



Model #RK-403

Operations Manual

Revision C





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Copyright Statement

This document is intended only for the owner and personnel authorized to operate the tool.

It contains relevant rules and information which may not be:

- Duplicated
- Distributed
- Otherwise shared, either in whole or in part.

The copyright for this document is held by Industrial Rivet and Fastener Co. under license.

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1. General Information

1.1 | Purpose

This information was written with the intention of being read, understood and complied with in all points by persons responsible for the operation of the RK-403 Cordless Rivet Tool.

Prior to commissioning, please read the operating instructions and comply with the safety instructions. Work station faults can only be prevented if the contents of these operating instructions are known and fault-free operation can be ensured.

We are not liable for damages and operational errors that result from noncompliance of these operating instructions. If difficulties arise nonetheless, please contact us and we will gladly provide assistance.

1.2 | Proper and Improper Use

The tool may only be used, as described in these instructions, to set rivets within the specifications of this manual.

Proper intended use also includes:

- Complying with all instructions in the operating instructions
 - Complying with inspection and maintenance guidelines
- Any other use beyond this is not considered proper intended use.

Industrial Rivet and Fastener Co. is not liable for any damages resulting from non-compliance.



1.3 | Warranty and Liability

Industrial Rivet & Fastener Co. (hereinafter “IRF”) warrants to the initial retail customer and original distributor (“Warrantee”) that RivetKing® branded tools will be free from defects in material and workmanship for a period of one year from the purchase date, provided that the products are used in accordance with “IRF’s” instructions as to maintenance, operation, and use.

Warranty and liability claims for personal and property damage are excluded if they occur as the result of one or more of the following:

- improper use
- improper installation, commissioning, operation and maintenance
- operating the tool with defective safety equipment or improperly installed or non-functioning safety and protective devices
- failure to comply with the information contained in this document
- regarding transport, storage, assembly, placement into service, operation, and maintenance of the tool
- unauthorized modifications to the tool
- improperly performed repair work
- catastrophic events beyond human control and acts of God



1.4 | Owner Responsibility

The owner is responsible for ensuring that all persons using the tool are familiar with basic work safety and accident prevention rules and have been briefed on tool operation. Safety practices should be reviewed regularly with all personnel operating the tool.

1.5 | Personnel Responsibility

All persons assigned to work with the tool should be aware of the basic work safety and accident prevention rules prior to commencing work.

Personnel must be trained and briefed before operating this tool. Personnel responsibilities for installation, placement into service, operation, maintenance, and repair must be clearly defined. Personnel in training may operate the tool only under the supervision of an experienced person.

1.6 | Disclaimers

- This product uses a 20V DC Motor.
- RivetKing® is not liable for damages resulting from failure to adhere to the instruction manual.
- RivetKing® is not responsible for tool damage caused by the use of non-recommended lithium batteries.
- No changes, additions, or modifications may be made to the tool without permission of the manufacturer.
- Should repairs or maintenance be required, use only original replacement parts.
- All possible safety risk factors must be addressed immediately.

2. Safety Information



Please read the following safety information and fire and/or other serious injury. Keep all safety information and instructions for future reference.

2.1 | General Safety Instructions

- **Read and understand all safety instructions before operating tool.** Failure to follow all safety procedures may increase risk of personal injury.
- **Do not use a damaged tool.** A damaged tool can be unpredictable and carries increased risk of personal injury.
- **Examine tool at regular intervals and maintain working order.**
- **Do not use outside of intended specifications.** Use outside of set specifications can be unpredictable and increase risk of personal injury.
- **Do not tamper with or modify the tool without written instruction to do so.**
- **This tool is designed for setting blind rivets.** Do not insert anything but blind rivets into the tool. Doing so may cause damage to tool or operator.



2.2 | Safety of Work Area

- **Keep work area clean and well lit.** A messy or poorly lit work area may cause accidents.
- **Do not operate tools in flammable or explosive environments.** Flammable liquids, gas, and dust can cause combustion.
- **Keep children and bystanders away while operating a power tool.** Distractions can cause one to lose control of tool.
- **Take caution in unfamiliar environments.** Hidden hazards such as utility lines can increase risk of personal injury.
- **Wear gloves, safety glasses, and PPE.** Personal protective equipment reduces risk of injury in case of accident.

