



ENFASCO INC.
ENGINEERED FASTENER CO.
7300 ROUTE 130 • PENNSAUKEN • NEW JERSEY 08110
Phone (856) 662-7660 Fax (856)662-6172
INTERNET <http://www.enfasco.com>
E-Mail: sales@enfasco.com

Fasteners / Hardware / Pneumatic Tools

Operating Instructions

RH100E

(Pneudraulic Spin/Pull Rivet-Nut Installation
Tool)



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Safety Instructions

RH100E

- 1) This Rivet-nut tool must only be used as a hand-held device.
- 2) Do not modify tool or its components in any way.
- 3) Do not throw tool.
- 4) Maximum Air Pressure inlet: 125psi
Note: Safety pop-off valve will engage if maximum air pressure achieved.
- 5) Use appropriate Mandrils/nose pieces supplied only by Enfasco Inc.
- 6) **Disconnect air supply from the Rivet-Nut tool at the time of tool set-up and maintenance.**

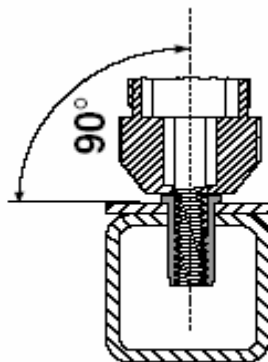
Technical Data

RH100E

<u>Operating Air Pressure:</u>	90-110 psi
<u>Capability:</u>	¼-20 thru ½-13 threads S.S. Maxtite Rivet-Nut M6-M12 threads S.S. Maxtite Rivet-Nut
<u>Height:</u>	12" Tall
<u>Weight:</u>	6.3 Pounds
<u>Setting Force:</u>	10,000 pounds

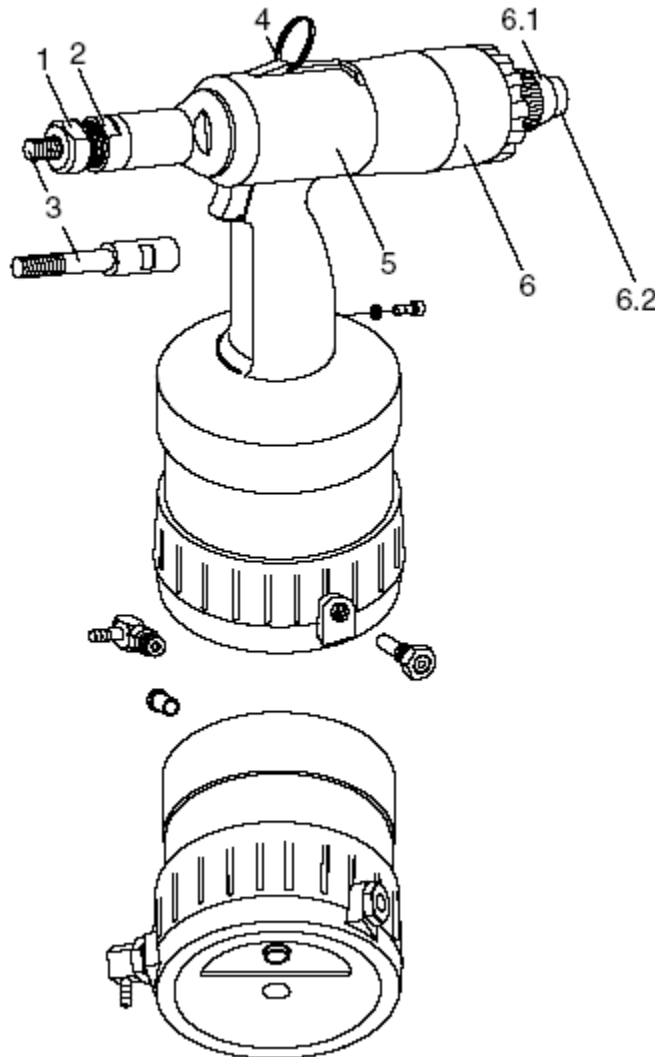
Proper Rivet-Nut Installation Angle

Tool must be oriented in a 90° Angle to the Work piece.



