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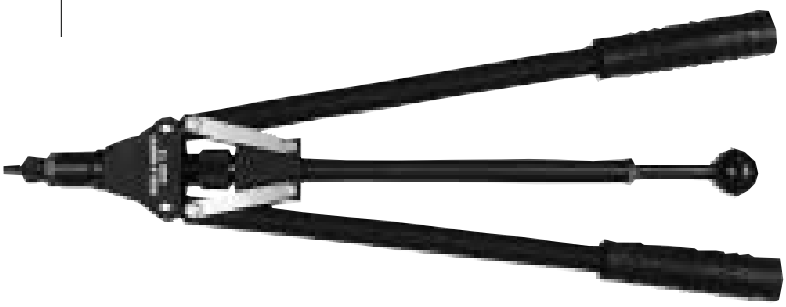
BRK 10
Double Lever Type Hand Tool



The BRK 10 is a double lever type hand tool that is stroke distance controlled by means of an adjustable stop. Once the stroke distance is set the tool will install the Rivnut® or Rivstud® in a single thickness material. The tool also features a plunger rotation knob for spin on and spin off of the product.

Installation Sequence

- Retract the plunger knob fully and hold the threads of the Rivnut® against the tool mandrel.
- While holding the Rivnut® steady push the plunger in threading the Rivnut® onto the tool mandrel with the Rivnut® head against the tool anvil nose piece.
- Place the Rivnut® into the hole and squeeze the handles of the tool together until the mechanical stroke stop of the tool is reached.
- Pull the plunger from the tool unthreading from the installed product.

Operation

Tool for setting a range of blind rivet nut sizes. Fastener is spun on to mandrel and withdrawn after setting, by push-pull lever. Stroke adjustment by means of a mechaincal stop. Rate of setting: 1 to 5 pieces per minute - Weight: 1,900 g. The hand tool is supplied complete with nosepieces and mandrels to suit M5, M6, M8, M10.

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INTRODUCTION

The BRK10 rivet nut setting tool is designed to set rivet nuts of sizes M5, M6, M8, and M10 (in steel). Little maintenance is necessary: just keep it clean and use the proper setting stroke.

INSTALLING THE MANDREL AND ANVIL [Fig 1]

The BRK10 tool is supplied with a box containing M5, M6, M8, and M10 mandrels and anvils; as well as one locking pin. Make sure that the anvil and mandrel chosen correspond to the rivet nut being set. If this is not the case, change them as follows:

- Unscrew the anvil
- Pass the locking pin through the hole located on the tool body to prevent rotation of the threading mandrel
- Unthread the mandrel with the wrench provided (turning counter-clockwise)
- Thread in the new mandrel while preventing rotation with the locking pin
- Remove the nut and thread it onto the new anvil
- Screw on the anvil and tighten with the nut

HOW TO ADJUST THE STROKE [Fig 2]

1. Close the two levers (tight against the body) and keep them in this position until the end of the adjustment.
2. Turn the knurled adjustment wheel so that it stops against the lower body: the stroke is then set to zero.
3. Turn the knurled adjustment wheel until the desired stroke is achieved. One turn of the ring corresponds to a stroke of 1mm. You can use the wrench provided to check your adjustment.

TOO MUCH STROKE RISKS BREAKING THE MANDREL AND/OR TEARING OUT THE RIVET NUT THREADS. NOT ENOUGH STROKE CAUSES INSUFFICIENT SETTING AND POOR PERFORMANCE OF THE RIVET NUT.

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ADJUSTMENT OF THE ANVIL [Fig 3]

1. Loosen the nut
2. Begin with the tool in maximum adjustment, as carried out previously
3. Adjust the anvil to length of the nut as indicated on the drawing
4. Tighten by using the nut

INSPECTION

- Lubricate all moving parts regularly
- Check the condition of the mandrel threads, if necessary change the mandrel
- If the threads of the mandrel are clogged, clean them with a brush
- Before and during use, lubricate the mandrel threads; this will prolong its life
- A rivet nut threaded onto the end of the mandrel effectively protects it from damage during periods of non-use

USE

- Push apart the two levers to their maximum travel
- Pull back on the center ball
- Put the rivet nut on the front of the mandrel and push in on the center ball so that the mandrel threads completely into the rivet nut
- Place the rivet nut in the workpiece
- Setting is carried out by squeezing the two levers until they contact the lower tool body
- Pull back on the center ball to release the mandrel

DURING ALL OF THESE OPERATIONS THE TOOL MUST BE KEPT PERPINDICULAR TO THE WORK OR THERE WILL BE A RISK OF BREAKING THE MANDREL AND/OR DAMINGING THE THREADS OF THE RIVET NUT.

Note: To remove a defective nut, drill with a diameter equal to the installation hole. A new fastener can then be set in place.