2.3 | Operational Safety

- **Keep the Guide Rod Tube (*fig. 6, #9*) of rivet tool unobstructed to ensure safe operation.** If the tube is obstructed, use of the tool may cause damage to tool or operator.
- **Never aim the tool at oneself or another person.** The tool has potential to create a high-velocity projectile which may cause injury.
- **Frequently clean nose components & jaws.** It is possible for metal particles to accumulate inside the tool. Frequent cleaning will ensure tool is in working condition.



- **Mandrel collector must be emptied at half capacity.** Tool may not function properly if the mandrel collector is blocked. To prevent this, empty the mandrel collector once it is halfway filled.
- **Be aware of high-velocity projectiles.** It is possible for the riveting process to generate a high-velocity projectile.
- **Pull trigger when nosepiece is in full contact with working surface.** If full contact is not achieved, the tool may fail.

2.4 | Electrical Safety

- **Do not expose the power tool to rain or high humidity.** Water may increase risk of electric shock or damage tools.
- **Disconnect tool from power sources before servicing.** Servicing a powered tool may result in accidental discharge or harm to user or tool safety.
- **Ensure power switch is in the off-position before connecting a power source to the tool.**

2.5 | Personal Safety

- **Do not operate the power tool while fatigued or under the influence of alcohol or drugs.** Impairment such as loss of coordination and balance will increase risk of personal injury.
- **Pay full attention to the power tool while it is on.** A moment of inattention may result in personal injury. Remove the battery when not in use.



- **Wear protective personal equipment such as protective glasses, gloves, and/or ear plugs.** Protective equipment will reduce risk of personal injury.
- **Maintain secure footing and keep balance steady.** Loss of balance may result in personal injury.
- **Use hearing protection in accordance with employer's instructions or local regulations.** Prolonged exposure to high noise levels can cause permanent hearing loss.
- **Keep loose hair, clothing, jewelry, or other away from tool.** Loose clothes, jewelry, and hair can become caught by moving parts.

2.6 | Battery Safety

- **Before use, read warning label of the charger and battery.**
- **Do not attempt to service a damaged battery.** Service should only be performed by authorized providers.
- **Do not use battery if it is damaged.** Lithium-ion batteries may be flammable or explosive.
- **If liquid spills from battery, avoid contact. If contact with battery fluid occurs, rinse with water to neutralize the acid.** Battery acid can cause chemical burns, resulting in personal injury
- **Separate battery from tool or charger when not in use.** Keeping the battery in the tool or charger may result in shortened battery lifespan or accidental discharge of tool.



- **Ambient temperature of battery when charging and discharging must be between 32-104°F. (0-40°C).** Failure to adhere may result in lower battery performance and lifespan, difficulty charging, or decreased voltage.
- **Long-term storage of battery (>3 months) must be placed at approximately room temperature (68±5°F).** A battery stored at improper temperature may become unusable or hazardous to use.
- **Do not expose batteries to direct sunlight, fire, or other sources of heat.** Batteries are extremely flammable. Careless use may result in electrical fire.
- **For disposal, refer to local waste disposal regulations.** Waste disposal regulations may vary by region.



3. Product Overview

3.1 | Package Contents

- 1 RK-403 Riveting Tool
- 2 Lithium Batteries [20V, 2.0Ah]
- 1 Charger [100-240V, 50-60Hz]
- 1 Wrench
- 1 Belt Clip
- 1 Set of Complete Nosepieces [10 TOTAL]
 - 1/8" (3.2mm) Standard and Retention version
 - 5/32" (4.0mm) Standard and Retention version
 - 3/16" (4.8mm) Standard and Retention version
 - 1/4" (6.4mm) Standard and Retention version
 - 3/16" (4.8mm) TigerBolt® Nosepiece
 - 1/4" (6.4mm) TigerBolt® Nosepiece

