possible that the jaws are wearing or break. Clean or change it. Possible than the mandrel is to thik. Check the rivet sizes C4.

GUARANTEE.

For this MAQUINAS ANDREA machine, we provide a 6-month guarantee against material and workmanship defects from the date of purchase (verified by invoice or delivery document) Damage that has occurred will be corrected by replacement or repair. Damage caused by normal wear, overloading or improper handling is excluded from the guarantee. Claims can only be accepted if the device is sent without having been disassembled, to a MAQUINAS ANDREA branch office, your MAQUINAS ANDREA sales representative or a customer service agent for MAQUINAS ANDREA power tools.

DECLARATION OF CONFORMITY.

Declaration of the manufacture according to 93/37/EC.

This product has been designed exclusively for being built into another machine, or mounted onto another machine or other machines. It is forbidden to put this product into operation before the conformity of the final product with the provisions of the regulation 98/37/EC has been fulfilled. The conformity is fulfilled, for example, if is this accessory is driven by a MAQUINAS ANDREA power tool according to the operating instructions or the pictogram instructions on the packing.

CE 09 MAQUINAS ANDREA

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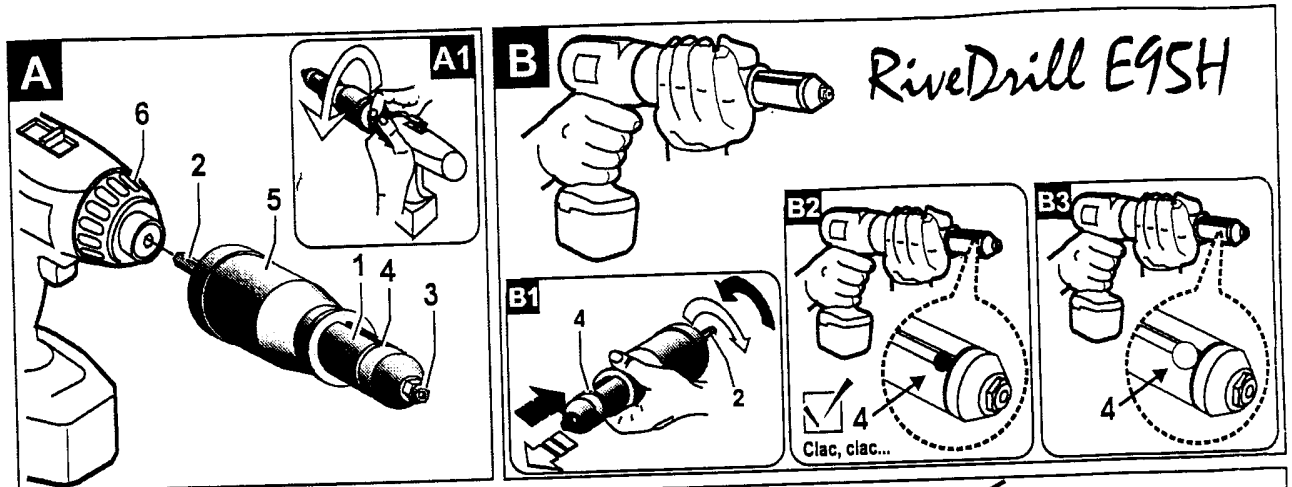
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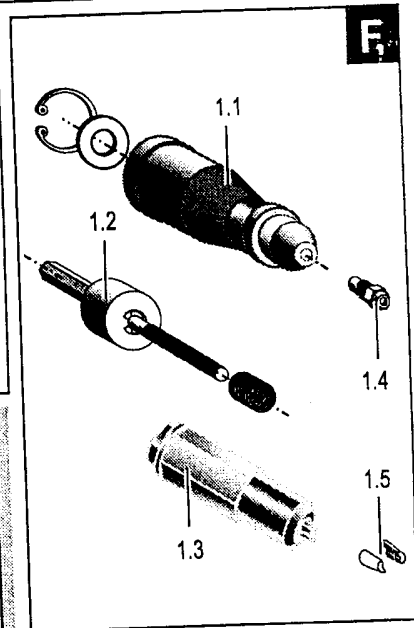
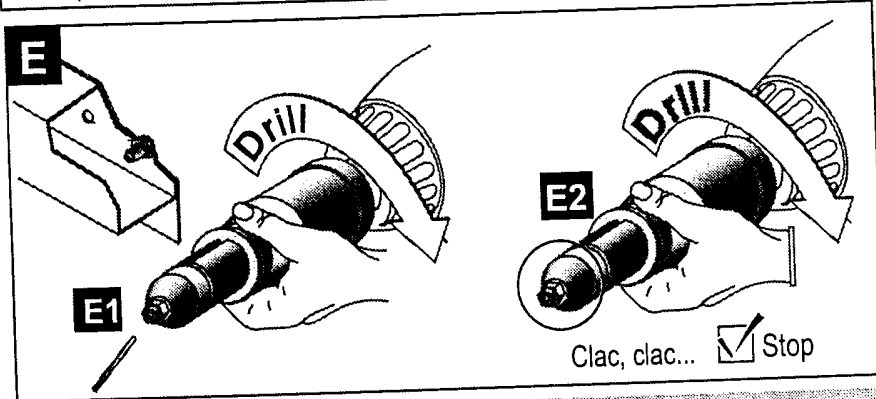
C Shows diagrams C1, C2, and C3. C2 and C3 show depth markings: $>4mm$ and $<10mm$. C1 shows a rivet with diameter $\varnothing D$.

