

OPERATING INSTRUCTIONS

HAND TOOL FOR BLIND RIVET NUT M5-M12

TIOS HN12 R



TECHNICAL INFORMATION

Capacity: Blind rivet nuts M5–M6–M8–M10–M12
Material: Aluminium, Steel and Stainless Steel
Size: 210 (L) x 180 (H) x 40 (P) mm
Weight: 1,82 kg

DESCRIPTION OF THE TOOL

1. Tool body
2. Front and back lever
3. Turning knob
4. Mandrel M12
5. Anvil M12
6. Counter lock nut
7. Stroke indicator
8. Ratchet switch
9. Lever extension system



INSTRUCTIONS

The hand tool will be standard equipped with the M12 anvil and M12 mandrel. The other components will be stored separate in the carton box.

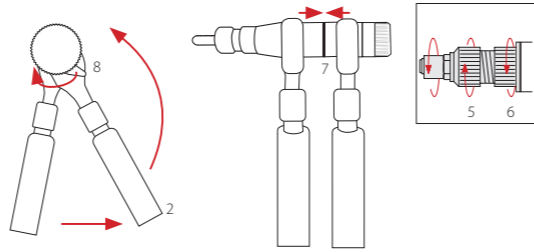
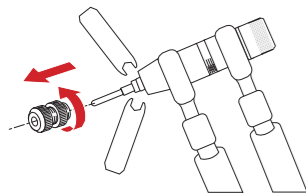
FIRST USE:

Make sure before using the tool that the anvil and mandrel are suitable for the thread of the insert to be used. Otherwise change to a different size.

CHANGE TO A DIFFERENT SIZE:

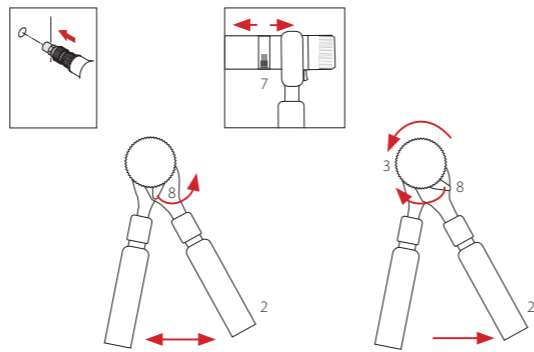
Unscrew the anvil (5) and the lock nut (6). Use the two spanners in the carton box to unscrew the mandrel (4). Please note that the mandrels have **left-handed thread**. To unscrew turn the mandrel clockwise. Replace it by choosing the correct size from the spare parts in the carton box and turn counter clockwise to fasten.

A



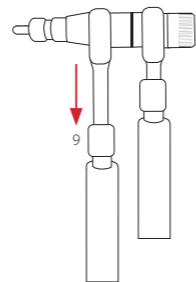
B

ANVIL ADJUSTMENT:
 After changing to a different size at A, it is necessary to adjust the anvil (5) and its counter lock nut (6). Put the tool in its starting position by pushing the ratchet switch (8) to the left and turn the back lever (2) counterclockwise until the stroke indicator (7) is invisible. The tool body is now in starting position. The protrusion of the mandrel out of the anvil must be as long as the whole rivet nut. Unscrewing the counter lock nut (6) to adjust the anvil (5) by turning left or right, to increase or decrease the length. After the correct length is applied, screw the counter lock nut until it is tight.