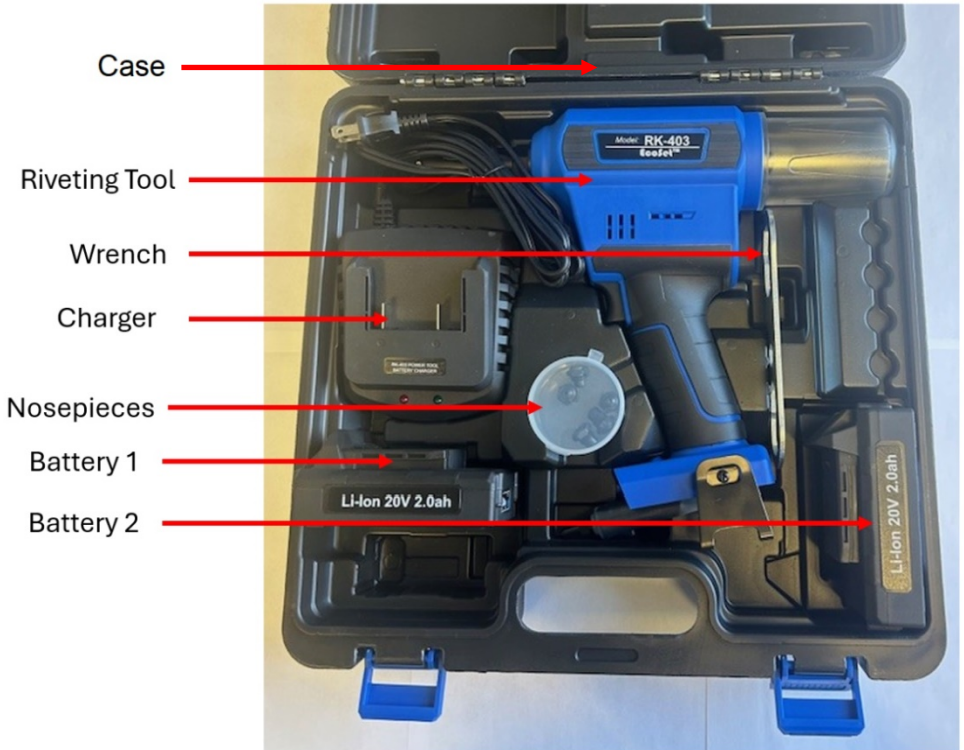


Figure 1

3.2 | Anatomy



Figure 2

4. Specifications

4.1 | Technical Parameters

Model	RK-403 EcoSet™
Description	CORDLESS RIVETING TOOL FOR STANDARD RIVETS
Max force	20kN
Work capacity	3/32" – 1/4" (3/32" nosepiece not included)
Voltage info	Motor: 20V Li-Ion Battery & Charger: 20V
Weight	Tool body (no battery): 3.3 lbs / 1.51 Kg Battery weight: 0.8 lbs / 0.38 Kg Charger weight: 0.8 lbs / 0.37 Kg
Dimensions (L x W x H)	Tool body: 11" x 4" x 10" (279.4 x 101.6 x 254 mm)

- **Work capacity**
 - Specifications: 1/8" – 1/4" (3.2mm – 6.4mm)
- **Tool body**
 - Weight 3.3 lbs. (1.51 Kg) (excluding battery)
 - Motor: 20V Brushless DC Motor
 - Tool stroke: 1.06" (27mm)
 - Max force: 20kN
- **Lithium battery**
 - Rated Voltage: 20V
 - Capacity: 2.0Ah
 - Weight: 0.8 lbs. (0.38 Kg)
- **Charger**
 - Input voltage: 100-240V/50-60Hz
 - Output Voltage: 20V
 - Charging time: ≤ 60 Min.
 - Weight: 0.8 lbs. (0.37 Kg)

4.2 | Proper Use of Nosepieces

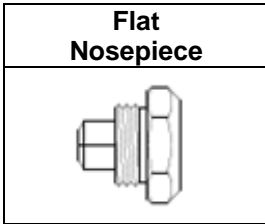


Figure 3

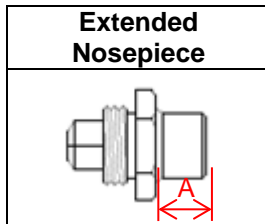


Figure 4

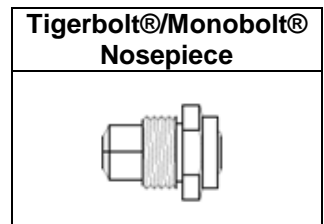


Figure 5

- A flat nosepiece (*FIG. 3*) is suitable for situations such as larger flanges, larger rivet heads, shorter mandrels, etc.
- With small rivets, it is recommended to use an extended nosepiece (*FIG. 4*). **However, when using this nosepiece there is a strict requirement on mandrel length which is calculated as follows:**
 - **(1.25" + A = Minimum required Mandrel Protrusion Length)**
- If the rivet mandrel is too short, it may lead to difficulties properly setting rivet, resulting in possible tool damage.
- A Tigerbolt®/Monobolt® nosepiece (*FIG. 5*) is suitable for the Tigerbolt®/Monobolt®, which is a structural rivet with an external locking feature.
- Special nosepieces may be necessary depending on varying configurations of rivets. Flat nosepieces (*FIG. 3*) are the standard configuration for most rivets.
- The aperture of the nosepiece (gap between correct nosepiece and housing) is 0.2 – 0.5mm (special requirements are not in this range).