REPLACEMENT PARTS

Kit containing M5 mandrel and anvil: 2351 2005 001
Kit containing M6 mandrel and anvil: 2351 2006 001
Kit containing M8 mandrel and anvil: 2351 2008 001
Kit containing M10 mandrel and anvil: 2351 2010 001

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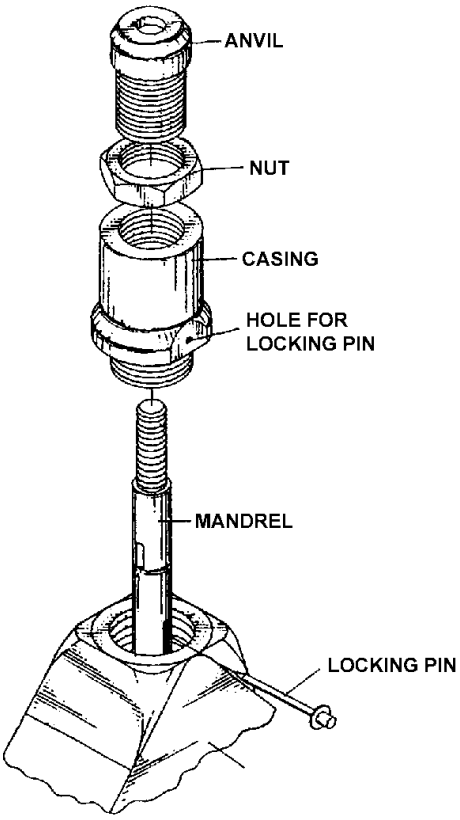

FIG. 1

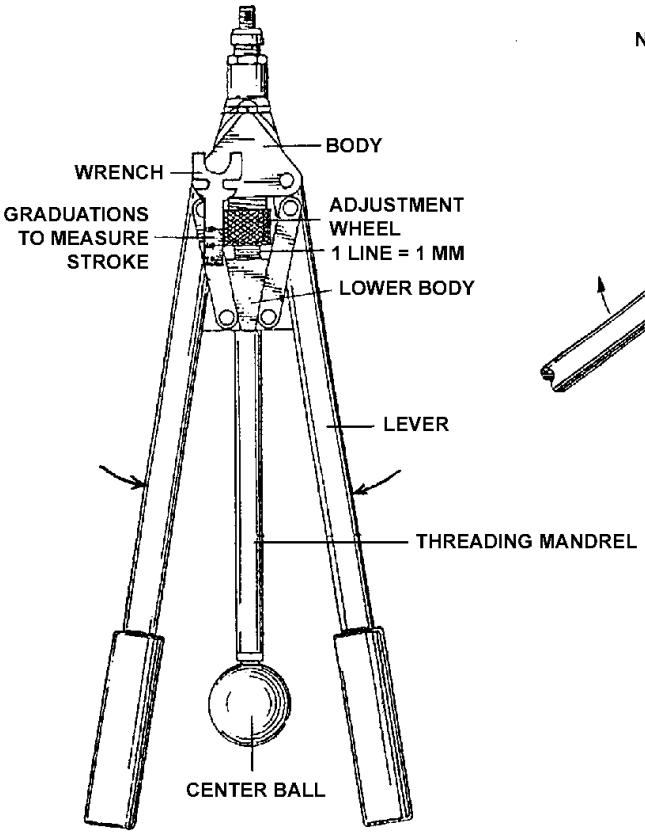

FIG. 2

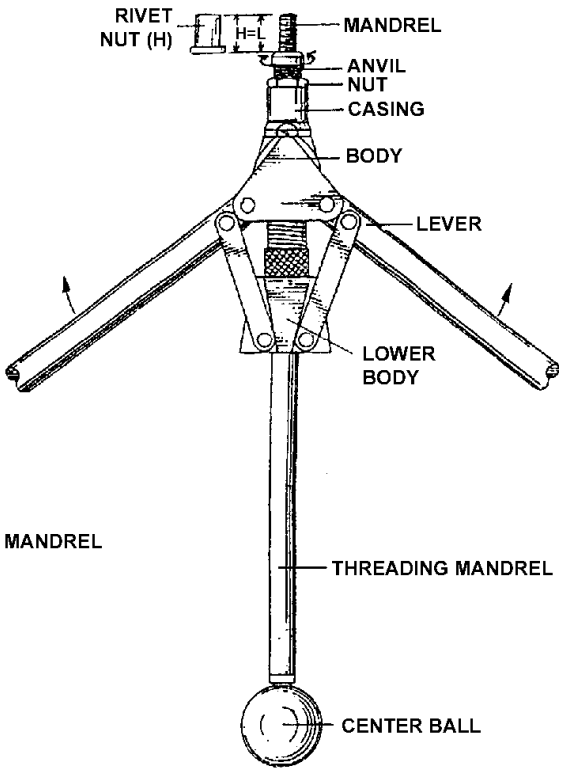

FIG. 3