



Smart **RiveDrill**

Use and Maintenance
Uso y Mantenimiento



Máquinas Andrea, S.L.
At your service

Since 1966



Smart riveting machine for drilling machine

www.rivedrill.com www.rivedrill.net www.rivedrill.es www.rivedrilliberica.com
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Seguridad

Usar guantes en la mano que sujeta RiveDrill, y gafas y calzado de seguridad. NutDrill es una herramienta profesional y requiere atención y aprendizaje antes de usar. Estar atento a la reacción en la mano que sujeta RiveDrill. Si la reacción aumenta, parar y enfriar.

Condiciones de uso

- NutDrill se debe instalar **solo en taladradores reversibles de baterías**, con control de velocidad y de par "torque" Fig. 1
- Ensayar en **vacío** los cuatro movimientos con velocidad **mínima, sin golpear en los finales de recorrido** Fig. 2.
- Usar siempre **el mandril y la boca, adecuados** Fig. 3
- Determinar **experimentalmente, remachando al aire**, antes de comenzar a trabajar, **el "torque" adecuado**, que necesitan las tuercas remachables Fig. 4
- Si NutDrill aumenta la reacción en la mano, **no insistir, parar y dejar enfriar**.

Información Previa

1. Descripción e Instalación.
1- Remachadora. 2- Eje. 3- Boca. 4- Mandril. 5- Taladrador. Fig. 1
Instalación. NutDrill se instala **como una broca**. Asegurarse que queda bien centrado y apretado. Fig. 1

2. Movimientos.

- Cuando el taladrador gira a la derecha ó a la izquierda y NutDrill **está libre (sin sujetar por la mano)**, el **mandril de NutDrill gira también** a la derecha o a la izquierda respectivamente.
- Cuando el taladrador gira a la derecha o a la izquierda y **NutDrill se sujeta con la mano** para que no gire, el **mandril se desplaza hacia el interior ó hacia el exterior** respectivamente. Fig. 2

3. Bocas y Mandriles.

Colocar el mandril y la boca adecuado a cada medida de tuerca, de rosca métrica ó americana. Los mandriles y bocas no siempre están incluidos en la unidad de compra. Se pueden adquirir a parte, en el distribuidor o en Internet. La rosca de montaje de las bocas y de **los mandriles es de izquierdas**. Fig. 3

4. Enroscar la tuerca.

Con la punta del mandril completamente afuera (8 a 10 mm aprox.), accionar la taladradora hacia la derecha, dejando que NutDrill enrosque la tuerca **completamente, y parar**. Fig. 4

5. Ajuste del par ó "torque".

Un "torque" mayor del necesario, puede producir rotura del mandril o de la tuerca. Un "torque" menor del necesario puede dejar las tuercas sin apretar. **Empezar probando un "torque" bajo**, por ejemplo, menor que el de la tabla de Fig. 5. Con la tuerca enroscada en el mandril, Fig. 4, **y con la velocidad mínima, sujetar NutDrill, con la mano enguantada, para que no gire**. Será normal, que no consiga aplastar la tuerca y que suene el sonido fuerte del embrague del taladrador, indicando que hay que aumentar el "torque". Parar, aumentar el "torque" y probar de nuevo. Cuando la tuerca se aplaste suficiente, memorizar la graduación del "torque". **Este será el "torque"**, para esas tuercas.

6. Eliminar la presión "P".

Hacer girar la taladradora hacia la izquierda, y sujetar NutDrill con la mano enguantada, **durante dos segundos**,

para eliminar la presión "P", separándose la tuerca de la boca de NutDrill y seguidamente soltar la NutDrill para que gire libremente, mientras se sujeta ahora la tuerca de prueba para que desenrosque completamente. Parar. !Enhorabuena! Ahora ya se puede empezar a trabajar con NutDrill.

7. Enroscar, Remachar, Quitar presión y Desenroscar con NutDrill Inteligente.

Cuando NutDrill coloca tuercas sobre estructuras fijas, genera automáticamente un par de giro "inteligente", "Smart Torque" (flecha negra), que ayuda al operador, reduciendo el esfuerzo de reacción en su mano (flecha verde). Ahora el operador experimentará en su mano una reacción menor que cuando probó las tuercas de Fig. 5 remachandolas al aire. Notará que la **tuerca insertable se agarra casi sólo a la estructura**.

Para remacharla, una vez enroscada como en Fig. 4 insertarla en el agujero estructural, y **accionar la taladradora a marcha lenta hacia la derecha, mientras la sujeta con la mano enguantada, para que no gire, hasta escuchar el sonido fuerte del embrague**. Parar y cambiar el sentido del taladrador hacia la izquierda. **Sujetar NutDrill con la mano, durante 2 segundos, para eliminar la presión, y sin dejar de girar a la izquierda, soltar la mano para que gire libremente hasta que desenrosque la tuerca completamente**. NutDrill queda lista para el siguiente remache.

Información adicional

Repuestos. El usuario, si lo desea, puede desmontar la arandela elástica del eje de NutDrill, con alicate de puntas para extraer el Rotor Completo, de fácil sustitución. Las piezas se pueden comprar "on line" y descargar manual de mantenimiento en: www.rivedrill.es, www.rivedrilliberica.com, www.rivedrill.com, www.rivedrill.net.

Tabla 8 Indica algunos valores típicos de resistencia de tuercas,

Garantía

En caso de observarse algún defecto de fabricación contacte con su distribuidor, aportando factura de compra. Los mandriles no están incluidos en la garantía ya que son consumibles como las brocas. Los defectos producidos por no aplicar las "Condiciones de uso", el uso inadecuado, la sobrecarga ó sobrecalentamiento, ó el desgaste normal, así como los gastos de envío o recepción, no están incluidos en la garantía.

Declaración de Conformidad

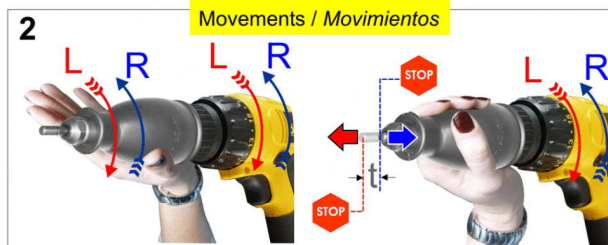
Máquinas Andrea, S.L. - Calle Islas Cíes 61, 28035 Madrid (España)
Declara que RiveDrill satisface los requisitos de la Directiva 2006/42/CE según el Anexo V del Parlamento Europeo y del Consejo, de 17 de mayo de 2006. RiveDrill esta diseñada para ser accionada por una máquina taladradora de baterías, sólo después de haberse determinado la conformidad del producto terminado con el requerimiento de la directiva.

