



HEAVY DUTY RATCHET THREADED NUT RIVETER KIT 111PC

MODEL NO: **AK3995**

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 & 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. KEEP THESE INSTRUCTIONS SAFE FOR FUTURE USE.



Refer to
instruction
manual



Wear eye
protection

1. SAFETY

- ☐ **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 that 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 work area.
- ✓ Check moving parts alignment on a regular basis.
- * **DO NOT** hold the workpiece by hand. Secure workpiece with a clamp, vice or other adequate holding device.
- * **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. INTRODUCTION

Quick-change mandrel system enables rapid switching between different nut rivet sizes, improving workflow efficiency. Ergonomic comfort grips provide optimal handling and precise operation, even in restricted spaces. The ratcheting mechanism, with clear in-use depth increments, ensures the correct setting of nut rivets. Suitable for installing a wide range of threaded nut rivets across automotive and workshop applications. Includes metric and imperial mandrels: 8-32, 10-24, 1/4-20, 5/16-18, 3/8-16, M5, M6, M8, M10, M12. Supplied with assorted metric and imperial threaded nut rivets for immediate use. Suitable for aluminium, steel and stainless steel nuts. Supplied in a storage case.

3. SPECIFICATION

Model No	AK3995
Suitable Rivet Types	Aluminium - Yes / Steel - Yes Stainless Steel - Yes / Structural - No
Nett Weight	3.7kg

4. CONTENTS

fig.1

1	Heavy duty ratchet riveter
2	Metric mandrels M5 / M6 / M8 / M10 / M12
3	Imperial mandrels 8-32 / 10-24 / 1/4-20 / 5/16-18 / 3/8-16
4	Assorted metric and imperial rivet nuts
5	Storage Case

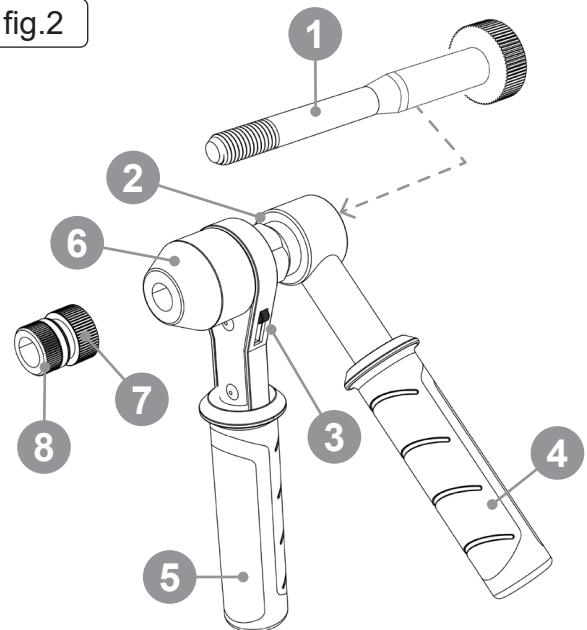


5. OPERATION

5.1. INSERT THE THREADED MANDREL

- 5.1.1. Screw the required size mandrel collar (fig.2.8) and mandrel lock nut into the front threaded sleeve (fig.2.6) and insert the mandrel (fig.2.1) into the setting tool from the rear.

fig.2



1	Mandrel
2	Scale
3	Ratchet Direction Switch
4	Rear Lever
5	Front Lever
6	Threaded Sleeve
7	Mandrel Lock Nut
8	Mandrel Collar

5.2. STARTING POSITION OF THE TOOL

- 5.2.1. In the starting position, push the ratchet switch up (fig.3).
- 5.2.2. If the scale is not in the zero position, turn the rear lever clockwise to zero the scale (see fig.3).
- 5.2.3. Make sure that both levers are parallel to each other.

5.3. LOADING A RIVET NUT

- 5.3.1. Screw the rivet nut onto the mandrel.

NOTE: The rearmost thread (fig.4) of the mandrel must be visible at the leading edge of the rivet nut.

- 5.3.2. Secure the mandrel collar with the lock nut (fig.4).

5.4. DETERMINE STROKE

NOTE: The best way to determine the correct stroke is to read the scale during a test run on a test piece.

- 5.4.1. Set the stroke to zero after each adjustment (fig.3). The stroke determined in the test can be used as the working stroke.
- 5.4.2. The stroke is equal to the maximum gripping range (fig.5.Y) of the rivet nut minus the material thickness (fig.5.Z) of the workpiece

NOTE: When selecting the rivet nut to be set, make sure that the required gripping range is met with respect to the work piece. Otherwise, correct fastening cannot be guaranteed.

