

KRAFTWERK®

FAVORITE TOOLS SINCE 1979

Instruction Manual

Industrial lever hand rivet nut tool kit

Art. 4264

EN



A. FEATURES

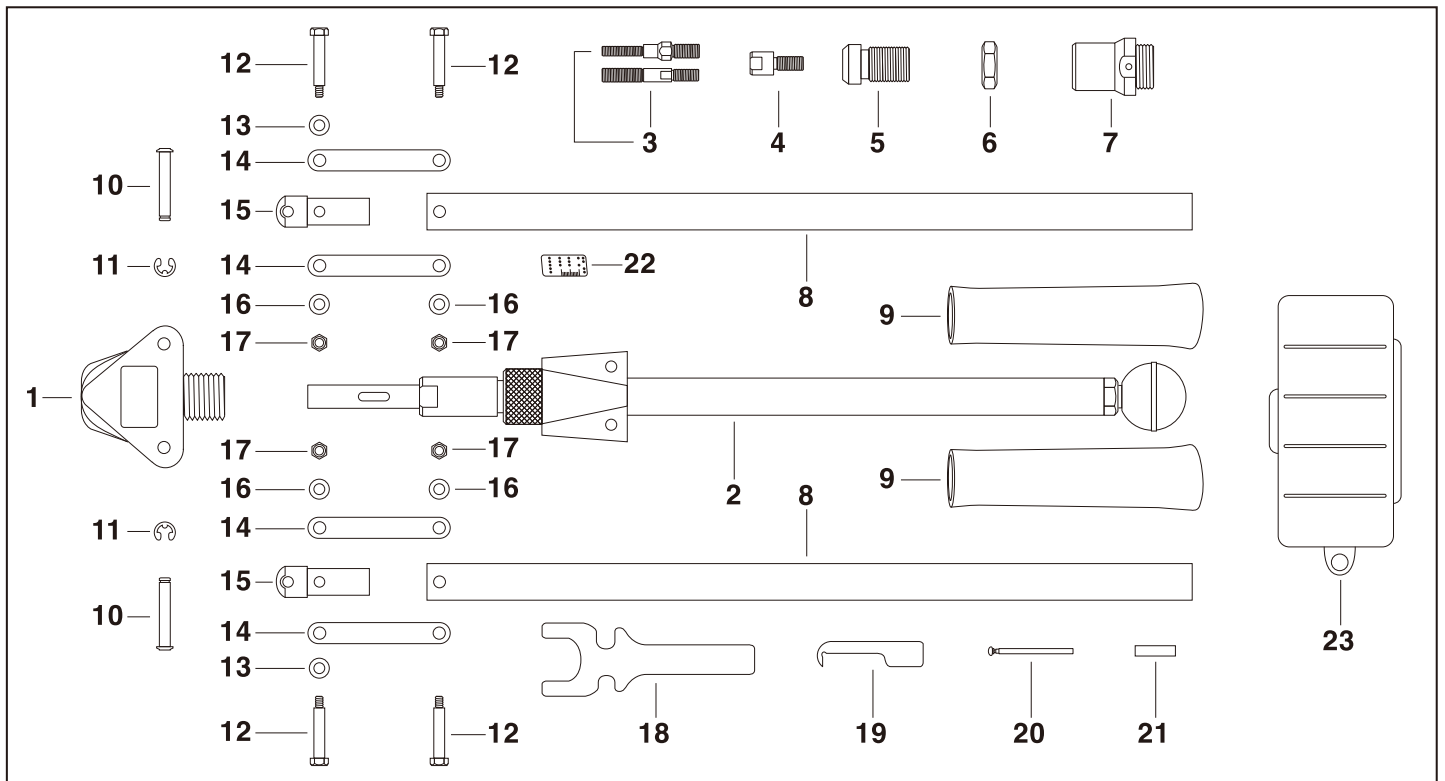
- **4264 RIVET NUT TOOL** is designed to fasten **RIVET NUTS** with the **THREADED MANDRELS**, from M5 x 0.8 up to M10 x 1.5 in all materials (Aluminum, Steel and Stainless Steel/Inox) firmly and build up enough **Female Threads** securely in the thin base metals and pipes with weldless, tapping-free and one-side work in order to fasten with a **Bolt**.
- **4264** is also designed to set **RIVET BOLTS/STUDS** with the optional **THREADED SOCKETS**, from M5 x 0.8 up to M8 x 1.25 in all materials (Aluminum, Steel and Stainless Steel/Inox) firmly and build up enough **Male Threads** securely on the thin base metals and pipes with weldless and one-side work in order to fasten with a **Nut**.
- **4264** is equipped with a **QUICK-DRILL UNIT**, just "Push & Pull" the DRILL UNIT KNOB to drive THREADED MANDREL or THREADED SOCKET to engage with and release from RIVET NUT or RIVET BOLT/STUD quickly!
- **4264** is equipped with a **worldwide patented FIXING-HOLES DEVICE**, simply inserts the FIXING-HOLE PIN not only to solve the headache problem of RIVET NUT stuck on the working THREADED MANDREL or RIVET BOLT/STUD stuck in the working THREADED SOCKET that might happen when engaging with or fastening RIVET NUT or RIVET BOLT/STUD, but also to assist THREADED MANDREL or THREADED SOCKET to mount to or dismount from the TOOL easily just with a single SERVICE WRENCH.

B. SPECIFICATIONS

- **4264 Tool Dimensions and Net Weight:**
Dimensions (Closed type): L 530 x W 130 mm. Net Weight: 2.15 kgs.
- **4264 Working Capacity:**
 - 1) RIVET NUTS/THREADED INSERTS (Aluminum, Steel, Stainless Steel/Inox)
ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25, M10x1.5 (M4x0.7 available)
 - *2) RIVET BOLTS/STUDS (Aluminum, Steel, Stainless Steel/Inox)
ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25

* **4264** can fasten RIVET BOLTS/STUDS with the optional THREADED SOCKETS on request.
- **4264 Standard Accessories:**
 - 1) THREADED MANDRELS:
ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25, M10x1.5 : 1 pc of each.
 - 2) NOSEPIECES:
ISO Metric Size: M5, M6, M8, M10 : 1 pc of each.
 - 3) NOSEPIECE LOCK NUT, SERVICE WRENCH, SMALL RULE, FIXING-HOLE PIN, PIN RETAINER, PARTS PLASTIC BOX, TRAY, STEEL CARRY CASE, OPERATION MANUAL:
1 pc of each.
- **4264 Optional Accessories:**
 - 1) THREADED MANDRELS: M4 x 0.7
 - 2) THREADED SOCKETS (to fasten RIVET BOLTS/STUDS):
ISO Metric Thread Size: M5x0.8, M6x1.0, M8x1.25

