



MODEL:

1442

PRODUCT TYPE:

**13" NUT/THREAD SETTING HAND RIVETER KIT
WITH 3PC METRIC AND 3PC SAE MANDREL/NOSEPIECE SETS
AND RIVET NUT ASSORTMENT****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

This tool is intended to be used to install metric M5, M6, M8 and SAE 10-24, 1/4-20, 5/16-18 rivet nuts. 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**

- Use of this product can expose you to chemicals including ethylene glycol, gasoline vapors and engine exhaust, which are known to the State of California to cause cancer, birth defects, or reproductive harm. For more information, visit www.P65Warnings.ca.gov. Always wear ANSI approved safety equipment, safety glasses 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.

DRILL SIZE GUIDE

Metric

Nut Size	Drill Size
M5	7mm (9/32")
M6	9mm (3/8")
M8	11mm (7/16")

SAE

Nut Size	Drill Size
10-24	7mm (9/32")
1/4-20	9mm (3/8")
5/16-18	11mm (7/16")

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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:

- New "Toolless Quick-Change Head" design allows for easy changing of mandrels and nose pieces by hand
- Disassembly of tool never required, unique spring loaded inner hex sleeve automatically locks the rotation of hand installed mandrels
- Patented structure increases power and leverage
- 6 interchangeable mandrel/nosepiece sets in Metric M5, M6, & M8 and in SAE 10-24, 1/4-20, & 5/16-18
- Includes 10 pieces of each of the following rivet nuts: M5, M6, M8, 10-24, 1/4-20 and 5/16-18

ADDITIONAL SIZES AVAILABLE FROM YOUR SELLER:

8-32 (# 1442-8/32A)
10-32 (# 1442-10/32A)
3/8-16 (# 1442-3/8-16A)

SPECIFICATIONS:

Weight: 2.43 lbs. (1100g)
Length: 13" (330mm)
Max. Working Stroke: 9mm
Max. Effective Working Stroke: 7mm
Arm Force Multiplier: 30

DO NOT DISCARD – GIVE TO USER



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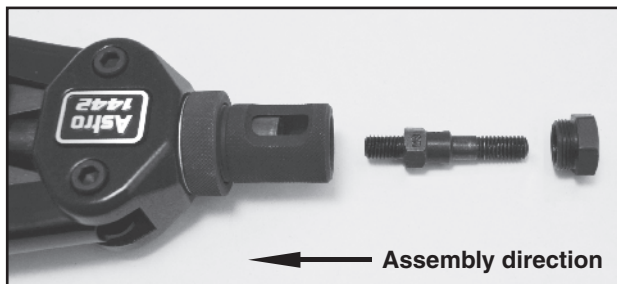
WARNING



Always wear ANSI approved safety goggles when using this product (Users and Bystanders). Failure to read and follow all warnings and operating instructions may result in damages and serious injuries or death.

OPERATING INSTRUCTIONS:

1. Choose the rivet nut size to be installed.
2. Install the correct size mandrel/nosepiece for the rivet nut to be installed. See photos and instructions for changing the mandrel/nosepiece and adjustment.
3. Drill a hole in the work product the same size or slightly larger than the outside diameter of the rivet nut to be installed.
4. To install the rivet nut, open the handles outward as far as possible and thread the rivet nut clockwise onto the mandrel until reaching the nosepiece.
5. Insert the rivet nut fastened to the riveter into the pre-drilled hole until flush with the work product, and pull handles inward to secure the rivet nut into the hole. If the rivet nut is loose in the hole, open the handles outward, turn #19 knob clockwise, and pull handles inward until the rivet nut is secure in the hole. Repeat as necessary until the rivet nut is secure in the hole. See adjustment instructions if necessary.
6. Turn the #19 knob counterclockwise until the mandrel is removed from the rivet nut. The rivet nut installation is complete if the rivet nut is secure from movement in the hole.



