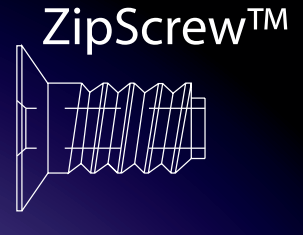
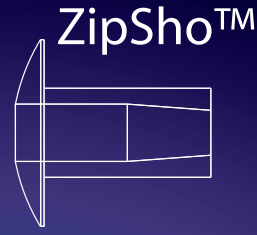
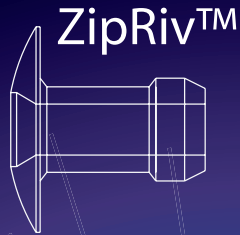


QuickRiveting Catalog

R I V E T



K I N G®



ZipRiv™

ZipSho™

ZipScrew™

Tools

www.rivetking.com

Quick Riveting Systems



What is QuickRiveting?



The Modern, Faster, Low Finished Cost Successor to Blind Riveting. QuickRivets are permanent fastener designed for blind or 1 sided riveting in medium and high volume applications. Rivets are aligned in a paper strip called a pod or magazine so that the rivets can be automatically fed into the quickriveter. The result? An increased output, lower assembly cost and labor saving permanent fastening solution.

Why QuickRiveting?

Increased Output

QuickRivets can be installed up to 4 times faster than traditional blind rivets or screws. Cycle times are limited to less than 2 seconds and installation speeds can reach up to 30 ppm (Semi-Automatic) and 60 ppm (fully automatic).

Reduced Labor

Many users require additional labor to pre-install standard rivets or screws for faster assembly. The QuickRivet eliminates this task, by allowing the user to feed the rivets themselves. And in those applications where the user is installing the standard blind rivet or screw individually by hand, the QuickRivet offers the increased assembly speed because the feed of the tool occurs once per pod, as apposed to once per rivet. The increased output leads to a reduction in the number of assemblers required to meet the manufacturing demand of your product.

Minimal Waste, Improved Safety

Standard blind rivets have a disposable nail or mandrel that can pose a safety problem when dropped on the floor. The QuickRivet System employs a re-usable mandrel that can be used for up to 50K rivets. The only waste generated is that of the paper pods (made of recycled paper), which can again be recycled.

Cost Savings

Increased Output & Production Capacity, Reduced Labor Cost, Minimized Waste and Improved Safety equals overall cost savings to the user.

Improved Joint Quality & Performance

Permanent fastening offers a higher clamp up value then that of screws. In addition, because of the clamping force applied, the joint is more secure when under shear and tension loads as well as resists vibration.

Fine Tuning & Flexibility

Due to the variety of rivet types, materials, front jaw assemblies, and mandrel sizes, the QuickRiveting System can be fine tuned to work perfectly with your application. Whether a tight clinch for good hole fill or a light clinch for use as a pivot or when used with fragile PCB's. The QuickRivet System is completely customizable, yet can be interchanged with other QuickRiveting products for use on other assembly lines.