C. PARTS LIST



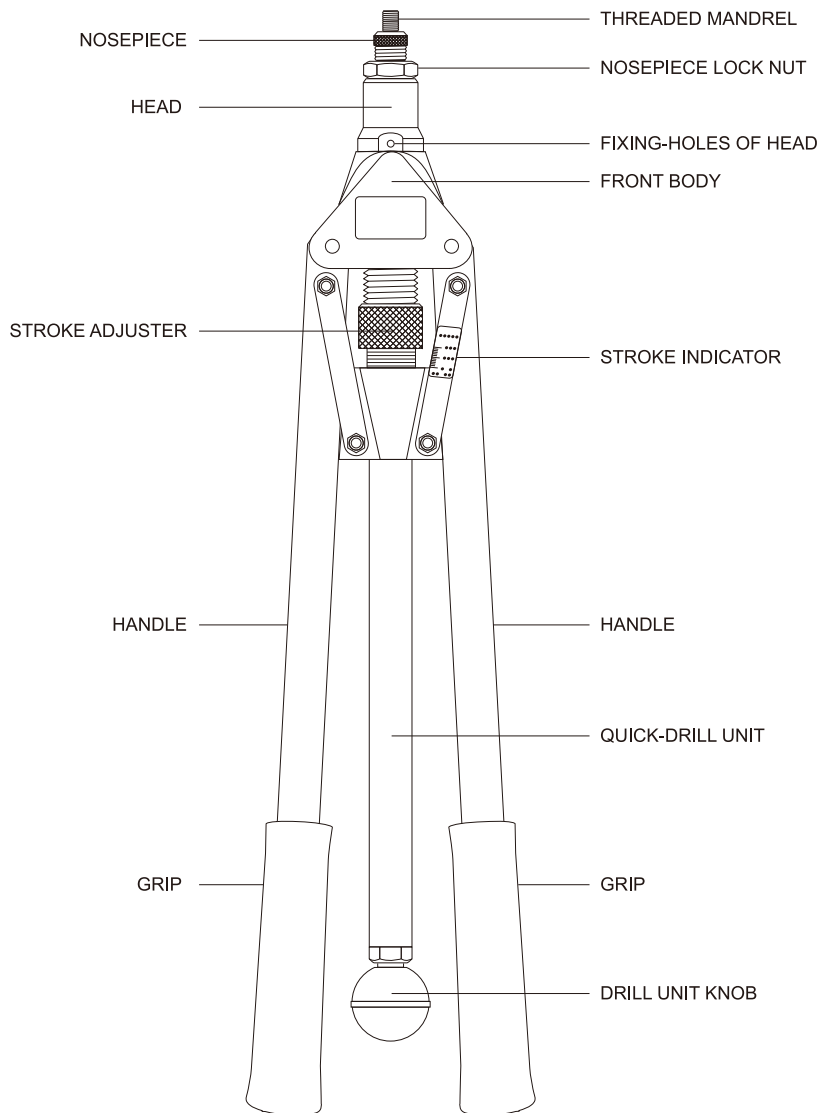
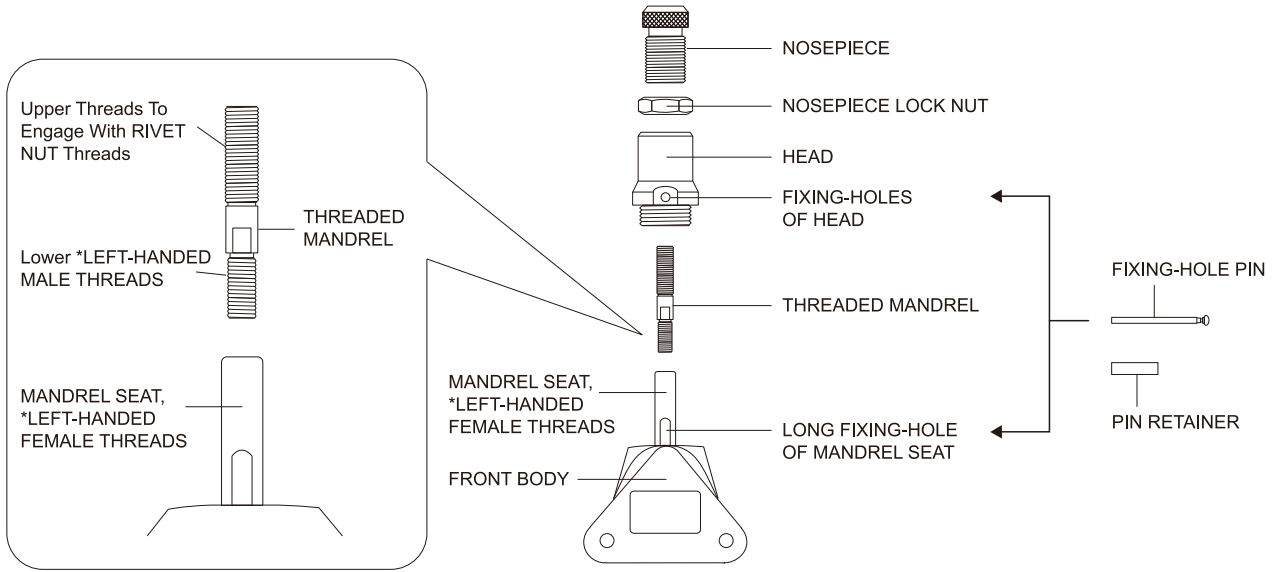
No	Part Name
1	Front Body
2	Quick-Drill Unit, Complete Set
• 3-M4	Threaded Mandrel, M4x0.7 (Option)
• 3-M5	Threaded Mandrel, M5x0.8
• 3-M6	Threaded Mandrel, M6x1.0
• 3-M8	Threaded Mandrel, M8x1.25
• 3-M10	Threaded Mandrel, M10x1.5
• 4-M5	Threaded Socket, M5x0.8 (Option)
• 4-M6	Threaded Socket, M6x1.0 (Option)
• 4-M8	Threaded Socket, M8x1.25 (Option)
• 5-M4	Nosepiece, for M4 (Option)
• 5-M5	Nosepiece, for M5
• 5-M6	Nosepiece, for M6
• 5-M8	Nosepiece, for M8
• 5-M10	Nosepiece, for M10

No.	Part Name
• 6	Nosepiece Lock Nut
7	Head
8	Handle
9	Grip
10	Pin, L329
11	Snap Ring
12	Bolt, L252
13	Washer, 12x6
• 14	Arm
15	Joint
16	Washer, 10x5
17	Nylon Nut, M5
18	Service Wrench
19	Small Rule
20	Fixing-Hole Pin
21	Pin Retainer
22-MA	Stroke Indicator, Metric & Inch Sizes
22-A	Stroke Indicator, Inch Size
23	Parts Plastic Box
24	Steel Carry Case (Not Shown)
25	Tray (Not Shown)

REMARKS:

- 1) • means Wearing Parts.
- 2) Threaded Mandrels are for setting Rivet Nuts.
- 3) Each Nosepiece can set same size of Rivet Nut and Rivet Bolt/Stud.

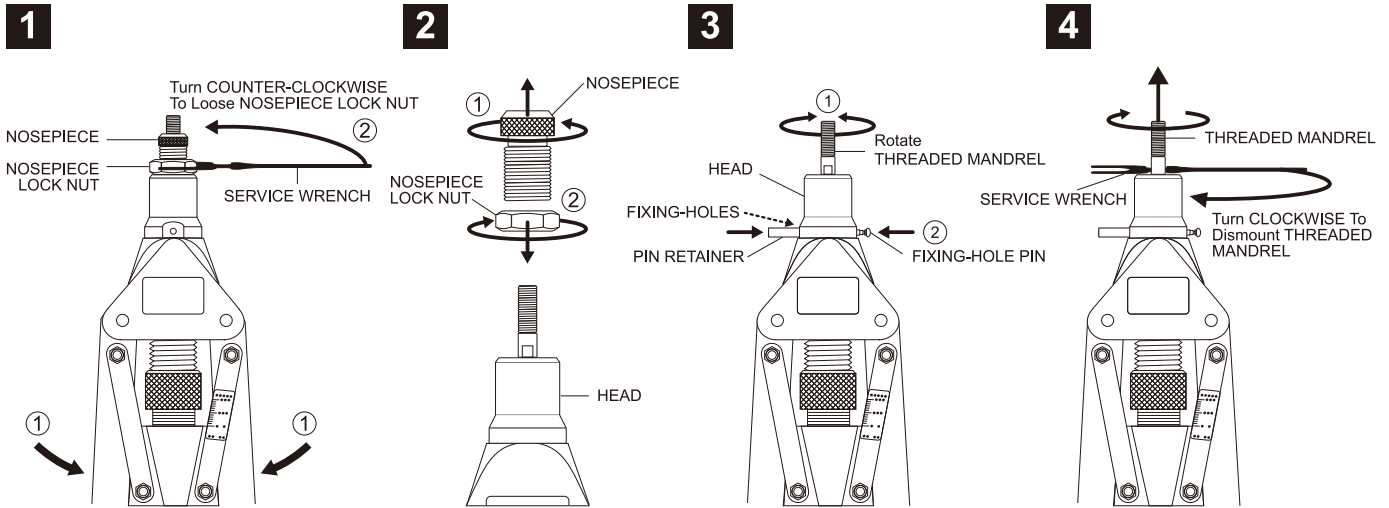
D. MAIN PARTS NAME



E. HOW TO CHANGE THREADED MANDREL AND NOSEPIECE

PRECAUTION :

Check the Thread Size of Fastening BOLT and WORKPIECE Thickness to determine the Thread Size, Grip Range, Material and Type of RIVET NUT, then drill or punch the correct size of Hole in the WORKPIECE to fasten RIVET NUT. The Working Size of THREADED MANDREL and NOSEPIECE should be same as the Thread Size of RIVET NUT.