C

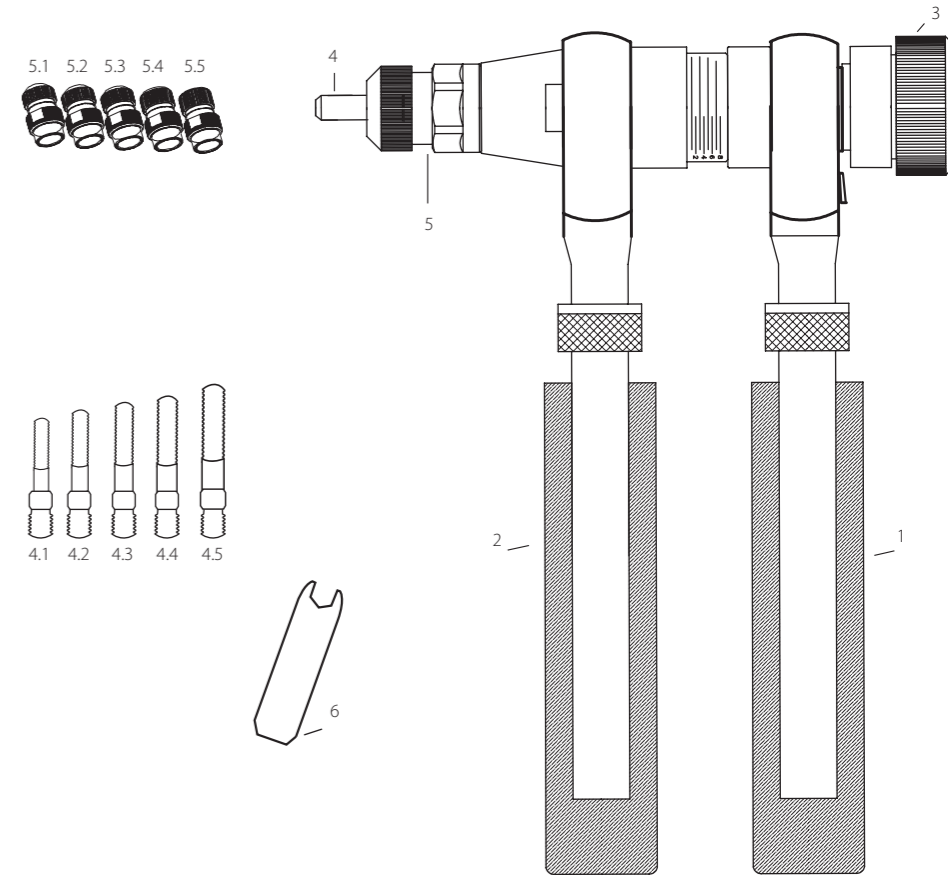
SETTING A THREADED INSERT:
 Put the tool in start position by pushing the ratchet switch (8) to the left and turn the back lever (2) counterclockwise until the stroke indicator is invisible. Screw the insert on the threaded end of the mandrel and insert it into the hole of the material. The hole size must be slightly larger than the rivet nut, check the drill specifications of the rivet nut. Push the ratchet switch (8) to the right and open the levers (2) for one third till you hear the ratcheting sound of the mechanism, then close the levers completely. Repeat these steps to clamp the rivet nut into the material tightly. The tool body is now extended and the stroke indicator (7) visible for checking the correct stroke. After the rivet nut is set, push the ratchet switch (8) to the left and turn the back lever (2) one time counterclockwise, this will release the threaded insert. Unscrew the insert, by using the turning knob (3) on the back of the tool.



D

EXTENDING THE LEVERS:
 When working with (stainless) steel threaded inserts the workingload of the tool can be lowered by extending the levers. The extended levers creates a bigger power ratio and makes it much lighter to clamp the stronger material threaded inserts. Push the lever extension system (9) down to unlock and slide the lever down till the right position. In case of a small and narrow working area you can choose to extend only the front or back lever.

Note: The levers can get stuck when too much force or speed is applied during extension of the levers.



Drawing no.	Item code	Description	Qty
1	04ASN12R101	Black grip for ASN12R Q-tool	1
2	04ASN12R102	Red grip for ASN12R Q-tool	1
3	04ASN12R103	Turning knob for ASN12R Q-tool	1
6	04ASN12R104	Spanner for ASN12R Q-tool	2
4.1	04ASN12R122	Mandrel M5 for ASN12R Q-tool	1
4.2	04ASN12R123	Mandrel M6 for ASN12R Q-tool	1
4.3	04ASN12R124	Mandrel M8 for ASN12R Q-tool	1

Drawing no.	Item code	Description	Qty
4.4	04ASN12R125	Mandrel M10 for ASN12R Q-tool	1
4.5	04ASN12R126	Mandrel M12 for ASN12R Q-tool	1
5.1	04ASN12R142	Anvil complete M5 for ASN12R Q-tool	1
5.2	04ASN12R143	Anvil complete M6 for ASN12R Q-tool	1
5.3	04ASN12R144	Anvil complete M8 for ASN12R Q-tool	1
5.4	04ASN12R145	Anvil complete M10 for ASN12R Q-tool	1
5.5	04ASN12R146	Anvil complete M12 for ASN12R Q-tool	1