



MODEL:

ADN38

PRODUCT TYPE:

**XL RIVET NUT DRILL ADAPTER KIT
- 3/8" CAPACITY****WARNING**

Study, understand and follow all instructions provided with this product. Read these instructions carefully before installing, operating, servicing or repairing this tool. Keep these instructions in a safe accessible place.

INTENDED USE OF THE TOOL

WEAR WORK GLOVES (RUBBER COATED PREFERRED) FOR GRIPPING THE ADAPTER, ESPECIALLY FOR LARGEST SIZES. This tool is designed to be used with a cordless drill that uses a clutch to limit torque to different settings. Use tool to set aluminum, steel and stainless rivet nuts up to 3/8" (10mm) in sheet metal. Do not use this tool outside of the designed intent. Never modify the tool for any other purpose or use.

**WARNING****Caution: To help prevent personal injury**

- Normal use of this product is likely to expose the user to dust and/or microscopic particles containing chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Always wear appropriate safety equipment and clothing when using this product. Study, understand and follow all instructions provided with this product. Failure to read and follow all warnings and operating instructions may result in damages and serious injury or death.
- Always wear ANSI approved goggles when using this product. (Users and By standers).
- Never use this tool for any application other than for which it was designed.
- Only use accessories designed for this tool.
- Never alter or modify this tool in any way.
- Improper operation and/or maintenance of the tool, modification of the tool, or use of the tool with accessories not designed for it could result in serious injury or death.
- Always select the correct accessories of the correct size and design for the job that you are attempting to perform.
- Always work in a clean, safe, well-lit, organized and adequately equipped area.
- Do not begin repairs without assurance that vehicle is in secure position, and will not move during repair.



**XL RIVET NUT DRILL ADAPTER KIT
- 3/8" CAPACITY**



MADE IN CHINA



**Astro Pneumatic
Tool Company**

www.astrotools.com

1 YEAR LIMITED WARRANTY

• Astro Pneumatic Tool Co. warrants our products to the original user against defective material or workmanship for a period of 1 year (except where noted on our price schedule) from the date of 1st use. Astro reserves the right to determine whether the product failed because of defective material, workmanship or other causes and to charge back for missing parts. Astro Pneumatic Tool Co., at its discretion, will repair products covered under this warranty free of charge. The distributor should direct the original user to return the product (with the exceptions listed below) with the distributor's name, address, adequate proof of date of purchase or a copy of warranty card, and a short note explaining the problem. **Failures caused by accident, alteration, or misuse are not covered by this warranty.**

• If one part of this product fails, please do not return the entire product. Astro will replace free of charge component parts of this product that fail within 1 year of first use by the original user. Items included in this category include but are not limited to kits, hand tool kits and any other product where there are multiple items or components that make up the unit. Please contact the phone number below in order to obtain the replacement components covered under warranty.

• Astro Pneumatic Tool Co. or its authorized service representatives must perform all warranty repairs. Any repair to the product by unauthorized service representatives voids this warranty. The rights under this warranty are limited to the original user and may not be transferred to subsequent owners.

• This warranty is in lieu of all other warranties, expressed or implied, including warranties of merchantability and fitness for a particular purpose. Some states do not allow the exclusion of limitations of incidental or consequential damages so the above limitations may not apply to you.



**PLEASE DO NOT RETURN ANY PRODUCT WITHOUT CALLING
1-800-221-9705 FOR INSTRUCTIONS**

**Before Use**

When unpacking, check the parts diagram and part number listing on page 4 to make sure all parts are included. If any parts are missing or damaged, please call your distributor.

PRODUCT INFORMATION:

- Easily convert your cordless, pneumatic or corded drills into a power rivet nut setter
- Use 12V and up cordless drills for aluminum and steel rivet nuts, or 18V+ for larger sizes like M10 & 3/8" and/or stainless (drills must feature torque limiting clutch)
- CNC machined from solid billet aluminum and features durable bearings

DO NOT DISCARD – GIVE TO USER



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**XL RIVET NUT DRILL ADAPTER KIT
- 3/8" CAPACITY****I. Product Technical Data:**

Dimensions: 8.5" x 5.5" x 2.4"

Weight: 2.5 lbs

Hex Shank Size: 6.35mm (1/4")

Riveting Capability:

Rivet Nut Size		SAE 10-24	SAE 1/4-20	SAE 5/16-18	SAE 3/8-16	M5	M6	M8	M10
Nut Material	Aluminum	✓	✓	✓	✓	✓	✓	✓	✓
	Steel/Copper	✓	✓	✓	✓	✓	✓	✓	✓
	Stainless Steel	✓	✓	✓	✓*	✓	✓	✓	✓*

* Tool is capable but may require very high grip strength

Rivet Type: Rivet Nut

Stroke Limit: Maximum 0.7 inch

Working Torque: Refer to section III. **Operation Guide**

Recommended RPM: Low speed, driver setting (<240 RPM)

Requirements of Driving Tools: Requirements of cordless driving tool:

- Adjustable torque setting.
- Chuck capacity of 6.35 mm (1/4") shank.
- Min 12V for aluminum, or M5 and 10-24 steel rivet nuts.
- Min 14.4V for steel rivet nuts in M6, M8, 1/4" & 5/16" or stainless in M5 or 10-24.
- Min Full-size 18V+ for M10 and 3/8" rivet nuts and all other sizes in stainless steel.