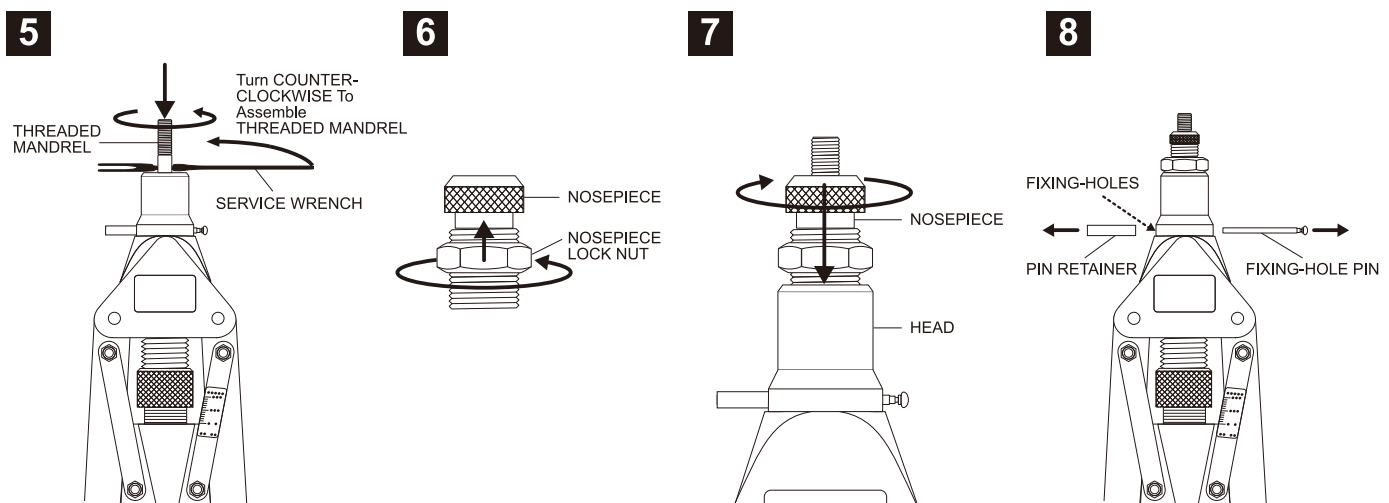


Close 2 HANDLES completely ①, use SERVICE WRENCH to loose NOSEPIECE LOCK NUT by turning Counter-Clockwise ②.

Use Hand to unscrew NOSEPIECE and NOSEPIECE LOCK NUT from HEAD ①, then dismount NOSEPIECE LOCK NUT from NOSEPIECE ②.

Use Hand to rotate THREADED MANDREL to align 2 FIXING-HOLES of HEAD with inside LONG FIXING-HOLE of MANDREL SEAT ①, then insert FIXING-HOLE PIN through the FIXING-HOLES and put PIN RETAINER onto FIXING-HOLE PIN End ②. The free rotation of MANDREL SEAT is locked.

Use SERVICE WRENCH and Hand to loose and dismount THREADED MANDREL from MANDREL SEAT by turning Clockwise. (NOTE: MANDREL SEAT has Left-Handed Female Threads.)
Now the TOOL is ready for changing another size of THERADED MANDREL and NOSEPIECE.



Use Hand and SERVICE WRENCH to assemble the working size of THREADED MANDREL into MANDREL SEAT firmly by turning Counter-Clockwise. (NOTE: MANDREL SEAT has Left-Handed Female Threads.)

Use Hand to assemble NOSEPIECE LOCK NUT onto the working size of NOSEPIECE.

Use Hand to screw NOSEPIECE into HEAD by turning Clockwise.

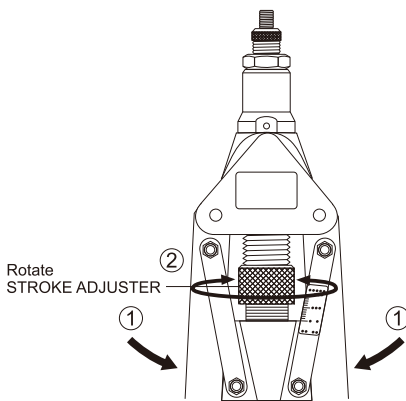
Finally, take off PIN RETAINER and pull FIXING-HOLE PIN from the FIXING-HOLES.

F. HOW TO ADJUST STROKE DISTANCE

[WARNING]

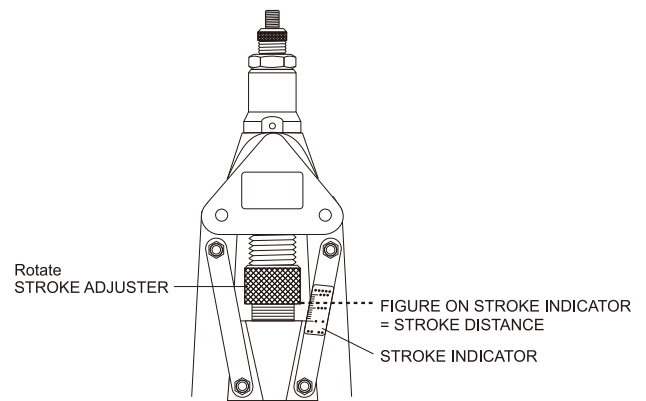
- The proper Stroke Distance is decided as per the WORKPIECE Thickness and the Grip Range of RIVET NUT. Each RIVET NUT has its own Grip Range, the Maximum Grip and Minimum Grip.
- The WORKPIECE Thickness must be WITHIN the Grip Range of RIVET NUT or BETWEEN the Maximum Grip and Minimum Grip of RIVET NUT for safe and firm fastening.
- If the Maximum Grip of RIVET NUT is SMALLER than the WORKPIECE Thickness, this TOOL and RIVET NUT Threads might be damaged.
- If the Minimum Grip of RIVET NUT is LARGER than the WORKPIECE Thickness, this RIVET NUT can not be gripped firmly in the WORKPIECE.
- Adjusting TOO LONG Stroke Distance might damage this TOOL and RIVET NUT Threads, while TOO SHORT Stroke Distance can not fasten RIVET NUT firmly in the WORKPIECE.

1



Close 2 HANDLES completely ①, rotate STROKE ADJUSTER ② to adjust the proper Stroke Distance in 2 popular ways.

