INSTRUCTIONS FOR:

THREADED NUT RIVET KIT

Model No: **AK396**

Thank you for purchasing a Sealey product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

⚠ ***IMPORTANT:*** **PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS AND CAUTIONS. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY AND WILL INVALIDATE THE WARRANTY. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.**

1. SAFETY INSTRUCTIONS

❒ **WARNING!** *Ensure Health & Safety, local authority and general workshop practice regulations are adhered to when using this equipment.*
✓ Familiarise yourself with the application and limitations of the riveter, as well as the potential hazards.
✓ Maintain the riveter in good condition (use an authorised service agent).
✓ Replace or repair damaged parts. *Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.*
✓ Keep the work area clean, uncluttered and ensure there is adequate lighting.
✓ Keep the riveter clean for best and safest performance.
❒ **WARNING!** Always wear approved eye or face protection when operating the riveter.
✓ Keep children and unauthorised persons away from the working area.
✓ Check moving parts alignment on a regular basis.
✗ **DO NOT** hold the workpiece by hand. Secure unstable workpiece with a clamp, vice or other adequate holding device.
✓ Ensure the workpiece is correctly secured before operating the riveter.
✗ **DO NOT** use the riveter for any purpose other than that for which it is designed.
✗ **DO NOT** operate the riveter if any parts are damaged or missing, as this may cause failure and/or personal injury.
✓ When not in use return to the case and store in a safe, dry, childproof area.

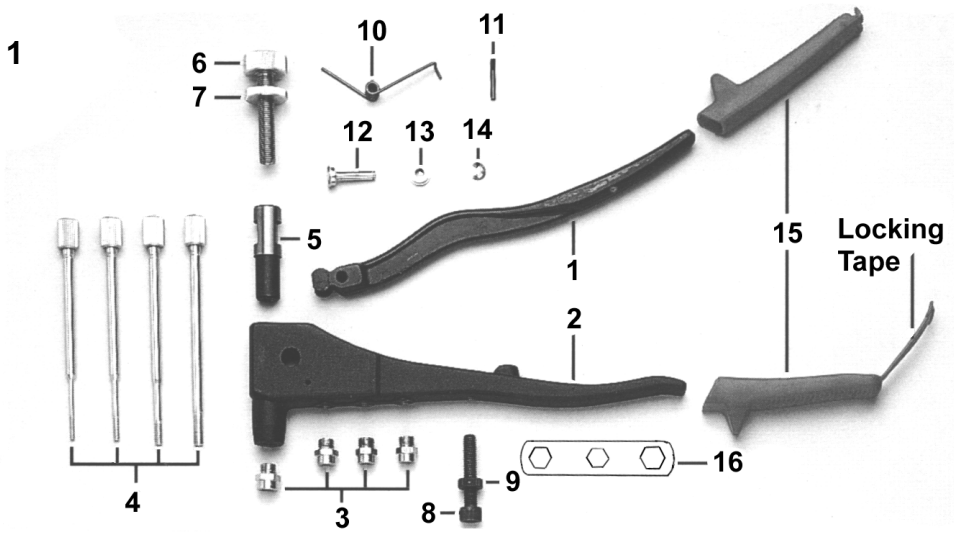
2. CONTENTS

Check the content of the kit against the item list and fig. 1 (riveter shown in component form). If any item is found to be damaged or missing contact your dealer immediately.

1. Handle
2. Body
3. Nosepiece (4 - M3/4/5/6)
4. Mandrel (4 - M3/4/5/6)
5. Collet Case
6. Adjusting Knob
7. Lock Nut
8. Stroke Bolt
9. Stroke Nut
10. Torsion Spring
11. Torsion Spring Pin
12. Fulcrum Pin
13. Fulcrum Pin Bearing
14. Snap Ring
15. Grips
16. Wrench

Not shown - four starter packs of aluminium threaded rivets - M3 x 0.5, M4 x 0.7, M5 x 0.8, M6 x 1.0.

fig. 1



3. APPLICATIONS

The AK396 kit is suitable for fitting threaded rivet nuts of the following materials and sizes.

