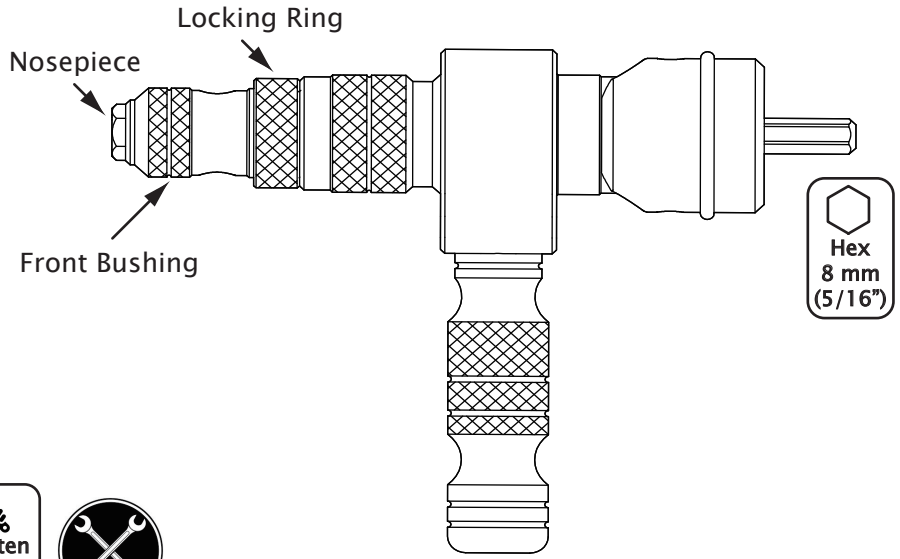
User's Manual

B-RA60282 - BATO 60282

Blind Rivet Drill Adapter



Tighten All Parts Securely

1. Tighten **FRONT BUSHING** into **HANDLE HOUSING** securely.
2. Tighten **NOSEPIECE** into **FRONT BUSHING** securely.
3. Tighten **LOCKING RING** with **HANDLE HOUSING** securely.

WARNING

Read User's Manual before Use!

WARNING

Read and understand User's Manual before use, and always give it to user.

SWIVEL

WARNING!

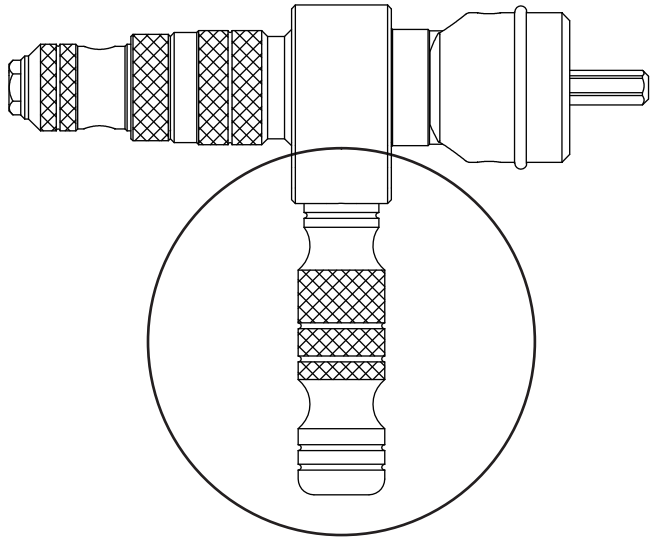
Side Handle may swivel and hit any object within its spin, including hand. Hold Side Handle & Drill Firmly at any time drill is driving the adapter. Always drive adapter in low speed.
In any emergency, power off drill immediately!

CAUTION!

Continuous uses will significantly heat up the main body.
Caution on HOT SURFACE.

TORQUES WARNING

When riveting, both hands need to hold drill & side handle firmly to withstand torques in counter directions. For better control of riveting operations and for safety, REQUIRED to drive the adapter in low speed <20 RPM all the time, and the lower the better.
In any emergency, power off drill immediately.



Side handle gets assembled in loosing fit with main body and it is not detachable. Take note that the clearnace between main body and side handle is a design feature.

