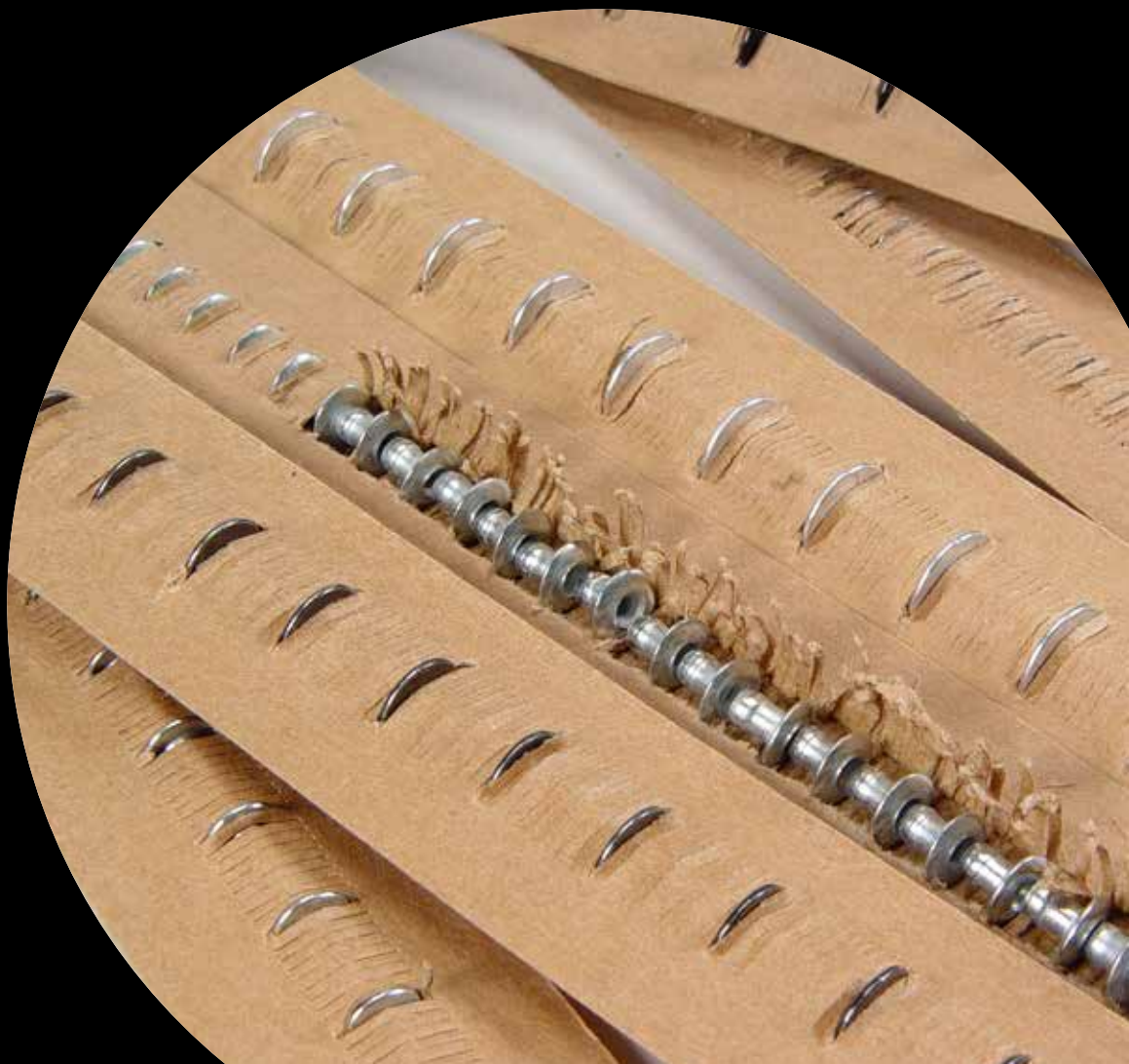
RIVET KING®

QUICKRIVETING SYSTEM

RIVETKING® QUICKRIVETING SYSTEM®



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 the number of assemblers required to meet the manufacturing demand of your product.