5. Operating Guide

5.1 | Preparing Tool for Use

- Inspect tool. Make sure no parts are damaged before use.
- Using wrench provided, mount the correct nosepiece correlated to the part being set.
- Insert Lithium battery. Only use battery provided by RivetKing®. Strictly follow the warning on the battery label.

5.2 | Battery Use and Storage

- Fully charge battery before use. Interruption of charging will not affect or damage the battery.
- To install battery, align the tongue of the battery with the groove in the casing so it can slide into place.
- Slide battery on until it locks with an audible click. Check battery is correctly locked in place.
- The battery is equipped with a locking mechanism. When the battery is mounted on the tool, it will be fixed in place.
- To remove battery, press the unlock button and slide the battery off the tool. Do not disassemble.
- Store riveting device in a well-ventilated and dry environment in order to protect from water or dust accumulation.



- When charging, the battery's temperature must be between **32°F-104°F. (0-40°C)**.
- When in long-term storage (3+ months), it is recommended for the battery to be kept near room temperature. **(68±5°F)**.

5.3 | Setting Blind Rivets

- Insert rivet into nosepiece.
- Position rivet on desired area of application.
- Pull the trigger to engage tool and set rivet in place. It may be necessary to pull the trigger multiple times depending on the rivet used
- When rivet has been set completely, as the tool returns to its initial position, lightly tilt the tool backwards so mandrel is dropped into the mandrel collector.

5.4 | Emptying the Mandrel Collector



**ALWAYS PERFORM THE RIVETING
PROCESS WITH THE MANDREL
COLLECTOR ON TO PREVENT INJURY.**

- The tool is fitted with a quick-release mandrel collector.
- Turn mandrel collector counter-clockwise approximately 60° and pull off to remove.
- Empty mandrel collector into other container or dispose.
- Screw mandrel collector back onto product clockwise.



- Empty the mandrel collector when it is at half capacity. Failure to do so may result in reduced service life of the tool.

5.5 | Shutoff Feature

- If the motor is overloaded, the tool will stop running and the red fault light on top of the tool will flash.
 - In this case, remove the battery and nose housing, and check for trouble spots.
 - If there are no issues, press the trigger to reset tool to normal state.
- If the battery is empty or running at low voltage, the tool will be forced to power off, and the red fault light on top of the tool will flash.

6. Maintenance and Care



All repairs should be carried out by qualified personnel using only original replacement parts available from Industrial Rivet & Fastener Co., to ensure safety.



Be cautious while performing front-end maintenance due to spring-loaded mechanism in the tool.

6.1 | Maintenance Frequency

- Tools must be maintained and have parts replaced only by experienced personnel.
- It is recommended that personnel **check and clean inner nose and jaws daily for metal dust and particles.**
- Thorough inspection of tool should be carried out **after 500,000 actuations or annually**, whichever is sooner.
- Component life is dependent on size of rivet applied, frequency of use in one minute, cleanliness of tool, proper maintenance and total number of actuations.

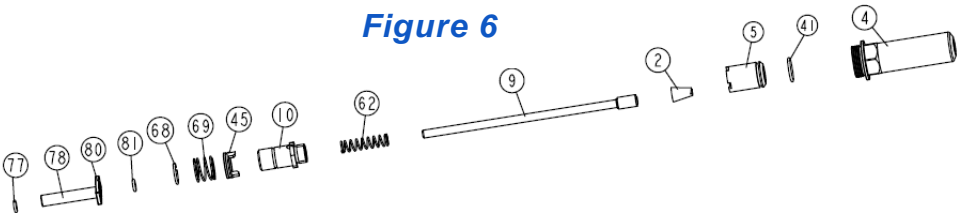


6.2 | Preventive Maintenance

- Check that mounted nose equipment is correct for desired rivet size and is fitted properly.
- Make sure detachable parts are properly tightened before use. The mandrel collector, nosepiece, and battery are examples of detachable parts.
- Remove front jaw nose assembly and clean all visible areas beneath nose cap to remove metal shavings and debris daily.
- Inspect for cracks or other damage to tool.

6.3 | Jaw Cleaning Procedure

Figure 6



- Take care during removal due to spring-loaded mechanism.
- Refer to *Figure 6* and *Figure 7* as visual aid.
- Disconnect battery from tool.
- Remove the nose casing (*fig. 6, #4*) using wrench provided by loosening at the wrench point.

