



AAA Guide to using the Bralo TR-308 Nut Rivet Tool

SETTING UP YOUR BRALO TR-308



1. Choose the correct diameter and thread of the mandrel. To insert an M6 Right Hand Threaded Blind Rivet Nut (Nutsert) you will need to fit an M6 RHT mandrel and M6 nosepiece to the nosepiece case.



2. Remove the existing nosepiece and locknut to expose the mandrel shaft.



3. Pull the handles apart until the flat on the mandrel appears above the body. Hold the centre knob and, using the mandrel spanner, unscrew the existing mandrel from the nosepiece case. Then screw the M6 mandrel into the nosepiece case and tighten with the spanner. Be careful not to overtighten.



4. Set the crimping stroke by pulling the handles of the riveter are approximately 400-430mm apart. Rotate the adjusting ring in the centre to set the handle opening to 400-430mm.

5. Select a Blind Rivet Nut with a grip range suitable for the thickness of your material. E.g. 1.2 - 2.4mm, 2.0 - 3.0mm or 2.5 - 4.5mm. Check that the Blind Rivet Nut fits tightly into the hole drilled in the tube (usually 9mm or 10mm).



6. Next, pull the handles apart and screw the M6 nosepiece so that an M6 Blind Rivet Nut finishes flush with the end of the mandrel.



7. Screw the lower locknut onto the nosepiece case.

USING THE BRALO TR-308

1. Pull the handles apart and screw a Blind Rivet Nut onto the mandrel until it is flush with the end.
2. Push the mandrel firmly into the drill hole.



3. Squeeze the arms together to crimp the Blind Rivet Nut firmly in position.



4. Turn the centre knob to unwind the mandrel from the Blind Rivet Nut. Support the handles with your hand and do not expand them too much to prevent the mandrel from breaking.



To insert Left Hand Threaded Blind Rivet Nuts you will need to change the mandrel. (See separate instructions).