

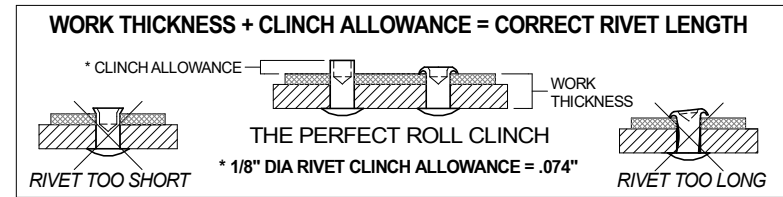
**PINTONKA RIVET TOOL**  
THE NEW STANDARD IN TUBULAR RIVET SETTING

ACTUAL SIZE

THE PINTONKA TOOL IS NOT INTENDED FOR RIVETS LARGER THAN 1/8" DIAMETER OR RIVETS MADE FROM STAINLESS STEEL OR HARDENED MATERIAL. THE RIVET LENGTH MUST BE CAREFULLY DETERMINED BEFORE USING THE TOOL AS DAMAGE CAN RESULT BY ATTEMPTS TO SMASH DOWN A RIVET THAT IS TOO SHORT OR TOO LONG FOR THE WORK. ALWAYS FOLLOW THE STEPS BELOW TO CALCULATE THE CORRECT RIVET LENGTH FOR THE JOB. THE PINTONKA TOOL WORKS PERFECTLY WHEN USED AS INTENDED — IT IS NOT GUARANTEED IF DAMAGED BY MISUSE.

**1. SELECT THE DIE DRIVER THAT MATCHES THE WORK**  
THE T-HANDLE DIE DRIVER IS FAST AND CONVENIENT. USE THE HEX HEAD DIE DRIVER IN TIGHT SPACES WHERE THE T-HANDLE WOULD STRIKE THE WORK.

**2. INSTALL THE DIES IN THE BEST ORIENTATION FOR THE JOB**  
THE DIES ARE INTERCHANGEABLE IN THE TOOL ALLOWING THE RIVET TO BE CLINCHED WITH THE HEAD INSIDE OR OUTSIDE THE WORK. DIES ARE HELD IN PLACE BY A FRICTION CLIP — REMOVE BY PULLING STRAIGHT OUT.



**3. CALCULATE THE CORRECT RIVET LENGTH FOR THE JOB**  
A) USE DIGITAL CALIPERS TO MEASURE YOUR WORK THICKNESS TO THE NEAREST .001" (ONE THOUSANDTH OF AN INCH). DIGITAL CALIPERS ARE INEXPENSIVE AND WIDELY AVAILABLE. THIS IS A REQUIRED STEP.

*EXAMPLE: A PENNY MEASURES .056" THICK*

B) ADD CLINCH ALLOWANCE TO THE THICKNESS OF YOUR WORK. FOR 1/8" DIAMETER RIVETS THE CLINCH ALLOWANCE IS .074". (SEE THE IMAGE ABOVE)

*EXAMPLE: THE PENNY IS .056" THICK + .074" CLINCH ALLOWANCE = .130"*

C) SELECT THE RIVET LENGTH THAT WILL ACCOMMODATE YOUR WORK THICKNESS + CLINCH ALLOWANCE MEASUREMENT. RIVETS ARE SOLD BY LENGTH IN 1/32" INCREMENTS. IN ORDER FOR THE RIVET TO CLINCH TIGHTLY YOUR WORK THICKNESS + CLINCH ALLOWANCE MEASUREMENT MUST FALL WITHIN THE RIVET'S CLINCH RANGE OF +/- .015". (SEE THE TABLE ON BACK)

*EXAMPLE: USING THE TABLE ON BACK THE NUMBER .130" FALLS WITHIN THE CLINCH RANGE OF THE 4/32" RIVET. THIS IS THE CORRECT LENGTH FOR THE JOB. SHORTER OR LONGER RIVETS WILL NOT CLINCH PROPERLY.*

**4. APPLY THE PINTONKA TOOL AND TIGHTEN UNTIL "JUST SNUG"**  
CLINCH THE RIVET BY TIGHTENING THE TOOL UNTIL "JUST SNUG". STOP AND CHECK YOUR WORK. TIGHTENING THE TOOL UNTIL JUST SNUG WILL FORM A PERFECT ROLL CLINCH WHEN THE RIVET LENGTH IS CORRECT FOR THE JOB.

**TIP:** IF THE RIVET TURNS IN THE TOOL MINOR SURFACE SCRATCHING MAY RESULT. PREVENT THIS BY PLACING BLUE TAPE OVER THE RIVET HEAD PRIOR TO APPLYING THE TOOL. TAPE ALSO MAKES ASSEMBLY EASIER.

**HAVE FUN WITH YOUR PROJECTS!**

# THE PINTONKA CLINCH RANGE TABLE

\* USE WORK THICKNESS + CLINCH ALLOWANCE MEASUREMENT \*

RIVET LENGTH	CLINCH RANGE
3/32"	.079" — .109"
4/32"	.110" — .140"
5/32"	.141" — .171"
6/32"	.173" — .203"
7/32"	.204" — .234"
8/32"	.235" — .265"
9/32"	.266" — .296"
10/32"	.298" — .328"
11/32"	.329" — .359"
12/32"	.360" — .390"
13/32"	.391" — .421"
14/32"	.423" — .453"
15/32"	.454" — .484"
16/32"	.485" — .515"
17/32"	.516" — .546"

RIVET LENGTH	CLINCH RANGE
18/32"	.548" — .578"
19/32"	.579" — .609"
20/32"	.610" — .640"
21/32"	.641" — .671"
22/32"	.673" — .703"
23/32"	.704" — .734"
24/32"	.735" — .765"
25/32"	.766" — .796"
26/32"	.798" — .828"
27/32"	.829" — .859"
28/32"	.860" — .890"
29/32"	.891" — .921"
30/32"	.923" — .953"
31/32"	.954" — .984"
32/32"	.985" — 1.015"

ALL NUMBERS GIVEN IN INCHES

RIVETS ARE SOLD BY LENGTH IN 1/32 INCH INCREMENTS

CLINCH RANGE NUMBERS ARE RIVET LENGTH +/- .015 INCH

IF YOUR MEASUREMENT FALLS BETWEEN RIVET LENGTHS USE THE SHORTER RIVET