5.5. TIGHTENING

- 5.5.1. Make sure that the ratchet switch is in the starting position (fig.3).
- 5.5.2. Insert the rivet nut into the prepared workpiece (fig.6).
- 5.5.3. Push the levers apart with both hands and observe the scale.
- 5.5.4. Tighten the rivet nut until the previously calculated stroke is reached.

fig.3

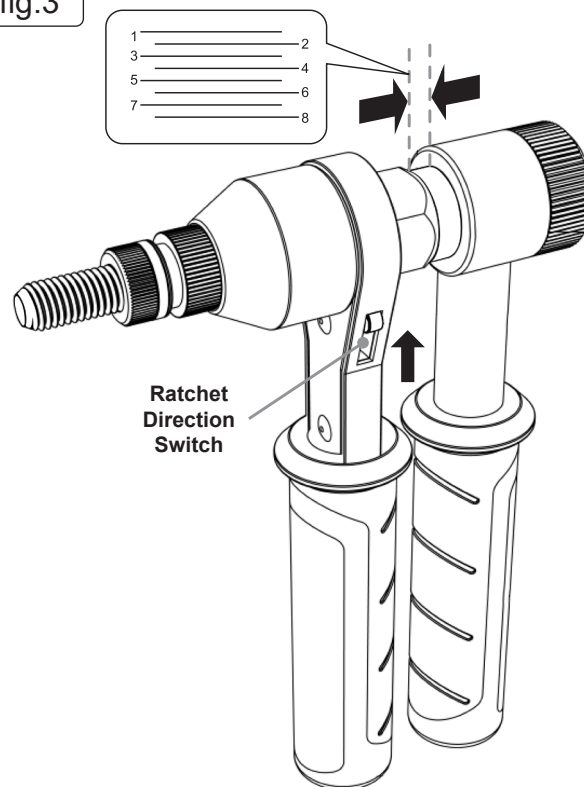


fig.4

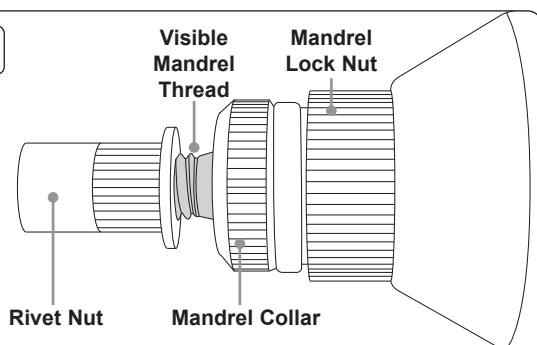


fig.5

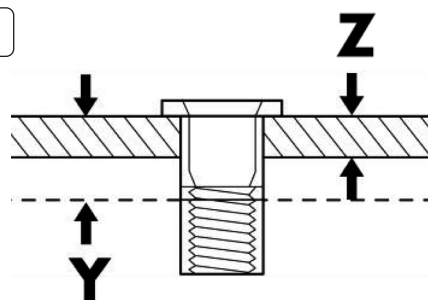


fig.6

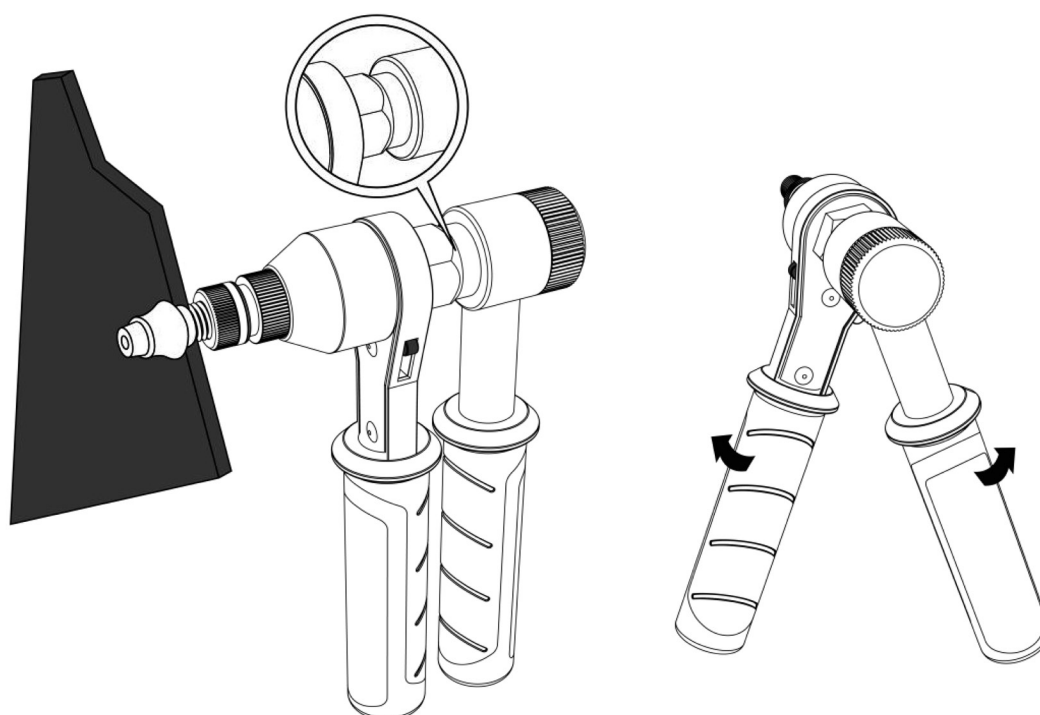
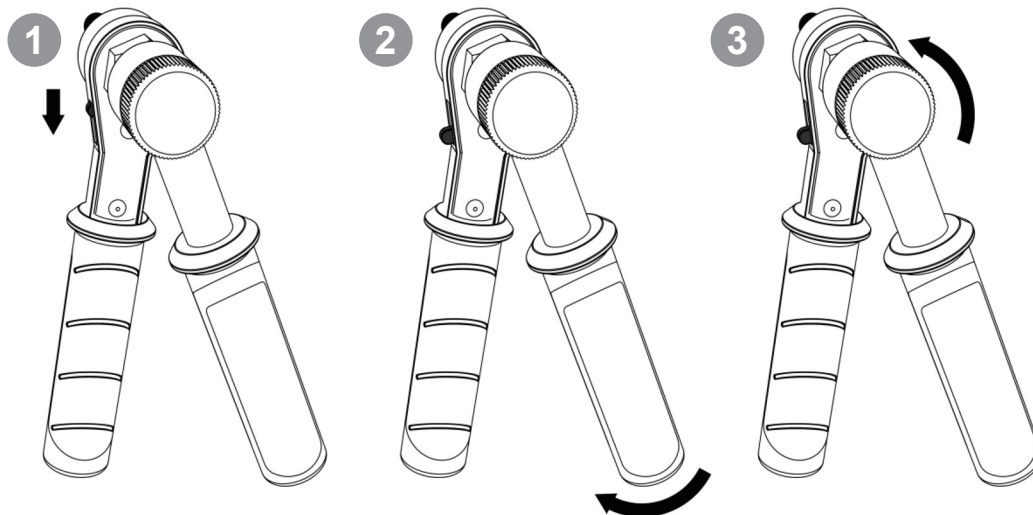


fig.7



5.6. RELEASING THE RIVET NUT FROM THE THREADED MANDREL.

- 5.6.1. Press the ratchet switch down (fig.7.1).
- 5.6.2. Turn the rear lever one turn clockwise to loosen the threaded mandrel (fig.7.2).
