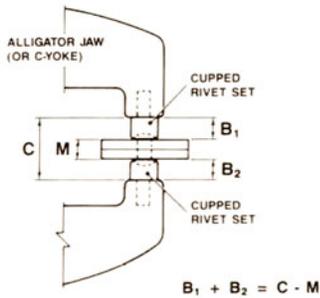


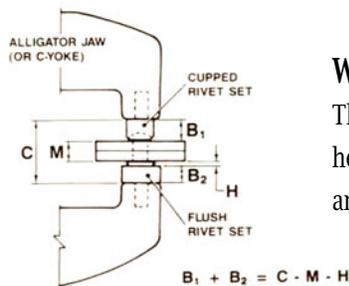
# Selecting Rivet Sets For Your Compression Riveters

To develop maximum power, the riveter must drive the rivet near the end of the riveter's stroke. Therefore, the combined length of the two rivet sets must be correct. **Determine the correct length as follows:**



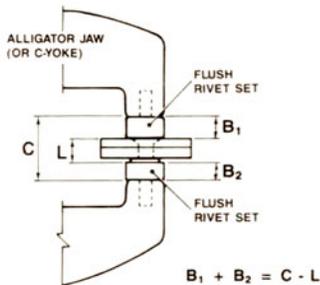
## When two cupped rivet sets are used:

The length of the body dimensions of the two rivet sets ( $B_1, B_2$ ) should equal the closed height dimension of the yoke ( $C$ ) minus the total thickness of material being riveted ( $M$ ).



## When one cupped & one flush set are used:

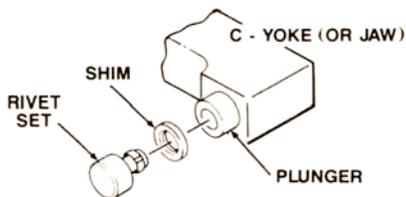
The length of the body dimensions of the two rivet sets ( $B_1, B_2$ ) should equal the closed height dimension of the yoke ( $C$ ) minus the total thickness of material being riveted ( $M$ ) and the height of the finished rivet head driven by the flush set ( $H$ ).



## When two flush sets are used:

The length of the body dimensions of the two rivet sets ( $B_1, B_2$ ) should equal the closed height dimension of the yoke ( $C$ ) minus the overall length of the rivet after it is driven ( $L$ ).

The closed height dimension of the yoke referred to is the opening available when the jaws or plunger are in extreme closed or forward position with both rivet sets removed.



If necessary, select rivet sets a little short and shim to proper length with hardened shims (1/64", 1/32", 1/16" or 1/8" thick).

## Head or die configuration:

Cupped or flush; available in button, round, brazier, universal or flat head configurations.

