

PATTA®

Cordless Riveter

DRG18-50 | 64



User Manual
& Safety Instructions

www.patta.com



Safety Instructions

WARNING: Please read all of the following safety information and instructions. Failure to comply with the safety information and the instructions can lead to electric shock, fire, and/or serious injuries. Please keep all safety information and instructions for future reference.

Workspace safety

1. Keep your workspace clean and provide sufficient lighting. Messy or insufficiently illuminated work areas can lead to accidents.
2. Do not operate the Rivet Gun in an environment with risk of explosions (areas that contains flammable liquids, gases, or dust). Rivet Guns create sparks that can inflame the dust or the vapors.
3. Keep children and other people away while operating the Rivet Gun. In case of distraction, you can lose control of the machine.

Electric safety

1. Do not expose Rivet Guns to rain or humidity. Water entering a Rivet Gun increases the risk of electric shock and tool damage.

People safety

1. Stay alert, be careful with your actions and use the Rivet Gun in a reasonable way.
2. Do not use the Rivet Gun if you are tired or under the influence of alcohol, drugs, or medication. A momentary inattention while using the Rivet Gun can lead to serious injuries.
3. Wear protective clothing and always wear protective safety glasses. Wearing protective clothing like a dust mask, skid-proof safety shoes, a protective helmet or ear protectors (depending on the conditions and requirements you use the Rivet Gun for) reduces the risk of injuries.
4. Remove adjusting tools and screwdrivers before switching on the Rivet Gun. A tool or screwdriver placed into a rotating part of the device can lead to injuries.
5. Avoid unnatural body positions. Ensure you are standing firmly and always preserve your balance. This way you can better control the Rivet Gun, should an unexpected situation occur.
6. Wear appropriate clothes. Do not wear large clothes or jewelry. Avoid putting your hair, clothes, and gloves close to the moving parts of the device. Loose clothing, long hair, and jewelry can be caught up in the moving parts.
7. Make sure that the mandrel collection device is connected and used correctly.

Operation and handling of the Rivet Gun

1. Do not overload the machine. Use the Rivet Gun that is suitable for your work. The suitable Rivet Gun allows you to work better and safer in the specified range of performance.
2. Do not use a Rivet Gun that has a defective trigger switch. A Rivet Gun which cannot be turned on and off any more is dangerous and has to be repaired.
3. Remove the battery before making adjustments to the device, changing accessories, or putting the device away. This safety precaution prevents the inadvertent start of the Rivet Gun.
4. Store unused Rivet Guns out of the reach of children. Do not allow persons not familiar with the device or persons who haven't read these instructions to operate the device. Rivet Guns are dangerous when in the hands of inexperienced persons.
5. Pay attention to the maintenance of Rivet Guns. Check if the moving parts are functioning flawlessly and do not jam. Check for broken and damaged parts that could influence the operation of the Rivet Gun. Repair the damaged parts before using the device. Accidents with Rivet Guns usually stem from maintenance failures.
6. Use the Rivet Gun, accessories, tools, etc. according to these instructions. Take into consideration the working conditions and the type of work. The use of Rivet Guns for tasks other than the intended ones can lead to dangerous situations.

Use and handling of the battery tools

1. Only recharge the batteries in charging devices approved by the manufacturer. There is a risk of fire when using a charging device designed for a specific battery type when it is used with other batteries. In Rivet Guns, only use batteries that have been designed for this tool. Using other battery types could lead to fire and injuries.
2. When not using the battery, keep it away from paper clips, coins, keys, nails, screws, and other small metallic objects which may cause the contacts to connect. If the battery contacts short-circuit, it may lead to burns or fire.
3. Fluid may emerge from the battery if it is used incorrectly. Avoid contact with that fluid. In case of accidental contact with the body, rinse the area with water. If the battery fluid comes in contact with the eyes, additionally call for medical help. Uncontained battery fluid can lead to burns and irritation of the skin.

Service

1. Only let qualified personnel repair your Rivet Gun and use only original spare parts. This ensures the continuous safety of the Rivet Gun.

Safety information for Rivet Guns

1. Hold the Rivet Gun firmly with both hands when working with this tool. The Rivet Gun can be operated safer when using both hands.
2. Immediately turn off the Rivet Gun if the electric rivet tool jams.
3. Be prepared for a high reacting torque which causes strong recoil. The tool jams when the Rivet Gun is overloaded.
4. Hold the Rivet Gun tightly.
5. Secure the workpiece that is to be riveted. A workpiece is held more securely by a clamping device or a bench vise than by hand.
6. Make sure that the power switch is turned to the "Off" position before inserting a battery. Holding your fingers close to the power switch when carrying the Rivet Gun or inserting a battery while "On" may lead to accidents.
7. Do not open the battery, as this leads to the risk of a short-circuit. Keep the battery away from heat (e.g. permanent sun radiation) and from fire due to the risk of explosion.
8. If the battery is damaged or used in an inappropriate manner, vapors may emerge from it. Get some fresh air and call for medical help in case of complaints. The vapors can lead to irritation of the respiratory tracts.
9. If the battery is defective, fluid may emerge from it and coat adjacent objects. Check the parts affected, clean them or replace them, if necessary.
10. Use the battery specifically designed for the Rivet Gun. This is the only way to prevent the dangerous overload of the battery.

