

Precautions

- Always wear eye protection when using the riveter.
- Do not hold the workpiece by hand, always secure with a clamp or in a vice, etc.
- Do not operate the riveter if any parts are missing or damaged.
- Keep the riveter clean and maintain in good condition.



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Safety First. Be Protected.

Guarantee

If this product fails through faulty materials or workmanship, contact our service department direct on: **+44 (0) 1926 818186**. Normal wear and tear are excluded as are consumable items and abuse.

TOOL CONNECTION

The Complete Connection

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LASER[®]

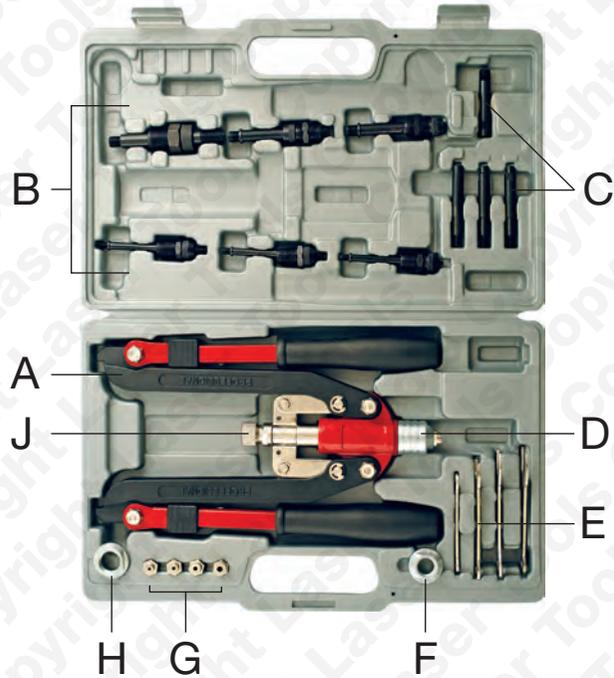
Heavy Duty Riveter Set

Instructions



Heavy Duty Riveter Set

This comprehensive heavy duty riveting set is designed for pop rivets and also nut rivets (Rivnuts), capable of handling up to 12mm and also the male version of the Rivnut, the Rivbolt. A professional tool for any situation where heavy duty riveting is required.



Components	
A	Riveter
B	Mandrels and Bars (Rivnuts)
C	Bars (Rivbolts)
D	Nosepiece 10mm (pop rivets)
E	Spanners
F	Nosepiece 14mm
G	Mandrels (pop rivets)
H	Nosepiece 18mm
J	Draw-bar body grip

3736 - Heavy Duty Riveter

Spare Parts Available:	Laser Tools Part Number
M4 mandrel	2770
M5 mandrel	2771
M6 mandrel	2772
M8 mandrel	2773
M10 mandrel	2774
M12 mandrel	3864
Sleeve seat M12	3865
Sleeve seat nut riveter	0249
Sleeve seat riveter	0248
Jaws	2806

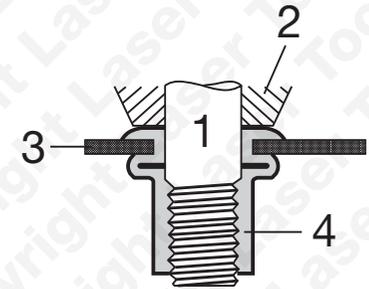
Instructions

Pop Rivets:

1. Screw nosepiece D onto riveter.
2. Select the pop rivet mandrel G which matches the shaft diameter of the rivet and screw it into the nosepiece. Tighten with the correct spanner E.
3. Extend and secure the riveter handles and insert the rivet shaft into the mandrel.
4. Place rivet in hole in workpiece.
5. Hold riveter firmly and squeeze handles closed to deform the rivet; continue squeezing until the rivet shaft shears (pops).

Rivnuts and Rivbolts:

1. Unscrew nosepiece D and internal rivet jaws (Right hand thread).
2. Select the required size mandrel and bar (B for Rivnuts or C for Rivbolts). Screw the bar into the draw-bar body and tighten (Left hand thread).
3. Select nosepiece H or F depending on mandrel size and screw into the draw-bar body and tighten, finally screw in the paired mandrel into nosepiece and tighten.
4. Screw the Rivnut or Rivbolt fully onto the mandrel bar.
5. Place Rivnut or Rivbolt in hole in workpiece and press down so that the flange of the Rivnut or Rivbolt is firmly against the face of the workpiece.
6. Hold riveter firmly and squeeze handles closed to deform Rivnut body.
7. Only squeeze riveter handles until the Rivnut or Rivbolt body has been compressed and deformed to hold firmly in the workpiece. Then stop squeezing and unscrew the draw-bar body grip J which unscrews the mandrel bar from the Rivnut or Rivbolt. Do not attempt to 'pop' or keep squeezing a Rivnut or Rivbolt - the mandrel bar may become damaged or break.



1	Mandrel bar
2	Mandrel
3	Workpiece
4	Rivnut

Note: When about to install a number of same-size Rivnuts or Rivbolts the riveter can be adjusted to maintain a safe pressure (so that the mandrel bar will not be damaged) and to give consistency of compression.

1. Prepare a sample of the workpiece, using the same materials, and with a hole of the correct diameter to take the selected Rivnut or Rivbolt.
2. Prepare riveter as detailed above and screw on Rivnut or Rivbolt.
3. Place Rivnut or Rivbolt in hole in workpiece and press down so that the flange of the Rivnut or Rivbolt is firmly against the face of the workpiece.
4. Squeeze riveter handles until the Rivnut or Rivbolt body has been compressed and deformed to hold firmly in the workpiece (refer to diagram above). Then keeping a light pressure on the handles, screw in the mandrel until the handles are closed; now lock the mandrel in position by tightening the lock nut.
5. All following Rivnuts or Rivbolts will be deformed and compressed to the same degree when the handles are closed.

Note: this setting applied only to one Rivnut or Rivbolt size and one workpiece thickness; the adjustment must be repeated every time there is a change in Rivnut size or workpiece thickness.