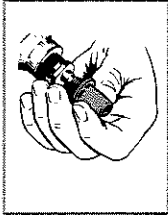
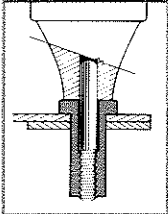


RIVNUT® fastener installation is quick and easy.



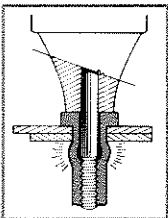
Step 1

The RIVNUT fastener is threaded onto the mandrel of an installation tool.



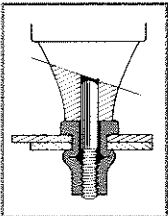
Step 2

The RIVNUT fastener, on the tool mandrel, is inserted into the hole drilled for installation.



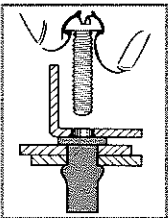
Step 3

The mandrel retracts and pulls the threaded portion of the RIVNUT fastener shank toward the blind side of the work, forming a bulge in the unthreaded shank area.



Step 4

The RIVNUT fastener is clinched securely in place. The mandrel is unthreaded, leaving the internal RIVNUT threads intact.



Blind nut plate

The properly installed RIVNUT fastener makes an excellent blind nut plate for simple screw attachments.

Surface Installation



The flat head RIVNUT fastener is used when head thickness won't interfere with surface contour or possible attachments to the RIVNUT.

Flush Installation



When the metal to be fastened is thinner than the RIVNUT head and a flush surface installation is required, the metal may be dimpled and a flat head RIVNUT fastener used.

Countersunk Installation



When the metal to be fastened is thicker than the head of the RIVNUT fastener, a 100° countersunk head RIVNUT may be used to give a flush surface installation.

Machine Countersunk Installation

A precision hole and countersink can best be obtained by these simple steps:

Step 1

Drill an undersized hole with a lead drill.

Step 2

Countersink the hole.

Step 3

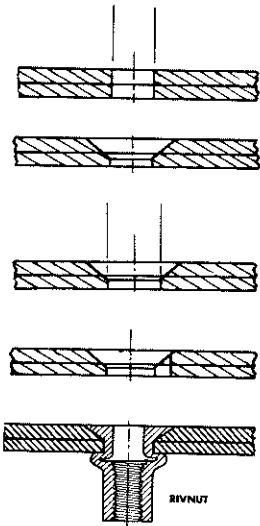
Drill correct diameter hole with sharp finish drill.

Step 4

If keyed RIVNUT fastener is to be used, cut a keyway with a round file or guided drill.

Step 5

Install RIVNUT fastener.

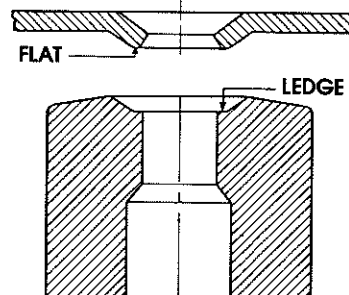


Dimple Countersink Installation

Metal thinner than a RIVNUT fastener head thickness requires a dimple countersink installation.

The ideal bulge on any RIVNUT fastener installation will always be formed against a flat under-surface. The bell-mouth that results from ordinary dimpling will not permit proper formation of the RIVNUT fastener bulge. RIVNUT fasteners upset against this sharp edge will form a weak bulge, a spread shank, and may possibly shear.

To provide a flat surface in the dimpling operation, a ledge at the bottom of the dimpling die must be used. The "flat" on the dimple will save costly deburring before dimpling and enables the RIVNUT fastener to form normally, providing maximum strength.



Dimple or press countersink hole. Note ledge at the bottom of the dimpling die.