Technical Specifications

DRG18-50 processing blind rivets of 3/32" to 3/16"

1. Weight: 3.67lbs / 1.67kgs (with battery)
2. Stroke: 0.92" / 21mm
3. Engine: 18V DC motor
4. Installation force: 2025lbf / 9000N

Quick-replacement of the rechargeable battery

Battery:

Charging device:

- | | |
|-------------------------------|--------------------------------------|
| 1. Nominal voltage: 18V | 1. Input voltage: 100-240V / 50-60Hz |
| 2. Capacity: 1.5Ah Li-ion | 2. Output voltage: 18V |
| 3. Weight: 0.82 lbs / 0.37kgs | 3. Recharging time: S60 minutes |
| | 4. Weight: 0.8lbs / 0.36kgs |

Nosepiece Sizes

3/32" [24mm] | 1/8" [3.2mm] | 5/32" [4.0mm] | 3/16"[5.0mm]

DRG18-64 processing blind rivets of 1/8" to 1/4"

1. Weight: 4.19lbs / 1.9kgs (with battery)
2. Stroke: 1" / 25.5mm
3. Engine: 18V DC motor
4. Installation force: 3822lbf / 17000N

Quick-replacement of the rechargeable battery

Battery:

Charging device:

- | | |
|-----------------------------|--------------------------------------|
| 1. Nominal voltage: 18V | 1. Input voltage: 100-240V / 50-60Hz |
| 2. Capacity: 3.0Ah Li-ion | 2. Output voltage: 18V |
| 3. Weight: 1.32lbs / 0.6kgs | 3. Recharging time: S120 minutes |
| | 4. Weight: 0.8lbs / 0.36kgs |

Nosepiece Sizes

1/8" [3.2mm] | 5/32" [4.0mm] | 3/16"[5.0mm] | 1/4"[6.4mm]

Operational description

Depicted components

The lettering of the components in the picture below refers to the main exterior parts of the Rivet Gun.

- | | |
|-----------------------|-------------------------------|
| A. Nosepiece | E. Trigger |
| B. Front sleeve | F. Riveting area illumination |
| C. Failure indication | G. Battery locking switch |
| D. Mandrel collector | H. Battery |



Charging the battery

Note: The battery is only partially charged on delivery.

To guarantee full power of the battery, charge it completely in the charger before first use. Pay attention to the charge indicator on the charging device.

The Li-ion battery can be recharged at any time without affecting its life. Interrupting the charging process doesn't damage the battery.

The battery is equipped with a temperature monitoring system which only allows for charging between 320F and 1130F (0°C and 45°C)

Please consider the notices for disposal.

Removing the battery

The battery (H) is equipped with a locking mechanism (G). As long as the battery remains inside the Rivet Gun it is held in position by a spring.

To remove the battery (H), press the unlocking button (G) and slide the battery from the electric riveting device. Don't use force.

Putting the device

into operation Insert the battery. Only use original Li-ion batteries with the voltage depicted on the type label of your Rivet Gun.

The use of other batteries may lead to injuries and risk of fire.

Lighting Mode

When pressing the trigger (E) or fixing the battery pack for the first time, the white LED (on the foot of the device) for illumination of the riveting area lights up and lasts for 15 seconds. If the device is not in use during these 15 seconds, pressing the trigger (E) will reset the lighting mode to counter to the next 15 seconds.

Changing nosepieces

The nosepieces(A) are marked with numbers corresponding to the rivet size. Hold the power switch(E) pressed, which will lead to the clamping mechanism moving into the rear position. Use the included wrench to change the nosepiece (A) and release the power switch.

Riveting

Insert the rivet into the nosepiece (A) and the other end of the rivet into the work-pieces to be riveted. Press the power switch until the rivet is removed, then release the power switch. Tilt the riveting device backward so that the removed mandrel pin falls into the mandrel collector (D). If the rivet doesn't come off in a single working stroke, repeat the procedure.