1-Julio-2017
Administradora.
Nuria Pérez

Description and Installation / Descripción e Instalación



Movements / Movimientos



Screw in / Enroscar



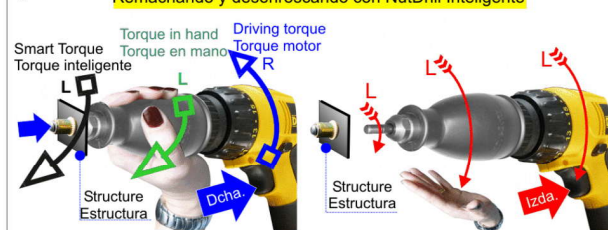
5 By selecting the tightening torque / Seleccionando el par de apriete



6 Removing pressure "P" / Eliminando presión "P"



7 Riveting and Unscrewing with Smart NutDrill / Remachando y desenroscando con NutDrill Inteligente



Material	Inox A2						Acero						Aluminio				
	M10	M8	M6	M5	M4	M3	M12	M10	M8	M6	M5	M4	M3	M8	M6	M5	M4
Rosca	13400	11300	9600	7300	4800	2700	14700	11000	8400	6500	5100	3900	2400	6000	5000	4400	3600
Resistencia (Newton)	13400	11300	9600	7300	4800	2700	14700	11000	8400	6500	5100	3900	2400	6000	5000	4400	3600

Mantenimiento.

El usuario, si lo desea, puede desmontar fácilmente la arandela elástica (A) del eje (B), de RiveDrill o NutDrill, con alicate de puntas, girando previamente el eje (B) hacia la derecha 10 vueltas, para eliminar la presión interior, con el fin de extraer y sustituir cualquiera de las partes interiores; Rotor completo, Tractor de Mordazas Completo, ó solo las Mordazas, o las Bocas, indicando el diámetro en este caso. Los repuestos se pueden adquirir, con el número de referencia que se indica, en su distribuidor o en Internet. Para facilitar el montaje de la arandela (A), debe estar el Rotor enroscado también unas 10 vueltas, en el Tractor. La durabilidad de RiveDrill y NutDrill aumenta si se limpian y engrasan las piezas. Conviene no superar las velocidades que se indican en las Instrucciones de Uso.

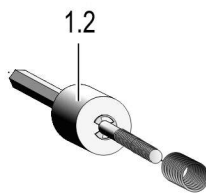
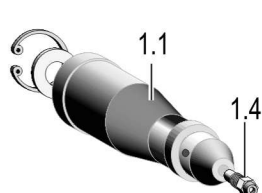
Nuestro servicio Post - Venta, no repara los Rotores ni los Tractores porta mordazas, que son sustituidos ó suministrados completos, para garantizar el perfecto funcionamiento, pero si suministra las piezas que los componen, cuando los clientes lo solicitan. Si el cliente lo desea puede enviar cualquier unidad para reparar, a porte pagado, a la dirección más próxima, de la que previamente el cliente será informado en nuestro Servicio Técnico por teléfono, WhatsApp +34 693215339 ó email.



Carcasa completa

Tractor Porta Mordazas

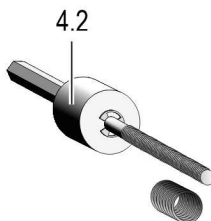
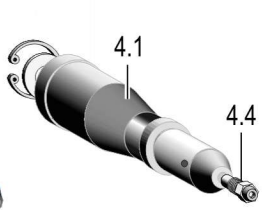
Rotor Completo



RiveDrill E95H

Spare Parts

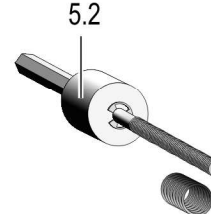
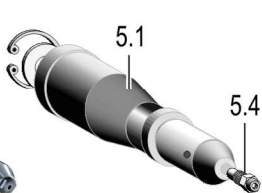
- 1.1 Complete body
- 1.2 Complete rotor
- 1.3 Complete jaw holder
- 1.4 Nosepiece (1 piece)
- 1.5 Jaw (2 pieces)



RiveDrill E95H.20

Spare Parts

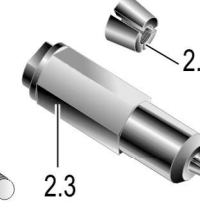
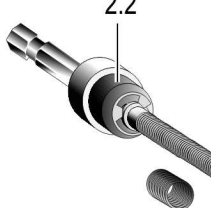
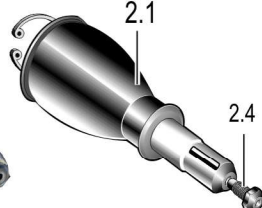
- 4.1 Complete body
- 4.2 Complete rotor
- 4.3 Complete jaw holder
- 4.4 Nosepiece (1 piece)
- 4.5 Jaw (2 pieces)



RiveDrill E95H.28

Spare Parts

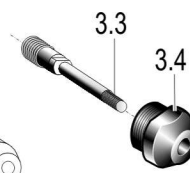
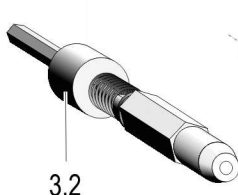
- 5.1 Complete body
- 5.2 Complete rotor
- 5.3 Complete jaw holder
- 5.4 Nosepiece (1 piece)
- 5.5 Jaw (2 pieces)



RiveDrill HP

Spare Parts

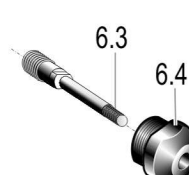
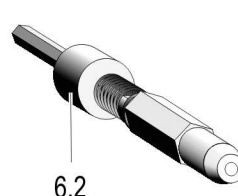
- 2.1 Complete body
- 2.2 Complete rotor
- 2.3 Complete jaw holder
- 2.4 Nosepiece (1 piece)
- 2.5 Jaw (3 pieces)



