

SIRC[®]
HN-02 User Manual

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Replacement Mandrels

Stock Code	Size	Thread
MN-5	5mm	RHT
MN-6	6mm	RHT
MN-6LHT	6mmLHT	LHT
MN-8	8mm	RHT

LHT - Left Hand Thread



SIRC[®]
HN-02 User Manual

LHT/RHT Blind Nut Rivets (Nutserts) AISI 304

Stock Code	Thread	Grip Range	Hole Size	L	T	Flange O.D
SS-BRN-060.7-4LHT	M6 LHT	0.7-4.0mm	10mm	15	0.75	12.7
SS-BRN-060.7-4RHT	M6 RHT	0.7-4.0mm	10mm	15	0.75	12.7
SS-BRN-064.2-6.6LHT	M6 LHT	4.2-6.6mm	10mm	15	0.75	12.7
SS-BRN-064.2-6.6RHT	M6 RHT	4.2-6.6mm	10mm	15	0.75	12.7
SS-BRN-083.0-4.5RHT	M8 RHT	3.0-4.5mm	11mm	20	1	15
SS-BRN-103.0-4.5RHT	M10 RHT	3.0-4.5mm	13mm	24	1	17



Grip range indicates the material thickness suitable for use with nutsert.
LHT - Left Hand Thread RHT - Right Hand Thread T - Flange Thickness L - length

Ideal for use with the following **PRO RIG**[®] wire balustrade systems

Nutsert Swage Stud System™



PATENT No. 2009100455

Nutsert Tension Rod System™



PATENT No. 2009100456



Heavy Duty Nut Rivet Insert Tool
M4-M10

HN-02 Tool is designed for frequent use up to M6 steel, aluminium, and stainless steel Nut Rivets. For M8 and M10 Nut Rivets the tool should be restricted to occasional use only.

Suitable for all materials including Stainless Steel, Steel, Aluminium Blind Nut Rivets.
Included in the Box: 1 x Tool and 1 x M4, M5, M6, M8 & M10 Mandrels and Nose Pieces.

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CHANGING MANDREL SIZE:

Step 1: Pull out Screw Handle

1.



Unscrew the screw handle retaining nut and pull out the entire screw handle.

Step 2: Insert Mandrel

2.



Insert the mandrel (threaded end first) in to the body of the tool. Replace the screw handle using the screw handle retaining nut.

Step 3: Thread on the nose piece

3.

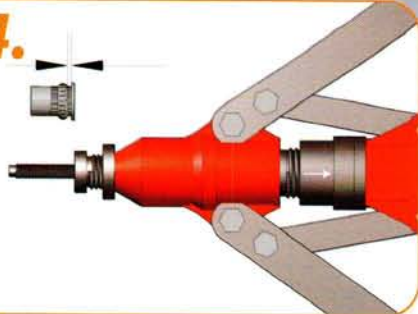


Thread the nose on to the main body of the tool. The nose piece being used must match the size of mandrel being used. Ensure the nose piece locking nut is on the nose piece before threading on.

STROKE & NOSE PIECE ADJUSTMENT:

Step 4: Increase Stroke length

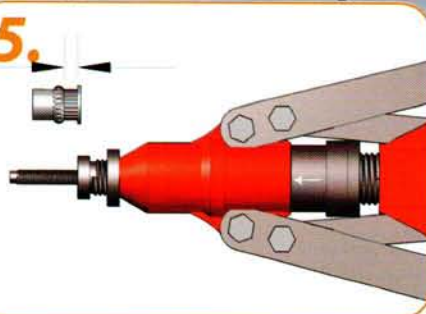
4.



To adjust the stroke to suit thinner walled materials unscrew the stroke adjusting nut. When in the desired position lock in place using the stroke adjustment locking nut.

Step 5: Decrease Stroke Length

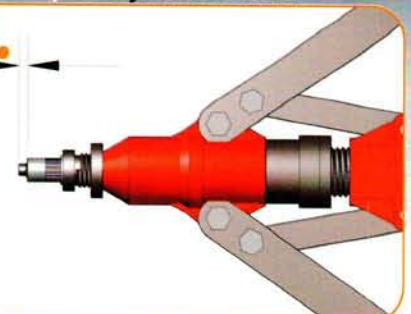
5.



To adjust the stroke to suit thicker walled materials screw the stroke adjusting nut. When in the desired position lock in place using the stroke adjustment locking nut.

Step 6: Adjust Nose Piece

6.



Adjust the nose piece so that the unthreaded tip of the mandrel protrudes from the end of the blind nut rivet when it is threaded on. Lock in place using the nose piece locking nut.

WARNING: Please ensure tool is correctly adjusted. Putting excessive pressure on the lever handles may cause damage to the tool.
TIP: Test the tool setting on a waste piece of material of the same thickness to ensure proper flaring of the blind nut rivet.

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THREADING ON THE NUT RIVET (NUTSERT):

Step 7: Prepare tool for the Nut Rivet

7.



Please Note: For LHT nut rivets move screw handle inwards

Prepare the tool for the nut rivet insertion by opening the handle levers and moving the screw handle outward. Moving the screw handle outward will rotate the mandrel anti clockwise.

Step 8: Thread on the Nut Rivet

8.

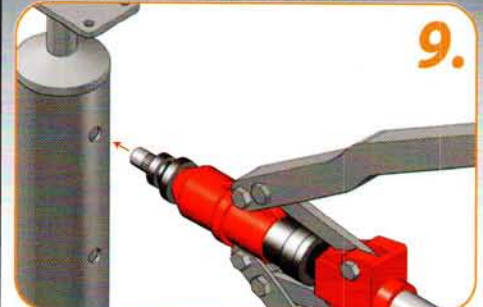


Please Note: For LHT nut rivets move screw handle outwards

Hold the nut rivet against the thread on the mandrel. Simultaneously push the screw handle inwards. Pushing the screw handle inwards will thread the nut rivet on to the mandrel.

Step 9: Insert Nut Rivet into hole

9.



With the nut rivet on the mandrel of the tool insert the nut rivet in to the pre-drilled hole.

INSERTING THE NUT RIVET (NUTSERT):

Step 10: Compress Nut Rivet

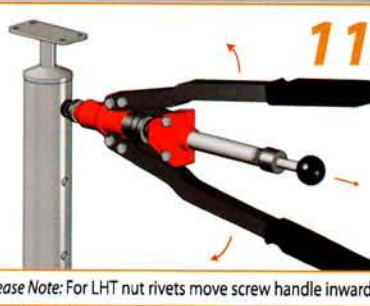
10.



Push the tool lever handles inwards to compress the nut rivet against the wall of the tube. This will fasten the nut rivet in place.

Step 11: Release the tool

11.



Please Note: For LHT nut rivets move screw handle inwards

Release the lever handles and pull the screw handle outwards. This will unthread the mandrel from the nut rivet.

Step 12: The finished Nut Rivet

12.



The nut rivet should now be securely in place and unable to turn. This will give you an extremely strong fixing thread for your required application.

WARNING: Please ensure tool is correctly adjusted. Putting excessive pressure on the lever handles may cause damage to the tool.
TIP: If the mandrel is difficult to unthread from the nut rivet, the compression may be too great. Try reducing the stroke.

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