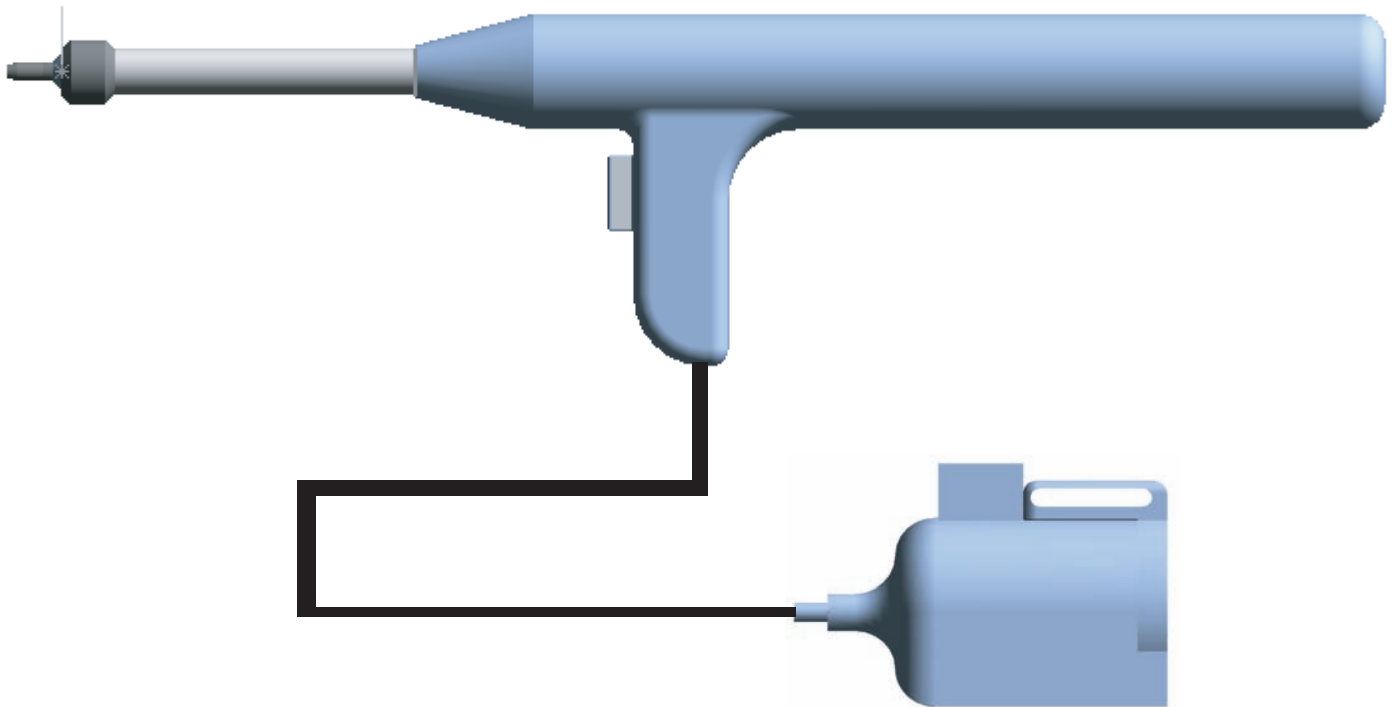
Reliability and Consistency

When the proper QuickRiveting Components are selected, you can be sure that the rivets will perform consistently both during and after assembly, eliminating the need for frequent adjustments.

Perfect For Electronic & PCB Applications

A Typical problem in standard blind riveting for electronic applications is due to the remaining portion of the nail or mandrel left in the rivet after assembly. Under the right conditions this small piece of the mandrel can fall out of the rivet into the electronic component causing a short circuit. QuickRivets are not affected by this condition because the mandrel is completely withdrawn from the rivet during assembly. In addition, QuickRivets are a great catalyst in dispersing heat generated in electronic components which makes it perfect for high temperature environments such as HeatSinks, Rampus Fixtures and Microchips.

RK-753 Assembly Tool

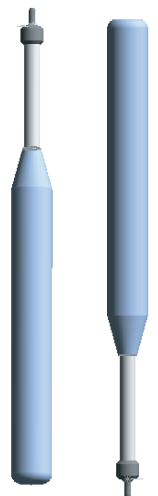


RK-753 Hand Tool

Built with speed, power and reliability in mind, the RK-753 is your turnkey solution to installing ZipRiv™ and ZipSho™ QuickRivets. The RK-753 HydroPneumatic QuickRiveter separates the nose of the tool from the weight of the tool body, therefore, the operator carries only 2.37 lbs, while the heavier remote intensifier is stored at ground level. In addition, an on-board oil reservoir allows for proper lubrication during use. Applicable nose pieces, mandrels, springs, and spare parts are always available from your local distributor.

