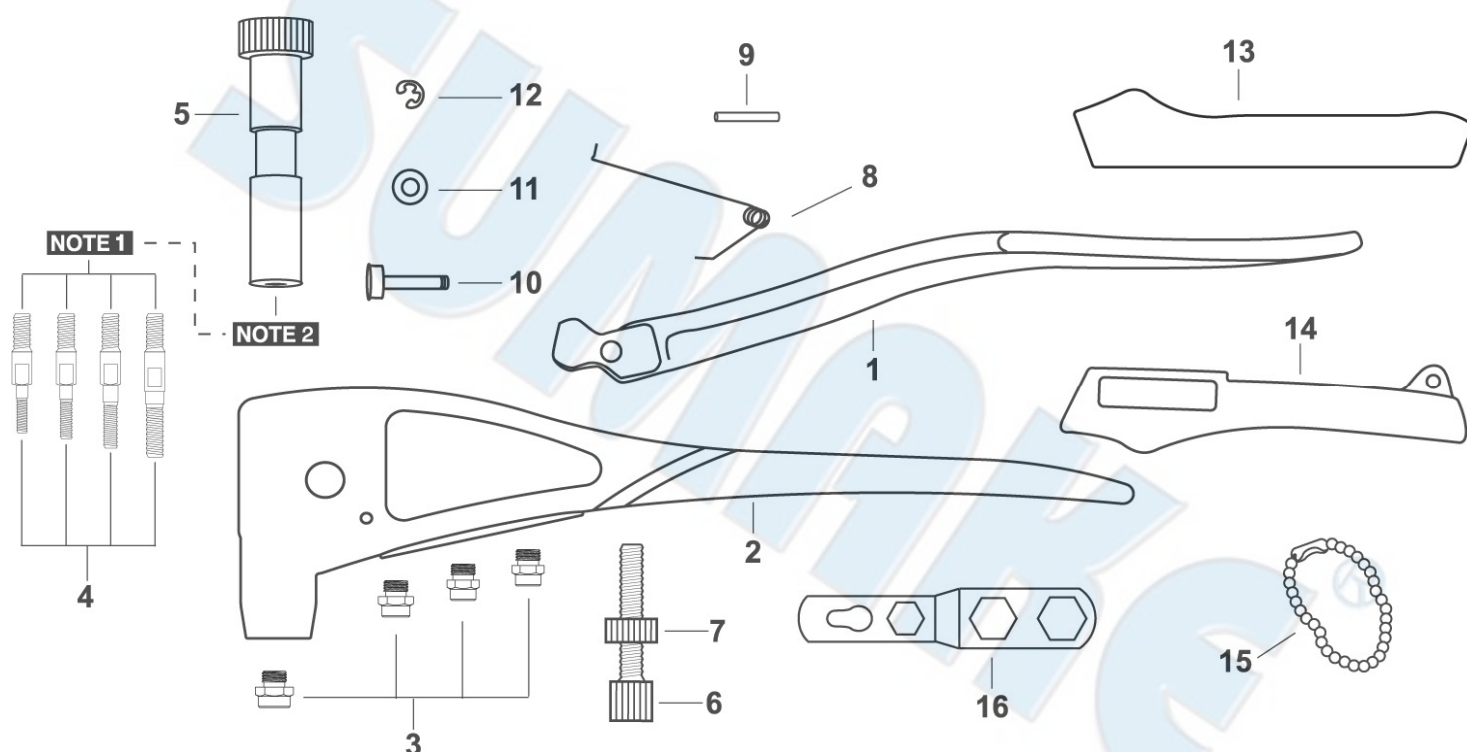


HT-6860M
HT-6860S

PROFESSIONAL HAND RIVET NUT TOOL (M3~M6)
PROFESSIONAL HAND RIVET NUT TOOL (#6-32~#1/4-20)



