



USATCO's RIVETNUT Driver Operating Instructions



RIVETNUT Material	RIVETNUT Thread Size					
	No. 4	No. 6	No. 8	No. 10	No. 12	No. 1/4"
Aluminum	•	•	•	•	••	
Brass & Steel	•	•	•	••		
Stainless Steel	•	•	••			

- -Recommended for production use.
- -Adequate but borderline, recommend power tool.

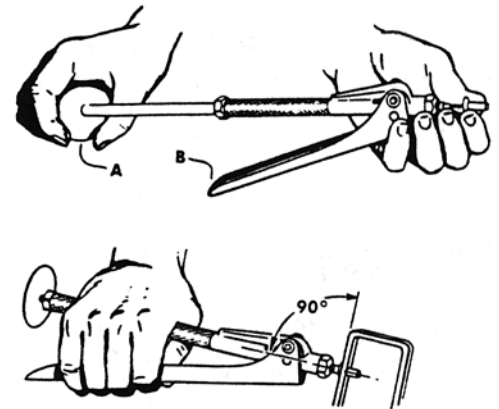
Driver Number	Sizes Available	Conversion Kits Available	Federal NSN Numbers
10-JP4	(4-40 Thread Size)	No. 10-JP4-C	NSN 5120-00-979-7601
10-JP6	(6-32 Thread Size)	No. 10-JP6-C	NSN 5120-00-224-9298
10-JP8	(8-32 Thread Size)	No. 10-JP8-C	NSN 5120-00-224-9297
10-JP10	(10-32 Thread Size)	No. 10-JP10-C	NSN 5120-00-224-9296
10-JP1/4†	(1/4-28 Thread Size)	No. 10-JP1/4-C†	

Manufactured in the USA by USATCO!

† Aluminum only

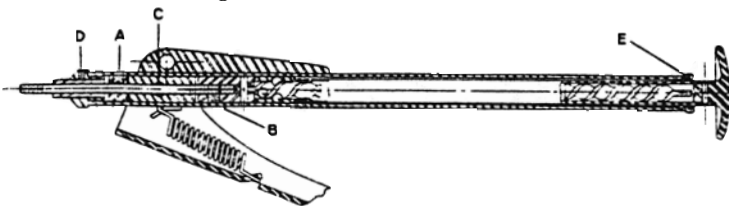
HOW TO OPERATE

With handle (A) all the way out, place RIVETNUT on pull-up stud. Hold RIVETNUT firmly to prevent turning while handle (A) is pushed all the way in (push - do not strike). This spins the stud, engaging all threads in the RIVETNUT. Place RIVETNUT in hole, holding tool at right angle to face of work. Squeeze lever (B) until solid resistance is met. **Lever will not need to go all the way down.** Excessive pressure will strip the threads. Release lever (B) and pull the handle (A) all the way out. This will unthread stud from RIVETNUT.



HOW TO REPLACE BROKEN OR DAMAGED PULL-UP STUD

1. Unthread anvil sleeve from tool.
2. Loosen 3 set screws at access hole "A".
3. Loosen two set screws at the access hole "B" and let key wrench remain in the second set screw to prevent rotation of coupling while stud is being unscrewed.
4. Secure pull-up stud in aluminum or copper jaws of vise and turn entire tool counterclockwise, unscrewing stud from coupling.
5. Before installing replacement stud, line up hole through cross pin indicated at "C".
6. Slip collar loosely on replacement stud and insert stud through plunger, screwing stud into coupling until end of stud is just past the second set screw hole, then tighten both set screws at "B" (longer threaded portion of stud goes into tool).
7. Tighten 3 set screws in collar through access hole "A".
8. Replace anvil and sleeve, tighten set screw "D" after anvil is properly adjusted for RIVETNUT length (see reverse page).



Note: Changing to pull-up stud of another thread size requires change of adjustable anvil, pull-up stud, collar and coupling. Follow above procedure, except nut "E" must be loosened to remove operating screw and slide from tool handle to replace coupling. See reverse page.

