MODEL:

ADR14

PRODUCT TYPE:

XL BLIND RIVET ADAPTER KIT - 1/4" 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. This tool is designed to be used in drills chucks to set blind rivets up to 1/4" in aluminum, steel and copper, and up to 7/32" in stainless steel. 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 BLIND RIVET ADAPTER KIT - 1/4" 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 drill into a power pop riveter
- Includes nose pieces for 3/32", 1/8", 5/32", 3/16", 7/32" and 1/4" for steel, aluminum, copper or up to 7/32" in stainless
- CNC machined from solid billet aluminum and features Japanese bearings

DO NOT DISCARD – GIVE TO USER

MODEL:

ADR14

PRODUCT TYPE:

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I. Product Technical Data:

Set Includes: 1X Main body, Assorted metric or imperial nosepieces, 1X Hex wrench, 1X User's manual, 1X Blow mold case

Hex shank: 6.35mm (1/4")

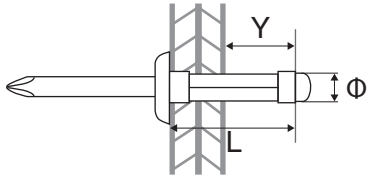
Rivet Type: Blind "Pop" Rivet

Weight: 2.0 lbs

Riveting Capability:

	Rivet Size Φ		Limit	Aluminum	Steel/Copper	Stainless Steel
Capacity / Limits	2.4mm	3/32"	Y<1/2"	✓	✓	✓
	3.2mm	1/8"		✓	✓	✓
	4.0mm	5/32"		✓	✓	✓
	4.8mm	3/16"		✓	✓	✓
	6.0mm	7/32"		✓	✓	✓
	6.4mm	1/4"		✓	✓	

Stroke Limit: Maximum 0.7 inch (**Y** should be less than 1/2" in most cases, beyond 0.6" may cause rivet mandrel to bottom out inside tool and jam)



Working Torque: Refer to section **III. Operation Guide (Page 3)**

Recommended RPM: Low speed, driver setting (<600 RPM)

Temperature Range: -20~120°C (-4~248°F)

Requirements of Driving Tools:

Requirements of cordless driving tool:

- Adjustable torque setting.
- Chuck capacity of hex 6.35 mm (1/4") shank.
- Min. 12V for aluminum and steel rivets up to 3/16".
- Min. 14.4V for stainless steel rivets up to 3/16" and thru 1/4" in aluminum.
- Min. 16V+ for 7/32" in steel and stainless and 1/4" in steel. (1/4" stainless mandrel and body is not recommended and may overheat the tool)

Requirements of electric or pneumatic driving tool:

- Chuck capacity of hex 6.35 mm (1/4") shank.
- With maximum torque > 190 in/lbs for aluminum and steel rivets up to 3/16" and 7/32" + 1/4" in aluminum.
- With maximum torque > 330 in/lbs for stainless steel rivets up to 3/16" and 7/32" + 1/4" in steel.

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II. SAFETY GUIDE:

1. For safety, read the USER'S MANUAL carefully before use of the riveting adapter.
2. Wear adequate protective gear including ANSI approved goggles and **thick work gloves.**
3. Only use the riveting adapter with driving tool that matches with requirements specified on **Product Technical Data**.
4. Switch off the driving tool before installing or uninstalling the riveting adapter.
5. 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.
6. The driving tool MUST be stopped if user releases the adapter's body during riveting.
7. During **Maintenance** and or when necessary, be careful in the disassembly of inner plunger tube as there is a pre-loaded spring inside.

III. OPERATION GUIDE:

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

WARNING: 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.

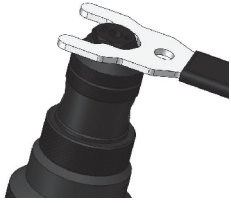
IMPORTANT: Before using the rivet adapter on your intended workpiece, use the adapter on a blind rivet without a workpiece by just holding the tool in the air to ensure your drill is powerful enough and on the correct settings to pop a rivet.

• Note that riveting on a work piece will require at least 20 in/lbs more torque than this test.

CRITICAL: Your rivet MUST NOT require more than the maximum stroke limit of this tool which is 18 mm (0.7").

Ensure your drill is in "driver" mode and not drill mode.

1. Tool Installation:



Swap the nose piece for the rivet size if the installed one does not match your intended rivet size, then tighten it onto the adapter with the wrench, check and confirm other components are tightly fixed in position; insert the hex shank into driving tool chuck. Tighten firmly and switch driving tool to low speed mode.

2. Riveting:

2.1 Hold the adapter with one hand and operate your driving tool with the other in REV until an audible clicking sound comes from the adapter tool.

2.2 Release the trigger, check and confirm from inspection hole on front tube that the plunger tube inside is at the maximum forward position.

2.3 Insert the rivet mandrel into center hole of nose piece and make sure the size of the rivet exactly matches the nose piece.