- Fit one wrench on the Jaw Case (*fig. 6, #5*) and one wrench on Nut 10 (*fig. 6*). Unscrew the jaw casing while holding the nut in place. **Do not adjust nut 10.**
- Casing contains 3 small jaws, a jaw pusher, washer, and spring. **Do not lose.** Inspect all pieces for wear, cracks, and damage and replace if needed.
- If a mandrel is jammed inside the tool, dislodge mandrel.

Figure 7 ● - light lubrication ● - liberal lubrication



- Clean jaws with a mineral spirit and coat outside with oil or Moly EP Grease per *Figure 7*.
- Place three jaws into jaw case, followed by jaw pusher and spring if necessary.



- Re-apply jaw case over nut 10 while holding nut 10 in place.
- Re-apply nose casing to tool.
- Reattach battery. Actuate tool without rivet. Check for proper function.



If any front-end parts are worn, check “Wear Parts” table (8.1, pg. 26) for available replacements.

6.4 | Waste Disposal

- Power tools, batteries, accessories, and packaging must be disposed of at an approved facility per local waste disposal regulations. Failure to do so may expose personnel and the environment to hazards.
- Defective power tools and batteries must be disposed of separately due to fire hazard.

7. Troubleshooting

Effect	Possible cause	Possible remedy
Tool does not grip fastener mandrel	Jaws worn	Replace jaws
	Battery voltage low	Charge or replace battery
	Foreign buildup in nose assembly	See Jaw Cleaning Procedure [pg. 15]
	Nose spring is weak or defective	Replace spring (<i>fig. 6, #62</i>)
	The nose piece is incorrect	Use proper nosepiece
	Jaw housing is loose	Tighten against locking ring
Mandrel is not properly disposed by tool	The nose piece is incorrect	Use proper nosepiece
	The housing is not screwed tightly.	Tighten the jaw tube, nose, or nose housing.
	Mandrel obstructs nose or is wedged in jaw	Change nosepiece or check degree of jaw wear
	Mandrel collector is full	Empty the mandrel collector [pg. 13]
Slow/delayed tool cycle	Foreign buildup in nose assembly	See Jaw Cleaning Procedure [pg. 15]
LED is blinking	Motor is overloaded	Inspect battery and nose housing. Release control switch and press again.
	Battery is empty or low voltage	Charge or replace battery
Tool does not operate	Battery is not fully inserted	Push the battery in until it snaps in place. [pg. 12]
	Action is beyond ability of the tool	Swap tool
	Mandrel collector is loose	Tighten cap



8. Parts, Kits, Accessories

8.1 | Wear Parts

Wear Parts (Sold Individually)			
ITEM#	REF#	DESC.	QTY
RK403-001-NP4	1	Nose Piece 1/8" (3.2) Rivet	1
RK403-001-NP5	1	Nose Piece 5/32" (4.0) Rivet	1
RK403-001-NP6	1	Nose Piece 3/16" (4.8) Rivet	1
RK403-001-NP8	1	Nose Piece 1/4" (6.4L) Rivet	1
RK403-001-NP6TB	1	Nose Piece 3/16" (4.8) Tigerbolt®/Monobolt®	1
RK403-001-NP8TB	1	Nose Piece 1/4" (6.4) Tigerbolt®/Monobolt®	1
RK403-001-NP3-RNP	1	Retention Nose Piece 3/32" (2.4mm)	1
RK403-001-NP4-RNP	1	Retention Nose Piece 1/8" (3.2mm)	1
RK403-001-NP5-RNP	1	Retention Nose Piece 5/32" (4.0mm)	1
RK403-001-NP6-RNP	1	Retention Nose Piece 3/16" (4.8mm)	1
RK403-001-NP8-RNP	1	Retention Nose Piece 1/4" (6.4mm)	1
RK403-002	2	Jaws	1
RK403-004	4	Nose Housing	1
RK403-005	5	Jaw Guide	1
RK403-009	9	Guide Rod Assy	1
RK403-010	10	Pulling Head	1
RK403-041	41	Jaw Housing O Ring	1
RK403-042	42	Collector Assy	1
RK403-045	45	Jaw Housing Retainer	1
RK403-062	62	Spring Washer	1
RK403-068	68	Snap Ring	1
RK403-069	69	Retainer Spring	1
RK403-077	77	Rear Tube O Ring	1
RK403-078	78	Rear Tube	1
RK403-080	80	Fixed Seat	1
RK403-081	81	Oring 2	1
RK403-085	85	Li-Ion Battery	1
RK403-WRENCH		Wrench	1
RK403-CHARGER		Charger	1