Minimal Wasted, 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 and 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 and 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.

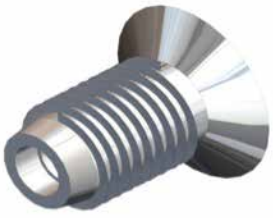
Perfect for Electronic and PCB Applications

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, Rambus Fixtures and Microchips.

DOME HEAD COUNTERSUNK HEAD

ZIPRIV®

ZIPSHO®



ZIPSCREW®

RIVETKING® RK-753™ ASSEMBLY TOOL

RK-753 QUICKRIVETING HAND TOOL

BUILT WITH SPEED, POWER, AND RELIABILITY IN MIND, THE RK-753™ IS YOUR TURNKEY SOLUTION TO INSTALLING ZIPRIV®, ZIPSHO®, ZIPSCREW®, AND ZIPGROOVE™ QUICKRIVETING PRODUCTS.

The RK-753 HydraPneumatic 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.

RK-753-P3 QUICKRIVETING HAND TOOL

TECHNICAL SPECIFICATION AND PERFORMANCE DATA

Setting Capacity:	3/32” (2.4) - 1/8” (3.2) – 5/32” (4.0) – 3/16” (4.8)
Rivet Types:	Rivetking® Zipriv®, Zipsho®, ZipScrew®, ZipGroove™ and ZipTronic™, Avdel®, Briv®, Chobert®, Rivscrew®, Grovit® and Avlug®, Avtronic®
Air Supply Pressure:	72.5 - 101.5 psi
Free Air Pressure:	74 psi with 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

1) ZIPRIV®, ZIPSHO®, ZIPSCREW®, ZIPGROOVE™ AND ZIPTRONIC™ ARE REGISTERED TRADEMARKS OF INDUSTRIAL RIVET & FASTENER CO.

2) BRIV ®, CHOBERT®, RIVSCREW®, GROVIT® AND AVLUG®, AVTRONIC® ARE REGISTERED TRADEMARKS OF AVDEL®, ACUMENT™ GLOBAL TECHNOLOGIES COMPANY, COPYRIGHT © 2007 ACUMENT™ INTELLECTUAL PROPERTIES LLC.

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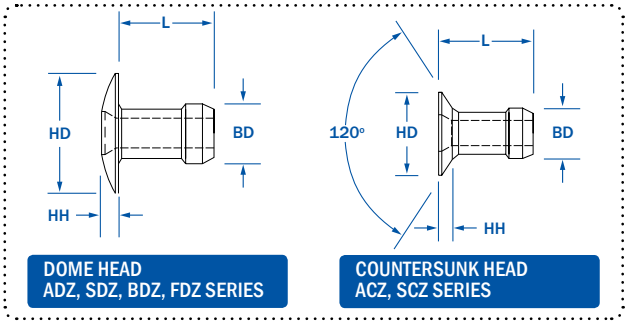
RIVETKING® ZIPRIV®

THE FOLLOWING PRODUCTS ARE COVERED UNDER ONE OR MORE OF THE FOLLOWING PATENTS/TRADEMARKS:
3,678,927 • 7385186 • 30 2009 028, 045.2/06 • 01391640

USPTO REG. NO. 77/613,036 • ROHS COMPLIANT

Extensively used in sheet metal fabrication, ZipRiv® offers a high clamp up to steel, brass, aluminum and some plastic substrates. The ZipRiv® can be identified by its bulge towards the tail of the rivet. Offered in dome and countersunk head styles in a variety of materials and finishes.