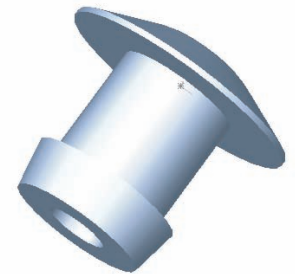
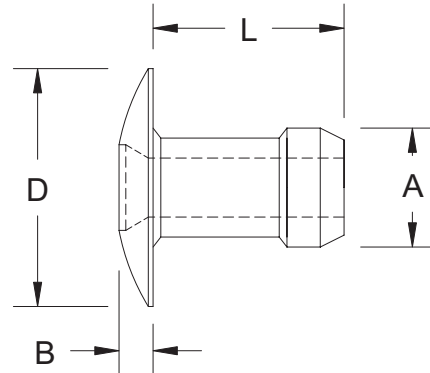
Technical Specifications & Performance Data	
Setting Capacity:	3/32" - 1/8" - 5/32" - 3/16"
Rivet Types:	RivetKing® ZipRiv™, ZipSho™, Avdel® Briv®, Chobert®, Grovit®, RivScrew®, Avlug®, Avtronic®
Air Supply Pressure:	72.5 - 101.5 psi
Free Air Pressure:	74 psi w/ 158.66 in≥
Traction Power @ 90psi:	874 lb/f
Stroke Length:	1.18" Minimum
Cycle Time:	1-2 Seconds
Weight:	2.376 lbs
Vibration:	2.7 m/s≤
Overall Length:	18.70" Inches
Noise Level:	70 dBa Max.
Intensification Ratio:	30:1

Upright, Downward, Foot Pedal and Custom Configurations are Available.



- 1) RivetKing®, ZipRiv™, ZipSho™ are registered trademarks of Industrial Rivet & Fastener Co.
- 2) Avdel®, Briv®, Chobert®, Grovit®, RivScrew®, Avlug®, Avtronic® are registered trade marks of Avdel Cherry Textron and Textron Fastening Systems.
- 3) Industrial Rivet & Fastener Company and RivetKing is in no way associated with Avdel Cherry Textron or Textron Fastening Systems.

Extensively used in sheet metal fabrication, ZipRiv™ offers a high clamp up to steel, brass, aluminum and plastic substrates. The Zipriv™ can be identified by its bulge towards the tail of the rivet. Offered in Dome or Countersunk Head Styles; Steel, Aluminum, Brass and Stainless Steel Materials with zinc clear, zinc black and black anodized finishes.



Other Head Styles
Available Upon Request

Inch Standard

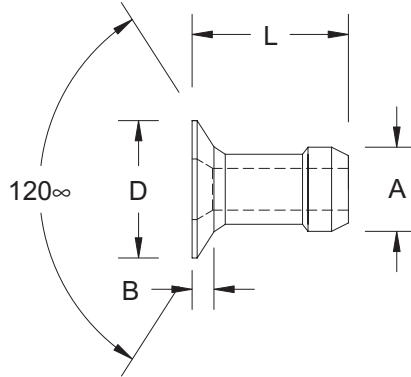
"A"	Part Number	Grip Range	Length	"D"	"B"	Hole Size	Pcs Per Pod
1/8"	[]DZ-0404	.045 - .095	.169				58
	[]DZ-0406	.085 - .135	.209				48
	[]DZ-0408	.125 - .175	.248	.257	.125	.1315	42
	[]DZ-0410	.165 - .215	.287	.233	.120	.1285	37
	[]DZ-0412	.215 - .255	.327				33
	[]DZ-0414	.245 - .295	.366				30
5/32"	[]DZ-0505	.062 - .115	.192				52
	[]DZ-0507	.105 - .155	.232				44
	[]DZ-0509	.145 - .195	.272	.322	.154	.1592	38
	[]DZ-0511	.185 - .235	.311	.298	.150	.1562	34
	[]DZ-0513	.225 - .275	.350				30
3/16"	[]DZ-0607	.080 - .155	.240				42
	[]DZ-0609	.145 - .205	.287				36
	[]DZ-0611	.195 - .255	.339	.382	.189	.1940	31
	[]DZ-0613	.245 - .305	.390	.358	.184	.1910	28
	[]DZ-0615	.295 - .355	.437				24