	M3 x 0.5	M4 x 0.7	M5 x 0.8	M6 x 1.0
Aluminium	✓	✓	✓	✓
Steel	✓	✓	✓	✓
Stainless Steel	✓	✓	✓	✗

4. OPERATION

4.1. Mandrel and nosepiece

4.1.1. Mandrel (fig. 1.4) is fitted/removed by pushing into/pulling out of central hole in adjusting knob (fig. 1.6).

4.1.2. Nosepiece (fig. 1.3) screws into and out of body (fig. 1.2) using wrench (fig. 1.16).

Note: Always use mandrel and nosepiece of the same size, determined by the size of rivet nut required.

4.2. Mandrel thread length

The length of mandrel thread exposed beyond nosepiece should be the same as the overall length of rivet nut to be fitted, see fig. 2.

4.2.1. Unscrew the lock nut (fig. 2.7) and open riveter by releasing locking tape at end of grips (fig. 1.15).

4.2.2. With mandrel knob (fig. 2.A) kept firmly against adjusting knob (fig. 2.6) rotate adjusting knob in or out as necessary to give the required length of exposed thread.

4.2.3. Lock adjusting knob (fig. 2.6) by screwing lock nut (fig. 2.7) down onto body (fig. 2.2).

4.3. Stroke pilot test

To ensure that rivet nuts are each compressed by the correct amount it is necessary to set the stroke of the riveter by doing a pilot test.

4.3.1. Prepare a sample of the workpiece material with a hole slightly larger than the rivet nut diameter.

4.3.2. Screw the rivet nut onto the mandrel until the nut flange contacts the nosepiece (fig. 1.3).

4.3.3. Unscrew stroke bolt (fig. 1.8) until it no longer restricts the movement of the handle (fig. 1.1).

4.3.4. Place the rivet nut through the hole in the sample and press down so that nut flange is held firmly against the upper face of the sample.

4.3.5. Squeeze riveter handle (fig. 1.1) to compress rivet nut. When rivet nut has formed a retaining bulge against the rear face of the sample (fig. 3) hold handle position and screw in stroke bolt (fig.1.8) until it contacts the handle. Lock stroke bolt in position by tightening down stroke nut (fig.1.9).

4.3.6. This setting applies only to the one rivet nut size and the one workpiece thickness - the pilot test must be repeated each time either nut size or workpiece thickness change.

4.3.7. Unscrew mandrel from rivet nut and screw on new rivet nut for the next operation.

fig. 2

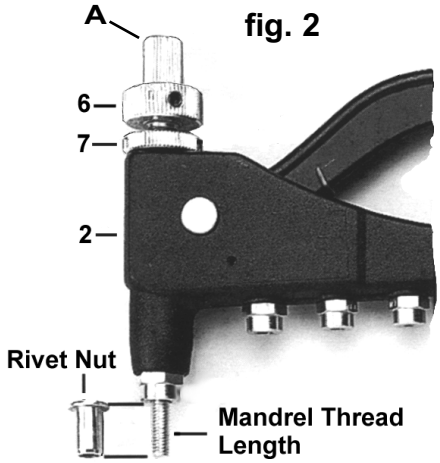
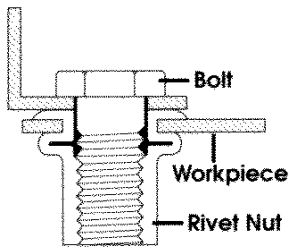


fig. 3



5. ALUMINIUM THREADED RIVETS

Aluminium threaded rivets are available from your Sealey dealer. Rivet details below:

Model No.	Thread	Quantity	Sheet Thickness
AK396/1	M3 x 0.5	50	0.25 - 1.5mm
AK396/2	M4 x 0.7	50	0.5 - 2.5mm
AK396/3	M5 x 0.8	50	0.5 - 2.5mm
AK396/4	M6 x 1.0	15	1.0 - 4.0mm

NOTE: *It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice.*

IMPORTANT: No liability is accepted for incorrect use of this product.

WARRANTY: Guarantee is 12 months from purchase date, proof of which will be required for any claim.

INFORMATION: For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.

SEALEY Professional TOOLS

Sole UK Distributor, Sealey Group,
Bury St. Edmunds,
Suffolk.

☎ *01284 757500* 🖷 *01284 703534* ***E-mail:*** *sales@sealey.co.uk*