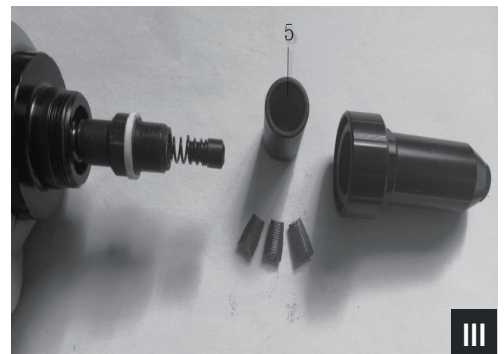
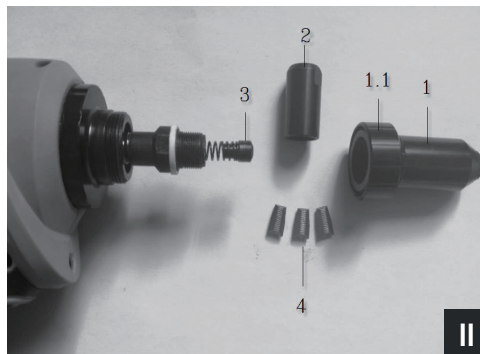
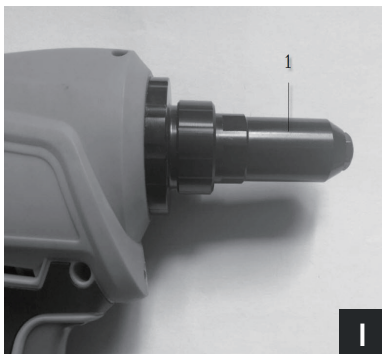
Failure

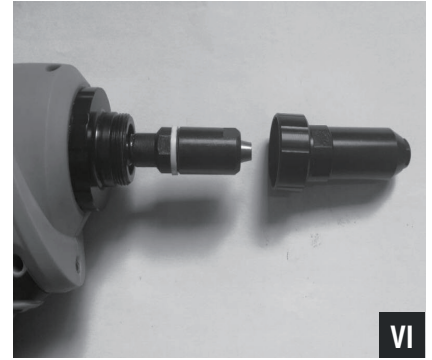
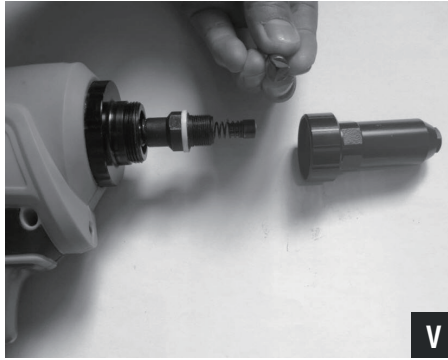
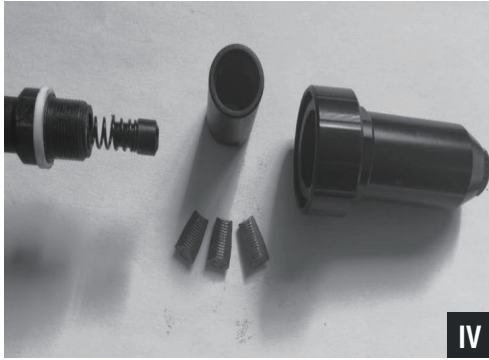
Over Current Protection: If the battery is overloaded, the device will stop operating and the failure indication (C) will light up in red for 5 seconds. In this case, don't press the trigger (E) anymore, please unfix the front sleeve (B), then press the trigger (E) to reset the device to normal state Low Voltage Protection: If the battery is empty or with low voltage, the device is powered down by a protective circuit and the failure indication (C) will light up in yellow for 10 seconds.

WARNING: Rivet size must be suitable for nosepiece (A), for example, a 5mm nosepiece should be fixed with 5mm rivet.

Changing the clamping jaw

The clamping jaws are worn parts. If you are unable to rivet in a single working stroke you should change the clamping jaws:





- I. (1) Front sleeve (1.1) Fixed nut
- II. (2) Clamping sleeve
(3) Conduit
(4) Clamping jaws (3 parts)
Remove the front sleeve (1) and the clamping sleeve (2) from the device (3) and remove the clamping jaws (4) from the clamping sleeve (2).
- III. Oil the clamping sleeve (2) with grease (5)
- IV. Hold the clamping sleeve (2) so that its forward part is faced down.
- V. Place the clamping jaws (4) in the clamping sleeve (2) with their smooth sides facing outwards.
- VI. Mount the clamping sleeve (2) with the new clamping jaws (4) and finally replace the front sleeve (1).

Battery Notes

Keep the battery away from moisture and water. Only store the battery at temperatures from 0° to 45°C. Do not leave the battery in the car, e.g. in summer. If the battery is working for significantly shorter periods of time after a recharge, it is weak and needs to be replaced.

Please consider the notices for disposal.