Material	Part# Prefix	1/8"		5/32"		3/16"	
Aluminum	A []	756 N	1312 N	1134 N	1734 N	1512 N	1312 N
Steel	S []	1134 N	1823 N	1645 N	2802 N	2246 N	1823 N
Brass	B []	1112 N	1912 N	1868 N	2757 N	2312 N	1912 N
Stainless Steel	F []	-	-	2446 N	3558 N	3558 N	5114 N
		Shear	Tension	Shear	Tension	Shear	Tension
TYPICAL PERFORMANCE SPECIFICATIONS							

ZipRiv™ Countersunk Head



Extensively used in sheet metal fabrication, ZipRiv™ offers a high clamp up to steel, brass, aluminum and plastic substrates. The Zipriv™ can be identified by its bulge towards the tail of the rivet. Offered in Dome or Countersunk Head Styles; Steel, Aluminum, Brass and Stainless Steel Materials with zinc clear, zinc black and black anodized finishes.



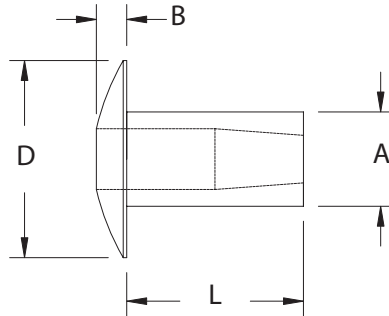
Other Head Styles
Available Upon Request

Inch Standard

"A"	Part Number	Grip Range	Length	"D"	"B"	Hole Size	Pcs Per Pod
1/8"	[] CZ-0405	.050 - .090	.170				65
	[] CZ-0406	.060 - .110	.172				64
	[] CZ-0407	.100 - .150	.212	.235	.035	.1315	52
	[] CZ-0408	.140 - .190	.252	.200	.023	.1285	44
	[] CZ-0410	.180 - .230	.292				38
	[] CZ-0411	.220 - .270	.332				33
5/32"	[] CZ-0505	.062 - .115	.204				59
	[] CZ-0506	.085 - .135	.224				54
	[] CZ-0507	.105 - .155	.244	.274	.040	.1592	49
	[] CZ-0509	.145 - .195	.284	.239	.028	.1562	42
	[] CZ-0511	.185 - .235	.324				36
	[] CZ-0513	.225 - .275	.364				32
3/16"	Available Upon Request						

Material	Part# Prefix	1/8"		5/32"		3/16"	
Aluminum	A []	700 N	1300 N	1100 N	1700 N	-	-
Steel	S []	900 N	1600 N	1600 N	2800 N	-	-
Brass	B []	Available Upon Request					
Stainless Steel	F []	Available Upon Request					
		Shear	Tension	Shear	Tension	Shear	Tension
TYPICAL PERFORMANCE SPECIFICATIONS							

Typically used in soft or brittle materials, ZipSho™ is designed for fastening applications that may be sensitive to clamping force and shock. ZipSho™ assembles materials such as acrylic, plastic, vinyl, rubber, wood or brittle metals that can crack or break under extreme clamping pressure. An internally tapered hole causes controlled radial expansion of the tail which firmly fastens without adversely affecting the riveted substrates.



Other Head Styles
Available Upon Request

Inch Standard

"A"	Part Number	Grip Range	Length	"D"	"B"	Hole Size	Pcs Per Pod
1/8"	[]DZS-0404	.000 - .062	.125				71
	[]DZS-0406	.062 - .125	.187				51
	[]DZS-0408	.125 - .187	.250	.217	.045	.132	39
	[]DZS-0410	.187 - .250	.312	.193	.033	.129	32
	[]DZS-0412	.250 - .312	.375				27
	[]DZS-0414	.312 - .375	.437				23
5/32"	[]DZS-0506	.062 - .125	.187				47
	[]DZS-0508	.125 - .187	.250				38
	[]DZS-0510	.187 - .250	.312	.257	.057	.164	31
	[]DZS-0512	.250 - .312	.375	.235	.047	.161	27
	[]DZS-0514	.312 - .375	.437				23
3/16"	[]DZS-0607	.062 - .125	.291				38
	[]DZS-0609	.125 - .187	.281				33
	[]DZS-0611	.187 - .250	.344	.349	.070	.194	28
	[]DZS-0613	.250 - .312	.409	.329	.060	.191	24
	[]DZS-0615	.312 - .375	.479				21