8.2 | Kits and Accessories

Figure 8



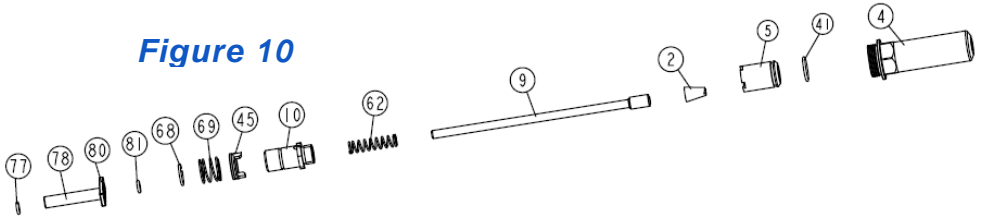
RK403-NPK		
Contents can be sold separately.		
REF#	DESC.	QTY
1	Nose Piece 1/8" (3.2) Rivet	1
1	Nose Piece 5/32" (4.0) Rivet	1
1	Nose Piece 3/16" (4.8) Rivet	1
1	Nose Piece 1/4" (6.4L) Rivet	1
1	Nose Piece 3/16" (4.8) Tigerbolt®/Monobolt®	1
1	Nose Piece 1/4" (6.4) Tigerbolt®/Monobolt®	1

Figure 9



RK403-NPK-RNP		
Contents can be sold separately.		
REF#	DESC.	QTY
1	Retention Nose Piece 1/8" (3.2mm)	1
1	Retention Nose Piece 5/32" (4.0mm)	1
1	Retention Nose Piece 3/16" (4.8mm)	1
1	Retention Nose Piece 1/4" (6.4mm)	1

Figure 10



RK403-KITA

Contents can be sold separately.

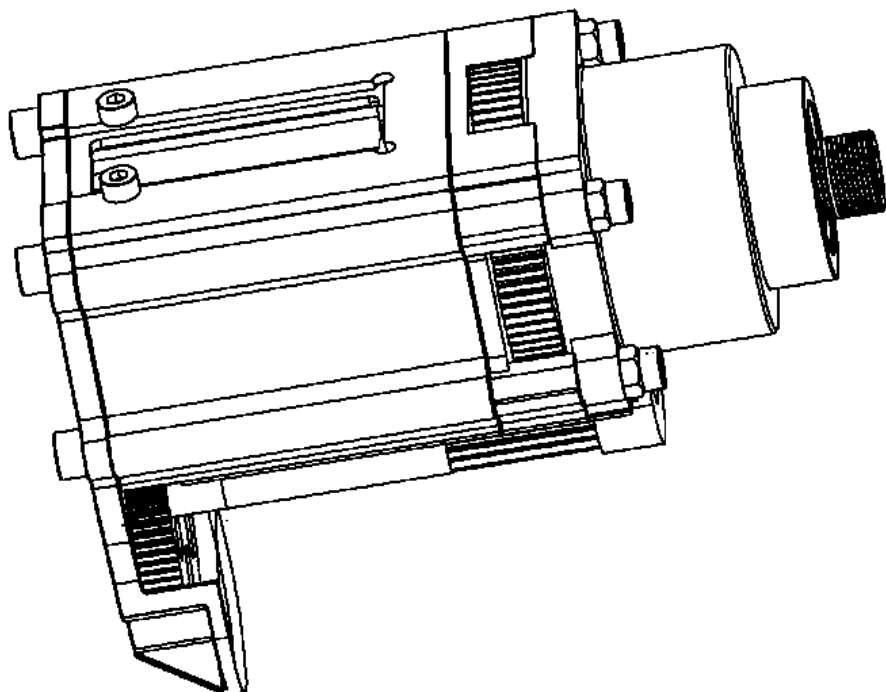
REF#	DESC.	QTY
2	Jaws	1
4	Nose Housing	1
5	Jaw Guide	1
9	Guide Rod Assy	1
10	Pulling Head	1
41	Jaw Housing O Ring	1
45	Jaw Housing Retainer	1
62	Spring Washer	1
68	Snap Ring	1
69	Retainer Spring	1
77	Rear Tube O Ring	1
78	Rear Tube	1
80	Fixed Seat	1
81	Oring 2	1

Accessories

ITEM#	DESC.
RKXXX-130 Jawset	Multi-Tool Jaw Set (3pc.) for RK-9000, RK-403 series. For parts /STR (In-Lock, MagnaLok, Interlock), /TB (TigerBolt, MonoBolt), /STM-XXX (StemLock, HemLock)

