

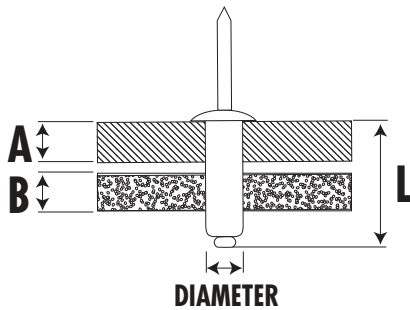
ARROW™ 
 HOW IT ALL COMES TOGETHER

RIVET GUIDE

▶ HOW TO DETERMINE RIVET TYPE, DIAMETER AND GRIP RANGE









Rivets are available in steel and aluminum, in three diameters and in three grip ranges. Steel rivets are stronger than aluminum. Use steel rivets for heavy duty jobs and when riveting steel to steel. Use aluminum rivets for lighter weight jobs and materials such as aluminum, fabrics, plastics, leather, etc. Determine rivet diameter by strength needed for job. Determine rivet grip range by thickness of materials being fastened. Use washers when joining soft materials or when existing hole is oversized.

It is important to select the correct length for your rivet. The length of a rivet is measured from the underside of the head to the tip of the stem. The head itself is not included in this measurement.



$$A+B+1.5(\text{DIAMETER})=L$$

The length of the rivet should be equal to the thickness of both objects you are fastening, plus 1.5 times the diameter of the rivet's stem.

RIVET	GRIP RANGE		
SPECIALTY	3/32" (2MM)		3/32" (2MM) FOR UP TO 3/32" (2MM) THICKNESS.
SHORT	1/8" (3MM)		1/8" (3MM) FOR UP TO 1/8" (3MM) THICKNESS.
MEDIUM	1/4" (6MM)		1/4" (6MM) FOR UP TO 1/4" (6MM) THICKNESS.
LONG	1/2" (12MM)		1/2" (12MM) FOR UP TO 1/2" (12MM) THICKNESS.
RIVET	HOLE SIZE		
3/32" (2MM)	3/32" (2MM)		3/32" (2MM) FOR SPECIALTY JOBS.
1/8" (3MM)	1/8" (3MM)		1/8" (3MM) FOR LIGHTWEIGHT JOBS.
5/32 (4MM)	5/32 (4MM)		5/32" (4MM) FOR MEDIUM WEIGHT JOBS.
3/16" (5MM)	3/16" (5MM)		3/16" (5MM) FOR HEAVY DUTY JOBS.

▶ RIVET IN 4 EASY STEPS

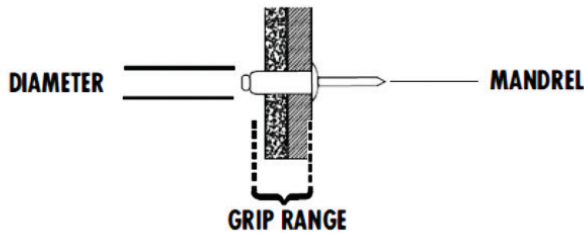
OPERATING INSTRUCTIONS

1. Select rivet

- Material – select based on the strength needed, corrosion resistance and material to be joined.
 - All steel* – high strength. Use when joining steel to steel.
 - Aluminum – medium strength. Use with aluminum where rust is a problem.

■ Size

- Diameter - Use larger diameters to create stronger joints.
- Grip Range - Select rivet with a grip range larger than the thickness of materials to be fastened.
 - NOTE: use washers when joining soft materials like leather or when the hole is oversized.



Select rivet with grip range larger than thickness of materials to be fastened. Drill hole same size as rivet diameter.

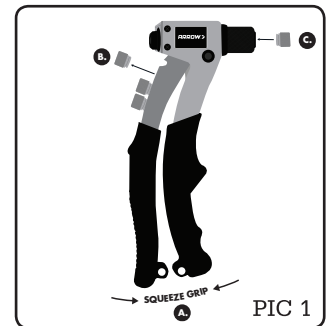
If there is no pre-existing hole, drill hole through materials to be fastened in accordance with blind rivet diameter.