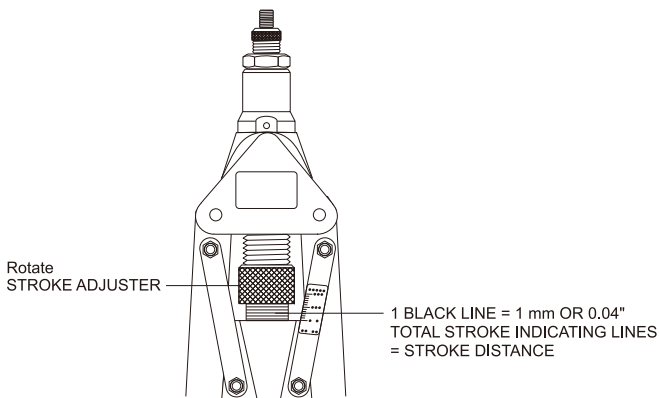
2



First Way: Rotate STROKE ADJUSTER to find out the Figure on the STROKE INDICATOR parallel with the Bottom Edge of the STROKE ADJUSTER:

Figure on STROKE INDICATOR = Stroke Distance

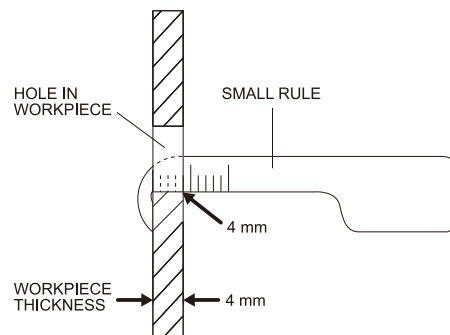
3



Second Way: Rotate STROKE ADJUSTER to find out the Total Exposed Black Lines of the STROKE INDICATING LINES:

1 Black Line = 1 mm or 0.04" Stroke Distance

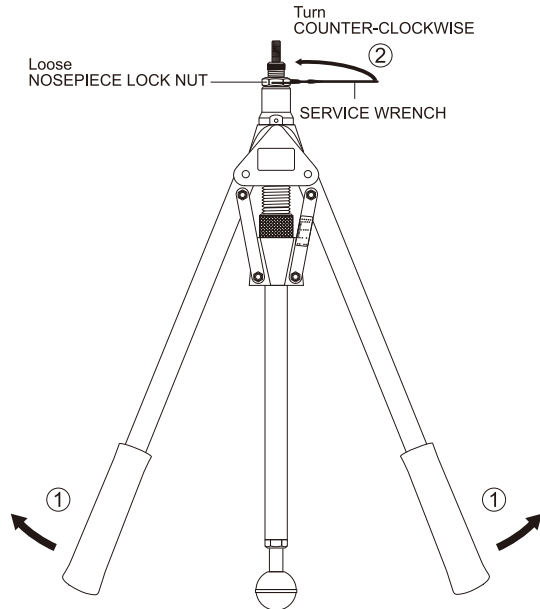
NOTE



NOTE: The SMALL RULE is specially designed to measure the WORKPIECE Thickness.

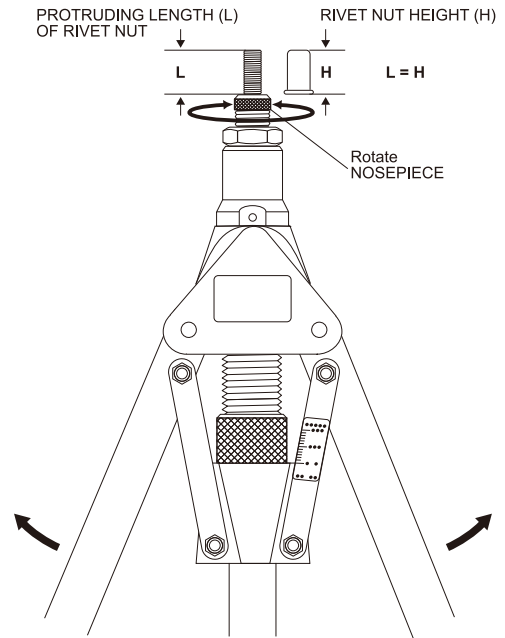
G. HOW TO ADJUST THE PROTRUDING LENGTH (L) OF THREADED MANDREL

1



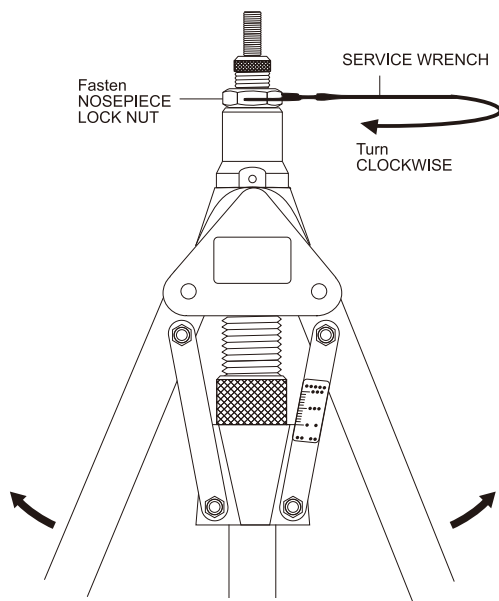
Open 2 HANDLES fully ①, use SERVICE WRENCH to loose NOSEPIECE LOCK NUT by turning Counter-Clockwise ②.

2



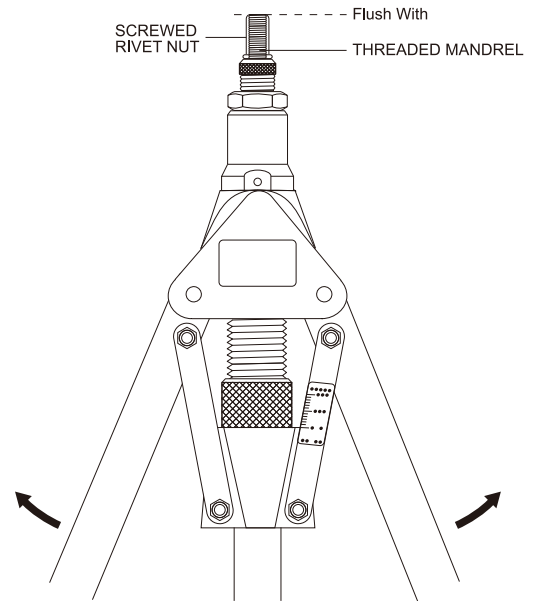
Use Hand to rotate NOSEPIECE to adjust the **Protruding Length (L)** of **THREADED MANDREL** to be same as the **RIVET NUT Height (H)**, $L = H$.

3



Finally use SERVICE WRENCH to fasten NOSEPIECE LOCK NUT by turning Clockwise.

NOTE

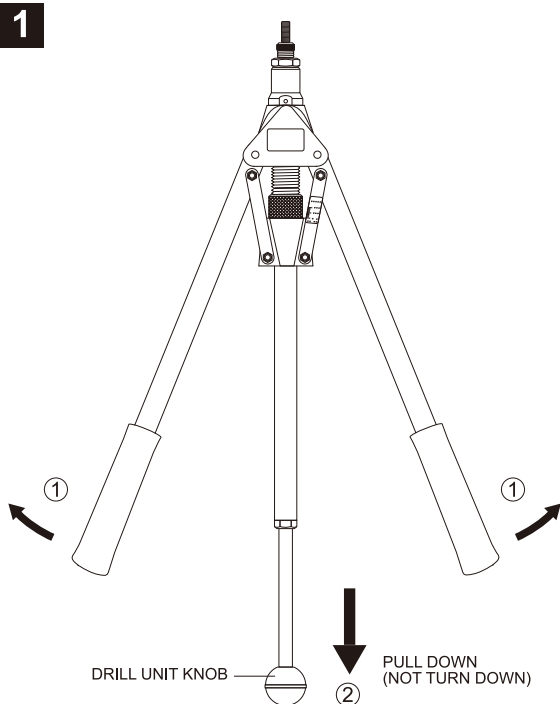


NOTE: After adjusting the Protruding Length(L) of **THREADED MANDREL**, the Screwed **RIVET NUT** should be flush with the **THREADED MANDREL**.