Maintenance and Service

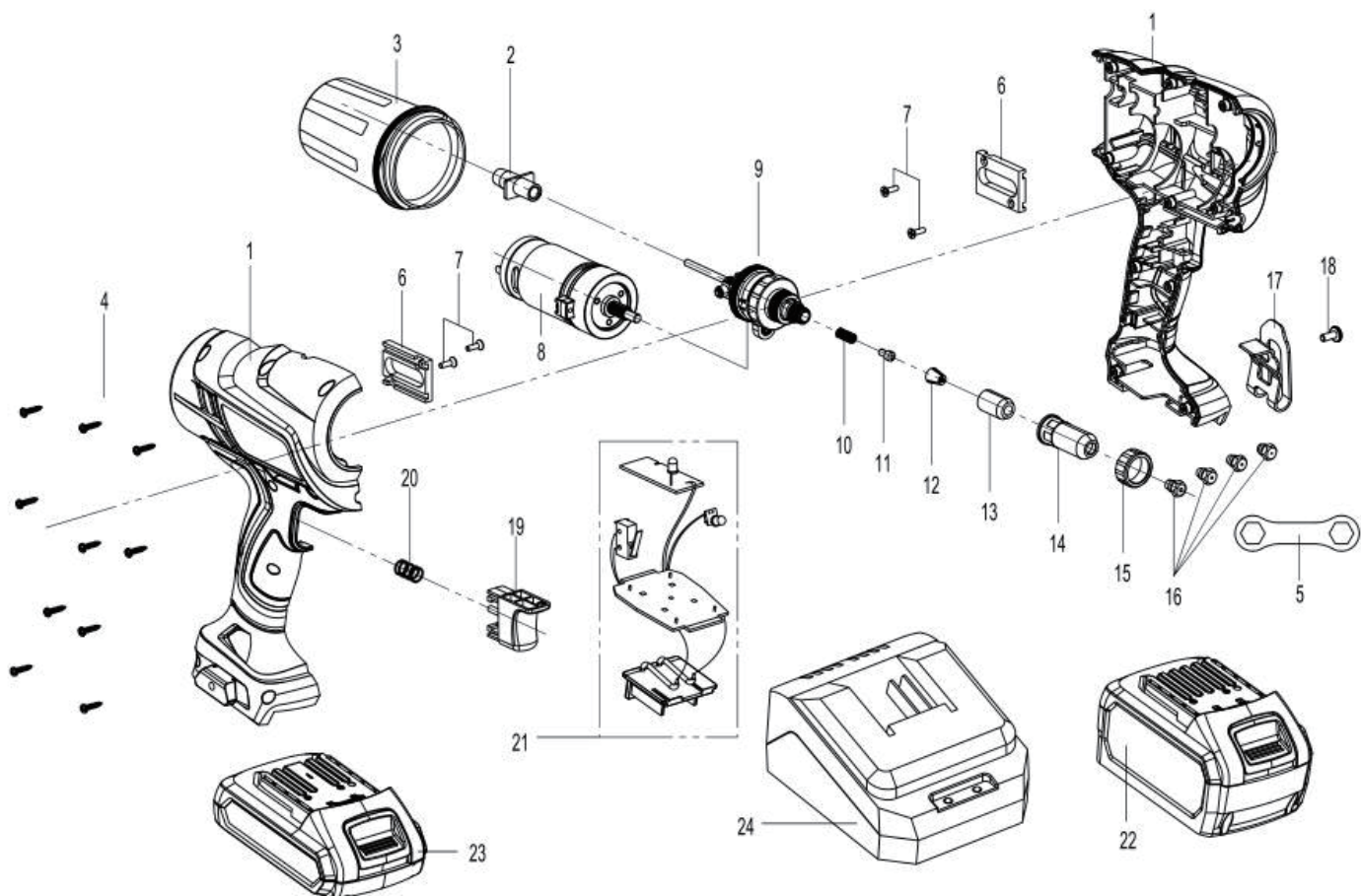
1. Take the battery out of the Rivet Gun for transportation and storage. Risk of injury occurs if you inadvertently press the power switch.
2. Keep the Rivet Gun and the ventilation slots clean to ensure good and safe operation.
If the Rivet Gun should fail despite the meticulous manufacturing and quality control procedures, the repairs should be done by an authorized service center for
3. electric riveting devices.

Disposal

1. Rivet Guns, accessories and packaging should be disposed in a way which makes them available for environment-friendly recycling.
2. Do not dispose of Rivet Guns in household waste.
3. Rivet Guns that are not functional need to be collected separately to make them available for environment-friendly recycling.

Batteries

1. Li-ion: Do not dispose of batteries in household waste, do not throw them into fire or water.
2. Batteries should be collected and recycled or disposed of in an environment-friendly way. Defective and non-functional batteries need to be recycled. Batteries that are not functional can be returned to your local distributor or directly disposed of in an environment-friendly way.