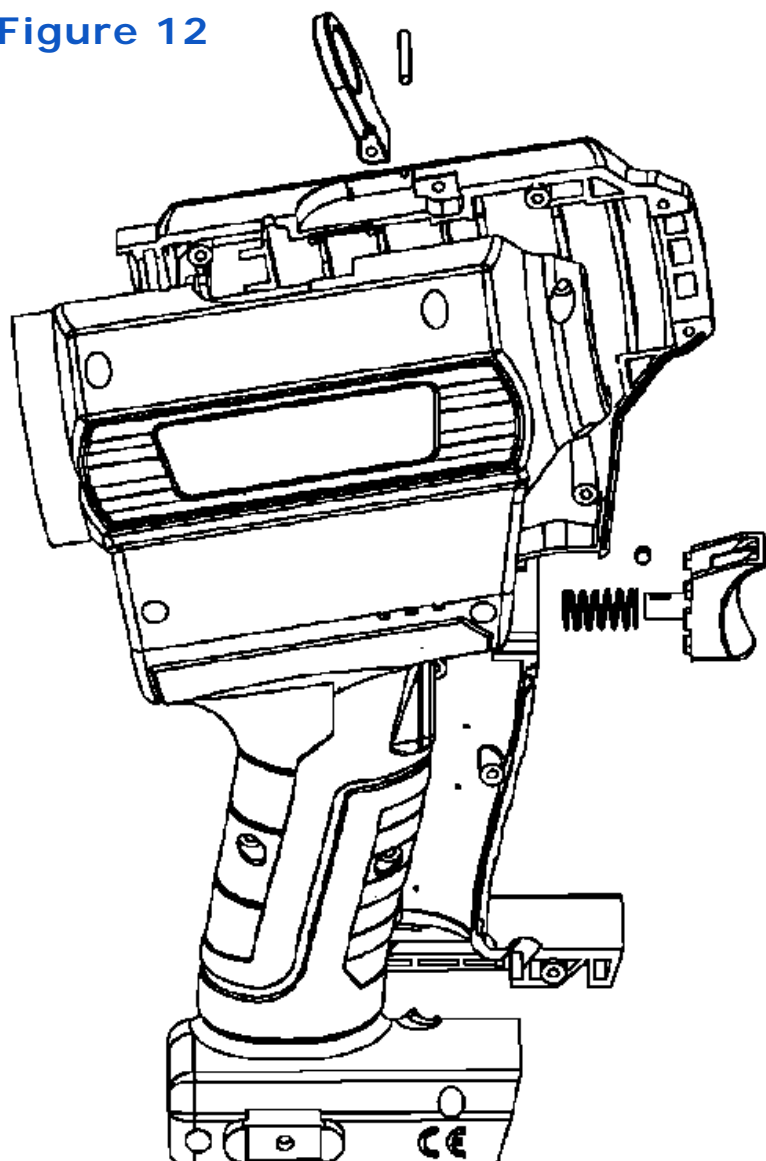
RK403-KITB - GEARBOX ASSEMBLY

Figure 11



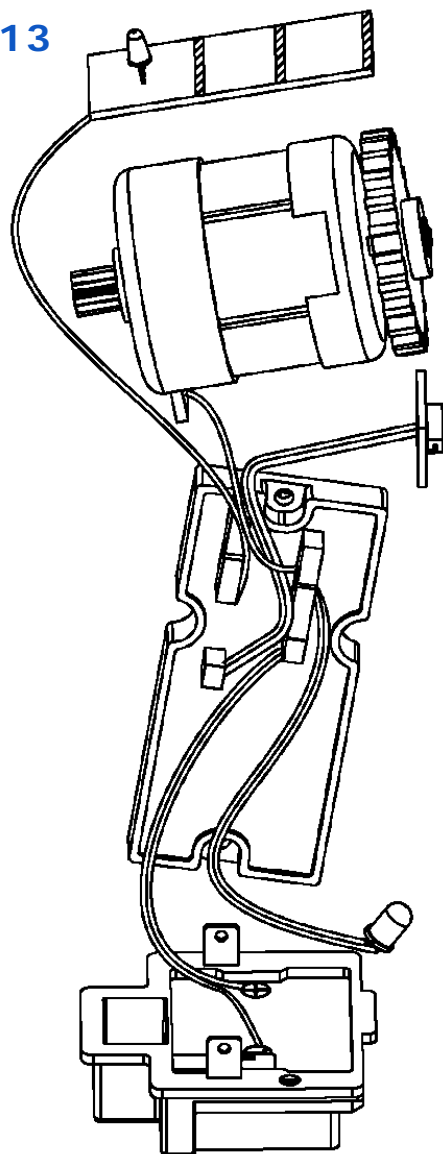
RK403-KITC – HOUSING ASSEMBLY

Figure 12



RK403-KITD - ELECTRICAL ASSEMBLY

Figure 13





Warranty Statement

Limited Warranty Policy for Industrial Rivet & Fastener Co. Inc., RivetKing® Branded Products