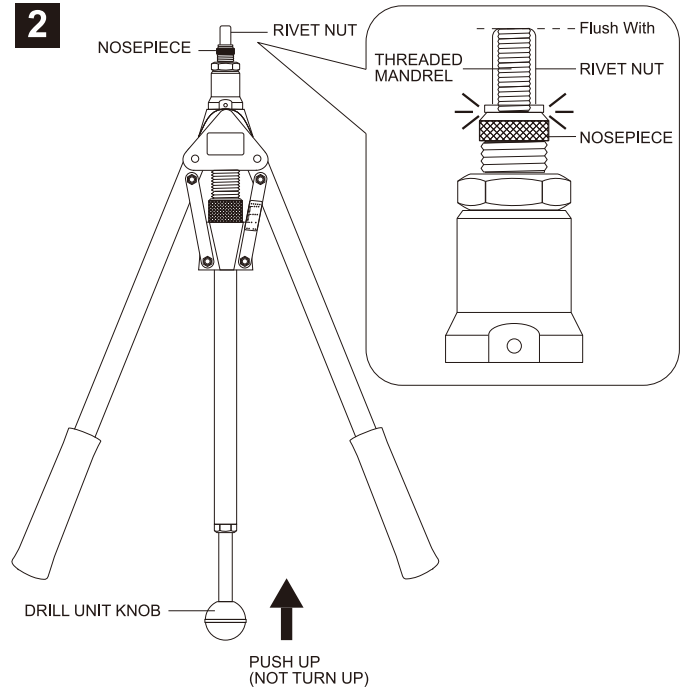
H. HOW TO OPERATE THIS TOOL TO SET RIVET NUT

PRECAUTION:

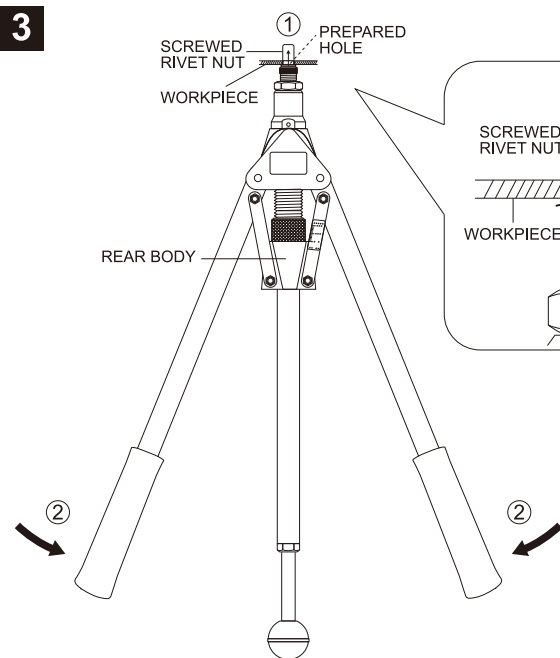
Before operating this TOOL, it is strongly requested to follow the above "E" to install the correct size of THREADED MANDREL and NOSEPIECE, the above "F" to adjust the proper Stroke Distance, and the above "G" to adjust the suitable Protruding Length (L) of THREADED MANDREL for engaging with RIVET NUT.



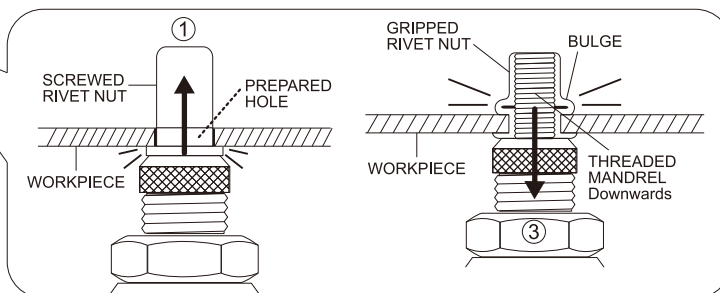
Open 2 HANDLES fully ①, Pull Down (NOTE: Not Turn Down) DRILL UNIT KNOB completely ②.



Screw RIVET NUT onto THREADED MANDREL by Pushing Up (NOTE: Not by Turning Up) DRILL UNIT KNOB Slowly until RIVET NUT touches NOSEPIECE. It is strongly suggested the RIVET NUT to touch the NOSEPIECE Slightly, NOT HEAVILY! The Screwed RIVET NUT should be flush with the THREADED MANDREL.



Insert the Screwed RIVET NUT into the Prepared Hole of WORKPIECE to touch WORKPIECE ①. Squeeze 2 HANDLES to touch REAR BODY ②, that drives THREADED MANDREL downwards to deform RIVET NUT a Bulge against the back of WORKPIECE to fasten RIVET NUT in the WORKPIECE ③.



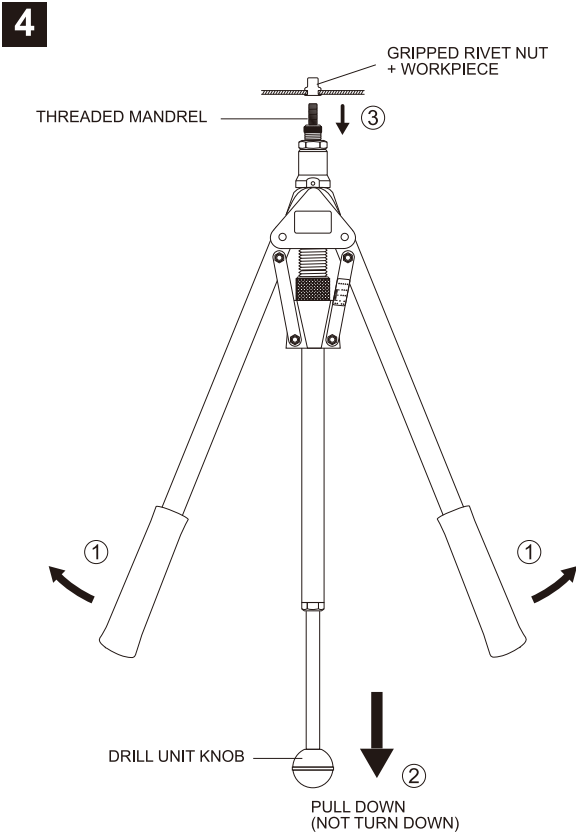
NOTE:

It is always suggested to SQUEEZE 2 HANDLES WITH BALANCED HAND FORCE to deform RIVET NUT a Normal Bulge against the back of WORKPIECE.

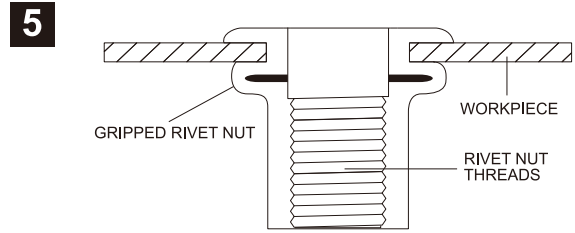
[WARNING]

If hand force CAN NOT squeeze 2 HANDLES to touch REAR BODY, DO NOT CONTINUE TO SQUEEZE 2 HANDLES, it may be caused by TOO LONG Stroke Distance. REDUCE The Stroke Distance immediately to protect this precious TOOL and RIVET NUT Threads from damage. See TROUBLESHOOTING K-2).

H. HOW TO OPERATE THIS TOOL TO SET RIVET NUT



Open 2 HANDLES fully ①, Pull Down (NOTE: Not Turn Down) DRILL UNIT KNOB ② to unscrew THREADED MANDREL from the Grippled RIVET NUT completely ③.

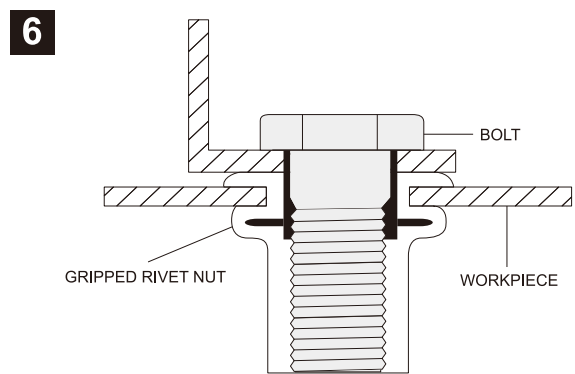


The RIVET NUT is therefore gripped in the WORKPIECE firmly and the RIVET NUT Threads are built up securely.

