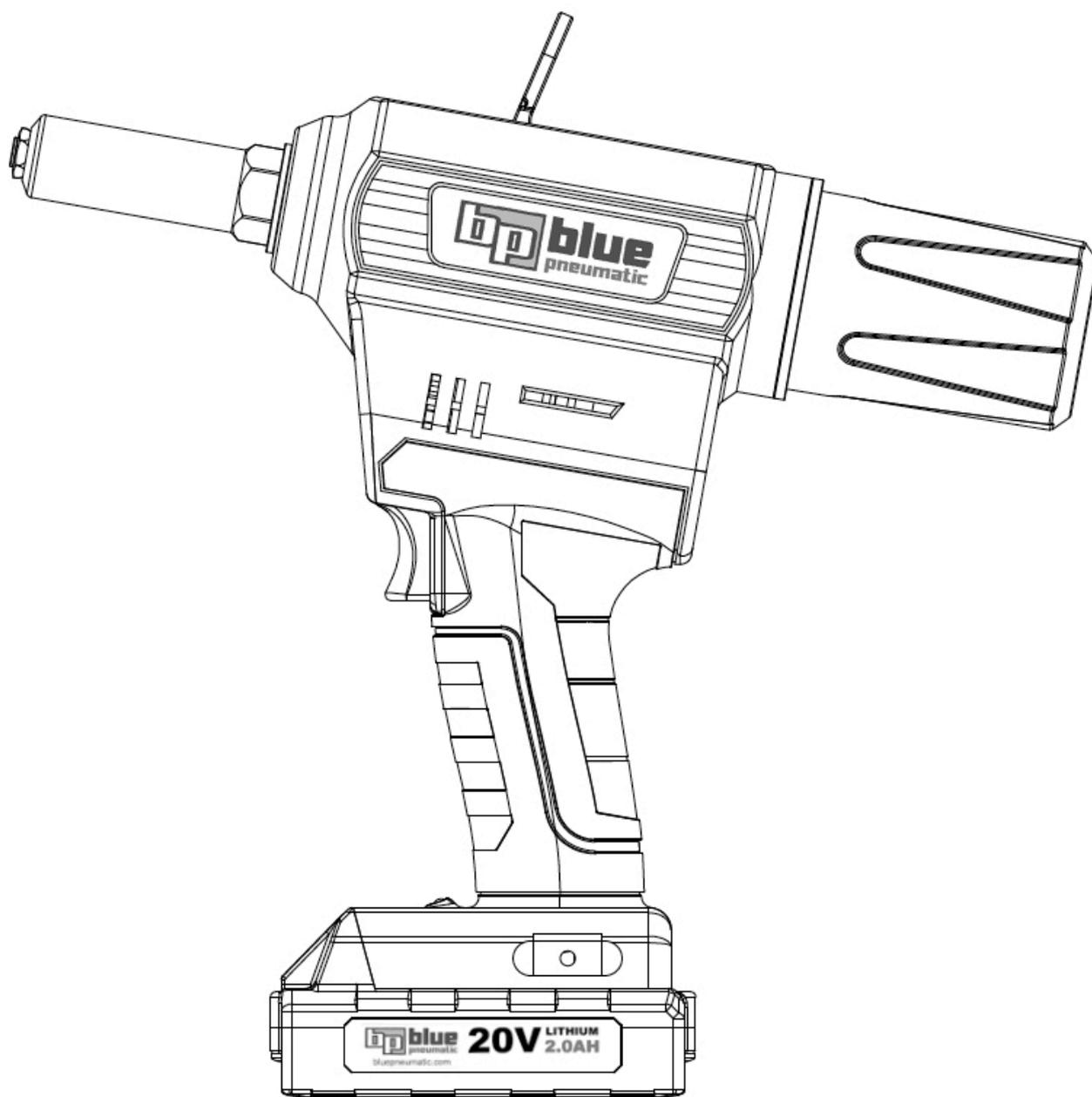


# Instruction Manual

BP-20CR lithium battery rivet tool



# Safety information and technical manuals

Please read the following safety information and instructions. Improper operation can lead to electric shock, fire or other serious injury. Please keep all safety information and instructions for future reference.