Industrial Rivet & Fastener Co. (hereinafter "IRF") warrants to the initial retail customer and original distributor ("Warrantee") that RivetKing® branded tools will be free from defects in material and workmanship for a period of one year from the purchase date, provided that the products are used in accordance with "IRF's" instructions as to maintenance, operation, and use.

Exclusions: This warranty does not cover consumable components, and it excludes damages caused by the use of non-genuine parts or accessories. Additionally, the warranty does not extend to products that have been subjected to misuse, neglect, accidents, improper installation, or maintenance, or products that have been altered or repaired by anyone other than the seller or its authorized agents.

Design and Construction Changes: IRF reserves the right to make periodic changes in design and construction for continuous improvement at our sole discretion.

Professional-Grade Quality: Over time, RivetKing hand tools and service equipment have earned a reputation for world-class quality, superior workmanship, and professional-grade durability. When properly used and conscientiously maintained, RivetKing tools can provide you their full lifetime of reliable service. However, this is not to say that our tools are indestructible. When subjected to intentional physical misuse and abuse, even RivetKing tools can break or fail prematurely.

Influence of Warranty Coverage: RivetKing Tools and our Distributors recognize that the warranty coverage which we offer on our tools and equipment has a significant influence on your decision to purchase and use RivetKing products. We also recognize that the intentional misuse and abuse of hand tools continues to be a common concern for us all. As a result of both considerations, Industrial Rivet has structured our warranty policies and product guarantees accordingly. While eminently fair by industry standards, RivetKing Warranty reserves the right to exclude products that have been obviously and intentionally misused and abused.



Remedies: In the event of a defect or failure, IRF will, at its sole option, either repair, replace, or rework the products covered by this warranty, ensuring that the cost does not exceed the invoice price. Additionally, for certain designated economy tool models, only replacement under warranty conditions will be provided, as these models are not intended to be serviced by our repair department; consumables for these models are available for purchase.

Claim Notification: This warranty shall be void if any person seeking to make a claim for defective or failed products fails to notify IRF within 30 days of receipt of evidence that the product is defective or has failed, or if said person fails to provide IRF with such evidence as is reasonably requested concerning the effect or failure, including without limitation, evidence of the date of purchase and date of installation.

Limitation of Liability: This warranty is in lieu of all other warranties, expressed or implied, including merchantability or fitness provided for herein. Under no circumstance shall IRF be liable for incidental or consequential damages arising from the defect or failure in its products.

Seller's Obligation: Seller's sole obligation under the foregoing warranty will be limited to, at Seller's option, repair or replacement of the tool. Returned goods will be evaluated by our warranty repair department and a conclusion will be determined and classified as:

- Warranty Repair or Replacement (free of charge)
- Abuse/Neglect (bench fee and/or hourly rate)
- Maintenance (Flat Fee)

If inspection by the seller of returned goods shows no breach of the foregoing warranty, Seller's regular conditioning charges (as stated above) apply. Upon this conclusion, we will either repair the tool at no cost to you and return it postage paid, or call you to inform you of the repair cost. The repair will need to be approved in writing before any work is performed

Tool Service and Preventive Maintenance Program: A comprehensive tool service and maintenance program is available. For details, contact your distributor, or local area sales representative at 1-800-289-7483..



Certificate of Conformance

We herewith declare that the devices specified below comply with the relevant EC guidelines with regards to design and construction type.

If the devices are modified without our authorization, this declaration will become null and void.

The devices specified below comply with the valid EGB / EMV standards applicable at the time of publication.

Company:

Company: Industrial Rivet & Fastener Co.

Location: 200 Paris Avenue Northvale, New Jersey 07647

Phone: 1-800-BUY-RIVET

Fax: 201-750-1050

Description of device:

Cordless Riveting Tool For Standard Rivets

Model:

RK-403

Applied EC guidelines:

2006/42/EG
2004/108/EG
EN55014
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