NutDrill ND

Spare Parts

- 3.1 Complete body
- 3.2 Complete rotor
- 3.3 Mandril
- 3.4 Nosepiece



NutDrill ND2

Spare Parts

- 6.1 Complete body
- 6.2 Complete rotor
- 6.3 Mandril
- 6.4 Nosepiece



SEGURIDAD Y CONDICIONES DE USO

Seguridad

Usar guantes en la mano que sujeta RiveDrill o NutDrill, y gafas y calzado de seguridad. Adoptar posturas estables y seguras. Mantener las áreas de trabajo despejadas, sin niños ni personas alrededor, ajenas a los trabajos que se realizan. Los vástagos residuales deben ser recogidos en contenedores adecuados y depositados en los recipientes clasificados según las normas medioambientales. Los vástagos residuales en el suelo pueden provocar resbalones y caídas. Estar atento a la reacción en la mano que sujeta RiveDrill o NutDrill, que puede aumentar si se sobrecalienta o sobrecarga. En este caso parar, enfriar y revisar las "Condiciones de Uso"

RiveDrill - Condiciones de uso

- a) RiveDrill se debe usar **solo** con taladradores reversibles de baterías, a las **velocidades** que se indican en "A".
- b) No superar la medida **máxima "Y"** (párrafo y fig. 4)
- c) Usar la **boca adecuada** (párrafo y fig.5)
- d) Parar **inmediatamente**, al romper el vástago del remache (párrafo y fig. 8)
- e) Si aumenta la reacción en la mano, **parar y dejar enfriar** (párrafo y fig. 8).

NutDrill - Condiciones de uso

- a) NutDrill se debe usar **solo en taladradores reversibles de baterías**, a velocidad mínima y con control de par "torque" Fig. 1
- b) Ensayar en **vacío** los cuatro movimientos con velocidad **mínima, sin golpear en los finales de recorrido** Fig. 2.
- c) Usar siempre **el mandril y la boca, adecuados** Fig. 3
- d) Determinar **experimentalmente, remachando al aire**, antes de comenzar a trabajar, **el "torque" adecuado**, que necesitan las tuercas remachables Fig. 4
- e) Si NutDrill aumenta la reacción en la mano, **no insistir, parar y dejar enfriar**.

GARANTIA Y DECLARACIÓN DE CONFORMIDAD

Calidad y Garantía

Todos nuestros productos han sido sometidos a un Control final de Calidad en el 100% de las unidades de venta. En caso de observarse algún defecto de fabricación contacte con su distribuidor, aportando factura de compra. Los defectos producidos por no aplicar las "Condiciones de uso" que se indican en las instrucciones de manejo, el uso inadecuado, la sobrecarga o sobrecalentamiento, o el desgaste normal, así como los gastos de envío o recepción, están excluidos de la garantía. Nuestra garantía se refiere únicamente a los productos RiveDrill. En ningún caso a productos derivados ni a las personas que los usan. El alcance de la garantía es, la reparación, la sustitución o

Declaración de Conformidad

Máquinas Andrea, S.L. con domicilio en Calle Islas Cíes 61, 28035 Madrid (España)

Declara que RiveDrill satisface los requisitos de la Directiva 2006/42/CE según el Anexo V del Parlamento Europeo y del Consejo, de 17 de mayo de 2006. RiveDrill está diseñada para ser accionada por una máquina taladradora de baterías, sólo después de haberse determinado la conformidad del producto terminado con el requerimiento de la directiva.

1-Julio-2017

Administradora.

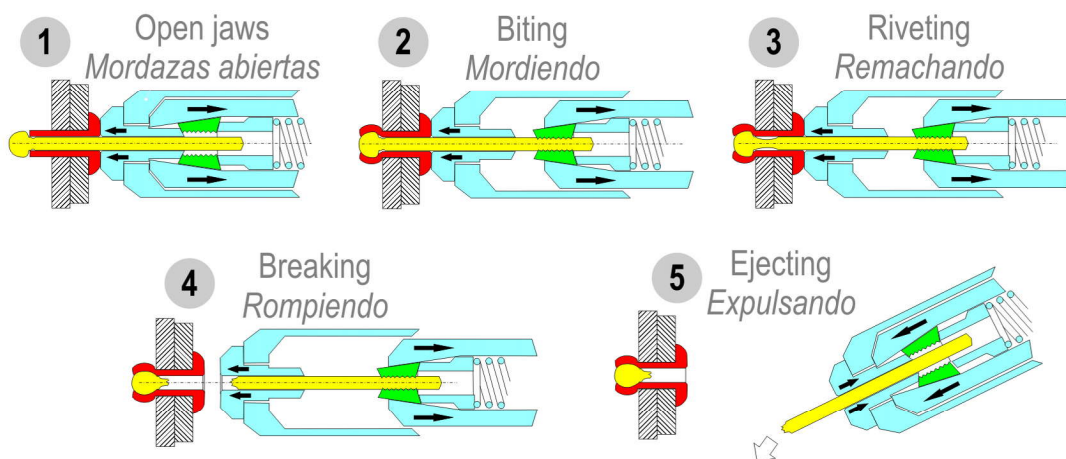
Nuria Pérez



MANTENIMIENTO Y REPARACIONES

RiveDrill y NutDrill tienen un sencillo mantenimiento que consiste en la sustitución de uno de sus dos módulos; Rotor o Tractor, que pesan poco y se pueden enviar por transporte muy rápido y económico. Por tanto el mantenimiento es muy rápido, sencillo y cómodo. Nuestro servicio Post - Venta, no repara estos componentes, que son sustituidos o suministrados completos, para garantizar el perfecto funcionamiento, pero si suministra las piezas que los componen, cuando los clientes lo solicitan. Cualquier unidad para reparar, debe enviarse a porte pagado, a la dirección más próxima, de la que previamente el cliente será informado en nuestro Servicio Técnico por teléfono ó WhatsApp +34 693215339

Normal riveting cycle / Ciclo de Remachado Normal



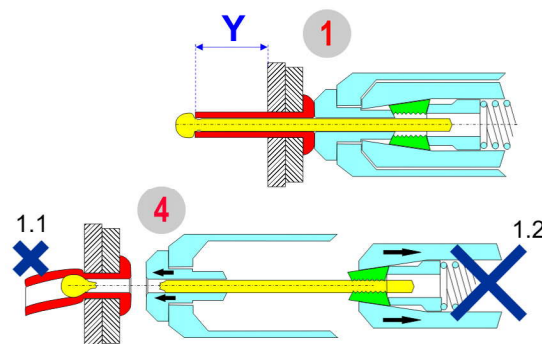
1 Unfulfilled condition: Excessive "Y" length Condición incumplida: Largura "Y" excesiva

Issue. Rivet larger and expensive, badly tightened, and twisted (1.1), and RiveDrill blocked. (1.2).