CHANGING MANDREL/ NOSEPIECE INSTRUCTIONS:

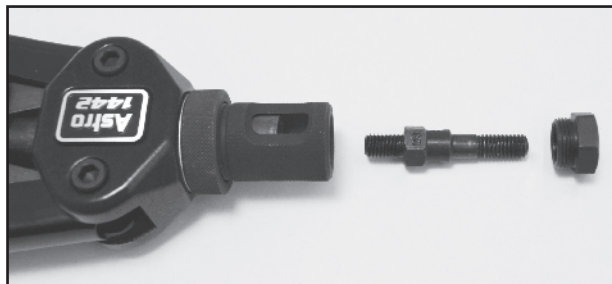
1. Remove and install the mandrel and nosepieces. Always keep the matched mandrel/nosepiece sets together.
2. Remove nosepiece from #3 sleeve by unthreading the nose piece counterclockwise. This can be done either by hand or with the provided wrench if too tight to do so.



3. Using your thumbnail or tool, press down to depress the #6 inner hexagonal sleeve that sits within the #3 outer sleeve. This should expose the lower hex portion of the mandrel.



4. Unthread the mandrel by hand to remove it from the sleeve. Once the mandrel has been threaded out far enough to clear the #6 hex sleeve you may release tension on this sleeve collar.
5. Choose the correct mandrel/nosepiece to be installed.



6. Thread the new mandrel into the tool by hand until it approaches the #6 hex sleeve and fully depress this sleeve to allow the mandrel to be threaded further until it stops. **The mandrel does not need to be torqued.** Release the hex sleeve and allow it to fully reengage the mandrel. If the mandrel and hex sleeve do not initially align, rotate the #19 knob while holding onto the mandrel until it clicks up and reengages.
7. Thread the matching nose piece into the #3 by hand. Torqueing the nose piece is optional.



IMPORTANT NOTICE



DO NOT USE TOO MUCH FORCE TO SET SMALLER SIZES, YOU WILL BREAK THE THREADED MANDREL. SET A PRACTICE RIVET NUT IN FRONT OF YOU IN THE AIR TO GAUGE THE FORCE REQUIRED. MANDRELS ARE CONSUMABLE PARTS.



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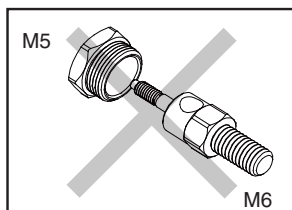
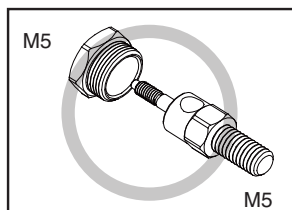
ADJUSTMENT INSTRUCTIONS:

1. Proper adjustment of the riveter is necessary for efficient and easy operation.
2. The adjustment of the riveter will vary, depending on the size and type of rivet nut being used and the hole size.
3. Adjust the riveter by opening the handles outward as far as possible loosening the #4 adjusting nut and turning the #3 outer sleeve clockwise to increase the number of threads on the mandrel protruding beyond the nosepiece for larger rivet nuts, and by turning the #3 outer sleeve counterclockwise for smaller rivet nuts. Once adjustment is set tighten the #4 adjusting nut by hand. Fine adjustment can be made by turning the rivet nut on the mandrel to position the rivet nut closer or further away from the nosepiece, as long as the mandrel is threaded all the way through the rivet nut.
4. Always assure that the mandrel is threaded into all threads of the rivet nut to prevent damage to the threads on the mandrel and/or the rivet nut.
5. If the handles are extended too far outward to provide enough leverage to pull the handles inward to set the rivet nut, turn the #3 outer sleeve clockwise or turn the rivet nut counterclockwise slightly to change the handle angle to provide the proper leverage.