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Components of the RH100E

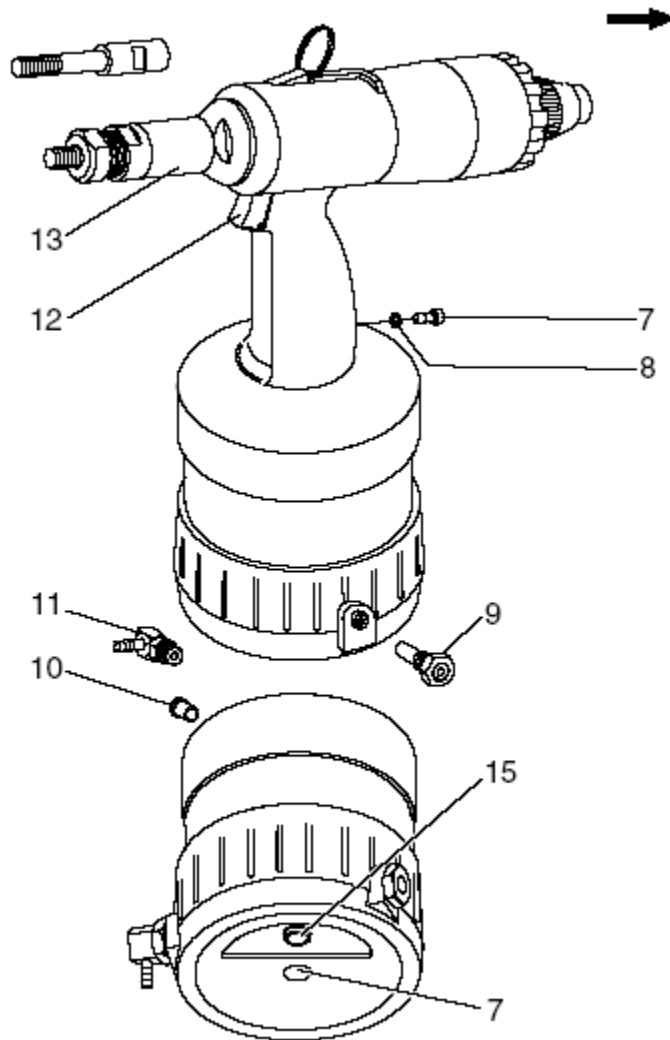


Figure

1	Anvil	
2	Lock Nut	(attaches Anvil to nosepiece)
3	Mandril	(threaded portion for installing rivet-nut)
4	Hanging feature	
5	Hydraulic housing	(location of pneumatic/hydraulics)
6	End Cap	(rotation of the air motor to left-hand rotation)
6.1	Adjustment Screw	(adjusts end stop for End Cap)
6.2	Button	(manually release left-handed rotation)



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Note: Socket Head Screw (7) and the o-ring (8) are screwed tightly into the grip. The socket head screw (7) must not be loosened, or the hydraulic oil will leak.

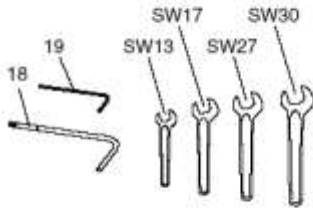
Figure

7	socket head screw	(oil inlet)
8	o-ring	(seals hydraulic oil system)
9	Safety Valve	(monitors inlet air pressure)
10	Plug	(protects thread against dirt)
11	Swivel Joint	(connection point for air hoses)
12	Trigger	(Starts Right-Hand Rotation) (Deforms Rivet-Nut)
13	Nose Piece	(Stops Left-Hand Rotation)
15	Stroke Adjustment Screw	(Covers Mandril) (adjust stoke)
7	Socket head screw in device floor	(closes opening to pull back rod)



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Required Tools



Required tools

You will require the following tools for all installation, servicing and maintenance work.

Tools

- Crank (18)
- Wrench¹
- Internal hex key (19)

SW13, SW17, SW27, SW30
SW4

¹No delivery possibility

Preparing the Rivet-Nut Tool for Use

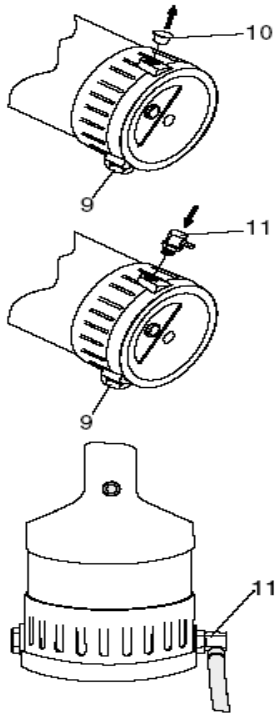
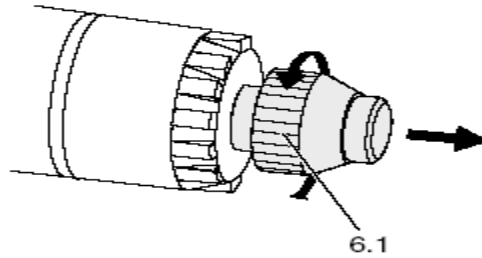
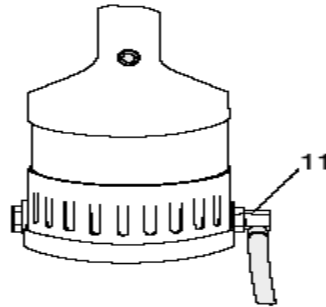


Figure
10- Remove connection port plug
11- Screw in Swivel Joint
9- Screw in safety Valve



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Preparing the Rivet-Nut Tool for Use



Note:

If you do not know the stroke setting, unscrew the adjustment screw (6.1) for the automatic switching to the left-handed rotation. This prevents tool damage!