Solution. Use rivets of correct measurement and replacement of; Rotor, or jaws Tractor, or both, if necessary.

Problema. Remache más largo y caro, mal apretado, y torcido (1.1), y RiveDrill atascado (1.2).

Solución. Usar remaches de medida correcta y sustitución de; Rotor, ó Tractor de Mordazas, o ambos, si es necesario.



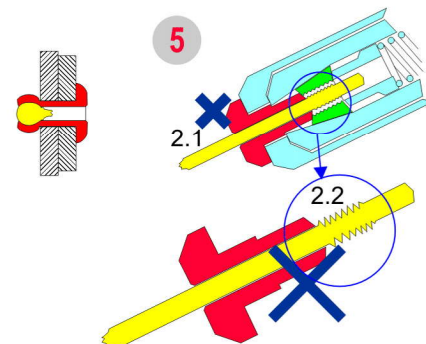
2 Incorrect nosepiece (2.1) Boca incorrecta (2.1)

Issue. The marks (2.2) on the residual mandrel of the rivet bite of the jaws, can not exit through the incorrectly used nosepiece.

Solution. Replace with larger nosepiece, or remove RiveDrill to remove the stuck mandrel of the rivet

Problema. Las marcas (2.2) en el vástago residual, de la mordida de las mordazas, no caben por la boca usada incorrectamente.

Solución. Sustituir por boca mayor ó desmontar RiveDrill para extraer el vástago atascado.



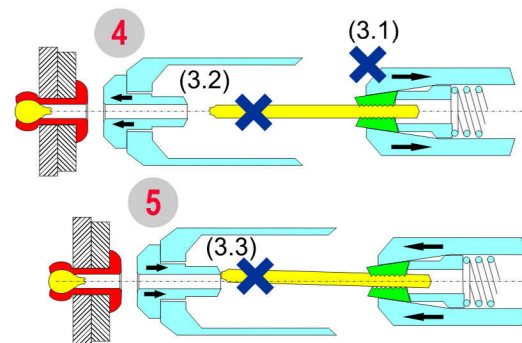
3 Do not stop the drill, immediately after riveting (3.1). No detener el taladrador inmediatamente después de remachar (3.1).

Unwanted effects. The broken mandrel leaves the nosepiece (3.2), and hit with it to return (3.3).

Solution. Remove RiveDrill to fit jaws and replace damaged parts.

Efectos no deseados. El vástago roto sale de la boca (3.2), y choca con ella al volver (3.3).

Solución. Desmontar RiveDrill para colocar las mordazas y sustituir las piezas dañadas.



4 Use RiveDrill only with battery drills, not electric. Do not exceed suggested speeds. During long cycles let cool. Do not overheat the tool with hard rivets.

Usar RiveDrill solo con taladradores de baterías, no eléctricos. No superar las velocidades sugeridas. Durante ciclos largos de trabajo dejar enfriar. No sobrecalentar la herramienta con remaches duros.



Security

Use gloves on the operator hand that is holding RiveDrill or NutDrill and glasses and safety Wearing shoes. Work in correct and stable position. If the reaction on the hand holding RiveDrill increase, stop working and leave it cool.

User Conditions

- RiveDrill must be used only with reversible battery (cordless) drill, and with speed indicated on table "A"
- Do not get over maximum size "Y" (Fig. 4)
- Use the correct nosepiece (Fig. 5).
- Stop immediately after break the mandrel of the rivet (Fig. 8).
- If the reaction on the hand holding RiveDrill increase, stop working and leave it cool. (Fig. 8). Failure to comply with these Conditions of Use may cause jams or breakdowns.

Previous Information.

1. Description
1 Riveter. 2 Axis. 3 Nosepiece. 4 Hole Control. 5 Hand protector. 6 Drill.

2. Installation. RiveDrill is installed as a drill bit; tightened, centred and without brushed, in any make of battery (cordless) drill, with torque control and speed. A security telescopic protector cover the hand, only in the models; E95H.28, E95H.20, E95H, y E95H.ND2.

3. RiveDrill interior movements. RiveDrill is hold with the gloved hand so that it does not rotate when the drill is operated. Turning to the right opens the control hole and closes the jaws (black). Turning to the left, the control hole closes, the jaws open and sound the clutch.

4. Rivets and measurement "Y". RiveDrill rivets in a single drive. Rivets of any length "L" can be used to join any thickness "X" but the "Y" dimension of the rivet should never be longer than the "Ymax" stroke indicated for each model, (Fig.4)

5. Nosepiece. Use only the nosepiece marked on its hexagonal side, with the number closest to the diameter of the rivet in mm, or its equivalent in inches. Some nosepieces are optional and are not included in the unit of purchase. Before replacing the nosepiece, move the tractor (jaw holder) by turning to the right until the control hole opens, to remove the pressure between the nosepiece (green) and the jaws (black). Without the nosepiece placed, the interior of RiveDrill does not move.

6. Initial position. Turn the drill to the left while holding it with the gloved hand so that it does not rotate until the control hole is closed and the clutch is heard, indicating that RiveDrill has the jaws open.

7. Operation. Smart RiveDrill transforms the rotary power of the drill (Mt), automatically generating a torque (St), which reduces the operator's hand (Ht) effort. Simultaneously it produces a powerful force (F)

How RiveDrill Works

8. Riveting. Holding RiveDrill with your gloved hand and turn the drill to the right until it rivets and stops immediately. The reaction in the hand is proportional to the hardness of the rivet used. If the reaction increases with use, it must be stopped, to avoid overheating which decreases durability.

9. Expell the mandrel. Turn to the left the drill by holding RiveDrill with the gloved hand, expelling the mandrel of the rivet down until the clutch sounds and expell the broken mandrel. RiveDrill is back to initial Position.