WEAR GLOVES

- Clutch provides a felt and/or audible indication of reaching max setting.

Requirements of electric or pneumatic driving tool:

- Adjustable torque setting.
- Chuck capacity of 6.35 mm (1/4") shank.
- With maximum torque > 190 in/lbs for aluminum and steel rivet nuts in smaller sizes.
- With maximum torque > 400 in/lbs for stainless steel rivet nuts.

Common Sizes Chart:

Rivet Nut	Rivet Nut Diameter	Drill Hole Size	Grip Range
M5	6.9mm OD	7mm (9/32")	26 – 16ga
M6	8.9mm OD	9mm (3/8")	26 – 13ga
M8	10.9mm OD	11mm (7/16")	26 – 11ga
M10	12.9mm OD	13mm (17/32")	26 – 11ga
10-24	6.9mm OD	7mm (9/32")	26 – 16ga
1/4-20	8.9mm OD	9mm (3/8")	26 – 13ga
5/16-18	10.9mm OD	11mm (7/16")	26 – 11ga
3/16-16	12.9mm OD	13mm (17/36")	26 – 11ga

II. SAFETY GUIDE:

1. Wear adequate protective gear including ANSI approved goggles and **THICK WORK GLOVES (RUBBER COATED)**
2. Only use the nut riveting adapter with driving tool that matches with requirements specified on **Product Technical Data**.
3. Switch off the driving tool before installing or uninstalling the nut riveting adapter.
4. The objects to be riveted **MUST BE SECURELY FIXED BEFORE** riveting in order to avoid possible injury. Unsecured objects may rotate with the driving tool if not secured.
5. The driving tool **MUST** be stopped if user releases the adapter's body during riveting.
6. During disassembly for mandrel changing or **Maintenance**, take care as there are pre-loaded springs within the tool.



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III. OPERATION GUIDE:

WARNING: WEAR WORK GLOVES (RUBBER COATED PREFERRED) FOR GRIPPING THE ADAPTER

IMPORTANT: Ensure the threads on mandrels are clean and the loaded rivet nut has full thread engagement with threaded mandrel during riveting. It is strongly recommended to clean and lubricate (ex. silicone spray, dry lube) the threads on mandrels before and after use.

CRITICAL: Before using the tool on your intended work piece, it is **REQUIRED** that you test the tool with a rivet nut on a test piece to determine the adequate torque needed for your rivet nut size, rivet nut material, and sheet metal thickness and material.

- Ensure drill is in "driver" mode and not drill mode. Different drills will require different torque limiting settings for the same material.
- On the test piece, set your drill to a low clutch setting and work up to higher settings until the torque level is enough to fully set the rivet nut but not over set - **WARNING:** Over setting rivet nuts may permanently damage the mandrel or tool.
- Once the torque level is determined, test again on a new hole at your intended setting to confirm. The knurled part of the rivet nut should look mushroomed and starting to become flat on the other side of the work piece and should not rotate when you install a bolt.

1. Tool Installation:



Install a new mandrel and nosepiece to match your intended rivet nut thread size. Use the included wrench to install the new mandrel into the #2 Plunger Tube. Ensure that the mandrel and other components are tightly fixed in position. After installing the front bushing cover and lock bushing, lightly tighten the new nosepiece onto the end of the tool. Install the hex shank drive end of the tool into your drill and affix tightly into its chuck.

2. Riveting:

- 2.1 While holding the adapter with your hand (**WEAR GLOVES**), operate the drill in the REV direction until you hear the adapter start to click. This means it has fully exposed the mandrel.
- 2.2 Switch the drill to the FWD setting.
- 2.3 Manually thread the selected rivet nut onto threaded mandrel; or hold the rivet nut in one hand and use another hand to pull the drill trigger slightly to have the nut threaded on by the tool.

2.4 Ensure the rivet nut has adequate thread engaged and that there is no cross threading. Check and confirm the objects to be riveted are **SECURE**.

2.5 Some small amount of clearance between nose piece and the flange of rivet nut may be beneficial to operation, but keep adequate thread engagement on the nut.