Rivet $\varnothing D$	3,2mm	1/8"	4,0mm	5/32"	4,8mm	3/16"
Aluminum	✓	✓	✓	✓	✓	✓
Steel	✓	✓	✓	✓	✓	✓
Stainless steel	✓	✓	✓	✓	✓	✓

C4 Shows a rivet with diameter $\varnothing M$, length L , and tool diameter $\varnothing D$.

$\varnothing D$	$\varnothing M$	L
3,2mm	$>1,8mm$	$>26mm$
1/8"	$<2,4mm$	$<31mm$
4,0mm	$>2,0mm$	$>26mm$
5/32"	$<2,2mm$	$<33mm$
4,8mm	$>2,7mm$	$>29mm$
3/16"	$<2,8mm$	$<34mm$

D Shows diagrams D1 and D2. D1 shows the tool being used to drill a hole. D2 shows the tool being stopped, with a checkmark and the text "Stop".



G Shows diagrams 3, 4, and 5. 3 shows a nozzle with diameter $\varnothing 3,2mm$ / $\varnothing 1/8"$. 4 shows a nozzle with diameter $\varnothing 4,0mm$ / $\varnothing 5/32"$. 5 shows a nozzle with diameter $\varnothing 4,8mm$ / $\varnothing 3/16"$.

Changing nozzles.
 1° Open the hole control, operating to the right the engine.
 2° Change nozzle and close the hole control by operating the engine to the left.
IMPORTANT. Never remove the nozzle with the hole control being closed, because the pressure of the jaws makes it very difficult to replace the new nozzle. Without the nozzle the riveter does not work.



FOR YOUR SAFETY

Working safely with this machine is possible only when the operating and safety information are read completely and the instructions contained there in are strictly followed.

Attention with the reaction of the hand that hold the RiveDrill. Release RiveDrill if the reaction is strong.

- ☐ In order to ensure that the machine functions safely, only use the blind rivets listed in the specifications together with the correctly matching nosepiece (nozzle) and with size are showed in the Figure C.
- ☐ High forces can occur during the working procedure, use grooves in the hand that the RiveDrill is hold, and therefore hold RiveDrill tool firmly. Do not use bracelets or other objects that can be hooked.
- ☐ Use only original ANDREA parts and accessories.

TOOL SPECIFICATION

Stroke (run) (without rivetting), 29 mm, (9/8")
 Maximum stroke (run) allowed in load (rivetting) 10 mm, (3/8")
 Maximum torque of entrance allowed, 8 Nm (70 Lbf.in)
 Aprox weight 280 g.
 Aprox length 141 mm
 Diameter, 60 mm
 Hex drive shank 8 mm (5/16").
 Included nosepieces (nozzles) 3 units for blind rivets of:
 3,0 mm 3,2mm 1/8"
 4,0 mm; 5/32"
 4,8 mm; 3/16"
 Capacity to rivet:
 The safety sizes for blind rivets must be observed in the graphic Figure C1, about diameter and material of blind rivets aluminum, steel or stainless steel.

USE AS INTENDED

- The device has been designed to be attached to a reversible drilling machine, reversible, cordless drill (12 vol. or more), to set blind rivets.
 - ☐ The rivet is fixed in a single action.
 - ☐ The mandrel of the rivet should be inserted completely in the RiveDrill.
 - ☐ Before insert the next rivet in the RiveDrill be sure to expel the mandrel before.
 - ☐ For damage caused by usage other than intended, the user is responsible.

OPERATING CONTROLS.

Figure A. The accessories described in the book instructions, are not always included in the given unit.

- 1 RiveDrill.
- 2 Drive Shank

- 3 Nosepiece.
- 4 Hole Control.
- 5 Telescopic body
- 6 Drilling machine
- 7 (Figure C) Blind Rivet
- F1 (Figure G) Fixing to be used with electric drill. Optional
- F2 (Figure H) Fixing to be used with battery drill. Optional
- SC (Figure SC) Small case. Optional

INITIAL OPERATION.

Figure A. Mounting of RiveDrill. Insert the drive shank 2 into the chuck of the drill and tight strongly, Figure A1. Covert the chuck of drill with the telescopic body of RiveDrill, 5

Figure B. Working procedure. RiveDrill is hold with the hand by the telescopic body 5 to not turn; figure B. RiveDrill transform the rotatory movement, that is coming by the drive shank 2 Figure B1, from the drill, in a lineal movement that open or close the hole control 4, figure B1. When the drill turns to the right or to the left, the inside mechanism of RiveDrill advances toward, setting the rivet or backward expelling the mandrel respectively. Looking at the figure. B1 the black arrows are showing to open the hole 4, the white arrow is showing to close the hole 4. In the end and beginning, in both ways, after 29 mm, is listened the sound clack, clack.

Try the movement without rivet.

- ☐ **Turning to the right, figure B2.** Looking at how the hole control 4 is closed and listen the clack, clack,
- ☐ **Turning to the left, figure B3.** Looking at how the hole control 4 is opened and after 29 mm, is listened the clack, clack,

Initial position to start to set a rivet. Changing nozzles (Fig. G)

The hole control 4 must be closed, like in the figure. B2. If the hole 4 is open, like in the figure B3, close the hole 4 turning on to the left the drill until hearing clack, clack....

USE

Figure C. Insert the blind rivet It. Insert the blind rivet 7, figure C, completely into the RiveDrill, with the Drill stopped. Caution. Don't use blind rivets with different sizes and materials that are indicated in figure. C1. Choose one of the nosepiece supplied (standard delivery) to fit the diameter of the blind rivet to be applied. If the RiveDrill is used with a nosepiece inadequate it may cause that it works deficiently. Check the blind rivet that the measures of the mandrels of the blind rivet are between the minima and the maximum of the chart of measures of the figure C4. Check the blind rivet that the hardness of the material of the blind rivets are inside of the capacity of the RiveDrill