Other Sizes Available Upon Request

Material	Part# Prefix	1/8"		5/32"		3/16"	
Aluminum	A []	623 N	1000 N	979 N	1624 N	1423 N	2291 N
Steel	S []	1148 N	1660 N	1926 N	2891 N	2615 N	3790 N
Brass	B []	1289 N	-	-	-	-	-
Stainless Steel	F []	Available Upon Request					
		Shear	Tension	Shear	Tension	Shear	Tension
TYPICAL PERFORMANCE SPECIFICATIONS							

ZipRiv™ Skewer Mandrels



"A"	Part Number*	Description	Hole Size	TipØ	Tip Color	Spring#	Long Spring#
1/8"	ZRTM-125-S	Standard	.128	.092	Green	ZRTS-125	ZRTS-125L
	ZRTM-125-1OS	#1 O.S.	.133	.097	Yellow	ZRTS-125	ZRTS-125L
	ZRTM-125-2OS	#2 O.S.	.138	.102	Blue	ZRTS-125	ZRTS-125L
5/32"	ZRTM-156-S	Standard	.156	.110	Green	ZRTS-156	ZRTS-156L
	ZRTM-156-1OS	#1 O.S.	.161	.115	Yellow	ZRTS-156	ZRTS-156L
	ZRTM-156-2OS	#2 O.S.	.166	.120	Blue	ZRTS-156	ZRTS-156L
3/16"	ZRTM-187-S	Standard	.191	.140	Green	ZRTS-187	ZRTS-187L
	ZRTM-187-1OS	#1 O.S.	.196	.145	Yellow	ZRTS-187	ZRTS-187L
	ZRTM-187-2OS	#2 O.S.	.201	.150	Blue	ZRTS-187	ZRTS-187L
	ZRTM-187-2OS	#3 O.S.	.204	.153	Red	ZRTS-187	ZRTS-187L

*Long mandrels are available. Just add the letter "L" to the end of the part number.

ZipSho™ Skewer Mandrels



"A"	Part Number*	Description	Hole Size	TipØ	Tip Color	Spring#	Long Spring#
1/8"	ZSTM-125-S	Standard	.128	.088	Green	ZSTS-125	ZSTS-125L
	ZSTM-125-1OS	#1 O.S.	.133	.092	Yellow	ZSTS-125	ZSTS-125L
	ZSTM-125-2OS	#2 O.S.	.140	.098	Blue	ZSTS-125	ZSTS-125L
	ZSTM-125-3OS	#3 O.S.	.144	.102	Red	ZSTS-125	ZSTS-125L
5/32"	ZSTM-156-S	Standard	.161	.107	Green	ZSTS-156	ZSTS-156L
	ZSTM-156-1OS	#1 O.S.	.169	.115	Yellow	ZSTS-156	ZSTS-156L
	ZSTM-156-2OS	#2 O.S.	.176	.122	Blue	ZSTS-156	ZSTS-156L
3/16"	ZSTM-156-3OS	#3 O.S.	.186	.132	Red	ZSTS-156	ZSTS-156L
	ZSTM-187-S	Standard	.193	.132	Green	ZSTS-187	ZSTS-187L
	ZSTM-187-1OS	#1 O.S.	.208	.146	Red	ZSTS-187	ZSTS-187L
	ZSTM-187-2OS	#2 O.S.	.218	.156	Yellow	ZSTS-187	ZSTS-187L

*Long mandrels are available. Just add the letter "L" to the end of the part number.