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Replacing the Mandril

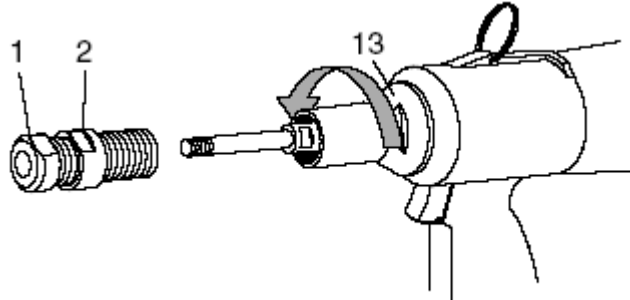


Figure
2
1
13

unscrew lock nut with wrench SW27
unscrew anvil
loosen nose piece with wrench SW30

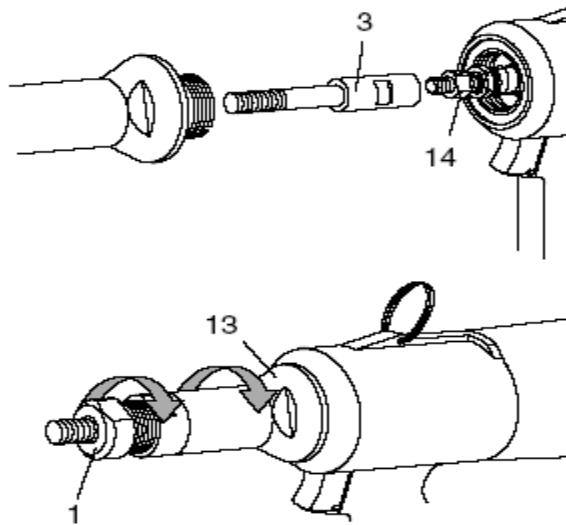


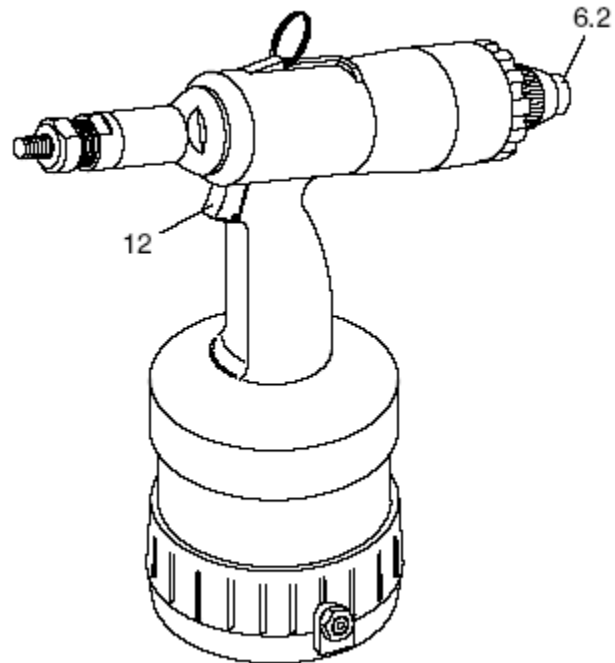
Figure
3
13

Use SW13 Wrench to tighten Mandril
Use SW30 screw on nose piece



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Trigger Left-Handed Rotation Manually



Step 1: Connect Air Supply

Step 2: Push Button 6.2- Air motor rotates in the left-hand direction

Step 3: Touch and release 12, air motor stops



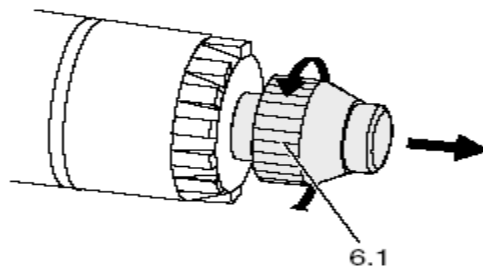
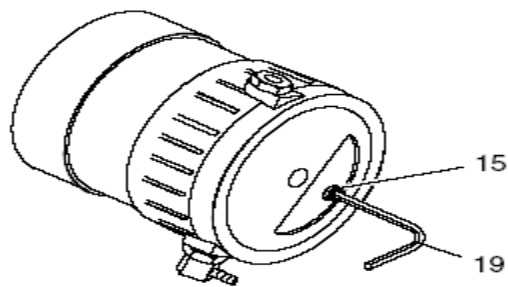
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Adjusting Tool Stroke

**Note: Thinner material requires a larger stroke
Thicker Material requires a smaller stroke**

Note:

If you do not know the stroke setting, unscrew the adjustment screw (6.1) for the automatic switching to the left-handed rotation. This prevents tool damage.