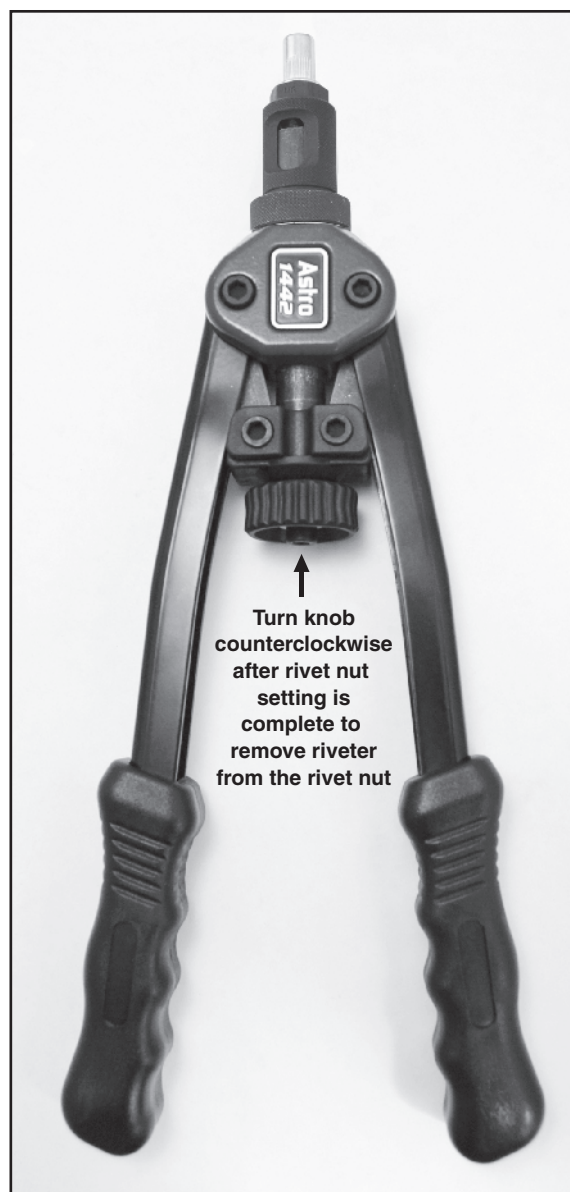


**Riveter properly prepared
for setting rivet nuts**

**⚠ Store matching nosepieces and mandrels
together when not in use to prevent mismatching
the sizes and for convenience.**