- 5.6.3. Turn the head of the threaded mandrel counterclockwise to release the mandrel from the rivet nut (fig.7.3)

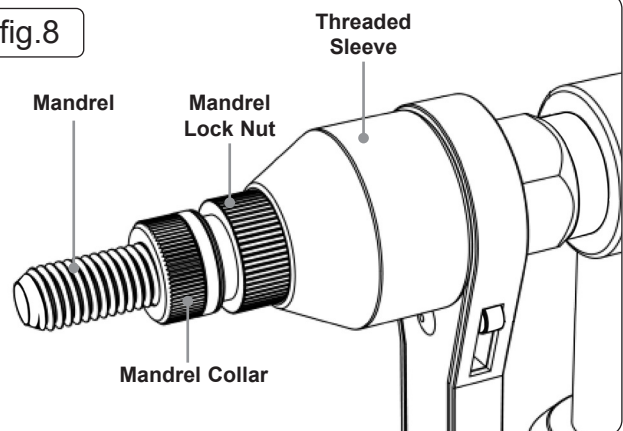
5.7. HOW TO CHANGE THE THREADED MANDREL (fig.8)

- 5.7.1. Loosen the lock nut from the mandrel collar.
- 5.7.2. Unscrew both parts from the threaded sleeve.
- 5.7.3. Pull out the mandrel.
- 5.7.4. Insert a new threaded mandrel.

6. MAINTENANCE

- 6.1. Clean the tool with a soft, damp cloth and dry thoroughly.
- 6.2. Lightly oil parts occasionally. Remove excess oil with a cloth.

fig.8



ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.



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 36 months from purchase date, proof of which is required for any claim.

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