N0.	Part Name	Qty
1	Right & left housing	1
2	Mandrel conduit	1
3	Mandrel collector	1
4	ST3 x 16-F screw	10
5	Wrench	1
6	Slider	2
7	Screw 1	4
8	Motor & gear box	1
9	Mechanical transmission	1
10	Spring 1	1
11	Conduit	1
12	Clamp jaw set	1
13	Clamping jaw front sleeve	1

N0.	Part Name	Qty
14	Front sleeve	1
15	Fixed nut	1
16	Nosepiece	4
17	Hook	1
18	Screw 2	1
19	Trigger	1
20	Spring 2	1
21	PCB	1
22	10 cell battery	1
23	5 cell battery	1
24	Charger	1

安全信息

注意：请阅读以下所有安全信息和说明。不遵守安全信息和说明可能导致触电、火灾和/或严重伤害。请保留所有安全信息与说明，以便将来参考

工作空间安全

1. 保持您的工作空间清洁，并提供 足够的照明 。凌乱或照明不足的工作区域可能导致事故。
2. 请勿在有爆炸风险的环境中操作铆钉枪（含有易燃液体、气体或粉尘的区域）。铆钉枪大电流及产生细微的火花，可以点燃灰尘或蒸气。
3. 操作铆钉枪时，让孩子和其他人远离，同时。如果分心，您可能会失去对机器的控制。

电气安全

1. 不要将铆钉枪暴露在雨中或潮湿环境中。进入铆钉枪的水会增加触电和工具损坏的风险。

人员安全

1. 保持警觉，小心你的行动，并以合理的方式使用铆钉枪。
2. 如果您感到疲倦或受到酒精，药品或药物的影响，请勿使用铆钉枪。使用铆钉枪时防护服像防尘口罩，防滑安全鞋，防护头盔或耳罩（取决于您使用铆钉枪的条件和要求）一样，可以降低受伤的风险。
3. 开启铆钉枪之前，请将无关的调节工具和螺丝刀远离工具。将工具或螺丝刀放置在装置的旋转部分（如机壳通风口）可能会伤害到操作者及工具。短暂的注意力不集中会导致严重伤害。
4. 穿戴防护服，并始终佩戴防护安全眼镜。
5. 避免不自然的身体姿势。确保你站得稳，并始终保持你的平衡。通过这种方式，您可以更好地控制铆钉枪，以防发生意外情况。
6. 穿合适的衣服。不要穿過大的衣服或珠宝。避免将头发、衣服和手套靠近设备的活动元件。宽松的衣服，长发与珠宝可能会被夹在活动元件中。
7. 确保废钉杆收集筒已连接并正确使用。

铆钉枪的操作和处理

1. 请勿使机器过载。使用适合您工作的铆钉枪。合适的铆钉枪可让您在指定的性能范围内更好，更安全地工作。
2. 不要使用功能不良的铆钉枪。如無法开启和关闭的铆钉枪或者工具顶部报警指示灯显示红色是危险的，必须修理。
3. 在对设备进行调整、更换配件或将拆卸装置收起之前，请取出电池。这种安全预防措施可防止铆钉枪的意外启动。
4. 将未使用的铆钉枪存放在孩童无法触及的地方。不要让不熟悉设备的人或没有读过操作手册的人操作设备。铆钉枪在没有经验的人手中时是危险的。
5. 注意工具的保养。检查移动部件是否正常运行，如工具沒有异常及被废钉杆卡住。检查可能影响铆钉枪操作的破损部件。使用设备前修复损坏的部件。铆钉枪事故都源于维护故障。
6. 按照这些说明使用铆钉枪，配件，工具等。考虑工作条件和工作类型，将铆钉枪用于预期任务以外的任务可能会导致危险情况。

电池工具的使用和处理

1. 只能在制造商认可的充电设备中对电池进行充电。使用专为特定电池类型设计的充电设备与其他电池一起使用时，存在着火风险。在铆钉枪中，仅使用已设计的电池或此工具。使用其他电池类型会导致火灾和伤害。
2. 不使用电池时，请将电池远离迴紋針，硬币，钥匙，钉子，螺丝和其他可能导致触点连接的小金属物体。如果电池接触短路，可能会导致灼伤或发火。
3. 如果使用不当，液体可能会从电池中流出。避免与该液体接触。如果意外接触身体，请用水冲洗该区域。如果电池液接触到眼睛，请另外寻求医疗帮助。电池的液体会导致灼伤和刺激皮肤。

服务

1. 只能让合格的人员修理您的铆钉枪，并且只能使用原装备件。这确保了铆钉枪的持续安全性。

铆钉枪的安全信息

1. 使用时，用双手牢牢握住铆钉枪。使用双手时铆钉枪可以更安全地操作。
2. 如果电动铆钉工具卡住，请立即关闭铆钉枪。
3. 为反扭矩造成强烈的后坐力做好准备。当铆钉枪过载时，工具会卡住。
4. 紧紧握住铆钉枪。
5. 固定要铆接的工件。一个工件通过夹具更牢固地固定设备或工作台而不是手动固定。
6. 插入电池之前，请确保将电源开关开启到「关闭」位置。携带铆钉枪或在「打开」状态下插入电池时，将手指靠近电源开关可能会导致事故。
7. 电池不能挪作他用，因为这会导致短路的风险。由于有爆炸危险，使电池远离热源（例如永久性太阳辐射）和火源。
8. 如果电池损坏或以不合适的方式使用，则可能会从中冒出蒸汽。呼吸新鲜空气，如有投诉，寻求医疗帮助。蒸气会刺激呼吸道。
9. 如果电池有缺陷，流体可能会从中流出并覆盖相邻的物体。检查受影响的部件，清洁它们或更换它们（如有必要）。
10. 使用专为铆钉枪设计的电池。这是防止电池危险过载的唯一方法。