BUILDING A ZIPRIV PART NUMBER

DESIGNATION				SIZE		FINISH
A	D	Z	-	04	04	BA

- MATERIAL PREFIX: A- Aluminum; S- Steel; B- Brass; F- Stainless Steal
- "Z" ZIP RIV
- HEAD STYLE: D- Dome Head; C- Countersunk Head
- GRIP CODE PER CHART
- DIAMETER CODE IN 32nds: 04 - 1/8"; 05 - 5/32"; 06 - 3/16"
- FINISH: SZ- Zinc ROHS; BA- Black Anodize; BZ- Black Zinc ROHS; TP- Tin Plated

		PART NUMBER	GRIP RANGE	LENGTH LENGTH MAX.	PCS/ POD PCS/ POD +/-1	HOLE SIZE MIN	HOLE SIZE MAX	BD BODY DIA MAX	HD HEAD DIA MAX	HH HEAD HEIGHT MAX
DOME HEAD	3/32" (2.4)	(X)DZ - 0304	.045-.095 (1.14-2.42)	.157 (3.98)	64	.093 (2.36)	.096 (2.44)	.0923 (2.35)	.162 (4.30)	.035 (0.89)
		(X)DZ - 0306	.085-.135 (2.15-3.43)	.197 (5.00)	52					
		(X)DZ - 0308	.125-.175 (3.17-4.45)	.237 (6.02)	44					
	1/8" (3.2)	(X)DZ - 0403	.025-.075 (0.64-1.91)	.152 (3.86)	59	.1285 (3.26)	.1315 (3.34)	.1235 (3.14)	.257 (6.60)	.039 (0.99)
		(X)DZ - 0404	.045-.095 (1.14-2.42)	.172 (4.37)	58					
		(X)DZ - 0405	.065-.115 (1.65-2.87)	.192 (4.87)	50					
		(X)DZ - 0406	.085-.135 (2.15-3.43)	.212 (5.39)	48					
		(X)DZ - 0408	.125-.175 (3.17-4.45)	.252 (6.41)	42					
		(X)DZ - 0410	.165-.215 (4.19-5.47)	.292 (7.42)	37					
		(X)DZ - 0412	.215-.255 (5.20-6.48)	.332 (8.44)	33					
		(X)DZ - 0414	.245-.295 (6.22-7.50)	.372 (9.45)	29					
	5/32" (4.0)	(X)DZ - 0505	.062-.115 (1.57-2.93)	.193 (4.91)	52	.1562 (3.97)	.1592 (4.04)	.1525 (3.88)	.332 (8.30)	.039 (0.99)
		(X)DZ - 0507	.105-.155 (2.66-3.94)	.233 (5.92)	44					
		(X)DZ - 0509	.145-.195 (3.68-4.96)	.273 (6.94)	39					
		(X)DZ - 0511	.185-.235 (4.69-5.97)	.313 (7.95)	34					
		(X)DZ - 0513	.225-.275 (5.71-6.99)	.353 (8.97)	31					
		(X)DZ - 0515	.265-.315 (6.73-8.00)	.393 (9.98)	26					
	3/16" (4.8)	(X)DZ - 0606	.065-.130 (1.65-3.30)	.212 (5.39)	46	.191 (4.85)	.194 (4.93)	.1875 (4.77)	.382 (9.80)	.046 (1.17)
		(X)DZ - 0607	.080-.155 (2.03-3.94)	.240 (6.10)	42					
		(X)DZ - 0609	.145-.205 (3.68-5.21)	.290 (7.37)	35					
		(X)DZ - 0611	.195-.255 (4.95-6.48)	.340 (8.64)	31					
		(X)DZ - 0613	.245-.305 (6.22-7.75)	.390 (9.91)	27					
		(X)DZ - 0615	.295-.355 (7.49-9.02)	.440 (11.18)	24					
		(X)DZ - 0617	.345-.405 (8.76-10.29)	.490 (12.45)	22					
		(X)DZ - 0619	.395-.455 (10.03-11.56)	.530 (13.46)	20					
COUNTERSUNK HEAD	1/8" (3.2)	(X)CZ - 0404	.057-.067 (1.45-1.70)	.165 (4.19)	72	.1285 (3.26)	.1315 (3.34)	.1245 (3.17)	.230 (5.50)	0.027 (0.74)
		(X)CZ - 0405	.050-.090 (1.27-2.29)	.170 (4.32)	72					0.029 (0.69)
		(X)CZ - 0406	.060-.110 (1.52-2.79)	.188 (4.77)	64					0.03 (0.76)
		(X)CZ - 0407	.100-.150 (2.54-3.81)	.228 (5.79)	52					
		(X)CZ - 0408	.140-.190 (3.56-4.83)	.268 (6.81)	44					
		(X)CZ - 0410	.180-.230 (4.57-5.84)	.308 (7.82)	38					
		(X)CZ - 0411	.220-.270 (5.59-6.86)	.348 (8.84)	33					
	5/32" (4.0)	(X)CZ - 0505	.062-.115 (1.57-2.93)	.204 (5.18)	59	.1562 (3.97)	.1592 (4.04)	.1535 (3.90)	.240 (6.50)	0.04 (1.02)
		(X)CZ - 0506	.086-.135 (2.15-3.43)	.224 (5.69)	54					
		(X)CZ - 0507	.105-.155 (2.66-3.94)	.244 (6.19)	49					
		(X)CZ - 0509	.145-.195 (3.68-4.96)	.284 (7.21)	42					
		(X)CZ - 0511	.185-.235 (4.69-5.97)	.324 (8.22)	36					
		(X)CZ - 0513	.225-.275 (5.71-6.99)	.364 (9.24)	32					