1. Preparation Instructions:

1.1 For safety, wear adequent ANSI approved rubber coated thick glooves, safety goggles and else needed personal protective equipment(s);
1.2 Install blind rivet drill adapter onto drill's chuck and lock it tightly;
1.3 Switch drill to low speed mode and gear up to its max torque;
1.4 Check and make sure rivets to be used does not exceed Y limit;
1.5 Check and make sure nosepiece is correct and tightened securely;
1.6 Power drill meets and or exceeds recommended min torque supply:

CRITICAL!

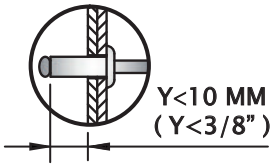
Min Torque Supply Reference Table
(Torque measured in low speed < 20 RPM)

Blind Rivet Size	in Material	Recommended Drill's Min Torque Supply (N.M)	Recommended Drill's Min Torque Supply (lbf.ft)
6.4 mm (1/4")	Structural	22	16.225
	Steel/Steel	17	12.5375
6.0 mm (7/32")	Steel/Steel	16	11.8
	Aluminum/Steel	12	8.85
4.8 mm (3/16")	Structural	14	10.325
	Stainless/Steel	12	8.85
4.0 mm (5/32")	Stainless/Steel	10	7.375
	Steel/Steel	9	6.6375
3.2 mm (1/8")	Stainless/Steel	7	5.1625
	Steel/Steel	6	4.425
2.4 mm (3/32")	Stainless/Steel	4	2.95
	Steel/Steel	3	2.2125

Note: Above data recorded on the basis of manufacturer's lab test, for reference only. Use power drill with higher torque supply than Drill's Min Torque Supply.

WARNING! DO NOT USE IMPACT DRIVER AS DRIVING TOOL!

WARNING! The objects to be riveted MUST be all time securely fixed!



CRITICAL!

**The rivet drill adapter has stroke limit < 21 mm.
REQUIRED to check and ensure Y less than limit 10 MM (3/8").
It is not allowed to run the adapter in any case of Y>10 MM.**

2. Operation Instructions:

**CRITICAL! Switch drill to low speed mode and manipulate its running rotation speed < 20 RPM. Low speed for better control of drill & riveting adapter, and for better fastening quality.
In any emergency, power off drill immediately!**

IMPORTANT!

In case of stuck spent mandrel, shake to clear the jam.
Refer to SECTION "3. Trouble-Shooting" for more information.

IMPORTANT!

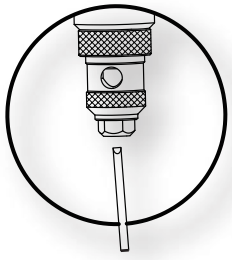
Tighten all parts securely in position at any time when changing spares and or any loosing occurs. Loosing part(s) may result in stuck spent mandrel and or function failure of the tool.

2.1 Insert blind rivet into pre-bored hole;
2.2 Drive blind rivet adapter to send inner plunger to front most postion and align it straightly to take mandrel. Push to have nosepiece pressure contact with rivet shank;
2.3 Reverse power drill's rotation and hold **Side Handle & Drill Firmly**, trigger to run drill in low speed < 20 RPM until mandrel pulled off;
2.4 Guide nosepiece down to ground then reverse drill's rotation to release spent mandrel. In case stuck spent mandrel happens, refer to SECTION "**3. Trouble-Shooting**" for more information.