## ◎Safety of working area:

- 1:Keep the working area clean to provide adequate lighting, messy work area not bright enough may lead to the occurrence of accidents.
- 2:Do not operate tools in dangerous environment (such as flammable liquid, gas or dust), bad operation can cause gas or dust combustion.
- 3:Please keep away from children or other people when you operate the tool. It may be out of control when lose concentration.

## ◎Electrical safety:

Do not expose the rivet tool to rain or high humidity. Water entering the rivet increases the risk of electric shock and tool damage.

## ◎Personal safety:

- 1:Do not use the rivet tool under the influence of fatigue or alcohol or drugs.
- 2:Pay attention when using the rivet tool.
- 3:Wear protective glasses and earmuffs, ect. to reduce the risk of injury.
- 4:Make sure the tools are always balanced to avoid unexpected situations.
- 5:Do not overload the use of tool, to use the performance, specifications and range of riveting tool to make your work better and safer .
- 6:Please separate the battery from the tool during transportation and storage.  
If the power switch is pressed carelessly, there will be hidden dangers.
- 7:Keep the guide pipe of rivet tool unobstructed to ensure safe operation.

## ◎Repair and maintenance:

Tools must be maintained and parts replaced by experienced personnel.

The cleaning is recommended for gripper and paw, the dust of the aluminum and iron in the top tube for everyday.

By professional maintenance personnel maintenance, and the use of original accessories, to ensure the use of safety.

If the rivet tool break down during the production and quality control process, pneumatic riveting tool should be maintained by an authorized service center.

## ◎Lithium battery charging safety instructions:

- 1: Before charging the battery, please read the warning label of the charger and the battery;
- 2: Do not use the damaged charger for charging;
- 3: Charger and lithium battery should not be placed in water, exposed to water, snow or wet environment;
- 4: If the battery also spills liquid, avoid contact; if there is contact, rinse with water and see a doctor immediately;
- 5: The ambient temperature of charging and discharging is  $0 \sim 40^{\circ}\text{C}$ ;
- 6: Long-term storage battery (more than 3 months) must be placed at the temperature of  $23 \pm 5^{\circ}\text{C}$ ;
- 7: The battery shall be stored according to the storage requirements, Three months for a full charge and discharge and recharge to 70% of the power;

### Note:

The battery is not fully charged when it leaves the factory.

- ◆ In order to ensure the full function of the battery, please fully charge it before using. Pay attention to the harging indicator on the charger. ,Lithium battery charging can be charged at any time, interruption of charging, does not affect its life, will not damage the battery.
- ◆ The battery is equipped with a temperature detection system.
- ◆ Old battery disposal please refer to waste disposal regulations.