Additional information

10. Spare parts. The user can, if desired, remove the elastic washer from the RiveDrill shaft, with pliers, to remove the; Rotor and the Tractor (Jaw holder) , or the jaws. The pieces can be bought online. Catalog and maintenance manual at www.rivedrill.es, www.rivedrill.com, www.rivedrill.net www.rivedrilliberica.com

Table "A" Indicates typical approximate values of rivet strength as well as maximum drill speeds for each RiveDrill model. The durability of riveters decreases with speed, overheating and long duty cycles.

Table "B" With the typical values of the diameters of the mandrels. Values other than those indicated may cause jams or breakdowns.

Warranty

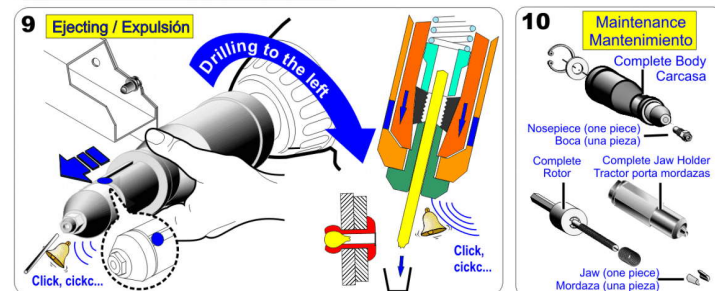
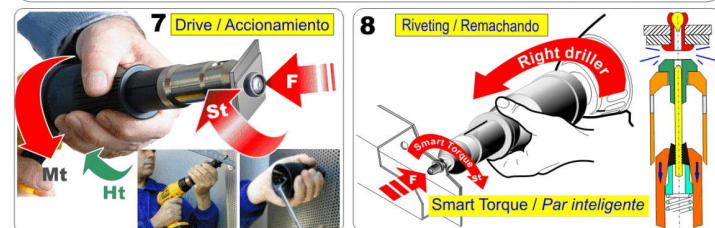
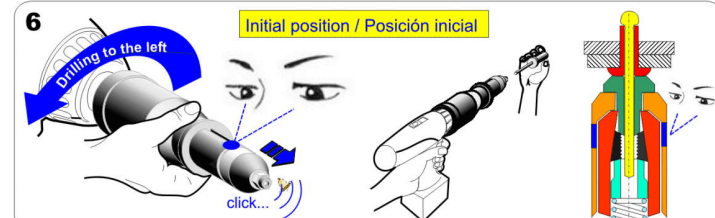
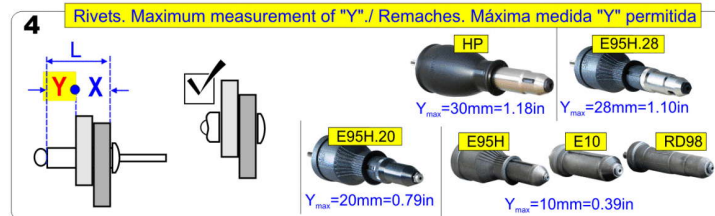
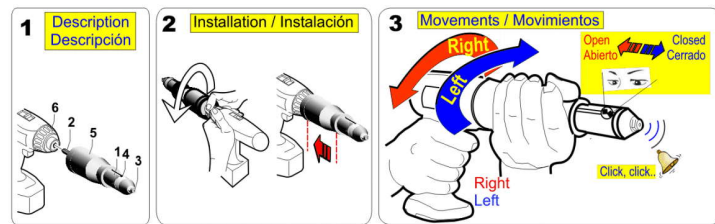
In case of a manufacturing defect, contact your distributor, supplying a purchase invoice. The defects produced by not applying; the "Conditions of use", overheating, or normal wear and tear, as well as shipping or receiving costs, are excluded from the guarantee.

Declaration of conformity

Maquinas Andrea, S.L. Calle Islas Cies 61, 28035 Madrid Declares that RiveDrill satisfies the requirements of Directive 2006/42 / EC in accordance with Annex V of the European Parliament and of the Council of 17 May 2006. RiveDrill is designed to be operated by a battery drill only after it has been determined the conformity of the finished product with the requirement of the directive.

July 1, 2017
Administrator.
Nuria Pérez

CE *Nuria Pérez*



Typical values of mandrel diameters based on diameters and rivet materials		Valores típicos de diámetros de mandriles en función de diámetros y materiales de remaches									
B	Mandrel d (mm)	D (mm)									
		2.4	3.2	4.0	4.8	6.4	8.0	10.0	12.0	16.0	20.0
		1.45	1.8	2.2	2.65	3.6	4.5	5.5	6.5	8.5	10.5
		2.0	2.4	2.93	3.85	4.8	5.8	6.8	7.8	9.8	11.8

RiveDrill models, maximum speed of drilling machine and resistance typical of rivets, depending on material, diameter, and type																				
Modelos RiveDrill, velocidad máxima de máquina taladradora y resistencia típica de remaches, según su material diámetro y tipo																				
A	Rivet material, diameter and strength Remaches, material, diámetro y resistencia	Stainless Steel A2 Acero Inox A2					Standard Steel DIN 1.0213 Estandar Acero DIN 1.0213					Aluminium 3.5% Mg Aluminio 3,5% Mg			Aluminium 2.5% Mg Aluminio 2,5% Mg		Rivet Type			
		1/4	3/16	5/32	1/8	3/32	1/4	3/16	5/32	1/8	1/4	3/16	5/32	1/8	3/32	1/4		3/16	5/32	1/8
R	Diameter (in) Diámetro (mm)	1/4	3/16	5/32	1/8	3/32	1/4	3/16	5/32	1/8	1/4	3/16	5/32	1/8	3/32	1/4	3/16	5/32	1/8	
		6.4	4.8	4.0	3.2	2.4	6.4	4.8	4.0	3.2	2.4	6.4	4.8	4.0	3.2	2.4	6.4	4.8	4.0	3.2
Y	Rivet strength (Newton) (*) Resistencia remache (n) (*)	9000	5800	3500	2500	1250	8800	5700	3100	2200	1100	4800	3100	2200	1100	4000	2300	1400	980	
		9000	5800	3500	2500	1250	8800	5700	3100	2200	1100	4800	3100	2200	1100	4000	2300	1400	980	
R	RiveDrill HP RiveDrill E95H.28 RiveDrill E95H.20 RiveDrill E95H.10 RiveDrill E10 RiveDrill RD38	30	28	20	10	10	30	28	20	10	10	30	28	20	10	10	30	28	20	10
		30	28	20	10	10	30	28	20	10	10	30	28	20	10	10	30	28	20	10
		30	28	20	10	10	30	28	20	10	10	30	28	20	10	10	30	28	20	10
		30	28	20	10	10	30	28	20	10	10	30	28	20	10	10	30	28	20	10
		30	28	20	10	10	30	28	20	10	10	30	28	20	10	10	30	28	20	10
Maximum speed Velocidad máxima		1400 r.p.m.					450 r.p.m.					Consulting / Consultando								

(*) Typical values of rivet strength may vary, depending on countries or manufacturers. The values given here are only approximate. (**) Los valores típicos de resistencia de los remaches pueden variar según países o fabricantes. Los valores señalados aquí son solo aproximados.



