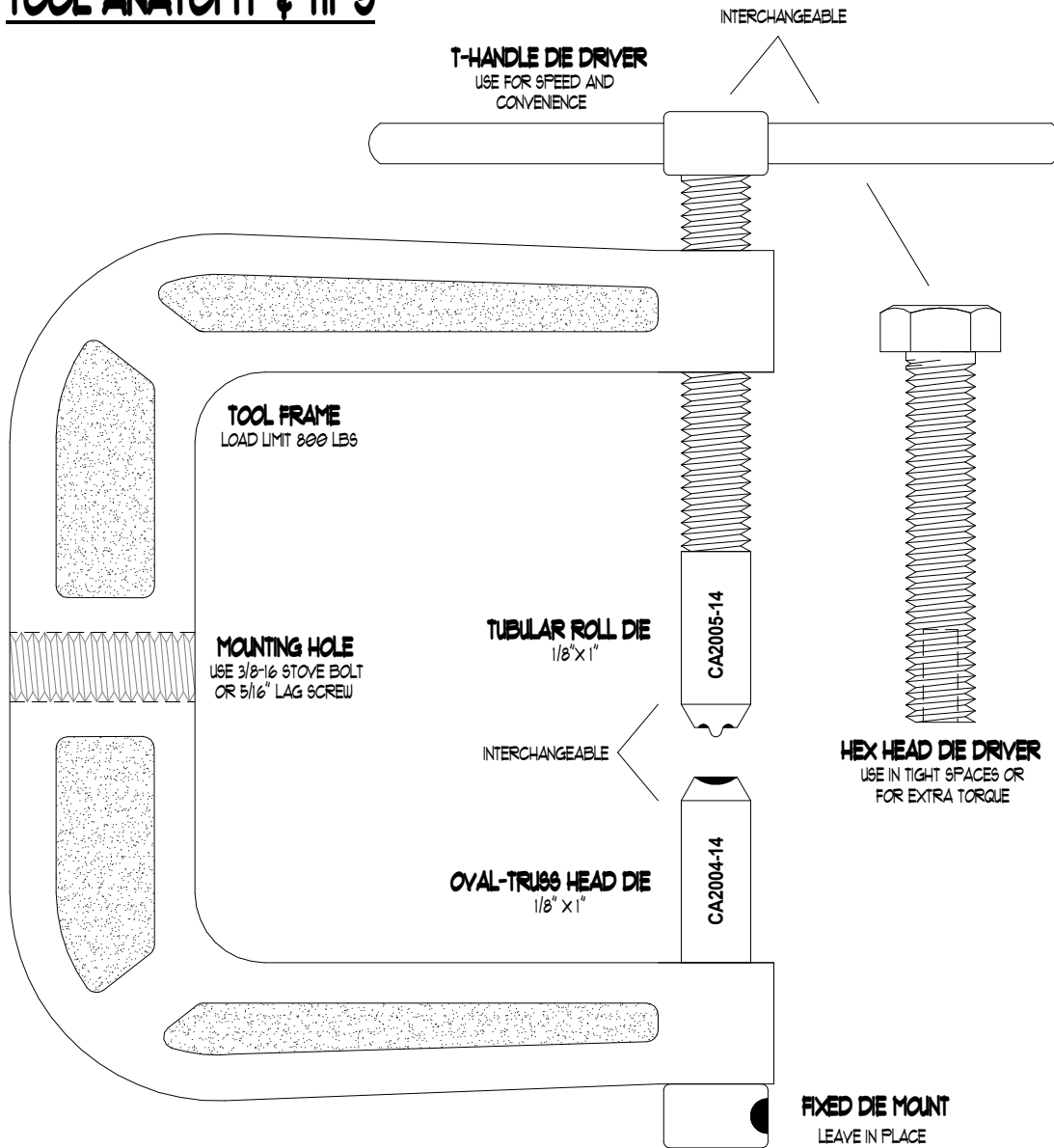


TOOL ANATOMY & TIPS



"THIRD HAND RIVET TOOL"