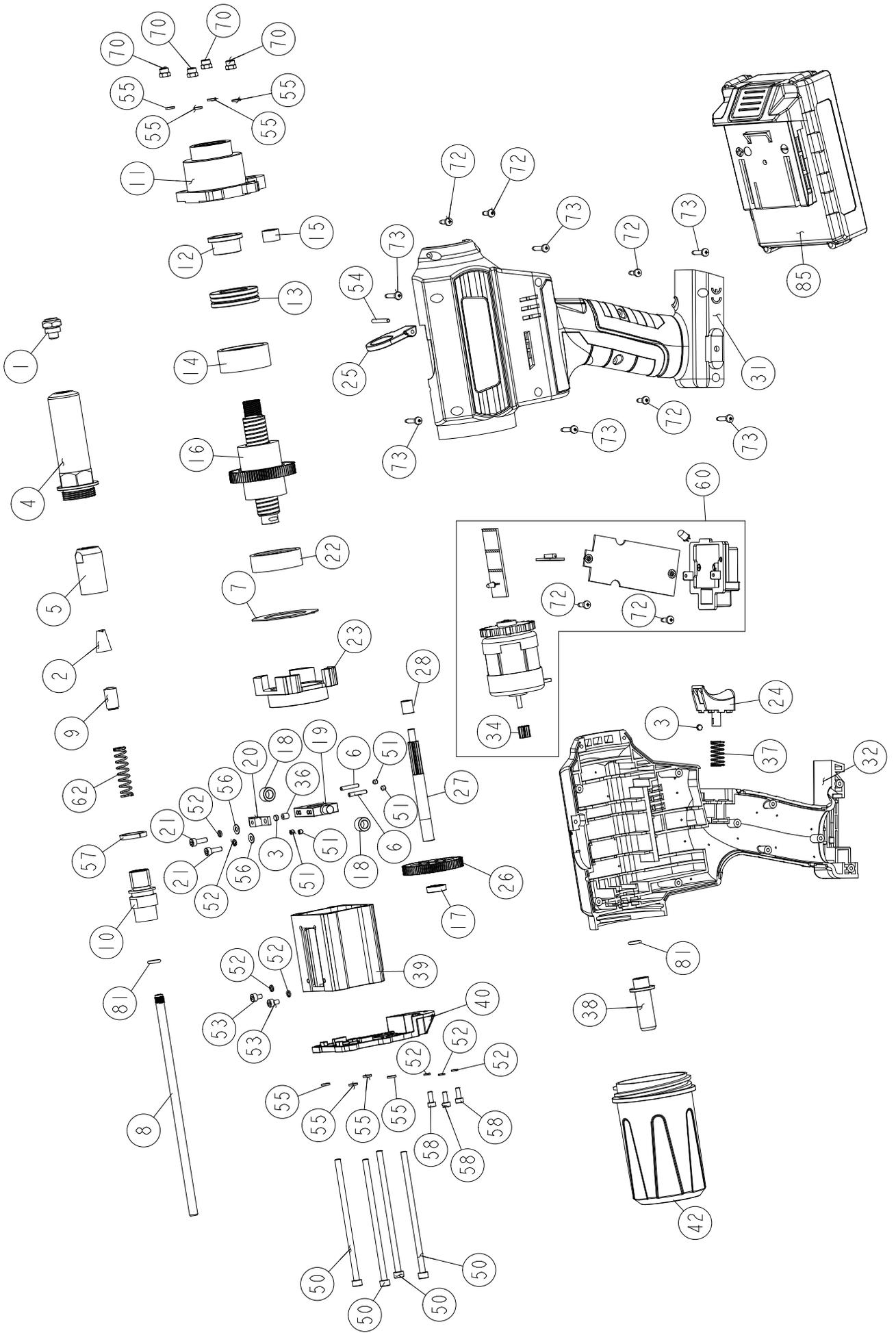
### ◎Remove the battery:

The battery is equipped with a locking mechanism. When the battery is mounted on the broach gun, it will be fixed. If the battery is to be removed, press the unlock button and the slider device on the tool. Do not disassemble.

### Free parts list:

1. Gun body size	BP-202CR	one piece
2. Lithium battery voltage	20V, 2.0Ah	one piece
3. Charger	100-240V/50-60Hz	one piece
4. Wrench	12、17、22、 、23.5、26conenosarc	one piece
5. Nozzle	$\phi 2.4$ (pick out and buy)、 $\phi 3.2$ 、 $\phi 4.0$ 、 $\phi 6.4$	each one piece