2.6 Refer to Section III. for determining the proper drill torque settings. (REQUIRED).

2.7 Put the rivet nut now threaded onto the tool's mandrel fully into the proper size hole (see Sizing Chart on page 2).

2.8 Align the adapter with the hole angle as best you can. While gripping the adapter firmly with one hand (wear work gloves), operate the drill in the FWD direction until you feel or hear the drill's torque clutch catching. The adapter should not rotate while the drill works. Release your grip on the adapter and reverse the drill out of the rivet nut. Depending on the material, you may need to manually help the adapter thread out of the rivet nut with your off hand.

Tip 1: If setting M10 or 3/8" and especially on stainless, high grip strength is required. Not all rivet nuts are the same, some require more force.

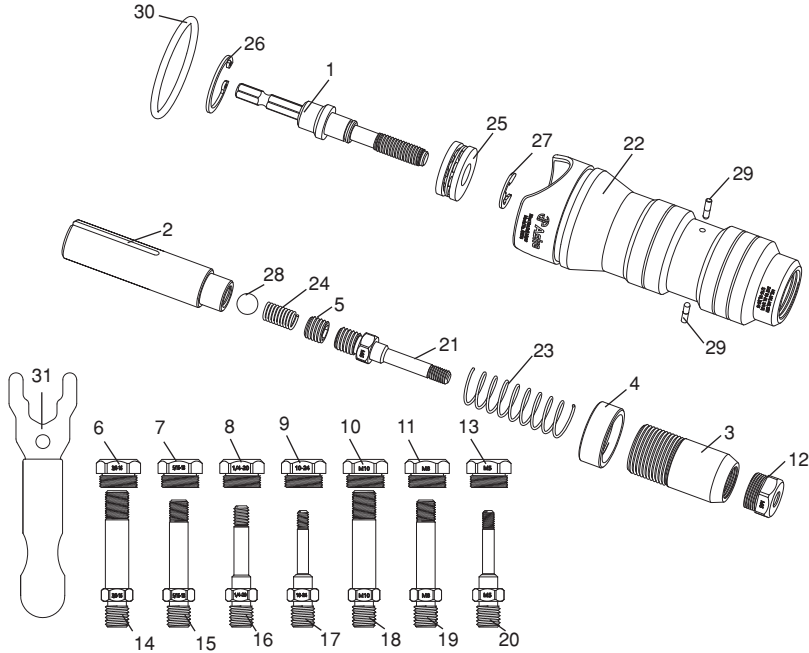
Tip 2: Make a note of the torque setting matching your application for future use.

IV. MAINTENANCE:

1. The nut riveting adapter is lubricated before shipping. Recommended: cleaning the components of plunger tube, and using lubricant grease to re-lubricate its parts on a yearly basis or earlier.
2. Threaded mandrel replacement:
Life span of threaded mandrel varies with usage frequency and the uses of different rivet nut sizes/types. Recommended: replacing the threaded mandrel with new spare and its nosepiece before worn-out.



PARTS BREAKDOWN:



Parts List

Index	Part No.	Description	Qty
1	ADN14-01	Hex Shank Driving Shaft	1
2	ADN14-02	Plunger Tube	1
3	ADN14-03	Front Bushing w/Knurling	1
4	ADN14-04	Locking Bushing	1
5	ADN14-05	Set Screw	1
6	ADN38-3/18-16N	SAE 3/18-16 Nosepiece	1
7	ADN38-5/16-18N	SAE 5/16-18 Nosepiece	1
8	ADN14-1/4-20N	SAE 1/4-20 Nosepiece	1
9	ADN14-10-24N	SAE 10-24 Nosepiece	1
10	ADN38-M10N	M10 Nosepiece	1
11	ADN38-M8N	M8 Nosepiece	1
12	ADN14-M6N	M6 Nosepiece	1
13	ADN14-M5N	M5 Nosepiece	1
14	ADN38-3/8-16M	SAE 3/8-16 Mandrel	1
15	ADN38-5/16-18M	SAE 5/16-18 Mandrel	1
16	ADN14-1/4-20M	SAE 1/4-20 Mandrel	1

Index	Part No.	Description	Qty
17	ADN14-10-24M	SAE 10-24 Mandrel	1
18	ADN38-M10M	M10 Mandrel	1
19	ADN38-M8M	M8 Mandrel	1
20	ADN14-M5M	M5 Mandrel	1
21	ADN14-M6M	M6 Mandrel	1
22	ADN38-22	Aluminum Handle	1
23	ADN14-23	Front Spring	1
24	ADN14-24	Inner Spring	1
25	ADN14-25	Thrust Ball Bearing	1
26	ADN14-26	C-Clip	1
27	ADN14-27	E-Clip	1
28	ADN14-28	Steel Ball	1
29	ADN14-29	Pins	2
30	ADN14-30	O-Ring	1
31	ADN14-31	Wrench Kit	1