NOTE: SHEAR AND TENSILE DATA VARIES BASED ON HOLE SIZE, ACTUAL GRIP AND SUBSTRATE MATERIAL SELECTION. FOR REFERENCE DATA PLEASE CONTACT THE ENGINEERING DEPARTMENT. FOR CRITICAL APPLICATIONS, WE SUGGEST OUR ENGINEERING DEPARTMENT PERFORM TESTING ON THE ACTUAL MATERIALS TO BE RIVETED. RESULTING DATA WILL BE PROVIDED UPON REQUEST.

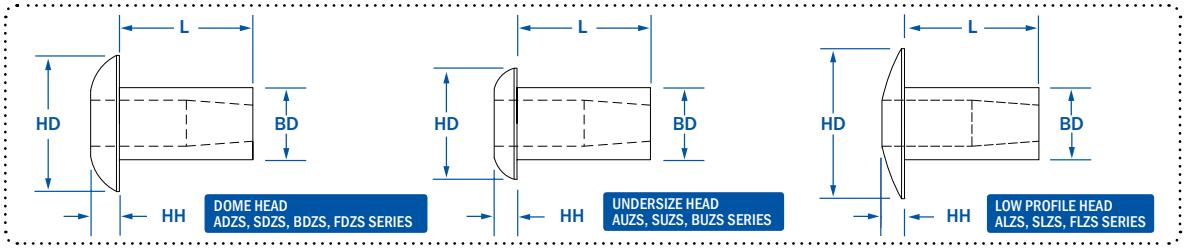
METRIC DIMENSIONS ARE IN PARENTHESIS

RIVETKING® ZIPSHO®

THE FOLLOWING PRODUCTS ARE COVERED UNDER ONE OR MORE OF THE FOLLOWING PATENTS/TRADEMARKS
3,678,928 • 7385185 • 30 2009 028, 046.0/06 • 01391641

USPTO REG. NO. 77/613,075 • ROHS COMPLIANT

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 uses controlled radial expansion of the tail which firmly fastens without adversely affecting the riveted substrates.