# BP-20CR Parts Diagram



## BP-20CR Parts List

Item	Description	Part No.	Number	Item	Description	Part No.	Number	Item	Description	Part No.	Number
1	nozzle	24M001A	1	19	Pulley mounting	R5B619A	1	42	Collector Assembly	M5B642A	1
2	Jaws	R4M002A	1	20	Hoare mounting	M5B620A	1	50	Allen m4*90	G5B650A	4
3	magnet	X5B603A	2	21	Screw m3x10	G5B621A	2	51	Set screw m3*3	G5B651A	4
4	Nose housing	R5B604A	1	22	Bearing3012	C5B622A	1	52	Spring Washer	G5B652A	7
5	Jaw guide-H	R5B605B	1	23	Screw housing	R5B623A	1	53	Allen M3*5	G5B653A	2
6	Pin2. 5x15	G5B606A	2	24	button	M5B624A	1	54	Pin2 5*22	G5B654A	1
7	Housing gasket	R5B607A	1	25	Lifting hook	M5B625A	1	55	Spring washer	G5B655A	8
8	Guide rod	R5B608B	1	26	Big gear wheel	R5B626A	1	56	Flat washer	G5B656A	2
9	Jaw pushser	R6L009A	1	27	Gear shaft	R5B627A	1	57	Slip ring	M5B657A	1
10	Pull head	R5B610A	1	28	Spindle pulley	R5B628A	1	58	Allen M3×8	G5B658A	3
11	Screw housing	R5B611A	1	31	Right housing	M5B631A	1	60	Motor assembly	E5B660A	1
12	Axle sleeve	R5B612A	1	32	Left housing	M5B632A	1	62	Spring	D5B662A	1
13	Thrust bearing	C5B613A	1	34	Gear 13*0-5	R5B634A	1	70	Lock nut	G5B672A	4
14	Bearing3016	C5B614A	1	36	Support pole	M5B636A	1	72	ST3×10	G5B602A	6
15	Bearing0808	C5B615A	1	37	Button on spring	D5B637A	1	73	ST3×16	G5B673A	6
16	Screw group	R5B616A	1	38	Guide rod fixed	R5B638A	1	81	O_RING	B48011A	2
17	Bearing	C5B617A	1	39	Stents	R5B639A	1	85	Lithium battery	E5B685A	1
18	pulley	R5B618A	2	40	Dead plate	R5B640A	1				

# Product parameters

## ©Riveting ability

Specifications:  $\phi 2.4 \sim \phi 6.4$

## ©Gun body

Weight: 1.51Kg(excluding battery)

Tool stroke: 27mm

Motor: 20V brushless DC motor

Pulling force: 20000N

## ©Lithium battery

Rated voltage: 20V

Capacity: 2.0Ah

Weight: 0.38Kg

## ©Charger

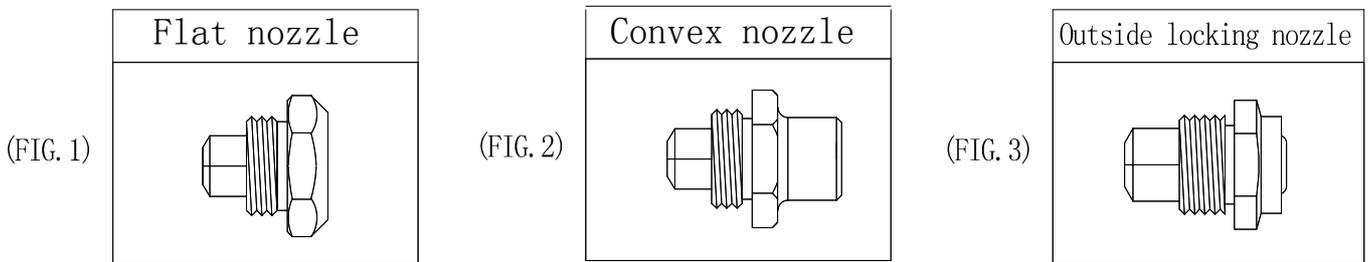
Input voltage: 100-240V/50-60Hz

Output voltage: 20V

Charging time:  $\leq 60$ Min

Weight: 0.37Kg

## ©Proper use of nozzle:



1: Flat nozzle (FIG. 1) is suitable for situations such as larger riveting plane space, larger rivet cap and shorter rivet rod etc.

2: With small space, it is recommended to use a convex nozzle (FIG. 2), but there is a strict requirement on the length of the rivet rod, rivet rod too short will lead to difficult to snap the rivet and jaws, jaw guide damage and other problems.

3: Outside locking nozzle (FIG. 3) is suitable for the outside locking rivet, which can better prevent the nail core from pulling out.

