

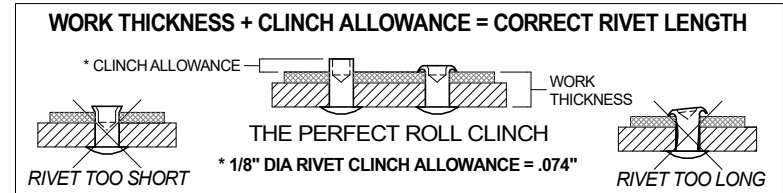
PINTONKA RIVET TOOL
THE NEW STANDARD IN TUBULAR RIVET SETTING

ACTUAL SIZE

THIS TOOL IS NOT INTENDED FOR TUBULAR RIVETS LARGER THAN 1/8" DIA. OR RIVETS MADE FROM STAINLESS STEEL OR HARDENED MATERIAL. RIVETS MUST BE ACCURATELY SIZED BEFORE SQUEEZING AS THE TOOL CAN BE DAMAGED BY ATTEMPTS TO SMASH DOWN A RIVET THAT IS TOO SHORT OR TOO LONG FOR THE WORK. THE PINTONKA RIVET TOOL IS NOT GUARANTEED AGAINST DAMAGE RESULTING FROM MISUSE. READ ALL INSTRUCTIONS BEFORE USING.

1. SELECT THE DIE DRIVER THAT MATCHES THE WORK
THE T-HANDLE DIE DRIVER IS FAST AND CONVENIENT. USE THE HEX HEAD DIE DRIVER IN TIGHT SPACES WHERE THE T-HANDLE WOULD STRIKE THE WORK.

2. INSTALL THE DIES IN THE BEST ORIENTATION FOR THE JOB
THE DIES ARE INTERCHANGEABLE IN THE TOOL ALLOWING THE RIVET TO BE SET WITH THE HEAD INSIDE OR OUTSIDE THE WORK. TO REMOVE THE DIE PULL STRAIGHT OUT. THE DIE IS HELD IN PLACE BY A FRICTION CLIP.



3. SELECT THE CORRECT RIVET LENGTH FOR THE JOB
A) USE DIGITAL CALIPERS TO MEASURE YOUR WORK THICKNESS TO THE NEAREST .001" (ONE THOUSANDTH OF AN INCH). DIGITAL CALIPERS ARE INEXPENSIVE AND WIDELY AVAILABLE.

EXAMPLE: A PENNY MEASURES .056" THICK

B) ADD CLINCH ALLOWANCE TO THE THICKNESS OF YOUR WORK. FOR 1/8" DIAMETER RIVETS THE CLINCH ALLOWANCE IS .074". (SEE IMAGE ABOVE)

EXAMPLE: THE PENNY IS .056" THICK + .074" CLINCH ALLOWANCE = .130"

C) SELECT A RIVET THAT WILL ACCOMMODATE THE MEASUREMENT YOU GET WHEN ADDING WORK THICKNESS + CLINCH ALLOWANCE. TUBULAR RIVETS ARE SOLD BY LENGTH IN 1/32" INCREMENTS. THE RIVET LENGTH MUST BE WITHIN +/- .015" OF YOUR WORK THICKNESS + CLINCH ALLOWANCE MEASUREMENT FOR THE RIVET TO WORK. (SEE CLINCH TABLE ON BACK)

EXAMPLE: THE PENNY THICKNESS + CLINCH ALLOWANCE = .130". A 4/32" RIVET IS .125" LONG (4 DIVIDED BY 32 = .125). THE NUMBERS .125" AND .130" ARE WITHIN .015" OF EACH OTHER. THE 4/32" RIVET WILL WORK.

4. TIGHTEN UNTIL "JUST SNUG"
CLINCH THE RIVET BY TURNING THE T-HANDLE UNTIL "JUST SNUG." STOP THERE. WHEN THE RIVET IS SIZED CORRECTLY TURNING THE HANDLE UNTIL "JUST SNUG" IS ALL IT TAKES TO FORM A PERFECT ROLL CLINCH.

IF THE RIVET TURNS IN THE TOOL MINOR SURFACE SCRATCHING MAY RESULT. PREVENT THIS BY PLACING BLUE TAPE OVER THE RIVET HEAD PRIOR TO APPLYING THE TOOL. TAPE ALSO MAKES ASSEMBLY EASIER.

HAVE FUN WITH YOUR PROJECTS!

THE PINTONKA.COM HANDY CLINCH RANGE TABLE

USE WORK THICKNESS + CLINCH ALLOWANCE MEASUREMENT

RIVET LENGTH	CLINCH RANGE
3/32"	.079" — .109"
4/32"	.110" — .140"
5/32"	.141" — .171"
6/32"	.173" — .203"
7/32"	.204" — .234"
8/32"	.235" — .265"
9/32"	.266" — .296"
10/32"	.298" — .328"
11/32"	.329" — .359"
12/32"	.360" — .390"
13/32"	.391" — .421"
14/32"	.423" — .453"
15/32"	.454" — .484"
16/32"	.485" — .515"
17/32"	.516" — .546"

RIVET LENGTH	CLINCH RANGE
18/32"	.548" — .578"
19/32"	.579" — .609"
20/32"	.610" — .640"
21/32"	.641" — .671"
22/32"	.673" — .703"
23/32"	.704" — .734"
24/32"	.735" — .765"
25/32"	.766" — .796"
26/32"	.798" — .828"
27/32"	.829" — .859"
28/32"	.860" — .890"
29/32"	.891" — .921"
30/32"	.923" — .953"
31/32"	.954" — .984"
32/32"	.985" — 1.015"

ALL MEASUREMENTS GIVEN IN INCHES

RIVETS ARE SOLD BY LENGTH IN 1/32 INCH INCREMENTS

IF MEASUREMENT FALLS BETWEEN RIVET SIZES USE THE SHORTER RIVET