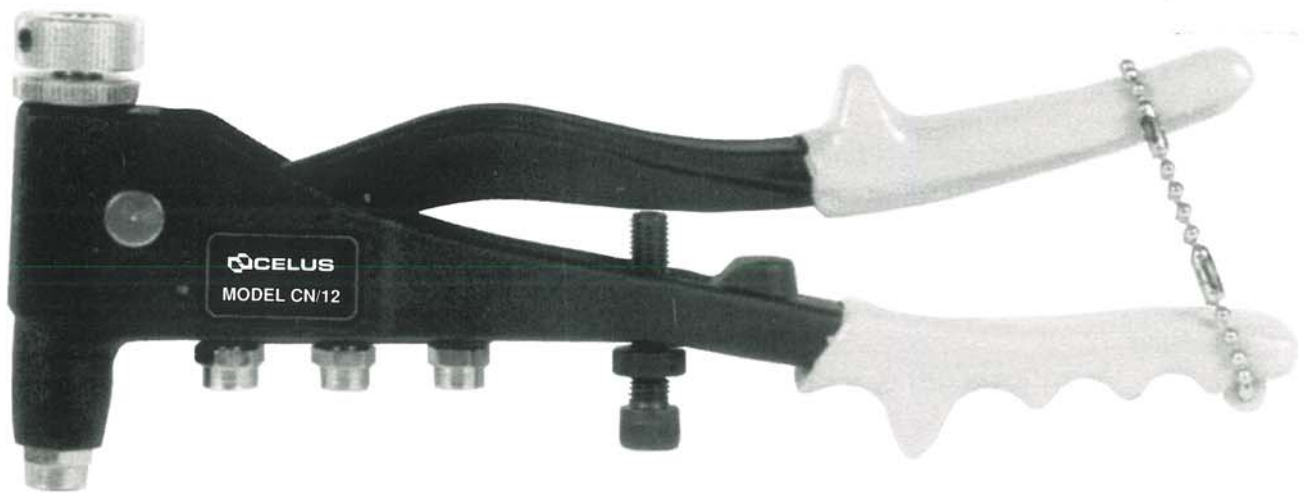


CELUS[®]

CN/12 HAND RIVET NUT TOOL



The Celus CN/12 Hand Rivet Nut Tool features rugged construction and a patented quick change mandrel design that does not require any tools to convert to a different size rivet nut. Just “pull and plug” to change the mandrel. This tool has an adjustment device to allow the user to adjust the mandrel thread length only once, lock it and set the same size rivet nut or “celnut” repeatedly with no further adjustment. This tool can easily set aluminum and steel celnuts from 6 - 32 to 1/4 - 20 and comes equipped with 5 mandrels and 4 nosepieces to set 6 - 32 up to 1/4 - 20.

* Also available in a convenient kit with a selection of our most popular celnuts and hand storage box.

**Industrial
Rivet &
Fastener Co.**





OPERATING INSTRUCTIONS

A. HOW TO ASSEMBLE AND CHANGE NOSEPIECE AND MANDREL:

1. Select Nosepiece same size as Mandrel
2. Use Wrench to Change Nosepiece.
3. Turn Lock Nut onto Adjusting Knob thread, then turn Adjusting Knob thread into Collet Case clockwise.
4. Just plug Mandrel into Adjusting Knob until Mandrel touches Adjusting Knob to assemble Mandrel, and pull Mandrel out from Adjusting Knob to change Mandrel.

B. HOW TO ADJUST MANDREL THREAD LENGTH (L):

1. Assemble same size of Nosepiece and Mandrel to Tool as per above "A" instruction. Turn Lock Nut up almost to touch Adjusting Knob, and open Tool Handle completely by loosening Locking Chain.
2. Rotate Adjusting Knob to adjust Mandrel Thread length (L) to be same as Rivet Nut length (H), $L=H$.
3. Turn Lock Nut down to touch Aluminum Body very tight, to be sure to turn down 1/8 circle more to lock Adjusting Knob position firmly and to fix Mandrel Thread length (L).