Security

Use gloves on the operator hand that is holding RiveDrill and glasses and safety Wearing shoes. NutDrill is a professional tool and require attention and training before use. Be care with the reaction on the hand is holding NuDrill. In this case stop, cool and check the "Terms of Use"

User conditions

- NutDrill is installed just in battery(cordless) reversible drill, with torque and speed control Fig. 1
- Try on air the four movements with slow speed and without hitting the end of the run Fig.2
- Use always the correct mandrel and guide Fig. 3.
- Determinate experimentally, riveting on the air, before start the work, the correct "torque" for the nut insert is going to use. Fig 4
- If NutDrill increase the reaction on the hand, do not insist, stop and leave cool

1. Previous information

Description. 1-RiveDrill NutDrill. 2-Axis. 3- Nosepiece. 4- Mandrel. 5- Drill. Fig. 1

Installation. NutDrill is installing as a drill bit. Be sure is centered and tightened. Fig. 1

2. Movements

- When the drill turns to the right or to the left and NutDrill is free (without holding with the hand), the mandrel of NutDrill also turns to the right or to the left respectively
- When the drill turns to the right or to the left and NutDrill is holding with the hand to not turn, the mandrel is moving inside or outside respectively. Fig. 2.

3. Guides and mandrels

Select correct mandrels and guide in American or metric sizes is going to be used. Those are not always included in the purchase unit. Can be purchased themselves with the distributor or online. The mountain thread for guides and mandrels are to the left. Fig. 3

4. Thread the nut

With the mandrel completely outside (8 to 10 mm aprox), turn the drill to the right, leaving NutDrill thread the nut insert completely, and stop. Fig 4.

5. Adjust the "Torque"

A mayor "Torque" that necessary, can break the mandrel or the thread. A minor "torque" than necessary can leave the nut insert without riveting. Began checking a slow "Torque", less than table Fig. 5. With the nut insert threaded on the mandrel, and with the minimum speed, hold NutDrill with the gloved hand to not turn. It will be normal, that you cannot set the nut insert and that the clutch of the drill sound strongly, that means you have to increase the "Torque". Stop, increase the "Torque" and try again. When the nut insert is well rivet, that will be the "torque for these sizes of nut inserts."

6. Avoid pressure on "P"

Turn the drill to the left, and hold

NutDrill with the gloved hand, for 2 seconds, to avoid the pressure "P", separating the nut insert from guide of NutDrill and immediately leave NutDrill to turn while you are now holding the test nut insert to be unscrewing. Stop. Congratulations! Now you can start working with NutDrill.

7. Screw, rivet, leave pressure and unscrew with Smart NutDrill.

When NutDrill set nut insert to a fixed structures, it produce automatically a "Smart torque" (black arrow) that help the user, reducing the reaction effort on their hand (green arrow). Now the user experiment a minor reaction that when check the nut insert on air Fig. 5. You will see that the nut insert is almost tightened itself to the structure.

To set the nut insert, when you had threaded like Fig. 4. Put into the hole, and turn the drill to the right while NutDrill is holding with the gloved hand, to not turn, until listen to the sound of the clutch. Stop and turn the drill to the left. Hold the Nutdrill for 2 second to leave the pressure, and keeping turning to the left, leave NutDrill turning to unscrew the nut insert completely. NutDrill is ready for the next nut insert.

Additional information

Spare parts. The user, if wish, can dismantle the elastic washer of NutDrill axis with needle nose pliers to remove the Complete rotor, to change it easily. The spare part can purchase online and load the maintenance manual at: www.rivedrill.es, www.rivedrilliberica.com, www.rivedrill.com, www.rivedrill.net.

Table 8 indicates some typical values of the resistance of the nut inserts.

Guarantee

In case of any manufacture fault contact with your distributor, supplied with purchase invoice. The defect produced because of do not applied the "user conditions", as overheating, or normal wear, also like delivery charges are excluded from the guarantee.

Declaration of conformity

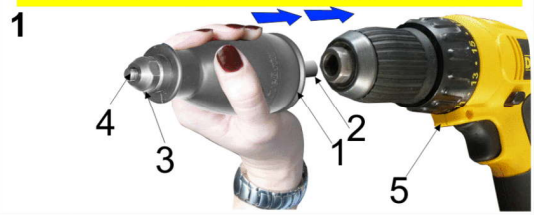
Maquinas Andrea, S.L. Calle Islas Cies 61, 28035 Madrid Declares that RiveDrill satisfies the requirements of Directive 2006/42 / EC in accordance with Annex V of the European Parliament and of the Council of 17 May 2006. RiveDrill is designed to be operated by a battery (cordless) drill only after it has been determined the conformity of the finished product with the requirement of the directive. July 1, 2017

Administrator.

