



Quick Change Nose Assembly



THE FUSION OF PRODUCTION AND TECHNOLOGY™

POWER SPIN™ BP-350Q
 ACCU-SPIN™ BP-600Q
 QUICK-SPIN™ BP-2000Q

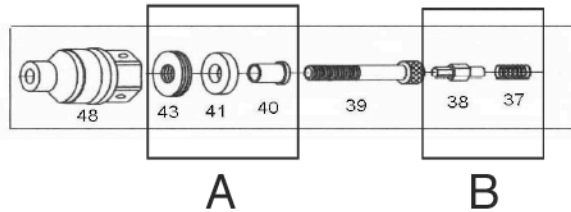
SPIN SPIN RIVET NUT TOOL
 Tool selection Chart

| Thread Size | Complete Tool part No. | Tool RPM | Quick Change Nose Assembly | Anvil Part #48 | A Bearing Set Part #s Mandrel Part #39 | | B Hex Drive and Spring Part #s | Dynamic Air Pressure PSI-Bars | Weight (LBS) | Min Air Hose | CFM |
|-------------|------------------------|----------|----------------------------|----------------|--|-------------|-----------------------------------|-------------------------------|--------------|--------------|-----|
| 6-32 UNC | BP-2000Q632 | 1800 | BPQ-632 | 600N6 | BBS632 | W060632-175 | HDS-632 | 60-90 | 2.2 | 3/8" | 5 |
| 8-32 UNC | BP-2000Q832 | 1800 | BPQ-832 | 600N8 | BBS832 | W08032-175 | HDS-832 | 60-90 | 2.2 | 3/8" | 5 |
| 10-24 UNC | BP-2000Q1024 | 1800 | BPQ-1024 | 600N10 | BBS1024 | W10024-175 | HDS-1024 | 70-90 | 2.2 | 3/8" | 5 |
| 10-32 UNF | BP-2000Q1032 | 1800 | BPQ-1032 | 600N10 | BBS1032 | W10032-175 | HDS-1032 | 70-90 | 2.2 | 3/8" | 5 |
| 1/4-20 UNC | BP-600Q420 | 500 | BPQ-420 | 600N14 | BBS420 | W14020-200 | HDS-420 | 70-90 | 2.8 | 3/8" | 5 |
| 5/16-18 UNC | BP-350Q518 | 300 | BPQ-518 | 600N516 | BBS518 | W51618-200 | HDS-518 | 70-90 | 2.8 | 3/8" | 5 |
| 3/8-16 UNC | BP-350Q616 | 300 | BPQ-616 | 600N38 | BBS616 | W03816-200 | HDS-618 | 70-90 | 2.8 | 3/8" | 5 |
| M3 | BP-2000Q-M3 | 1800 | BPQ-M3 | 600M3 | BBSM3 | W03005-35MM | HDS-M3 | 2.5-3.5 | 2.2 | 3/8" | 5 |
| M4 | BP-2000QM4 | 1800 | BPQ-M4 | 600M4 | BBSM4 | M04007-40MM | HDS-M4 | 2.5-3.5 | 2.2 | 3/8" | 5 |
| M5 | BP-600QM5 | 500 | BPQ-M5 | 600M5 | BBSM5 | M05008-40MM | HDS-M5 | 4.5-5.6 | 2.8 | 3/8" | 5 |
| M6 | BP-600QM6 | 500 | BPQ-M6 | 600M6 | BBSM6 | M06010-45 | HDS-M6 | 4.5-5.5 | 2.8 | 3/8" | 5 |
| M8 | BP-350QM8 | 300 | BPQ-M8 | 600M8 | BBSM8 | M08125-50 | HDS-M8 | 4.8-6.3 | 2.8 | 3/8" | 5 |
| M10 | BP-350QM10 | 300 | BPQ-M10 | 600M10 | BBSM10 | M10015-50 | HDS-M10 | 4.8-6.3 | 2.8 | 3/8" | 5 |

Blue Pneumatic Spin Spin Rivet Nut tool.



Head Ass'y for Any Size (#48, #43, #41, #40, #39, #38, #37)



Care Instructions:

In order to prolong the life of your spin spin tool.

1. Use filtered air along with a regulator with and oiling system. Clean, dry air is recommended to prolong tool life.
2. High temperature bearing grease is required on bearing set. Bearing must be kept in a wet lubricated condition.
3. Replace Mandrel(socket head cap screw) when threads become visibly deformed or produce drag when threading in or out or the threads of the fastener. We recommend using Unbrako, Camcar or Halocrome brands to ensure the highest possible performance.

Operating Instructions

To get started: With the tool unattached to the air source, thread the insert onto the mandrel (which is a socket head cap screw) until it touches the anvil. Make sure that the screw is long enough to allow one full thread to extend past the insert. To simplify set up, be sure measurement is based on the longest insert you will be installing during that installation session.

Connect the tool to the air source. Make sure to operate tool at the appropriate recommended air pressure(see tool selection chart).

Press the top rocker trigger marked "F", for forward, to thread the insert onto the tool until it touches the anvil. The insert is ready to be installed.(Fig. A)

Place the insert through the hole in the workpiece(Fig. B). Press top rocker trigger marked "F". The mandrel will spin causing the fastener to collapse and securely fasten in the hole. The tool will stall when the installation is complete.

Press rocker trigger "R" for reverse. This will spin tool out of the workpiece.

Note:

The tool will stall optimally only when the following variables are in place. The most appropriate rpm model of tool is used with the most appropriate amount of air pressure for the insert to be placed. For example, a 300 rpm tool is most appropriate with a 5/16-18 fastener at 90psi air pressure, however, with an 8-32 nose assembly, the tool has too much power to stall(see tool selection chart). The tool will still place the insert. In this case the user must use discretion(by teasing the trigger) to avoid damaging the threads of the fastener.



Fig A



Fig B