PARTS LIST

No.	Parts No.	Description	Q'ty
1	HT6860-01	Upper Handle	1
2	HT6860-02	Aluminum Body	1
3	HT6860-03A	Nosepiece, for M3 Rivet Nut	1
	HT6860-03B	Nosepiece, for M4 Rivet Nut	1
	HT6860-03C	Nosepiece, for M5 Rivet Nut	1
	HT6860-03D	Nosepiece, for M6 Rivet Nut	1
	HT6860-03E	Nosepiece, for #6 Rivet Nut	1
	HT6860-03F	Nosepiece, for #8 Rivet Nut	1
	HT6860-03G	Nosepiece, for #10 Rivet Nut	1
	HT6860-03I	Nosepiece, for 1/4" Rivet Nut	1
4	HT6860-04A	Threaded Mandrel, for M3x0.5 Rivet Nut	1
	HT6860-04B	Threaded Mandrel, for M4x0.7 Rivet Nut	1
	HT6860-04C	Threaded Mandrel, for M5x0.8 Rivet Nut	1
	HT6860-04D	Threaded Mandrel, for M6x1.0 Rivet Nut	1
	HT6860-04E	Threaded Mandrel, for 6-32 Rivet Nut	1
	HT6860-04F	Threaded Mandrel, for 8-32 Rivet Nut	1

No.	Parts No.	Description	Q'ty
4	HT6860-04G	Threaded Mandrel, for 10-24 Rivet Nut	1
	HT6860-04H	Threaded Mandrel, for 10-32 Rivet Nut	1
	HT6860-04I	Threaded Mandrel, for 1/4-20 Rivet Nut	1
5	HT6860-05	Rotation Sleeve, with Threaded Mandrel Seat	1
6	HT6860-06	Stroke Bolt	1
7	HT6860-07	Stroke Nut	1
8	HT6860-08	Torsion Spring	1
9	HT6860-09	Torsion Spring Pin	1
10	HT6860-10	Fulcrum Pin	1
11	HT6860-11	Fulcrum Pin Bearing	1
12	HT6860-12	Snap Ring	1
13	HT6860-13	Upper Grip	1
14	HT6860-14	Lower Grip	1
15	HT6860-15	Bead Chain Lock	1
16	HT6860-16	Wrench	1

HT-6860M(S)-P-1608A-KA

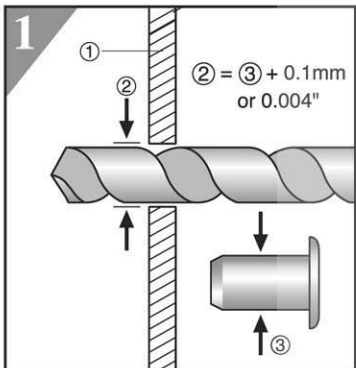
Working Capacity

Rivet Nut Thread Size	M3x0.5	M4x0.7	M5x0.8	M6x1.0
	6-32	8-32	10-24, 10-32	1/4-20
Rivet Nut Material				
Aluminum	●	●	●	●
Steel	●	●	●	●
Stainless Steel / Inox	●	●	●	

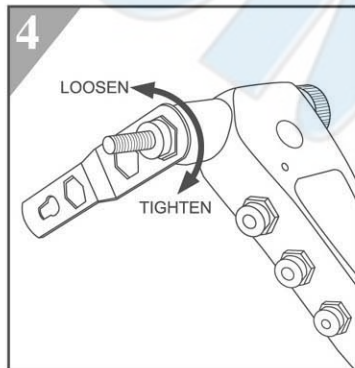
OPERATION INSTRUCTIONS

For Setting M3 ~ M6 or #6 ~ 1/4 Rivet Nuts

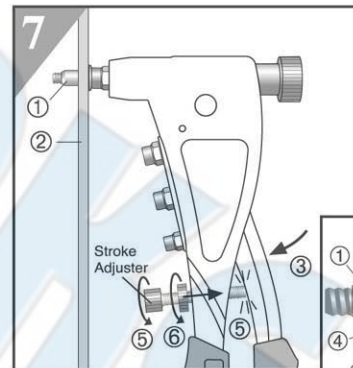
PARTS LIST ON REVERSE SIDE



- 1) Drill a Hole on the Work Piece ①, Hole diameter ② should be 0.1mm or 0.004" larger than Rivet Nut diameter ③.



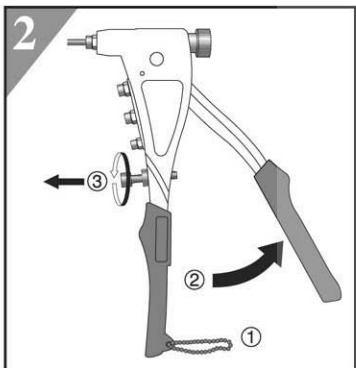
- 4) Exchange Nosepieces by Wrench.