技术标准

DRG18-50 用于加工2.4 [3/32"] 至 5.0[3/16"] 的盲铆钉

1. 重量：3.67磅 / 1.67公斤（含電池）
2. 行程：0.92"/ 21mm
3. 发动机：18V直流电机
4. 安装力：2025lbf / 9000N

电池

1. 标称电压：18V
2. 容量：1.5AH锂离子
3. 重量：0.82磅 / 0.37公斤

充电设备

1. 输入电压：100-240 V / 50-60 Hz
2. 输出电压：18V
3. 充电时间：60 分钟±10分钟
4. 重量：0.8磅 / 0.36公斤

枪嘴尺寸

3/32" [24mm] | 1/8" [3.2mm] | 5/32" [4.0mm] | 3/16"[5.0mm]

DRG18-64 用于加工3.2 [1/8"] 至 6.4[1/4"] 的盲铆钉

1. 重量：4.19磅 / 1.9公斤（含電池）
2. 行程：1"/ 25.5mm
3. 发动机：18V直流电机
4. 安装力：3822lbf / 17000N

电池

1. 标称电压：18V
2. 容量：3.0AH锂离子
3. 重量：1.32磅 / 0.6公斤

充电设备

1. 输入电压：100-240 V / 50-60 Hz
2. 输出电压：18V
3. 充电时间：120 分钟±10分钟
4. 重量：0.8磅 / 0.36公斤

枪嘴尺寸

1/8" [3.2mm] | 5/32" [4.0mm] | 3/16" [5.0mm] | 1/4"[6.4mm]

操作说明

零件描述（图片中组件的字母是指铆钉枪的主要外部部件）

- | | |
|------------|-----------|
| A. 枪嘴 | E. 开关扳机 |
| B. 外套筒 | F. 铆接区域照明 |
| C. 故障报警指示灯 | G. 电池锁定开关 |
| D. 废钉杆收集筒 | H. 电池 |



为电池充电

注意：交貨時電池仅部分充电。

为保证电池充满电，请在首次使用前在充电器中完全充电。注意充电设备上的充电指示灯，锂离子电池可以随时充电，而不会影响其使用寿命，中断充电过程不会损坏电池。电池配有温度监控系统，仅允许在32°F和113°F [0°C和45°C] 下进行充电。