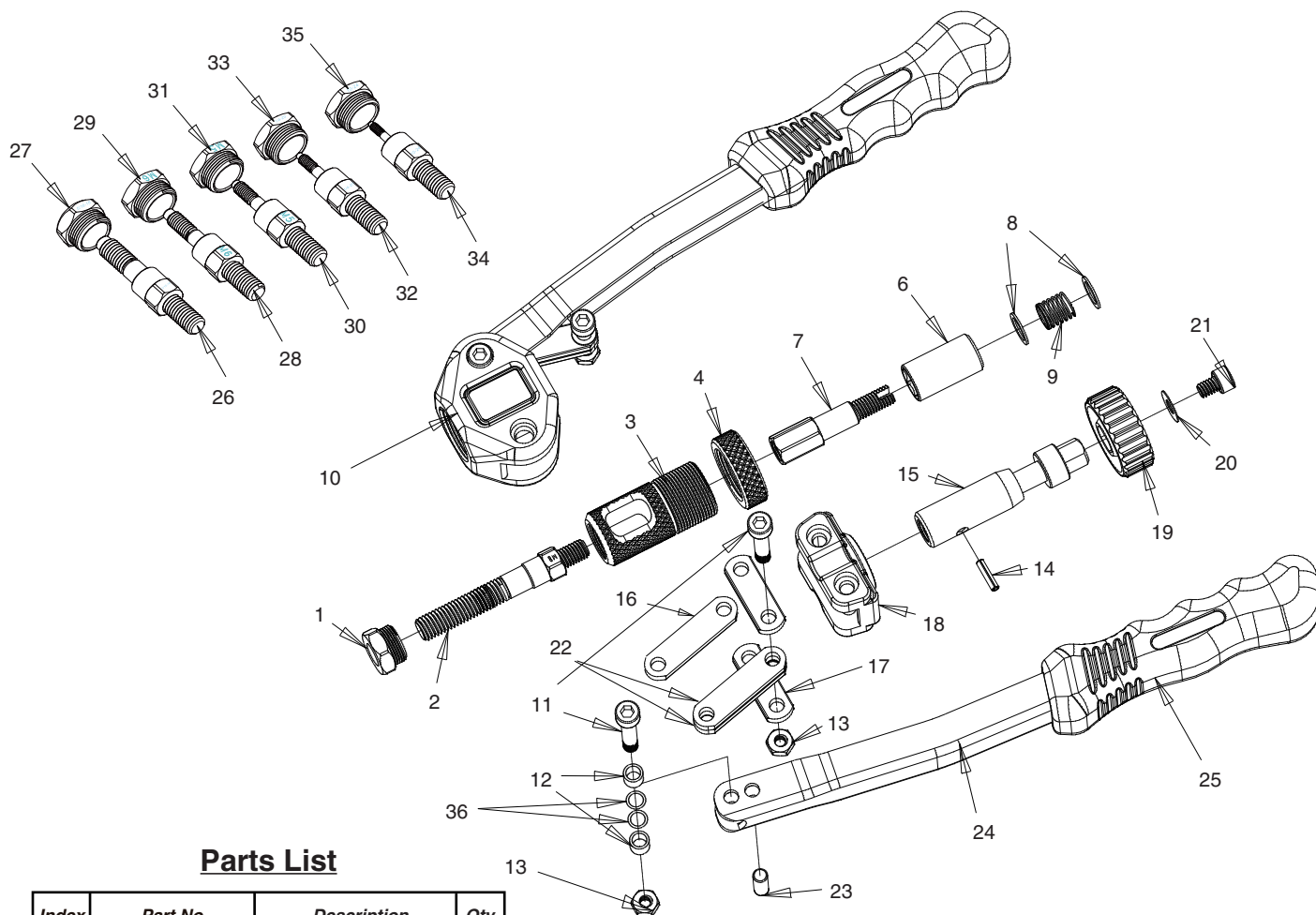


**Open handles
and thread
rivet nut
onto mandrel**



PARTS BREAKDOWN

Call 1.800.221.9705 for questions concerning performance of the product or other inquiries.



Parts List

Index	Part No.	Description	Qty
1	1442-A01	M8 Nosepiece	1
2	1442-A02	M8 Mandrel 8mmx1.25	1
3	1442-A03	Sleeve	1
4	1442-A04	Adjusting Nut	1
6	1442-A06	Hexagonal Sleeve	1
7	1442-A07	Riveting Bar	1
8	1442-A08	Spacer	2
9	1442-A09	Spring	1
10	1442-16	Main Body	1
11	1442-06	Screw	4
12	1442-04	Bushing	4
13	1442-03	Locknut	4
14	1442-A14	Opening Spring Pins	1
15	1442-A15	Pulling Bar	1
16	1442-36	Plastic Spacer	2
17	1442-09	Connecting Bar	2
18	1442-15	Main Shaft Drive	1
19	1442-13	Knob	1
20	1442-A20	Spacer	5

Index	Part No.	Description	Qty
21	1442-11	Screw	1
22	1442-08	Connecting Bar	4
23	1442-10	Bushing	2
24	1442-02	Handle	2
25	1442-01	Grip	2
26	1442-A26	Mandrel 5/16-18	1
27	1442-A27	5/16-18 Nosepiece	1
28	1442-A28	M6 Mandrel 6mmx1.0	1
29	1442-A29	M6 Nosepiece	1
30	1442-A30	M5 Mandrel 5mmx0.8	1
31	1442-A31	M5 Nosepiece	1
32	1442-A32	Mandrel 1/4-20	1
33	1442-A33	1/4-20 Nosepiece	1
34	1442-A34	Mandrel 10-24	1
35	1442-A35	10-24 Nosepiece	1
36	1442-37	Wire Washer	4