C. HOW TO ADJUST STROKE AND MAKE A PILOT TEST:

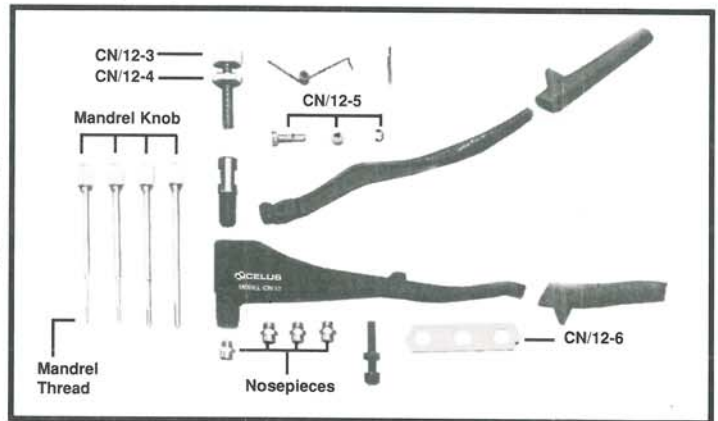
NOTE A proper stroke ensures Rivet Nut thread to be set up securely, SO THE PILOT TEST IS ALWAYS RECOMMENDED BEFORE SETTING DIFFERENT SIZE OF RIVET NUT.

1. Turn Stroke Bolt down to the lowest position, and adjust Mandrel Thread length (L) as per above "B" instruction.
2. Drill a hole on workpiece same or larger size than Rivet Nut diameter (Ø). Screw Rivet Nut onto Mandrel Thread by turning Mandrel Knob clockwise until Rivet Nut touches Nosepiece, then insert the screwed Rivet Nut into hole.
3. Squeeze Handle until Rivet Nut is set firmly by forming a bulge against the back of workpiece, and still hold Handle, adjust Stroke Bolt up to touch Handle and turn Stroke Nut to lock Stroke Bolt. The proper stroke of this size Rivet Nut is fixed then.
4. Release Handle and turn Mandrel Knob counterclockwise to unscrew Mandrel Thread from the Rivet Nut fixed in the workpiece hole (Fig. 4e). The pilot test is therefore completed.

WARRANTY: Your Celus Rivet Tool is warranted against defective materials or workmanship for a period of ninety days from date of purchase. MINIMUM ORDER FOR TOOL PARTS \$10.00.

D. HOW TO OPERATE THIS TOOL:

1. Determine material, type, thread size and grip range (workpiece thickness) of Rivet Nuts, assemble same size of Nosepiece and Mandrel as Rivet Nut size to Tool as per above "A" instruction.
2. Adjust Tool Mandrel Thread length (L) to be same as Rivet Nut length (H), $L=H$, as per above "B" instruction.
3. Make a pilot test and adjust stroke before setting different size of Rivet Nut as per above "C" instruction.
4. Screw Rivet Nut onto Mandrel Thread by turning Mandrel Knob clockwise until Rivet Nut touches Nosepiece, insert screwed Rivet Nut into prepared hole, squeeze Handle to set Rivet Nut until Handle touches Stroke Bolt, release Handle, then turn Mandrel Knob counterclockwise to unscrew Mandrel Thread from Rivet Nut. The Rivet Nut thread is set up in workpiece securely.
5. Complete fastening work with a Bolt or Screw.
6. If the next setting Rivet Nut is same size as previous one, just repeat above "4" procedure. Do Not Need Any Adjustment.



CN/12 SPARE PARTS LIST

PART NUMBER	DESCRIPTION
CN/12-1024 RM	10-24 MANDREL / NOSEPIECE SET
CN/12-1032 RM	10-32 MANDREL / NOSEPIECE SET
CN/12-1420 RM	1/4 - 20 MANDREL / NOSEPIECE SET
CN/12-632 RM	6 - 32 MANDREL / NOSEPIECE SET
CN/12-832 RM	8 - 32 MANDREL / NOSEPIECE SET
CN/12-3	ADJUSTING KNOB
CN/12-4	LOCK NUT
CN/12-5	FULCRUM PIN, BEARING, & E-4 CLIP
CN/12-6	3-WAY WRENCH

FOR PARTS, SALES, AND SERVICE IN THE U.S.A. CALL: