



INSTRUCTIONS FOR:
RIVET & THREADED NUT RIVET KIT
 Model No: **AK39602**

Thank you for purchasing a Sealey Rivet Kit. 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.

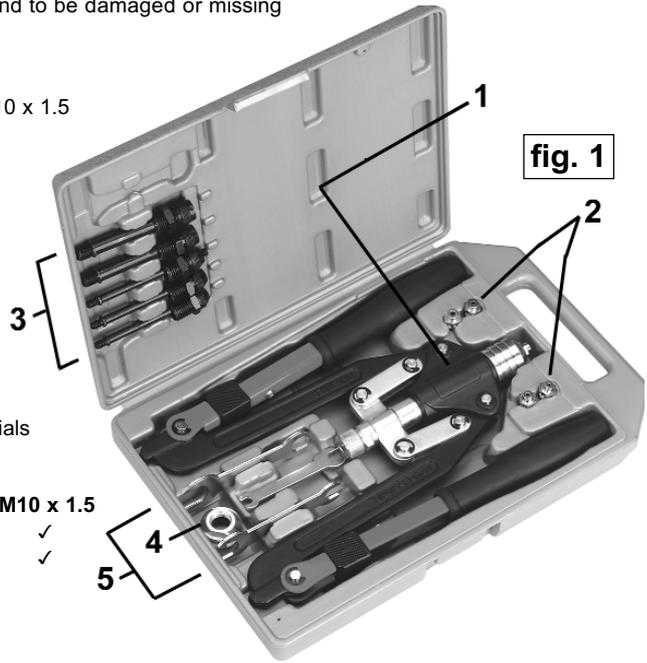
1. SAFETY INSTRUCTIONS

- ❑ **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 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. CONTENTS

Check the contents of the kit against the item list and fig. 1. If any item is found to be damaged or missing contact your dealer immediately.

1. Riveter
2. Pop Rivet Mandrels, 5 (1 in riveter)
3. Nut Rivet Mandrels & Bars, 5, M4 x 0.7, M5 x 0.8, M6 x 1.0, M8 x 1.25, M10 x 1.5
4. Nosepiece for Nut Rivet Mandrel
5. Spanners, 5.5/8.5mm, 12/17mm, 15/19mm



3. INTRODUCTION

Drop forged frame with patented folding mechanism for compact storage. Comfortable cushion grips. Suitable for installing threaded nut rivets for securing threads in thin sheet material. Heavy-duty head accepts threaded rivets up to M10. Suitable for aluminium and steel nut rivets and pop rivets.

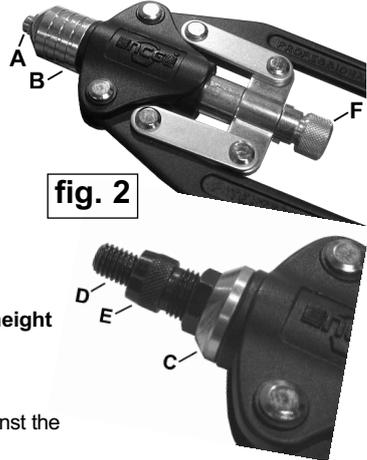
4. APPLICATIONS

The AK39602 kit is suitable for fitting threaded nut rivets of the following materials and sizes together with pop rivets up to 6.4mm (1/4") diameter.

	M4 x 0.7	M5 x 0.8	M6 x 1.0	M8 x 1.25	M10 x 1.5
Aluminium	✓	✓	✓	✓	✓
Steel	✓	✓	✓	✓	✓

5. OPERATION

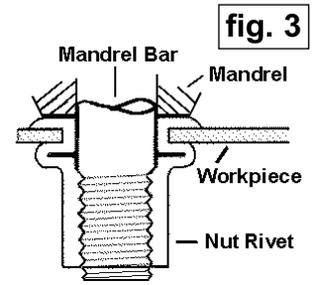
- 5.1. **Pop Rivets**
 - 5.1.1. Select the mandrel (fig. 2.A) which matches the shaft diameter of the rivet and screw it to the nosepiece (fig. 2.B) of the riveter.
 - 5.1.2. With the riveter handles extended and open, fully insert the rivet shaft into the mandrel.
 - 5.1.3. Place rivet in hole in the workpiece and squeeze the riveter handles closed to deform the rivet.
 - 5.1.4. If the rivet stem does not shear, open the handles, push the riveter further onto the stem and then close the handles again.
 - 5.1.5. When the stem shears, open the handles and remove the stem from the riveter.
 - 5.2. **Threaded Nut Rivets**
 - 5.2.1. Unscrew the pop rivet nosepiece (fig. 2.B) from the riveter body.
 - 5.2.2. Unscrew the jaw case assembly (fig. 4) from the draw bar body (fig. 2.F).
 - 5.2.3. Screw the nut rivet nosepiece (fig. 2.C) into the riveter body.
 - 5.2.4. Screw the appropriate mandrel bar (fig. 2.D) into the draw bar body. Note **left-hand** thread.
 - 5.2.5. Screw the corresponding mandrel (fig. 2.E) into the nosepiece.
- Note:** Always use mandrel and mandrel bar of the same size, determined by the size of nut rivet. To ensure that the nut rivet is compressed by the correct amount it is necessary to set the height of the mandrel by doing the following test.
- 5.2.6. Prepare a sample of the workpiece material with a hole slightly larger than the nut rivet diameter.
 - 5.2.7. Screw the nut rivet fully onto the mandrel bar.
 - 5.2.8. Place the nut rivet in the hole in the sample and press down so that the nut flange is held firmly against the upper face of the sample.



5.2.9. Squeeze the riveter handles to compress the nut rivet. When the rivet has formed a retaining bulge against the rear face of the sample (fig. 3) keep light pressure on the handles and screw in the mandrel (fig. 2.E) until the handles are closed. Lock the mandrel in position by tightening the lock nut. All following rivets will be deformed to the same degree when the handles are fully closed.

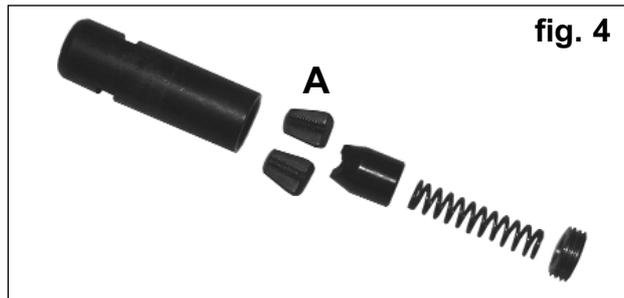
The setting applies only to the one rivet size and the one workpiece thickness - the test must be repeated each time there is a change in nut size and/or workpiece thickness.

5.2.10. Unscrew the mandrel bar from the nut rivet by turning the knurled end of the draw bar body (fig. 2.F) and then screw on a new nut rivet for the next operation.



6. MAINTENANCE

- 6.1. Keep all pivots lightly oiled.
 6.2. The jaw case assembly (fig. 4) should be disassembled, cleaned and oiled at regular intervals, depending on the frequency of use. The need for cleaning/jaw (fig. 4.A) replacement will be indicated by the riveter failing to grip the rivet shaft.



7. ALUMINIUM RIVETS

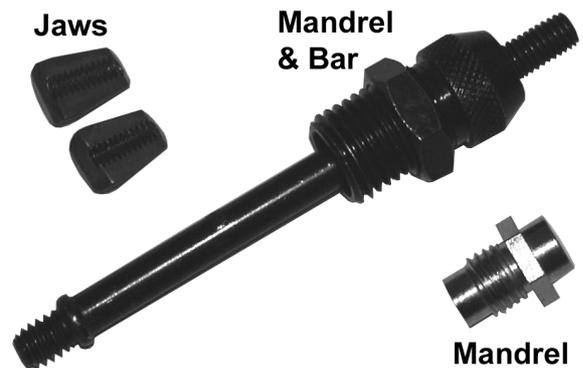
Aluminium threaded and pop rivets are available from your Sealey dealer.

Nut Rivets	Thread	Quantity	Sheet Thickness	Pop Rivets	Quantity	Size
AK396/2	M4 x 0.7	50	0.5 - 2.5mm	AK99/1	100	3.2(1/8") x 6.2mm
AK396/3	M5 x 0.8	50	0.5 - 2.5mm	AK99/2	100	3.2(1/8") x 7.4mm
AK396/4	M6 x 1.0	15	1.0 - 4.0mm	AK99/3	100	4.0(5/32") x 8.0mm
AK39602/1	M8 x 1.25	10	1.0 - 4.0mm	AK99/4	100	4.8(3/16") x 8.9mm
AK39602/2	M10 x 1.5	10	1.0 - 4.0mm	AK99/6	2000	3.2(1/8") x 10.2mm
				AK99/7	1200	4.0(5/32") x 10.2mm
				AK99/8	800	4.8(3/16") x 10.2mm

8. SERVICE PARTS

The following service parts are available:

Part No.	Description
AK39602/05	Jaws
AK39602/26M4	Mandrel and Bar, M4 Nut Rivet
AK39602/26M5	Mandrel and Bar, M5 Nut Rivet
AK39602/26M6	Mandrel and Bar, M6 Nut Rivet
AK39602/26M8	Mandrel and Bar, M8 Nut Rivet
AK39602/26M10	Mandrel and Bar, M10 Nut Rivet
AK39602/9-3.2	Mandrel, 3.2mm Pop Rivet
AK39602/9-4.0	Mandrel, 4.0mm Pop Rivet
AK39602/9-4.8	Mandrel, 4.8mm Pop Rivet
AK39602/9-6.4	Mandrel, 6.4mm Pop Rivet (Small)
AK39602/9-6.4	Mandrel, 6.4mm Pop Rivet (Large)



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.

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