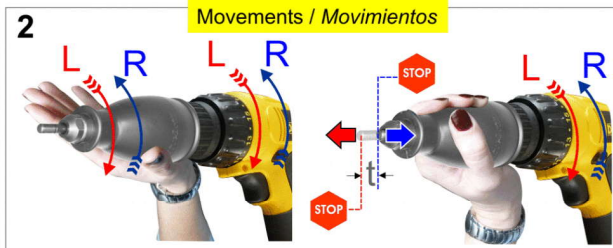
Nuria Pérez



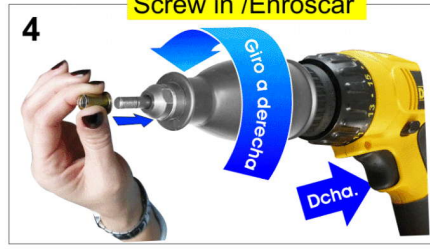
Description and Installation / Descripción e Instalación



Movements / Movimientos



Screw in / Enroscar



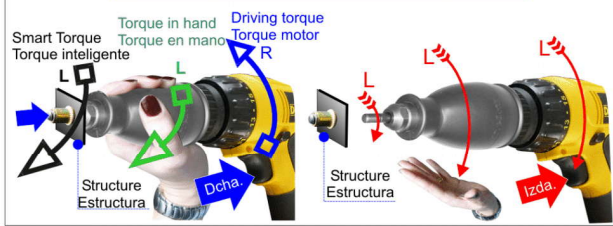
5 By selecting the tightening torque / Seleccionando el par de apriete



6 Removing pressure "P" / Eliminando presión "P"



7 Riveting and Unscrewing with Smart NutDrill / Remachando y desenroscando con NutDrill Inteligente



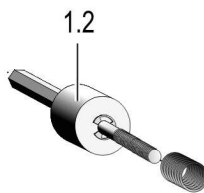
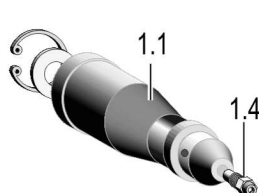
Material	Inox A2						Acero						Aluminio				
Rosca	M10	M8	M6	M5	M4	M3	M12	M10	M8	M6	M5	M4	M3	M8	M6	M5	M4
Resistencia (Newton)	13400	11300	9600	7300	4800	2700	14700	11000	8400	6500	5100	3900	2400	6000	5000	4400	3600
	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗	✗



Maintenance

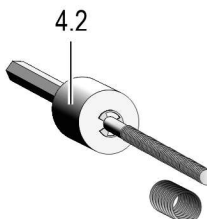
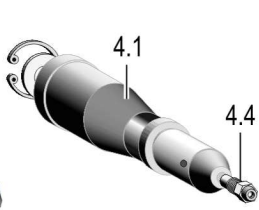
User, if wish, can dismantly the elastic washer (A) from the axis (B) RiveDrill of NutDrill with needle nose pliers turning first the axis (B) to the right 10 times, to avoid the inside pressure, with the idea to remove or change any inside part. Complete rotor, Mandrels or guides indicating the sizes. The spre parts can purchase through the distributor or online. In RiveDrill to put the Washer A you have to thread the spindle on the tractor around 10 times. Durability of both models increase if you keep the pieces clean and greased. Also do not exceed the speed indicated.

Our technical Service, do not repair the Complete Rotor or Complete jaw holder, they are substituted or supplied complete to warranty a well operation, but we supplied the spare parts when the clients required. If the client what can send a unit to repair freight cost prepaid calling fist to our phone number + 34 693215339. Or asking by email



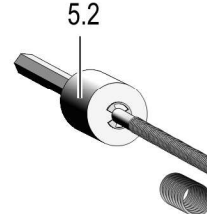
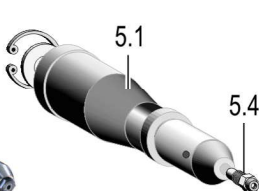
RiveDrill E95H Spare Parts

- 1.1 Complete body
- 1.2 Complete rotor
- 1.3 Complete jaw holder
- 1.4 Nosepiece (1 piece)
- 1.5 Jaw (2 pieces)



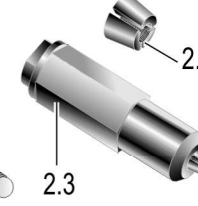
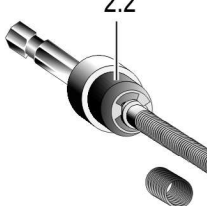
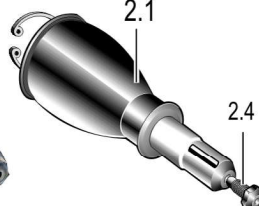
RiveDrill E95H.20 Spare Parts

- 4.1 Complete body
- 4.2 Complete rotor
- 4.3 Complete jaw holder
- 4.4 Nosepiece (1 piece)
- 4.5 Jaw (2 pieces)



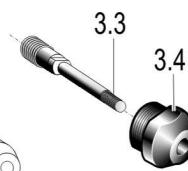
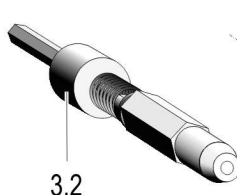
RiveDrill E95H.28 Spare Parts

- 5.1 Complete body
- 5.2 Complete rotor
- 5.3 Complete jaw holder
- 5.4 Nosepiece (1 piece)
- 5.5 Jaw (2 pieces)



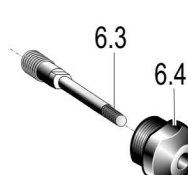
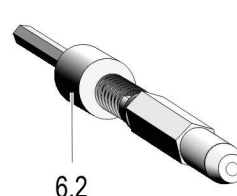
RiveDrill HP Spare Parts

- 2.1 Complete body
- 2.2 Complete rotor
- 2.3 Complete jaw holder
- 2.4 Nosepiece (1 piece)
- 2.5 Jaw (3 pieces)



NutDrill ND Spare Parts

- 3.1 Complete body
- 3.2 Complete rotor
- 3.3 Mandril
- 3.4 Nosepiece



NutDrill ND2 Spare Parts

- 6.1 Complete body
- 6.2 Complete rotor
- 6.3 Mandril
- 6.4 Nosepiece



Security AND USER CONDITIONS

Security

Use gloves on the operator hand that is holding RiveDrill or NutDrill and glasses and safety Wearing shoes. Work in correct and stable position. Keep the work area clear, without children or person around, external to work. Residual mandrels must be collected in suitable containers and deposited in containers classified according to environmental standards. Residual mandrels in the ground can cause slips and falls. Be aware of the reaction in the hand holding RiveDrill or NutDrill, which may increase if overheated or overloaded. In this case stop, cool and check the "Terms of Use"

RiveDrill - User conditions

- a) RiveDrill must be used only with reversible battery (cordless) drill, and with speed indicated on table "A". Drill Not included.
- b) Do not get over maximum size "Y"
- c) Use the correct nosepiece
- d) Stop immediately after break the mandrel of the rivet.
- e) If increase the reaction on the hand, stop and left cool.