4: According to the needs of different stations and different rivets, special nozzles can be selected. Flat nozzles (FIG. 1) are the standard configuration of the product.

5: The aperture of the nozzle, the gap between the correct nozzle and the rod is 0.2 - 0.5mm (special requirements are not in this range).

## ©Comparison table

Rivet size (mm)		$\phi 2.4$	$\phi 3.2$	$\phi 4.0$	$\phi 4.8$	$\phi 6.4$	$\phi 6.4$
Aperture of the nozzle (mm)		$\phi 1.7^{+0.1}_0$	$\phi 2.2^{+0.1}_0$	$\phi 2.7^{+0.1}_0$	$\phi 3.3^{+0.1}_0$	$\phi 4.3^{+0.1}_0$	$\phi 4.5^{+0.1}_0$

# Operational guidelines

## ©Lithium battery installation:

Insert the Lithium battery, only use the battery provided by the original factory, strictly follow the warning on the battery label.

## ©Replace nozzle:

The number of nozzle is according to the corresponding riveting specification, remove the head housing by hand, use a wrench to replace the nozzle. After the replacement, install the head housing.

## ©Power light:

When the switch is pressed, the white LED light on the lower part of the tool lights up for 10 seconds. If the tool does not move within 10 seconds, the white LED light will go off, pressing the switch will repeat the light for the next 10 seconds.

## ©Riveting:

Insert the rivet rod into the nozzle and press it on the workpiece. Press the power switch until the rivet rod breaks, then release the power switch until the tool is reset. Rivet rod into the mandrel bottle, if the rivet is not break at 1st pull, repeat it again. When the rivet rod into the mandrel bottle reaches 2/3, please empty the bottle to avoid the rivet rod jammed inside of the tool.

Note: only when the rivet rod into the mandrel bottle then can go next operation.

## ©Trouble:

If the motor is overloaded and the current protection is exceeded, the tool will stop running and the red fault light on top of tool will flash. In this case, please remove the battery and the nose housing to remove the trouble spots, then install the battery, press the switch board, and reset the tool to the normal setting. Low voltage protection, if the battery is empty or low voltage, the tool will be forced by the circuit protection device power off, the red circuit light on top of tool will flash.

## ©warning:

The specification of the rivet must match the nozzle. For example, a 4.8mm nozzle should be used with a 4.8mm rivet.

## © replacement of jaw:

jaw is the wearing part. The jaw teeth appears wear and can not grip the rivet rod or the rivet slipped when pulling then the jaws should be replaced.

## Trouble shooting

Symptom	Possible cause	Remedy
Difficult to pull the rivet	jaw damaged	Change jaw
	Battery under voltage	Charge or replace the battery
Grasp the rivet skid	jaw damaged	Change jaw
	jaw dirty	Clean the jaw and fill the lube oil
	Top tube spring failure	Change top tube spring
	The riveter nozzle is not correct	Use the proper riveter nozzle
Stuck when pull out the rivet	jaw dirty	Clean the jaw and fill the lube oil
	The jaw tube, nozzle or nozzle housing of the gun are not screwed tight	Tight jaw tube, nozzle and nozzle housing
	Rivet rod plug the nozzle	Change the proper nozzle or check the degree of wear of jaw sleeve
	The guide bar is stuck by mandrel	Change the proper guide bar and clean the mandrel bottle
Rivet no action	The battery is power off or low voltage	Charge or replace the battery
	Beyond the ability of the riveter	Change to use correct of riveters

- Thank you very much for choosing our lithium battery cordless rivet tool, to ensure the correct operation, please read this instruction manual carefully and place it in a safe area for reference.
- This instruction has included how to use lithium battery cordless rivet tool.
- Make sure the instruction manual is the right one for the product you are using.

**⚠ Disclaimers:**

- This product uses dc motor 20v.
- We accept no responsibility for the damages of any violation operation and trouble caused by operation with other devices.
- We accept no responsibility for any damage caused by Nonobservance of instruction manual.
- Our company is not responsible for tool damage caused by the use of non-original lithium batteries.