请考虑处置通知

取出电池

电池 [H] 配备了锁定机制 [G]。只要电池保持在铆钉枪内，它就会被弹簧固定到位。

要取出电池 [H]，请按解锁按钮 [G] 并从电铆接装置中滑动电池。不要用力。

将设备投入运行

插入电池。仅使用原装锂离子电池，其电压与铆钉枪类型标签上描述的电压相同。

使用其他的电池可能会导致受伤和起火

照明模式

首次按下扳机 [E] 或固定电池组时，用于照亮铆接区域的白色LED（位于外套筒下方）亮起并持续15秒。

如果设备在这15秒内未在使用中，按扳机 [E] 将重置照明模式重新接下来的15秒。

更换枪嘴

枪嘴 [A] 标有与铆钉尺寸相符的数字。握住电源开关 [E] 按下，机械传动组件尤其夹紧套筒部分后移，使枪嘴不受外力。

使用随附的扳手更换枪嘴 [A] 并松开电源开关使机械传动组件复位即可。

铆接

将铆钉插入枪嘴 [A]，将铆钉的另一端插入要铆接的工件中，按下电源开关，直到铆接完成废钉杆脱离，然后松开电源开关。

向后倾斜铆接装置，使遗留在枪嘴内的废钉杆落入废钉杆收集筒 [D]。如果铆钉在一次工作行程中没有脱落，请重复该过程。

失败

过流保护：如果电池过载，设备将停止运行，故障指示灯 [C] 将以红色亮起5秒。

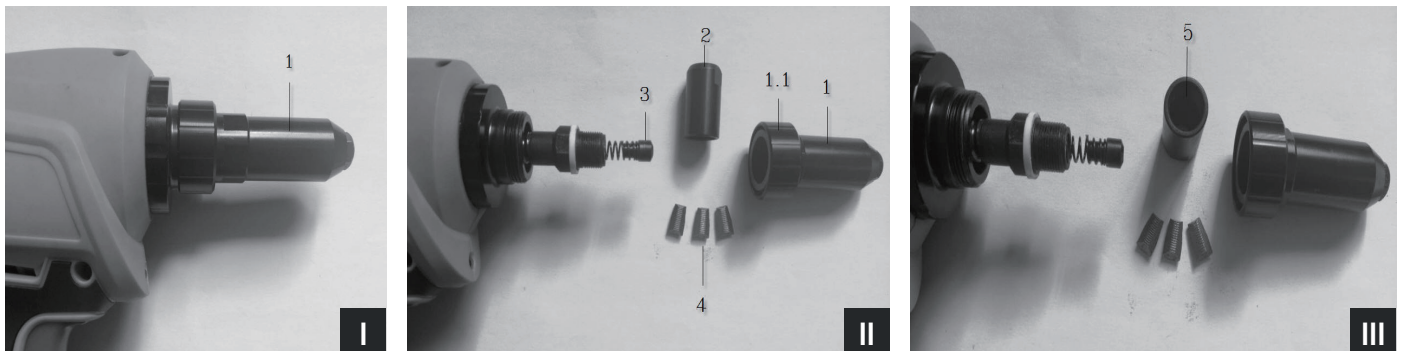
在这种情况下，不要再按下扳机 [E]，请解开外套筒 [B] 的固定，然后按扳机 [E] 将设备重置为正常状态。

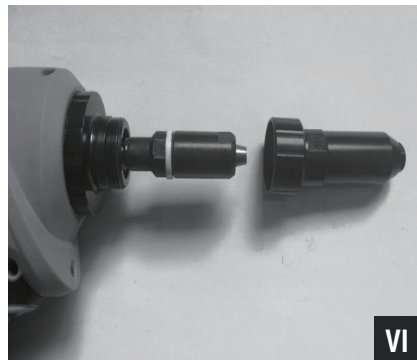
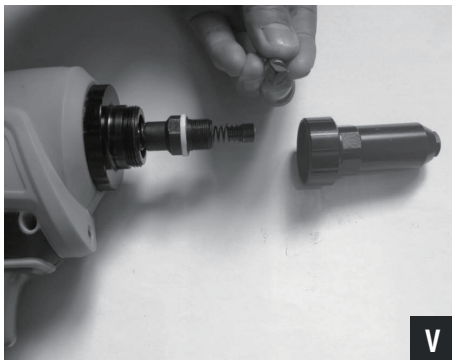
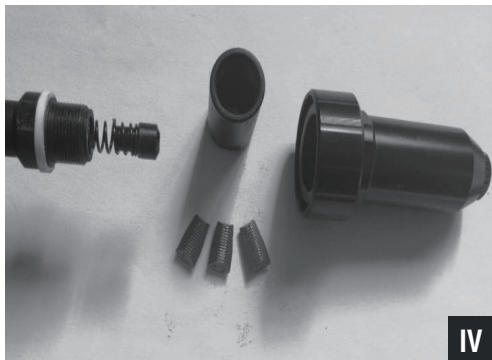
低电压保护：如果电池电量不足或电压低，则设备由保护电路断电，故障指示 [C] 将以黄色点亮10秒钟。

警告： 铆钉尺寸必须适合枪嘴 [A]，例如4.8-5.0mm枪嘴应用4.8-5.0mm铆钉固定。

更换夹爪

夹爪是易损件。如果您多次无法在一次工作行程中铆接，则应更换夹爪：





- I. [1] 外套筒 [1.1] 固定螺母
- II. [2] 夹紧套筒
 - [3] 顶芯
 - [4] 夹爪 [3 个部件]
 从工具上取下外套筒 [1] 和夹紧套筒 [2]，并从夹紧套筒 [2] 上取下夹爪 [4]。
- III. 用润滑脂给夹紧套筒 [2] 上油 [5]
- IV. 握住夹紧套筒 [2]，使其前部朝下。
- V. 将夹爪 [4] 放在夹紧套筒 [2] 中，使其光滑的侧面朝外。
- VI. 将夹紧套筒 [2] 与新的夹爪 [4] 一起安装固定，最后安装外套筒 [1]。