NutDrill - User conditions

- a) NutDrill must be used only in reversible battery(cordless) drill, at minimum slow speed and with torque. Drill not included
- b) Test on the air with minimum speed without hitting to the end of the run
- c) Use always correct size of mandrel and guide.
- d) Determinate experimentally, rivetting on the air, before begin the work, the torque or the nut insert you are going to use.
- e) If increase the reacción on the hand, stop and left cool.

Warranty and Declaration of Conformity

Quality and Warranty

All our product had been submit to a final quality control on the 100% of the units of sale. In case of see any manufacture defect please contact with your distributor providing the purchase invoice. The defect produced because of no applying the "User conditions" that are included on the user manual, incorrect use, overheating or overloading or normal wear, also with the delivery and back charges, are excluded of the warranty. Our warranty is only refer to RiveDrill products. In any case to other product or the person which use them. Warranty is repair, substitute or return, depends on the cases

Declaration of Conformity

Maquinas Andrea, S.L. with address in C/ Islas Cies 61, 28035 Madrid (Spain) Declare the RiveDrill satisfies the requirements of Directive 2006/42 / EC in accordance with Annex V of the European Parliament and of the Council of 17 May 2006. RiveDrill is designed to be powered by a battery drill (not included) only after conformity is determined of the finished product with the requirement of the directive
1-Julio-2017
Administradora.
Nuria Pérez



Maintenance and repair

RiveDrill and NutDrill have a very easy maintenance that consist in the substitution in one of its two modules; Rotor or Tractor (jaw holder) that weigh very few and can be deliver quickly.

Our Por-sale service do not repair the pieces, that are substituted or provided complete, to warranty the perfect fuction, but we provide the spare parts necessary when is required. Any replament unit had to be sent freight paid, to the address we will give after inform technical service by phone or WhasApp to 34 693215339



A

RiveDrill models, maximum speed of drilling machine and resistance typical of rivets, depending on material, diameter, and type
Modelos RiveDrill, velocidad máxima de máquina taladradora y resistencia típica de remaches, según su material diámetro y tipo

A Rivet material, diameter and strength <i>Remaches, material, diámetro y resistencia</i>		Stainless Steel A2 <i>Acero Inox A2</i>					Structural Steel DIN 1.5511 <i>Acero Estructural DIN 1.5511</i>		Standard Steel DIN 1.0213 <i>Estandar Acero DIN 1.0213</i>						Aluminium 3.5% Mg <i>Aluminio 3,5% Mg</i>					Aluminium 2.5% Mg <i>Aluminio 2,5% Mg</i>				Rivet Type		
Diameter (in) <i>Diámetro (mm)</i>		1/4	3/16	5/32	1/8	3/32	1/4	3/16	1/4			3/16	5/32	1/8		1/4	3/16	5/32	1/8	3/32	1/4	3/16	5/32	1/8		Peeled, <i>Flor</i>
		6,4	4,8	4,0	3,2	2,4	6,4	4,8	6,4	6,0	5,0	4,8	4,0	3,2	3,0	6,4	4,8	4,0	3,2	2,4	6,4	4,8	4,0	3,2		
R Rivet strength (Newton)(*) <i>Resistencia remache (*)</i>		9000	5800	3500	2500	1250	8800	3900	5700	4800	4000	3100	2200	1200	1100	4800	2600	1800	1100	550	4000	2300	1400	980		
Y MAX (mm)																										
30	RiveDrill HP	✗	●	●	●	●	✗	●	●	●	✗	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
28	RiveDrill E95H.28										✗	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
20	RiveDrill E95H.20										✗	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
10	RiveDrill E95H											●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
10	RiveDrill E10												●	●	●	●	●	●	●	●	●	●	●	●	●	●
10	RiveDrill RD98																	●	●	●	●	●	●	●	●	●
Maximum speed <i>Máxima velocidad</i>		● 1400 r.p.m					● 450 r.p.m.					✗ Consulting / Consultando														

(*) Typical values of rivet strength may vary, depending on countries or manufacturers. The values given here are only approximate.

(*) Los valores típicos de resistencia de los remaches pueden variar según países o fabricantes. Los valores señalados aquí son solo aproximados.



Material	Inox A2						Acero							Aluminio			
Rosca	M10	M8	M6	M5	M4	M3	M12	M10	M8	M6	M5	M4	M3	M8	M6	M5	M4
Resistencia (Newton)	13400	11300	9600	7300	4800	2700	14700	11000	8400	6500	5100	3900	2400	6000	5000	4400	3600
NutDrill ND			●	●	●	●			●	●	●	●	●	●	●	●	●
NutDrill ND2				●	●	●				●	●	●	●	●	●	●	●



Smart RiveDrill

In the World



RiveDrill

In the World



www.rivedrill.es



**You can, buy, sell, use, repair or know,
RiveDrill, anywhere in
nuria.andrea@rivedrill.net**



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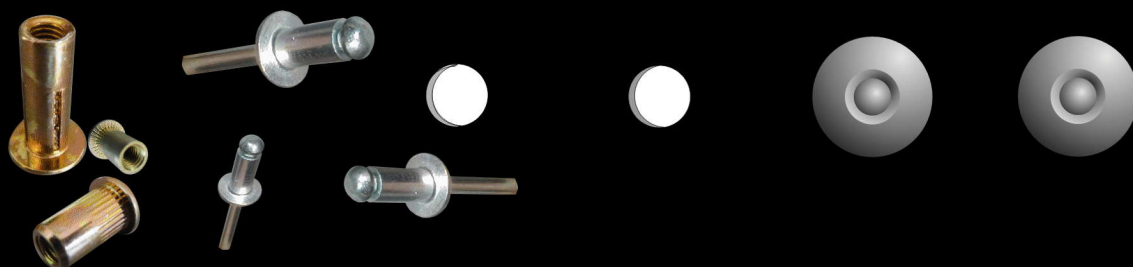
Máquinas Andrea, S.L.
At your service

Since 1966



Smart **RiveDrill**

Agujeros y remaches juntos para siempre



**RiveDrill con taladradoras,
la unión hace la potencia.**

Máquinas Andrea, S.L.
At your service

Since 1966