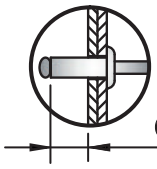
2.1

2.2

2.3



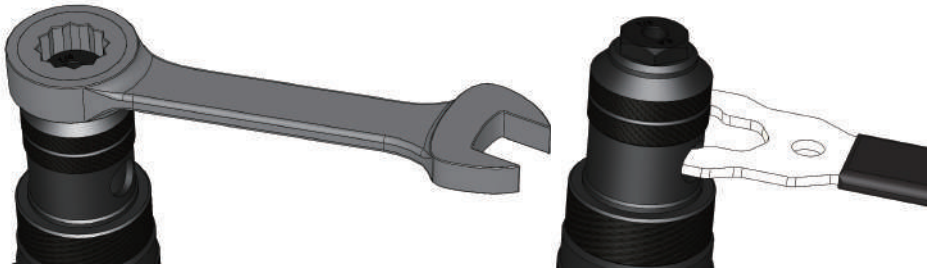
2.4



3. Trouble-Shooting:

Issue	Possible Causes	Solutions
Stuck spent mandrel	Loosing nosepiece	Tighten nosepiece with wrench included in the kit. Loosing nosepiece could possibly result in spent mandrel jam and or tool's failure. Check and make sure it is tightened into main body securely before every use.
	Loosing front bushing	Tighten front bushing in position with wrench, then tighten locking ring. Loosing front bushing could possibly result in spent mandrel jam and or tool's failure. Check and make sure it is tightened into main body securely before every use.
	Defect nosepiece	Replace to use one size up nosepiece in the stead.
	Oversized rivet	If the rivet size is smaller than 6.4 mm (1/4"), change to use one size up nosepiece than current, then shake the spent mandrel out. Make sure nosepiece & front bushing are tightened together into main body securely, drive plunger to front most position there the adapter emits sound and then shake to dump the spent mandrel.
	Deformed or contaminated mandrel	Repeat releasing operations and try to shake out the stuck spent mandrel, or change to use one size up nosepiece if applicable then shake to dump the stuck mandrel. In case "shake" does not work, use 17 mm wrench or adjustable wrench to loosen jaws case to clear the jam. Need to do it carefully because inside plunger tubing contains pre-loaded spring. Remember to tighten all parts back right and securely.

4. Maintenance:

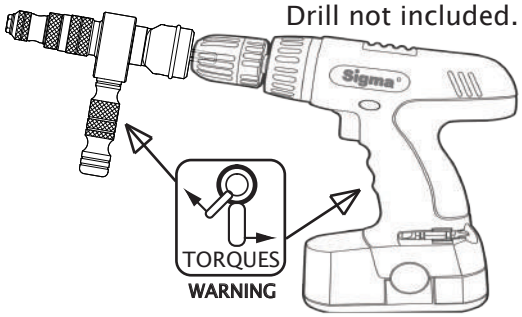


Tighten all parts securely in position at any time when changing spares and or any loosing occurs. Loosing part(s) may result in stuck spent mandrel and or function failure of the tool.

Recommend cleaning and replenishing #2 Lithium grease (working temperature -20~120°C) for transmition system every 2,000 pops or earlier.

5. Operation Diagram

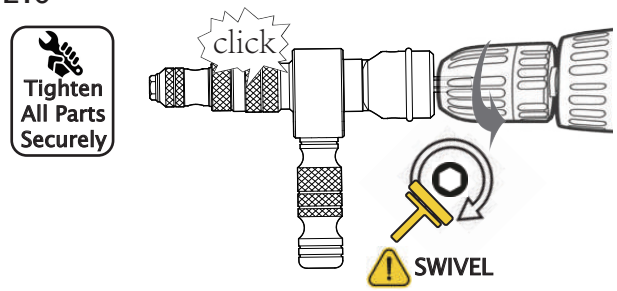
Drill not included.



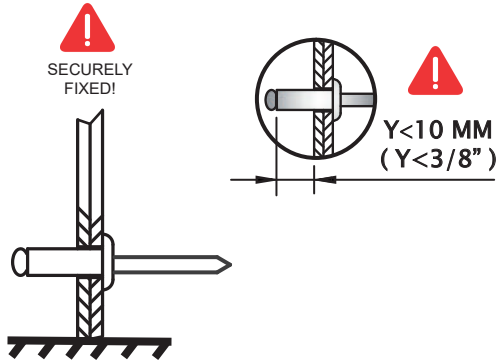
CRITICAL!

Refer to Section 1.6 for "Drill's Min Torque Supply" for the blind rivet to be used.