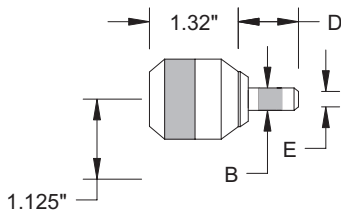
Nose Jaw Selection



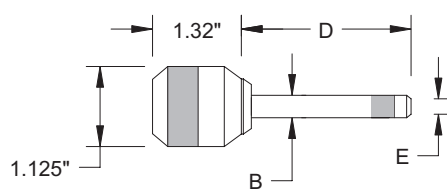
The Nose Jaw is an integral part of the QuickRiving System. The type of nose Jaw you select is application dependent. While the flat endform is standard, the recessed endform allows for high clamp up or can be used to deform a countersunk head into a dome head in order to capitalize on the benefits of SKU and Inventory reduction. The length and shape of the nose jaw is specifically designed to fit in hard to limited access and hard to reach area's.



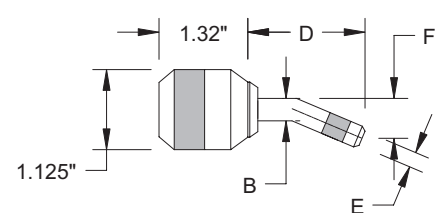
STANDARD NOSE



LONG NOSE

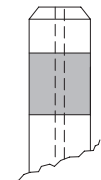


CURVED NOSE

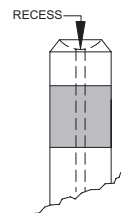


Long	Part#	Nose Type & Form	Dimension		
			B	D	E
1/8"	Z-7150-3004	STANDARD FLAT	.41	1.18	.20
	Z-7170-3004	STANDARD RECESSED	.41	1.20	.30
	Z-7150-4004	LONG FLAT	.41	2.18	.20
	Z-7170-3204	LONG RECESSED	.41	2.18	.30
	Z-7150-5004	CURVED LONG FLAT	.41	2.22	.20
	Z-7170-3304	CURVED LONG RECESSED	.41	2.22	.30
5/32"	Z-7150-3005	STANDARD FLAT	.48	1.30	.24
	Z-7170-3005	STANDARD RECESSED	.48	1.32	.41
	Z-7150-4005	LONG FLAT	.48	2.30	.24
	Z-7170-3205	LONG RECESSED	.51	2.30	.41
	Z-7150-5005	CURVED LONG FLAT	.48	2.23	.24
	Z-7170-3305	CURVED LONG RECESSED	.51	2.23	.41
3/16"	Z-7150-3006	STANDARD FLAT	.56	1.18	.33
	Z-7170-3006	STANDARD RECESSED	.56	1.20	.47
	Z-7150-4006	LONG FLAT	.56	2.30	.33
	Z-7170-3206	LONG RECESSED	.56	2.30	.47
	Z-7150-5006	CURVED LONG FLAT	.56	2.21	.33
	Z-7170-3306	CURVED LONG RECESSED	.56	2.21	.47

FLAT END FORM



RECESSED END FORM



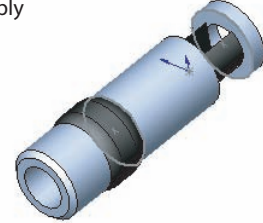
Consumable Tooling - Miscellaneous



Item#	Part Number	Description
1	ZRT-IC	Indexing Cursor
2	ZRT-PJ	Vice Jaws
3	ZRT-WX	Mandrel Wax
4	ZRT-HO	Hydraulic Oil
ZipRiv™ Mandrel Springs		
5	ZRTS-125	1/8" Short Mandrel Spring
	ZRTS-156	5/32" Short Mandrel Spring
	ZRTS-187	3/16" Short Mandrel Spring
	ZRTS-125L	1/8" Long Mandrel Spring
	ZRTS-156L	5/32" Long Mandrel Spring
	ZRTS-187L	3/16" Long Mandrel Spring
ZipSho™ Mandrel Springs		
5	ZSTS-125	1/8" Short Mandrel Spring
	ZSTS-156	5/32" Short Mandrel Spring
	ZSTS-187	3/16" Short Mandrel Spring
	ZSTS-125L	1/8" Long Mandrel Spring
	ZSTS-156L	5/32" Long Mandrel Spring
	ZSTS-187L	3/16" Long Mandrel Spring