NOTES:

IF THE RIVET NUT IS NOT FASTENED FIRMLY, please refer to the TROUBLESHOOTING K-1).

IF 2 HANDLES CAN NOT BE SQUEEZED TO TOUCH REAR BODY, please refer to the TROUBLESHOOTING K-2).



Complete the fastening work with a Bolt to the Grippled RIVET NUT.

I. HOW TO FASTEN THE SAME SIZE OF RIVET NUT

If the next gripping RIVET NUT is same size as previous one, just repeat the above "H" steps.

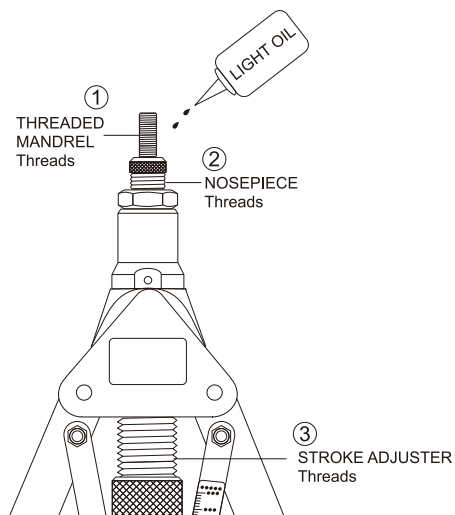
Don't Need Any Adjustment!

NOTE:

The PILOT TEST is always recommended before setting different sizes of RIVET NUT for proper fastening and protecting this precious TOOL and RIVET NUT Threads from damage.

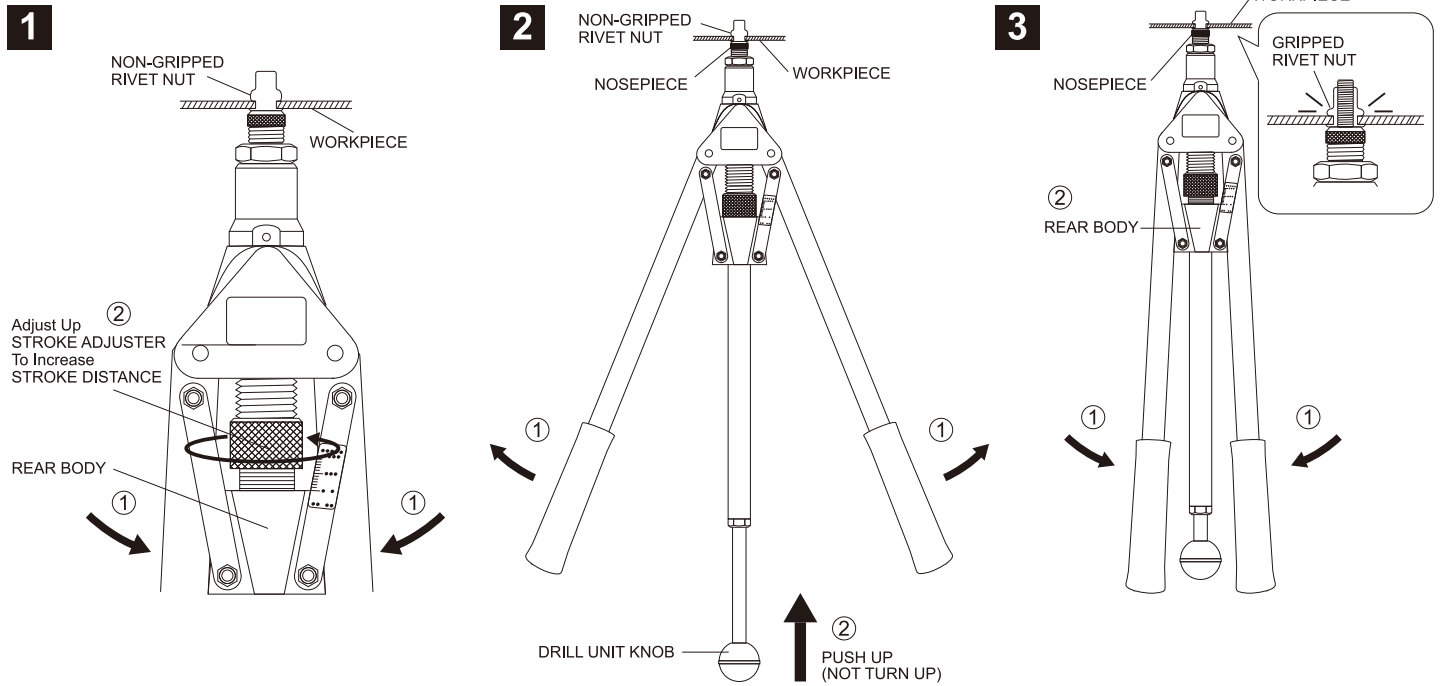
J. MAINTENANCE

This TOOL is a very sturdy and reliable tool, it only requires occasional Light Oil applied to the Threads of the THREADED MANDREL ①, NOSEPIECE ② and STROKE ADJUSTER ③.



K. TROUBLESHOOTING

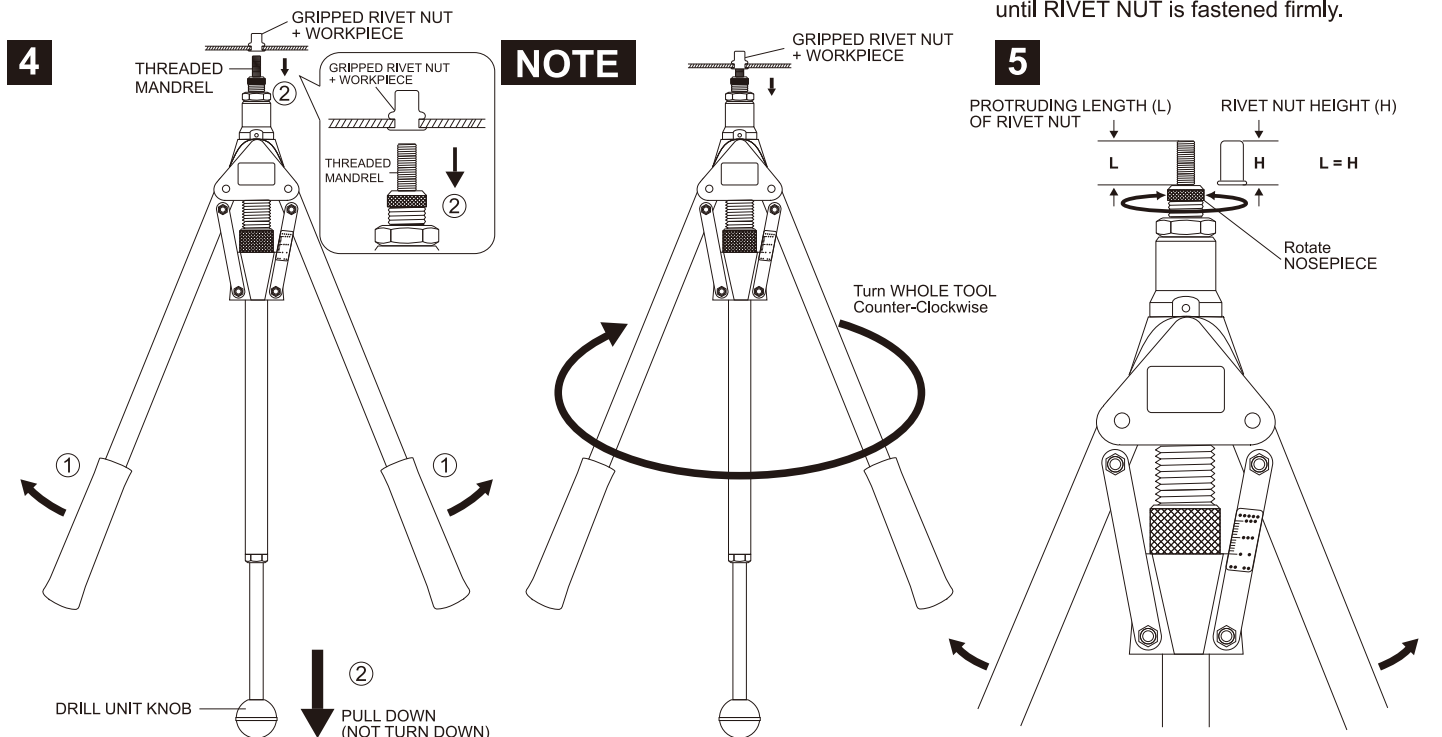
K-1) IF THE RIVET NUT IS NOT SET FIRMLY IN THE FIRST FASTENING OPERATION, HOW TO RE-SET THE RIVET NUT FIRMLY:



Still hold to squeeze 2 HANDLES to touch REAR BODY ①, adjust the STROKE ADJUSTER upward to increase the Stroke Distance 1.0mm or 0.04" step by step to try ②.