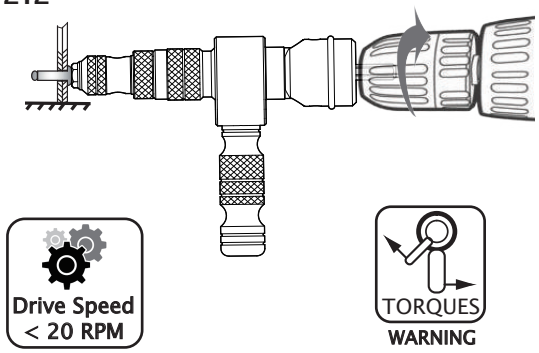
2.0



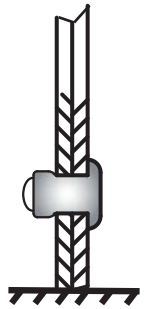
2.1



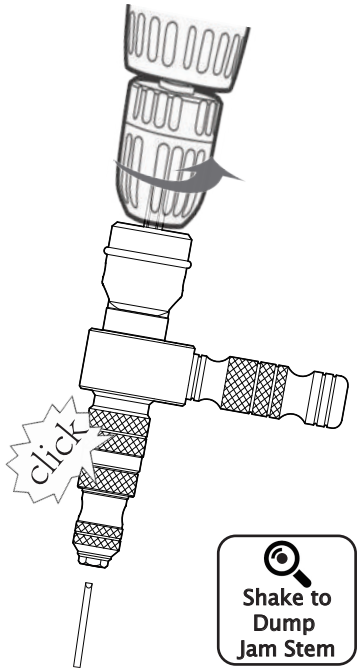
2.2



2.3

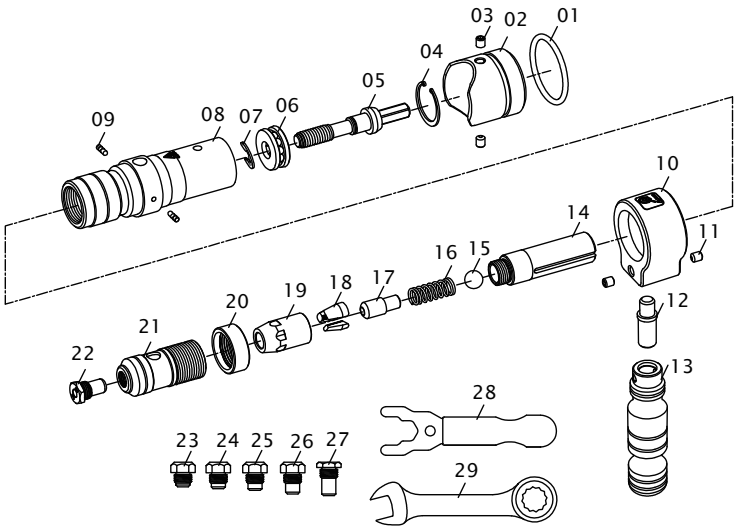


2.4



Refer to Section "2. Operation Instructions" for more detailed information.

6. Explosion & Part List



No.	Description	QTY
01	O-ring	1
02	Rear Housing	1
03	Set Screw	2
04	C-clip	1
05	Hex Drive Shaft	1
06	Thrust Ball Bearing	1
07	E-clip	1
08	Handle Housing	1
09	Insert Pin	2
10	Side Handle Case	1

11	Side Handle Set Screw	2
12	Insert	1
13	Side Handle	1
14	Inner Tube	1
15	Steel Ball	1
16	Spring	1
17	Plunger	1
18	Jaw	3
19	Jaw Case	1
20	Locking Ring	1
21	Front Bushing	1

22	6.4-1/4" Nosepiece	1
23	2.4-3/32" Nosepiece	1
24	3.2-1/8" Nosepiece	1
25	4.0-5/32" Nosepiece	1
26	4.8-3/16" Nosepiece	1
27	6.0-7/32" Nosepiece	1
28	Simple Wrench	1
29	Ratchet Wrench	1