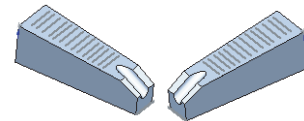
Universal Cursor

Item#1 -
Indexing Component for Mandrel
Assembly



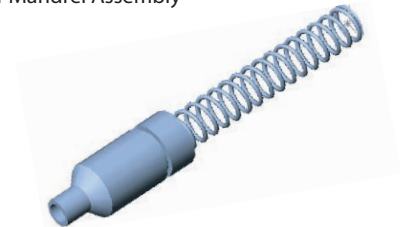
Universal Vice Jaws

Item#2 -
Mandrel Pulling Device



Universal Mandrel Spring

Item#5 -
For Mandrel Assembly



Hydraulic Oil

Item #4 -
For Hydraulic Tool

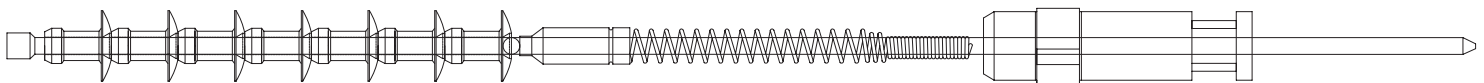


Mandrel Wax

Item#3 -
Increases Mandrel Life



Proper Mandrel Assembly



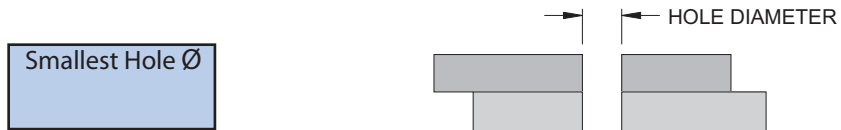
Fastener & Tooling Selection



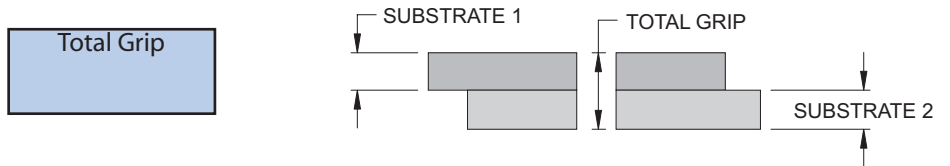
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A	D	Z	05	08	BA
Rivet Material	Head Style	Rivet Type	Nominal Hole \emptyset	Grip Range	Surface Finish
A luminum S teel B rass (F) Stainless	D ome C 'sunk L ow Profile T russ U ndersized	Z ipRiv Z ipSho	(03) 3/32" (04) 1/8" (05) 5/32" (06) 3/16" (08) 1/4"	See Specification Sheet for ZipRiv or ZipSho	P lain B lack A nodize B lack Z inc T in

Step 1 - Determine Rivet Type and Rivet Material Preference.

Step 2 - Determine the Closest Nominal Rivet Diameter via your Hole Size. Then record the Actual Hole Diameter in the box to the right.



Step 3 - Determine Rivet Grip Range via Total Grip Thickness. Record the Actual Total Grip Thickness of your assembly to the right.



Step 4 - Determine the Rivet Part Number by using the Chart Above, and record it to the right.

Rivet Part#

<input type="text"/>	<input type="text"/>	<input type="text"/>	-	<input type="text"/>	<input type="text"/>	<input type="text"/>	/	<input type="text"/>	<input type="text"/>
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Step 5 - Determine Proper Mandrel Size by referencing the actual hole diameter to the chart on page 8. Record the mandrel part# to the right.