电池说明

使电池远离潮湿和水。仅将电池存放在 0°C 至 45°C 的温度下。不要将电池留在车内，例如在夏季。如果电池在充电后工作的时间明显较短，则电池很弱，需要更换。

请考虑处置通知。

维护和服务

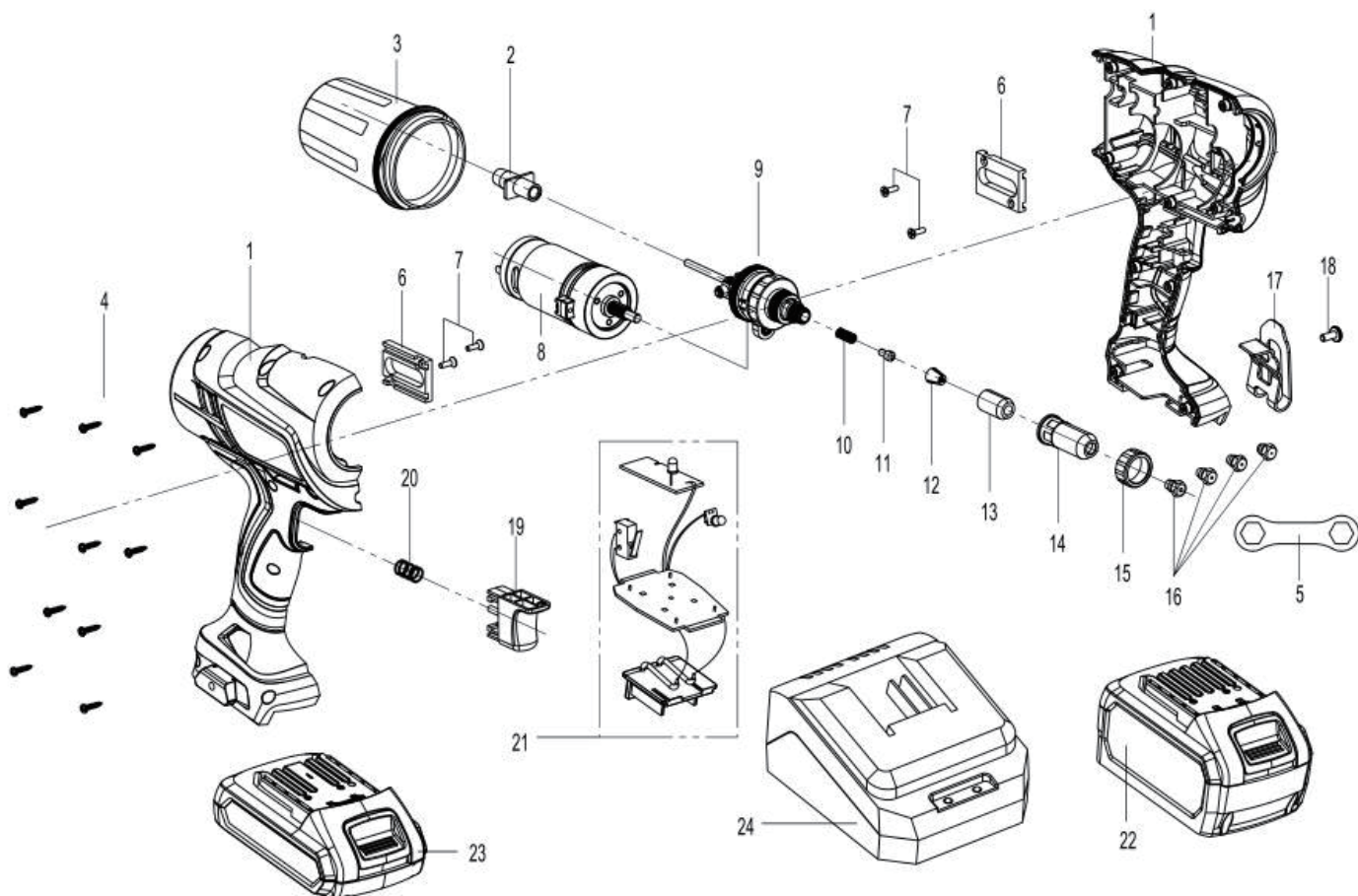
1. 将电池从铆钉枪中取出以进行运输和保存。如果您无意中按下电源开关，则有受伤的风险。
2. 保持铆钉枪和机壳通风槽清洁，以确保良好和安全的操作。
3. 如果拉铆零件无误和按正常铆接程序使用拉铆枪铆接的情况下出现故障，维修应由电动铆接装置的授权服务中心完成。

处理

1. 铆钉枪、配件和包装的处理方式应使其可用于环保回收。
2. 不要将铆钉枪丢弃在家庭垃圾中。
3. 无法正常工作的铆钉枪需要单独收集，以便进行环保回收。

电池

1. 锂离子：不要将电池丢弃在生活垃圾中，不要将它们扔进火或水中。
2. 电池应以环保的方式进行组装回收或拆卸。有缺陷和不起作用的电池需要回收。
不能正常工作的电池可以退回给您当地的经销商，也可以直接在环保的设备上处理。



N0.	Part Name部件名称	数量
1	左右 外壳	1
2	钉杆导管	1
3	废钉杆收集筒	1
4	ST3 x 16-F 螺丝	10
5	扳手	1
6	滑轨	2
7	螺钉1	4
8	电机和齿轮箱	1
9	机械传动组件	1
10	压簧 1	1
11	顶芯	1
12	三爪套件	1
13	夹紧套筒	1

N0.	部件名称	数量
14	外套筒	1
15	固定螺母	1
16	枪嘴	4
17	挂钩	1
18	挂钩螺丝 2	1
19	开关扳机	1
20	扳机弹簧	1
21	PCB線路板	1
22	3.0AH电池	1
23	1.5AH电池	1
24	充电器	1

Cordless Riveter

DRG18-50 | 64

User Manual & Safety Instructions

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