2.4 Make sure there is no space between nose piece and rivet flange.

2.5 Switch to the FWD direction of the driving tool.

2.6 Hold the adapter with one hand and lightly pull the trigger of the driving tool with your other hand to have the mandrel slightly gripped by the adapter, preventing the inserted rivet from falling out.

2.7 Insert the rivet body into drilled hole where it is to be riveted and position the adapter aligned with hole as best you can.

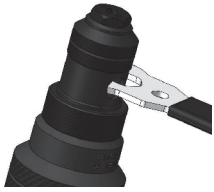
2.8 Grip the adapter firmly (wear work gloves) then pull the trigger on the driving tool until the mandrel is popped off of the rivet.

2.9 Reverse direction of the driving tool to release and expose the left-over rivet mandrel. Depending on the greasing of the tool's jaw pieces, the mandrel may or may not fall out on its own.

Tip: Use low RPM's for better control of riveting quality.

IV. MAINTENANCE:

1. Cleaning and lubricating:
   1.1 The riveting adapter is lubricated before shipping.
   Recommended: cleaning the components of plunger tube, and re-lubricating its parts on a yearly frequency or earlier.



   1.2 Recommended: cleaning the plunger tube and re-lubricating its parts when replacing worn-out chuck jaw pieces.
2. Chuck jaw pieces replacement:
   Life span of chuck jaw pieces varies with usage frequency and the uses of different rivet sizes/types.
   Recommended: replacing the chuck jaw pieces before they are worn-out to prevent jams.

Astro Pneumatic Tool Company
372 Old US Highway 52 South
Mount Airy, NC 27030

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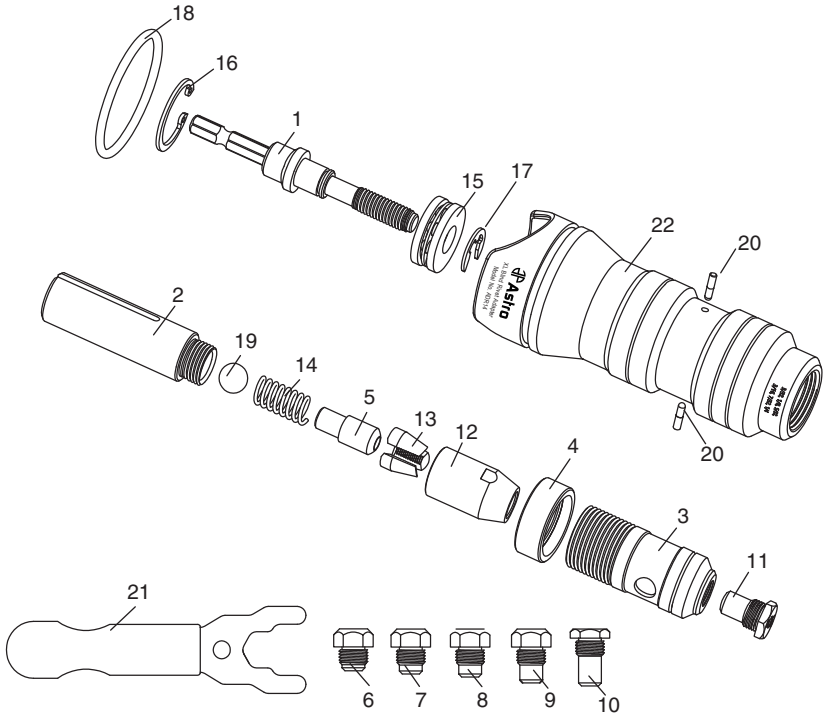
PARTS BREAKDOWN:

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



Parts List

Index	*Part No.*	*Description*	*Qty*
1	ADN14-01	Hex Shank Driving Shaft	1
2	ADR36-02	Plunger Tube	1
3	ADR14-02	Front Bushing w/Knurling	1
4	ADR36-04	Locking Bushing	1
5	ADR36-05	Plunger	1
6	ADR36-3/32N	3/32" Nosepiece	1
7	ADR36-1/8N	1/8" Nosepiece	1
8	ADR36-5/32N	5/32" Nosepiece	1
9	ADR36-3/16N	3/16" Nosepiece	1
10	ADR14-1/4N	1/4" Nosepiece	1
11	ADR14-7/32N	7/32" Nosepiece	1

Index	*Part No.*	*Description*	*Qty*
12	ADR14-03	Chuck Jaw Tubing	1
13	ADR36-12	Chuck Jaws Pieces(3pcs)	1
14	ADR14-04	Inner Spring	1
15	ADN14-25	Thrust Ball Bearing	1
16	ADN14-26	C-Clip	1
17	ADN14-27	E-Clip	1
18	ADN14-30	O-Ring	1
19	ADR36-17	Steel Ball	1
20	ADN14-29	Pins	2
21	ADN14-31	Wrench Kit	1
22	ADR14-01	Aluminum Handle	1