Mandrel Part#

Step 6 - Determine Proper Spring Size by referencing the chart on Page 9. Record the Spring Part# to the right.

Spring Part#

Step 7 - Depending on the type of clinch you prefer, Choose the proper Nose Jaw on page 10. If you are not sure, choose standard, flat. Record the Nose Jaw Part# to the right.

Spring Part#

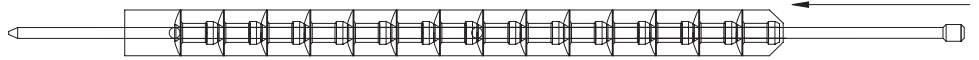
Set-Up & Assembly Process



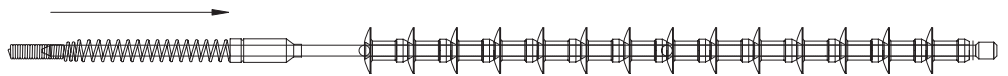
Step 1 - Install the Indexing Cursor into the barrel portion of the rivet tool making sure it is facing the proper direction. Then screw on the Nose Jaw Assembly onto the Barrel.



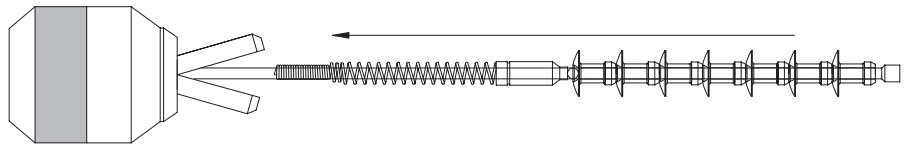
Step 2 - Insert the mandrel into the hole of the podded rivets. Then tear off and dispose of the podding paper.



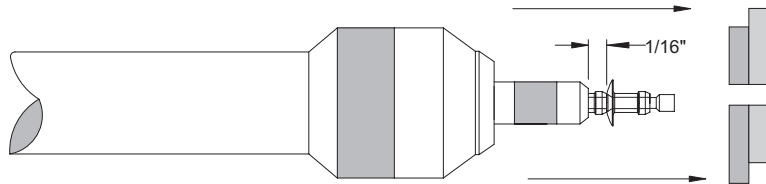
Step 3 - Insert the mandrel spring onto the mandrel in the proper direction.



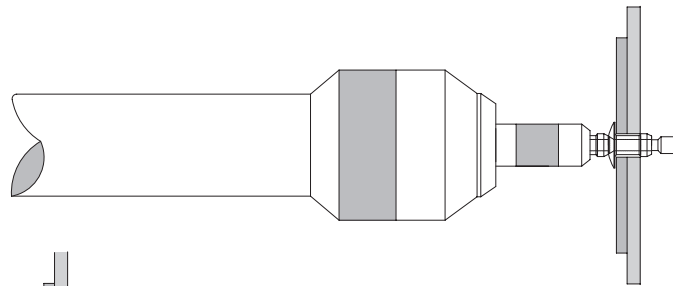
Step 4 - Split the nose jaw open and insert the mandrel assembly (mandrel, spring and rivets), inside the nose jaw until the last rivet remains outside of the nose jaw.



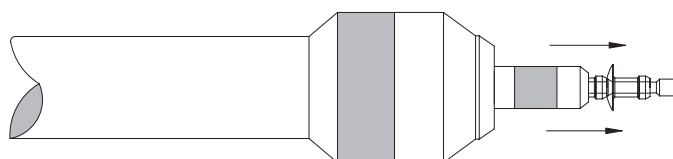
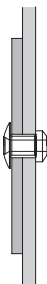
Step 5 - Make sure the head of the rivet is about 1/16" away from the front of the nose jaw. Proper spacing must be assured.



Step 6 - Using the handle of the tool, insert the rivet and mandrel through the hole of your workpiece until the head is sitting flush on the bearing surface. Pull the trigger to actuate the tools cycle and clinch the rivet.



Step 7 - After proper assembly, the next rivet will automatically feed through the nose jaw to advance the next rivet.



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