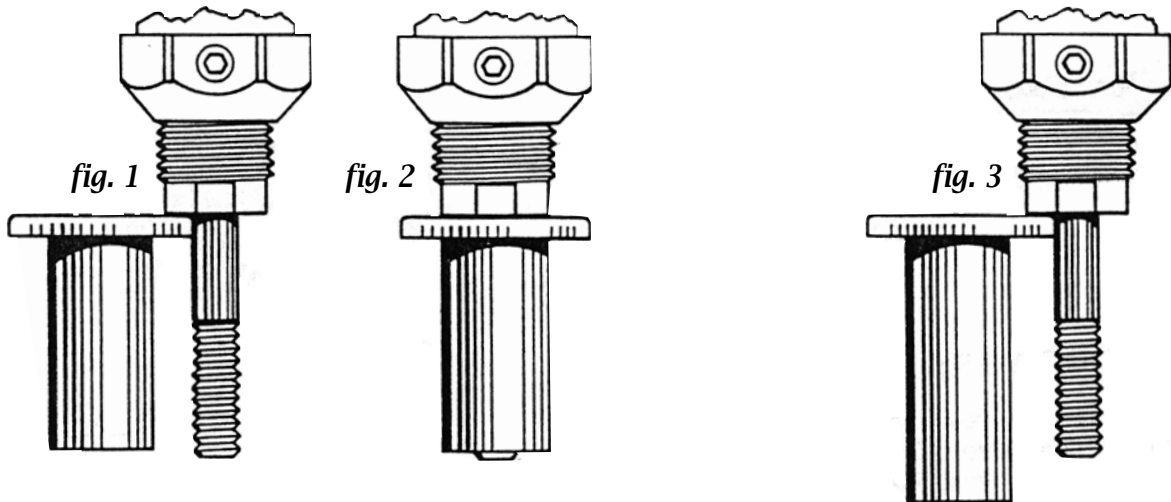
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Oiling: An occasional drop or two of heavy oil (SAE-20-30) on the operating screw (part no. U-22) and a drop of light oil on slide (part no. U-24) at bushing (part no. U-8) will keep tool operating smoothly (see breakdown illustration below).

ADJUSTING ANVIL TO SUIT RIVET LENGTH

RIVETNUT threads may be deformed or stripped if the pull-up stud does not engage all threads in the RIVETNUT. Speed Headers and all power tools have pull-up studs or anvils which can be adjusted easily to suit the RIVETNUT blank length. The following illustrations demonstrate proper relation between face of anvil and end of pull-up stud.



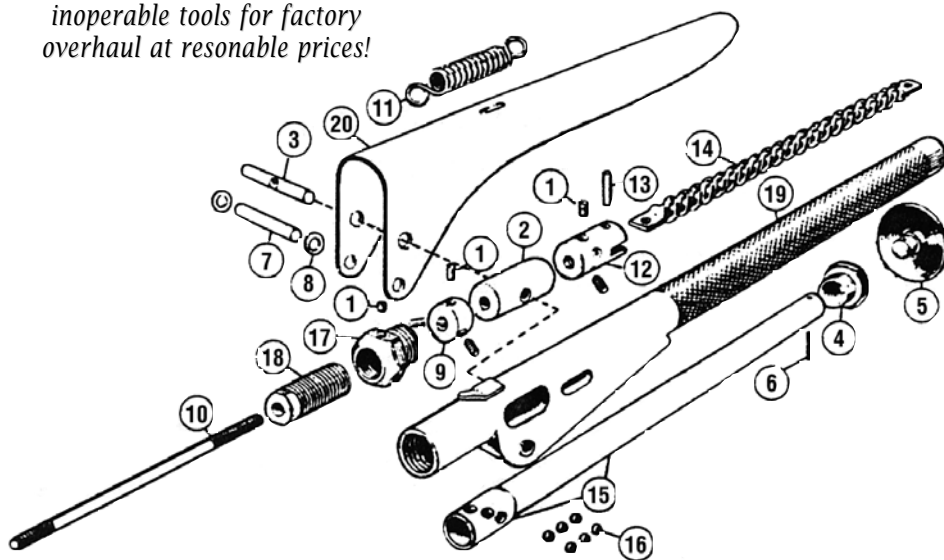
Open End RIVETNUT: Point of the pull-up stud should extend just beyond the end of the RIVETNUT, as in (fig. 1). (fig. 2) shows RIVETNUT head tight against anvil, ready for upset.

Closed End RIVETNUT: Thread RIVETNUT on pull-up stud all the way to bottom of threads. Back RIVETNUT off one complete turn, then adjust anvil so it contacts RIVETNUT head, as in (fig. 3).

REPLACEMENT PARTS

When ordering a tool or part, always specify thread size of RIVETNUT. Parts below are also suitable for C-6000 Speed Header, manufactured by B.F. Goodrich. Current prices on request.

Send us your damaged or inoperable tools for factory overhaul at reasonable prices!



#	Part No.	Description	Qty.
1	38-U-5	Set Screws No. 8/32 & 1/8	7
2	38-U-6	Plunger	1
3	38-U-7	Cross Pin	1
4	38-U-8	Slide Bushing	1
5	38-U-9	Knob	1
6	38-U-10	Knob Pin	1
7	38-U-13	Hinge Pin	1
8	38-U-14	Retainer for U-13	2
9	38-U-15*	Collar	1
10	38-U-16*	Pull-Up Stud	1
11	38-U-18	Spring	1
12	38-U-20*	Coupling	1
13	38-U-21	Pin	1
14	38-U-22	Operating Screw	1
15	38-U-24	Operating Slide	1
16	38-U-25	3/16" Hardened Steel Balls	6
17	38-U-28	Adjustable Anvil Sleeve	1
18	38-U-29*	Adjustable Anvil	1
19	38-U-31	Handle	1
20	38-U-32	Squeeze Handle	1

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