Open 2 HANDLES fully ① and Push Up (NOTE: Not Turn Up) DRILL UNIT KNOB until RIVET NUT touches NOSEPIECE Slightly ②.

Squeeze 2 HANDLES ① to grip again RIVET NUT until 2 HANDLES touch REAR BODY ②. If RIVET NUT is still not fastened firmly, repeat the above steps until RIVET NUT is fastened firmly.



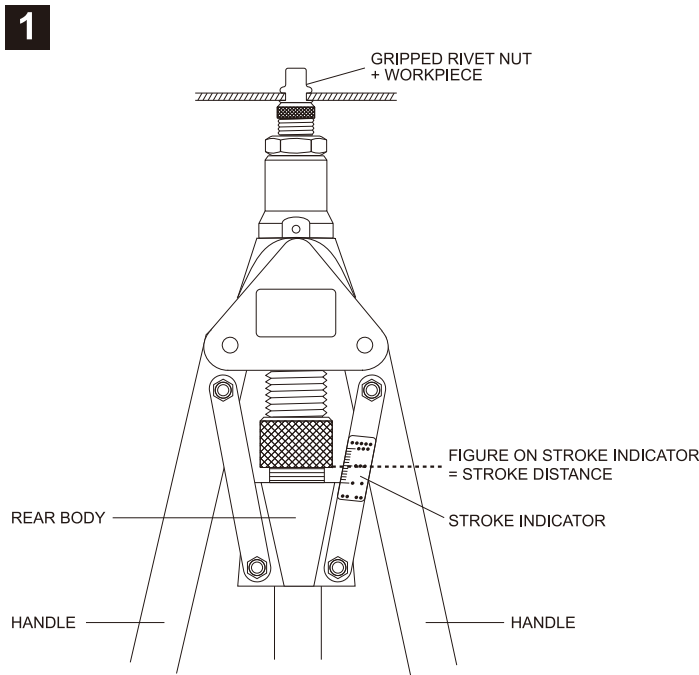
Open 2 HANDLES fully ① and Pull Down (NOTE: Not Turn Down) DRILL UNIT KNOB to unscrew THREADED MANDREL from the GrippED RIVET NUT and WORKPIECE ②.

NOTE: If the THREADED MANDREL still does not unscrew from the GrippED RIVET NUT and WORKPIECE, turn whole TOOL Counter-Clockwise to unscrew completely.

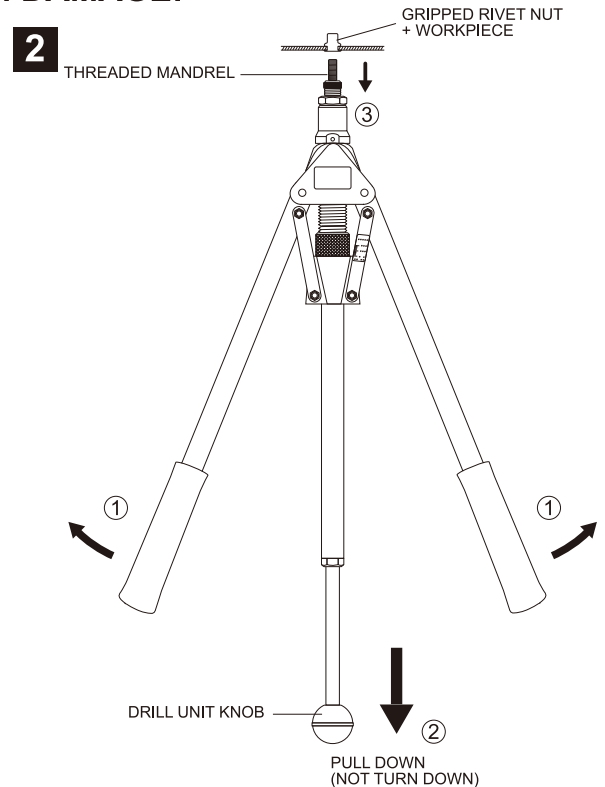
As the Stroke Distance has been re-adjusted, the Protruding Length (L) of THREADED MANDREL needs to be adjusted again to be same as RIVET NUT Height (H), $L = H$, as per the above "G" instruction.

K. TROUBLESHOOTING

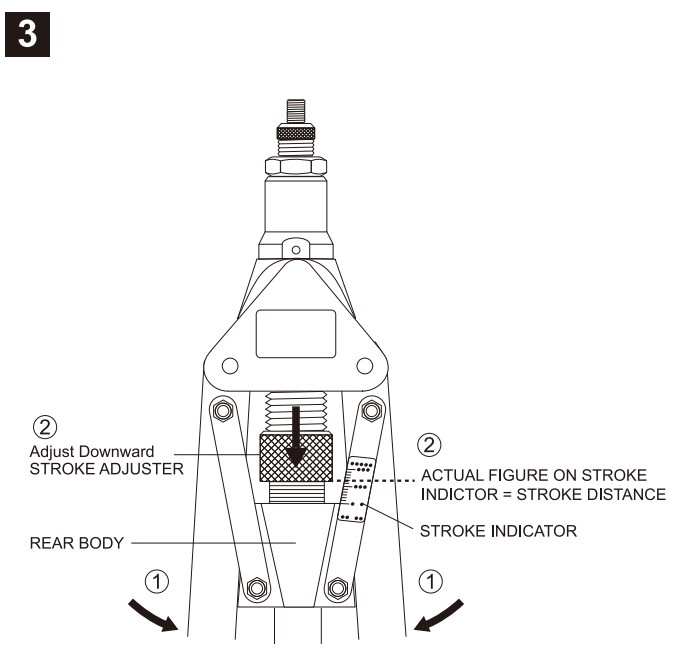
K-2) IF HAND FORCE CAN NOT SQUEEZE 2 HANDLES TO TOUCH REAR BODY, HOW TO RE-ADJUST THE CORRECT STROKE DISTANCE TO PROTECT THIS TOOL AND RIVET NUT THREADS FROM DAMAGE:



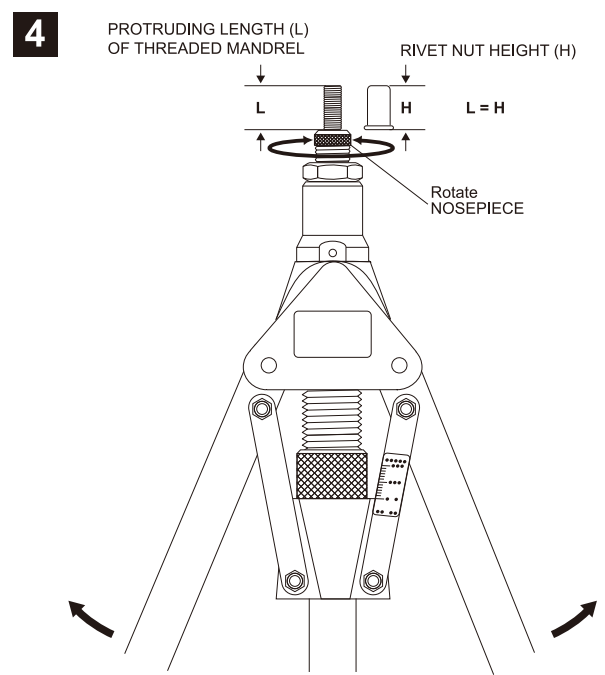
WARNING
DO NOT CONTINUE TO SQUEEZE 2 HANDLES!
 DO NOT CONTINUE TO SQUEEZE 2 HANDLES, still hold 2 HANDLES and find out the Actual Figure on STROKE INDICATOR and remember that.