Note: The stroke is approximately 9.0mm (.354) when stroke adjustment screw (15) has been screwed out to the limit by left hand rotations.



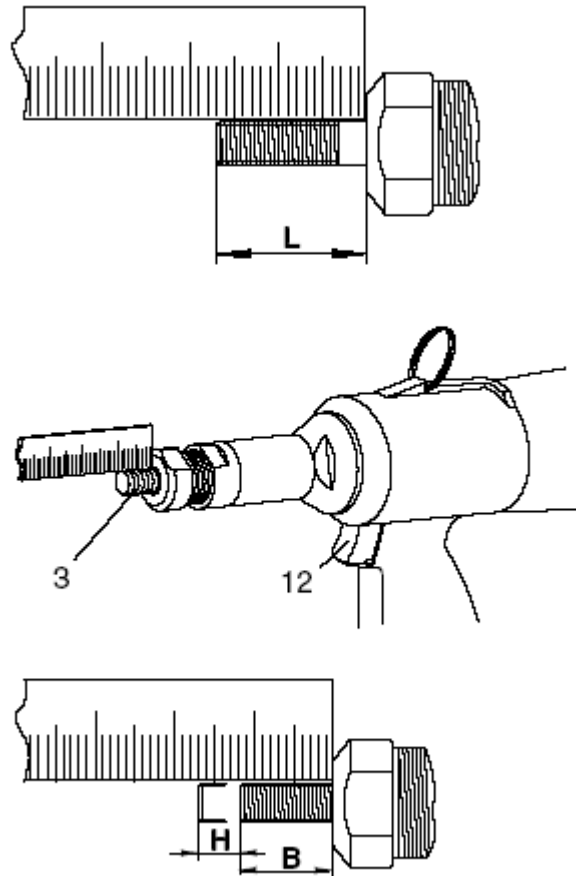
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Use SW4 hex wrench (19) to adjust internal hex nut (15):

Turn to right “-” to reduce the stroke.

Turn to Left “+” to increase the stroke.

4 Turns of hex nut (15) is 1mm (.039) stroke adjustment



Measure protruding length L of the Mandril (3)

Press the trigger (12) completely and hold measure remaining length B of the Mandril. H is the stroke tool is currently set for.

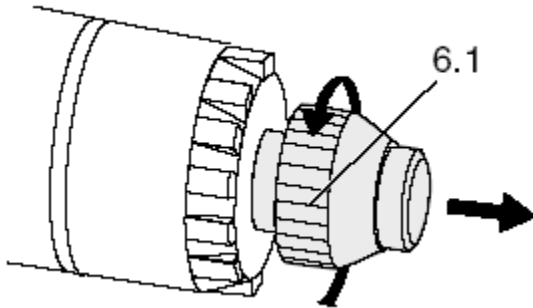
Release the trigger, Tap trigger (12) gently to stop Mandril (3) rotation



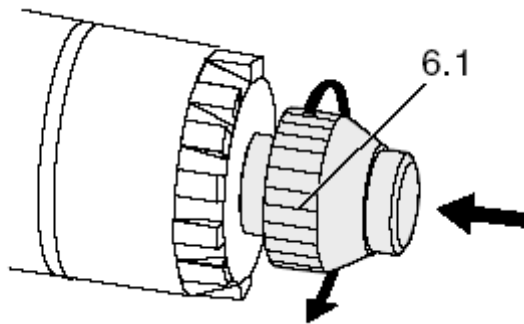
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Auto-Reverse Instructions for the RH100E

1) Before stroking the gun, make sure the auto-reverse is fully retracted from the air motor. Turn the black knob (figure 6.1) on the back of the end cap counterclockwise until the knob spins loosely



2) Set Stroke of the RH100E as described in this manual for your particular Rivet-Nut fastener. After Stroke distance is set for your Rivet-Nut, (Air lines attached) stroke the gun and hold the trigger fully depressed. Reattach the end cap and thread knob clockwise until resistance is felt while holding trigger fully depressed.



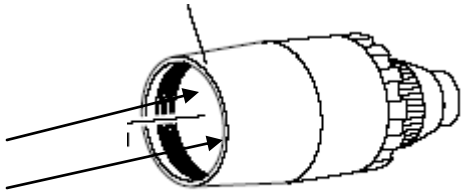
3) Once black knob is threaded to resistance, release trigger (gun will auto-reverse until trigger is tapped).



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Auto-Reverse Instructions for the RH100E **Continued**

4) Remove the end cap and turn the screws located inside the end cap clockwise until they come in contact with the black knob. Reattach end cap which completes auto-reverse set-up.



**For Technical tool assistance or
proper fastener selection**

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