



MAINTENANCE/OPERATING TIPS

TA-RivdomEVNG2 BATTERY Nut Insert Tool

Here are some handy maintenance/operating tips to help with the investment you have made in your tooling, to ensure its best operating life and minimise valuable down time.

Before performing any maintenance, firstly remove the battery from the tool.

- **Choosing the correct sized nose assembly:** Remove battery. Choose the appropriate nose assembly to suit the thread size of the nut insert that you wish to install. The changing of nose assembly size is a tool-free procedure. Firstly, remove the mouthpiece/anvil, then the union nut and front sleeve. Once removed, you can then remove the mandrel by pulling down on the safety slide against the spring, then unwind the threaded sleeve anticlockwise to remove. Reassemble the correctly chosen nose assembly by inserting the mandrel, then screw on the threaded sleeve clockwise by hand only until the last tooth of the tension sleeve engages on the safety slide (do not pull the safety slide). Fit the front sleeve and union nut (hand tighten only clockwise). Screw on the Mouthpiece/anvil (hand tight only) to the front sleeve. Reinstall the battery.

ATTENTION: Never use tools to change a threaded mandrel or threaded sleeve.

- **Adjust the setting force or stroke for the first time:** To turn the tool on, firstly press the trigger once. On the coloured LED screen you will see information relating to the current setup, press the OK button for 2 seconds, then enter your 4-digit pin code. Press OK & you will get into the main menu. Press OK on new setup. The menu guides you through the setup process with corresponding instructions on the OLED screen. Please note: the battery must be greater than 60% charged to complete setup mode. When the battery charge is greater than 60%, the riveting tool prompts you to screw on a nut insert by hand so that the threaded mandrel protrudes through the nut insert one turn of the thread. Then you can pull in the mandrel using the down arrow key until the nut insert just touches the mouthpiece. Confirm this position by pressing OK. Then the screen will ask whether you want to set the nut insert by force or stroke.

Note: The force and stroke values given in Table 1 are only reference values, in case of doubt you should always use a lower value when setting up. If you specify very small force values, the riveting tool will also ask you to enter a stroke value. You have to feel your way to the stroke value, as this depends on the material thickness in which the blind rivet nut / blind rivet stud is to be set. Here too, it is important to start with a small value.

Force	M3	M4	M5	M6	M8	M10	M12	Gradual adjustment
Aluminium	5*	7	8	14	22	24	25	Red values: 0,1 – 0,2
Steel	7	10	11	18	23	33	57	Blue values: 0,2 – 0,5
Stainless Steel	9	12	15	32	45	70	82	Green values: 0,5 – 1,0
Stroke	1,5	2,0	2,5	3,5	4,5	5,5	6,5	Stroke-values: 0,1 – 0,2

Table 1: Force & stroke settings

* kN + mm

For example – if choosing to set up the tool to install an M8 steel Nut Insert by force, you may start by selecting force from the screen menu at this time, then OK. As a guide only, the above settings in Table 1 suggests starting with a force of #23. By pressing either the up or down buttons, select #23 and then OK. Go down to select next then press OK. Insert the nut insert into a test piece application and pull the trigger. The screen will then prompt you to answer yes or no, was the installation a success? If yes, press OK and the tool will then ask if you would like to set the feed on control of the insert by mandrel pressure or trigger. Press NEXT. The tool then asks to store the setup between #1 - #99. Once stored, you can recall this #? anytime from the stored settings. To proceed using the tool with this setup, select the back button to return to the setup menu and select EXIT. The tool is now ready to accept the next M8 steel insert as you have set up.

To set the tool up by “stroke” rather than “force”, follow the same steps as above and when prompted, select Stroke.

Force versus stroke: A blind rivet nut / blind rivet stud set in the force mode is independent of the tolerances of the construction material and the blind rivet nut / blind rivet studs. This setting is made when setting up the blind rivet nut / blind rivet studs. On smaller nuts & studs, especially on aluminium material, the setting by stroke can be more accurate and safer.

□ **Emergency mode:** If the threaded mandrel / sleeve can no longer be unscrewed, proceed as follows:

1. Press the arrow keys, up & down together. The tool now shows on the display the instructions as follows:
2. Loosen the union nut and the front sleeve.
3. Press OK. Now the threaded mandrel /sleeve moves to the very front position.
4. Unscrew the mouthpiece counter clockwise and slide it away from the riveting tool.
5. Tighten the union nut with the front sleeve.
6. Hold the device with one hand. Through the gap between the mouthpiece and the front sleeve you can now loosen the tension sleeve counter clockwise with the other hand and remove the device from the threaded mandrel.
7. Pull the battery off the riveting tool and put the riveting tool and battery aside.
8. You can now remove the threaded mandrel with an open-ended spanner or a size 5 socket wrench.
9. Insert the mandrel (if necessary, a new mandrel), with the tension sleeve and the mouthpiece in the tool and insert the battery. Reduce the force or stroke to avoid further damage.

Please remember that jamming the threaded mandrel/threaded sleeve has usually damaged the thread of the rivet nut and the threaded mandrel/threaded sleeve and should be replaced. If the threaded mandrel/threaded sleeve cannot be removed, cut off the threaded mandrel/threaded sleeve with a suitable tool.

□ **Battery & Charger:** Perform a visual inspection of the battery charger to ensure that neither it nor the cord is damaged. If damaged, disconnect from power immediately and tag with a **Do Not Operate** tag.

Please Note: Should the tools LED continually flash **RED**, the tool has gone into emergency mode and you should stop using it immediately and send it into Profast for repairs.

Please remember : If in doubt, always contact Profast before attempting any repairs.