THE NEW STANDARD IN TUBULAR RIVET SETTING

1. SELECT THE DIE DRIVER THAT MATCHES THE WORK-

THE T-HANDLE DIE DRIVER IS FAST AND CONVENIENT WHEN SETTING SOFT RIVETS. IF YOU FIND IT DIFFICULT TO TURN THE HANDLE SWITCH TO THE HEX HEAD DRIVER

THE HEX HEAD DIE DRIVER IS BEST IN TIGHT SPACES WHERE THE SWING OF THE T-HANDLE WOULD STRIKE THE WORK OR WHENEVER EXTRA TORQUE IS NEEDED. TURN THE HEX HEAD WITH A 9/16" RATCHETING BOX END WRENCH.

2. USE THE RIGHT DIES INSTALLED IN THE BEST ORIENTATION FOR THE JOB-

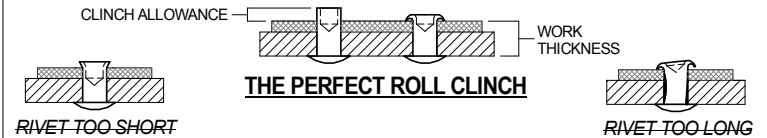
THE INCLUDED SQUEEZER DIES ARE FOR USE WITH 1/8" DIAMETER TUBULAR RIVETS ONLY. MANY ADDITIONAL DIE SIZES ARE AVAILABLE AT WWW.HANSONRIVET.COM. CHANGE THE ORIENTATION OF THE DIES (HEAD UP OR HEAD DOWN) TO SUIT THE JOB.

IMPORTANT: THIS TOOL IS NOT INTENDED FOR SOLID RIVETS. TUBULAR RIVETS WITH A DIAMETER OF 3/16" OR LARGER SHOULD BE MADE OF SOFT METALS SUCH AS ALUMINUM, COPPER OR BRASS. EXCEEDING THIS CAPACITY WILL BEND THE FRAME

3. MEASURE ACCURATELY TO DETERMINE THE CORRECT RIVET LENGTH-

MEASURE THE WORK THICKNESS WITH CALIPERS, ADD CLINCH ALLOWANCE AND ROUND TO THE NEAREST 1/32". RIVETS ARE SOLD BY LENGTH IN 1/32" INCREMENTS.

*** WORK THICKNESS + CLINCH ALLOWANCE = CORRECT RIVET LENGTH ***



RIVET BODY DIAMETER	CLINCH ALLOWANCE	RIVET BODY DIAMETER	CLINCH ALLOWANCE
1/16"	.037"	1/4"	.164"
1/8"	.074"	5/16"	.203"
3/16"	.122"	3/8"	.225"

4. TIGHTEN UNTIL JUST SNUG-

TURN THE DIE DRIVER UNTIL THE ROLL CLINCH IS JUST SNUG ON THE WORK. THE THREADED DIE DRIVERS GIVE YOU PRECISE CONTROL ON FRAGILE MATERIALS.

5. PROTECT THE HEAD-

IF THE RIVET TURNS IN THE TOOL SLIGHT SCRATCHING OF THE HEAD MAY RESULT. PREVENT THIS BY PLACING MASKING TAPE OVER THE RIVET HEAD PRIOR TO APPLYING THE TOOL. TAPE ALSO MAKES PRE-ASSEMBLY EASIER.

6. MOUNT THE TOOL TO ANY SOLID SURFACE, CLAMP IN A VISE OR USE IT HANDHELD-

MOUNTING THE TOOL WILL GIVE YOU A WELCOME "THIRD HAND" DURING THE RIVETING PROCESS. USE A 3/8-16 STOVE BOLT TO MOUNT IT UPRIGHT ON THE WORKBENCH OR SCREW IT VERTICALLY OR HORIZONTALLY TO A POST WITH A 5/16" LAG SCREW.