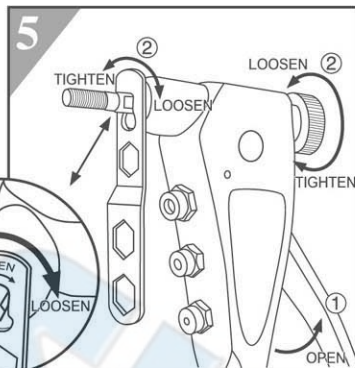
- 7) Insert the screwed Rivet Nut ① into the drilled Hole of Work Piece ②, squeeze Upper Handle ③ until Rivet Nut is installed firmly by forming a bulge ④ against the back of Work Piece ②; still hold Upper Handle ③ and adjust Stroke Bolt ⑤ up to touch Upper Handle ③, then turn up Stroke Nut ⑥ to lock Stroke Bolt ⑤ position. Now the proper Stroke is built up to protect the Rivet Nut thread and this Rivet Nut Tool as well.

NOTE

A proper Stroke ensures Rivet Nut thread to be installed securely, SO THE PILOT TEST IS ALWAYS RECOMMENDED BEFORE INSTALLING DIFFERENT SIZES OF RIVET NUT.



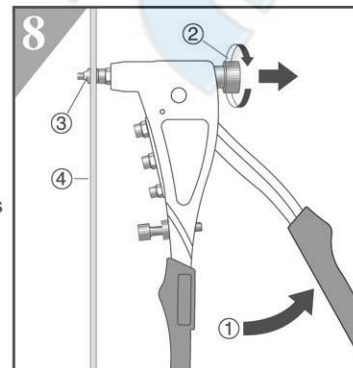
- 2) Loose Bead Chain Lock ① to open Upper Handle fully ②, and turn down the Stroke Bolt and Stroke Nut ③ to the lowest position.



- 5) Exchange Threaded Mandrels by Wrench.

NOTE

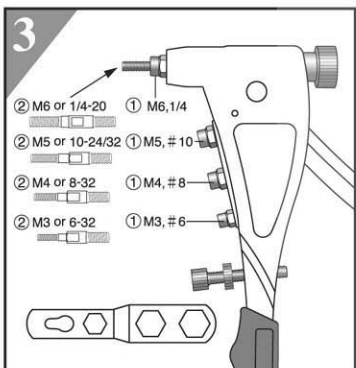
The Thread of Part No. 4 Threaded Mandrel for screwing into the Seat of Part No. 5 Rotation Sleeve is "LEFT-HANDED THREAD". Turn Wrench clockwise to loosen Threaded Mandrel, yet turn Wrench counter-clockwise to tighten Threaded Mandrel.



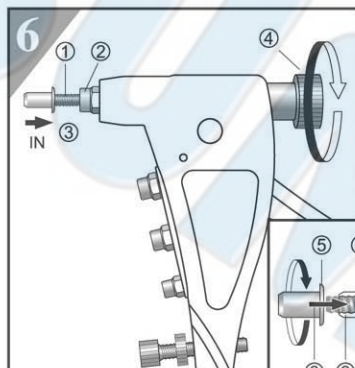
- 8) Release Upper Handle ① fully, and rotate Rotation Knob ② to unscrew Threaded Mandrel from the installed Rivet Nut ③. Now the Rivet Nut thread are built up securely in the Work Piece ④.

NOTE

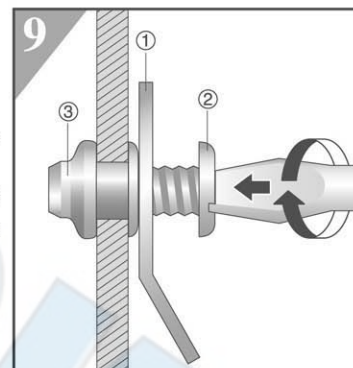
If the next fastening Rivet Nut is same size as previous one, Do Not Need Any Adjustment! Just repeat above 6) to screw Rivet Nut onto Threaded Mandrel, squeeze Tool Handles to set Rivet Nut until Upper Handle touches Stroke Bolt, finally follow above 8) to unscrew Threaded Mandrel from the installed Rivet Nut.



- 3) Select Nosepiece ① and Threaded Mandrel ② to be same size as Rivet Nut thread size.



- 6) Install same size Threaded Mandrel ① and Nosepiece ② to the Tool, screw the Rivet Nut ③ onto Threaded Mandrel ① by turning either Rivet Nut ③ or Rotation Knob ④ until Rivet Nut head ⑤ touches Nosepiece ②.



- 9) Fasten an Object ① by screwing a Bolt or a Screw ② to the installed Rivet Nut ③.