Open 2 HANDLES fully ① and Pull Down (NOTE: Not Turn Down) DRILL UNIT KNOB ② to unscrew THREADED MANDREL from the Gripped RIVET NUT and WORKPIECE ③.



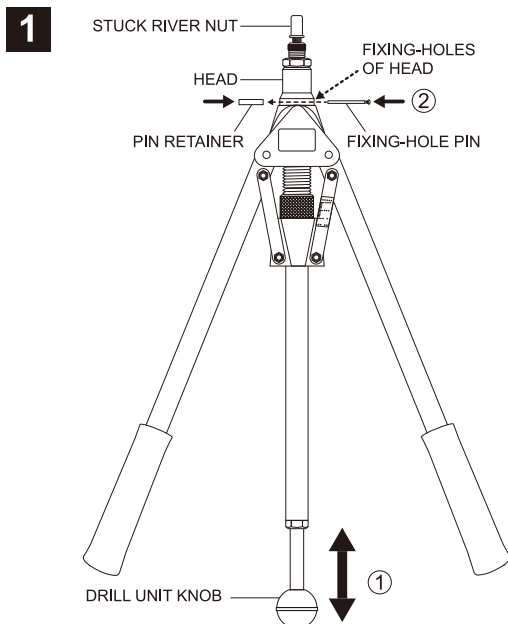
Close 2 HANDLES completely ① to touch REAR BODY, and adjust the STROKE ADJUSTER downward to let Bottom Edge of STROKE ADJUSTER parallel with the ACTUAL FIGURE ON STROKE INDICATOR ②. Now the correct Stroke Distance has been re-adjusted.



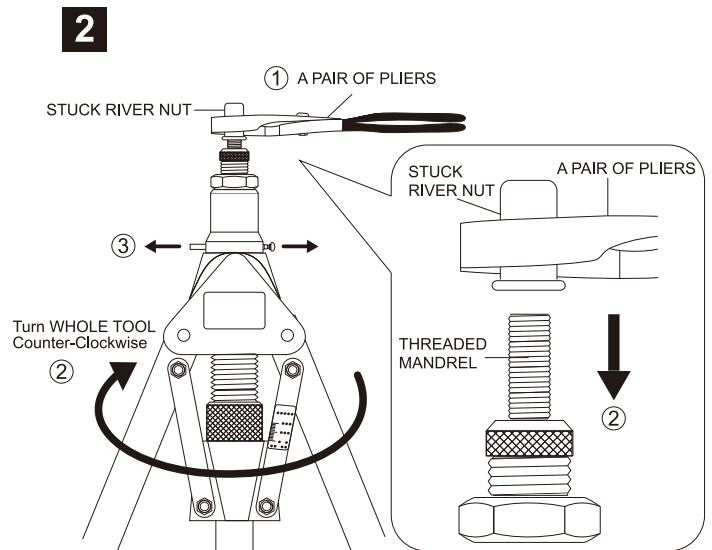
As the Stroke Distance has been re-adjusted, the Protruding Length (L) of THREADED MANDREL needs to be adjusted again to be same as RIVET NUT Height (H), $L = H$, as per the above "G" instruction.

K. TROUBLESHOOTING

K-3) HOW TO RESOLVE THE PROBLEM OF RIVET NUT STUCK ON THE THREADED MANDREL WHEN RIVET NUT SCREWS ONTO THREADED MANDREL'S THREADS BY PUSHING UP THE DRILL UNIT KNOB:

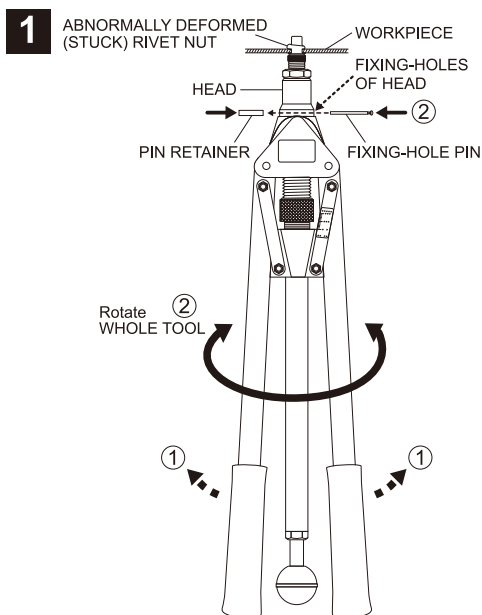


Pull Down and Push Up DRILL UNIT KNOB to align the FIXING-HOLES of HEAD with the inside LONG FIXING-HOLE of MANDREL SEAT ①, then plug the FIXING-HOLE PIN into these FIXING-HOLES and put the PIN RETAINER onto FIXING-HOLE PIN End ②, the free rotation of THREADED MANDREL is therefore stopped.

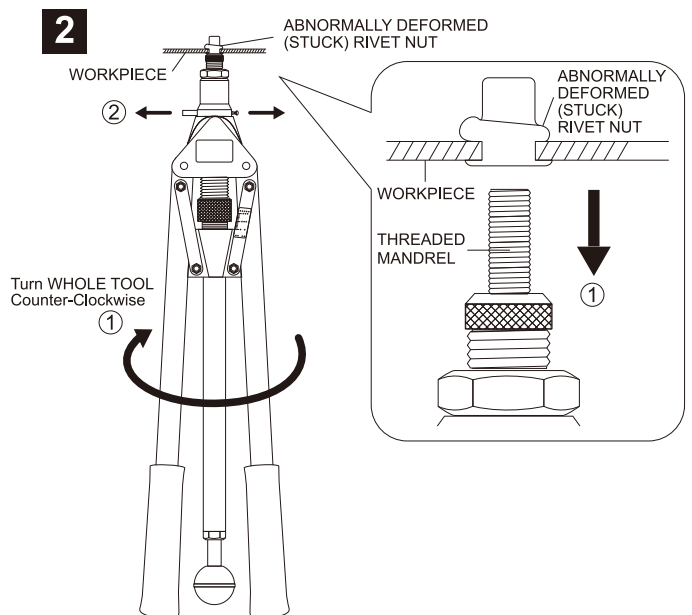


One person uses A Pair of Pliers to clamp the Stuck RIVET NUT ①, and another person turns whole TOOL Counter-Clockwise to unscrew the THREADED MANDREL from the Stuck RIVET NUT ②. Finally, take off PIN RETAINER and pull FIXING-HOLE PIN from the FIXING-HOLES ③.

K-4) HOW TO RESOLVE THE PROBLEM OF RIVET NUT STUCK ON THE THREADED MANDREL WHEN SQUEEZES 2 HANDLES AND DEFORMS RIVET NUT IN THE WORKPIECE ABNORMALLY:



Open 2 HANDLES a little bit ①, rotate whole TOOL to align the FIXING-HOLES of HEAD with the inside LONG FIXING-HOLE of MANDREL SEAT, then plug the FIXING-HOLE PIN into these FIXING-HOLES and put the PIN RETAINER onto FIXING-HOLE PIN End ②, the free rotation of THREADED MANDREL is therefore stopped.



Turn whole TOOL Counter-Clockwise to unscrew THREADED MANDREL from the Stuck RIVET NUT ①. Finally, take off PIN RETAINER and pull FIXING-HOLE PIN from the FIXING-HOLES ②.