2. Select correct nosepiece in accordance with rivet diameter. Rivet stem should fit snugly into nosepiece.

The Arrow RT187M features innovative thumbscrew nosepieces that are easy to remove and replace when using different size diameter rivets and unlike traditional rivet tools does not require a special tool to change the nosepieces.

HOW TO CHANGE NOSEPIECE (PIC 1):

- Keep rivet tool with handles compressed together in locked position when changing rivet nosepiece.
- Select nosepiece in accordance with rivet diameter and simply unscrew from handle.
- Thumbscrew the right size nose piece into rivet tool nose head.



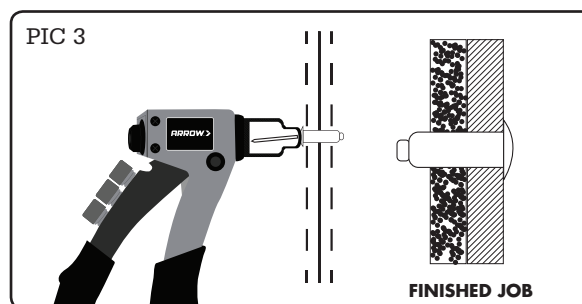
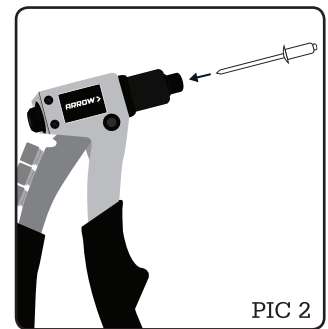
3. Open tool handles and insert pointed end of rivet into tool until flange is against nosepiece. (PIC 2)

4. Position tool with rivet by placing rivet in the hole with flange flush against surface.

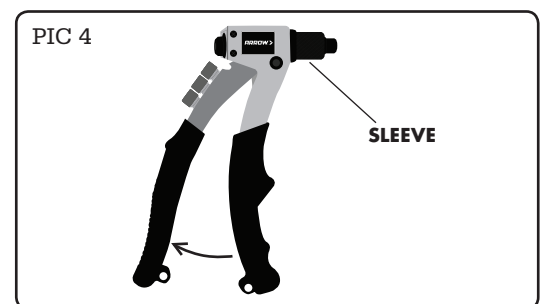
Squeeze handle to pull and cut off excess mandrel and set rivet (PIC 3).

- If two or more strokes are necessary to set rivet, handle must be reopened completely. Move rivet tool down against flange of rivet so that nosepiece is again in contact with head of rivet, and re-squeeze handles.

Once the rivet is set, open handle completely to allow mandrel to eject out of either end of rivet tool.



Place rivet in hole. Squeeze handle to pull & cut off excess mandrel (you may have to squeeze multiple times).



NOTE: If rivet mandrel is hard to put into rivet tool or does not eject out of back of rivet tool, you may need to grease or lightly oil tapered face of jaws, remove nosepiece and open handles completely. With jaws now showing, apply a small amount of grease or oil. Do not allow grease to get on serration of jaws. This will hinder ejection of mandrel. Replace nosepiece.

Adjustable Grip Range – To allow for less working stroke with more pull force, adjust the grip range by adjusting the sleeve outward to lengthen the working stroke (PIC 4).

By adjusting the sleeve inward you can reduce the pull force but will increase the working strokes to fasten a rivet.

By rotating the sleeve one circle, the working stroke is changed 1.25mm.

*RT187M is not recommended for use with 3/16" (5mm) diameter all-steel rivets.



Made in China

WARNING: Do not point rivet tool at anyone, rivet may fly when set. Always wear safety glasses when using this or any tool.

Manufacturer assumes no responsibility for any product failure due to improper use or use inconsistent with these instructions.