		PART NUMBER	GRIP RANGE	LENGTH LENGTH MAX.	PCS/ POD PCS/ POD +/-1	HOLE SIZE		BD BODY DIA MAX	HD HEAD DIA MAX	HH HEAD HEIGHT MAX
DOME HEAD	3/32" (2.4)	(X)DZS - 0304	.001-.062 (0.00-1.57)	.125 (3.17)	73	.098 (2.49)	.1005 (2.55)	.0975 (2.48)	.163 (4.3)	.037 (1.0)
		(X)DZS - 0306	.062-.125 (1.57-3.17)	.187 (4.75)	52					
		(X)DZS - 0308	.125-.187 (3.17-4.75)	.250 (6.35)	41					
	1/8" (3.2)	(X)DZS - 0404	.000-.062 (0.00-1.57)	.125 (3.17)	71	.129 (3.28)	.1315 (3.34)	0.1285 (3.27)	.217 (5.5)	.045 (1.2)
		(X)DZS - 0406	.062-.125 (1.57-3.17)	.187 (4.75)	51					
		(X)DZS - 0408	.125-.187 (3.17-4.75)	.250 (6.35)	39					
		(X)DZS - 0410	.187-.250 (4.75-6.35)	.312 (7.92)	32					
		(X)DZS - 0412	.250-.312 (6.35-7.92)	.375 (9.52)	27					
	5/32" (4.0)	(X)DZS - 0506	.062-.125 (1.57-3.17)	.187 (4.75)	47	.161 (4.09)	0.164 (4.16)	.1595 (4.06)	.257 (6.5)	.058 (1.5)
		(X)DZS - 0508	.125-.187 (3.17-4.75)	.250 (6.35)	38					
		(X)DZS - 0510	.187-.250 (4.75-6.35)	.312 (7.92)	31					
		(X)DZS - 0512	.250-.312 (6.35-7.92)	.375 (9.52)	27					
		(X)DZS - 0514	.312-.375 (7.92-9.52)	.437 (11.1)	23					
		(X)DZS - 0516	.375-.437 (9.52-11.10)	.500 (12.7)	21					
	3/16" (4.8)	(X)DZS - 0605	.000-.062 (0.00-1.57)	.156 (3.96)	50	.191 (4.85)	.194 (4.93)	.1895 (4.82)	.351 (8.9)	.071 (1.8)
		(X)DZS - 0607	.062-.125 (1.57-3.17)	.219 (5.56)	38					
		(X)DZS - 0609	.125-.187 (3.17-4.75)	.281 (7.17)	33					
		(X)DZS - 0611	.187-.250 (4.75-6.35)	.344 (8.74)	28					
		(X)DZS - 0613	.250-.312 (6.35-7.92)	.406 (10.31)	24					
		(X)DZS - 0615	.312-.375 (7.92-9.52)	.469 (11.91)	21					
		(X)DZS - 0617	.375-.437 (9.52-11.10)	.531 (13.49)	19					
		(X)DZS - 0619	.437-.500 (11.10-12.70)	.594 (15.09)	17					
UNDERSIZE HEAD	1/8" (3.2)	(X)UZS - 0404	.000-.062 (0.00-1.57)	.125 (3.17)	71	.120 (3.048)	.123 (3.124)	.1185 (3.01)	.217 (5.52)	.045 (1.15)
		(X)UZS - 0406	.062-.125 (1.57-3.17)	.187 (4.75)	51					
		(X)UZS - 0408	.125-.187 (3.17-4.75)	.250 (6.35)	39					
		(X)UZS - 0410	.187-.250 (4.75-6.35)	.312 (7.92)	32					
		(X)UZS - 0412	.250-.312 (6.35-7.92)	.375 (9.52)	27					
LOW PROFILE HEAD	1/8" (3.2)	(X)LZS - 0404	.000-.062 (0.00-1.57)	.125 (3.17)	71	.129 (3.28)	.1315 (3.34)	0.1285 (3.27)	.262 (6.66)	.041 (1.05)
		(X)LZS - 0406	.062-.125 (1.57-3.17)	.187 (4.75)	51					
		(X)LZS - 0408	.125-.187 (3.17-4.75)	.250 (6.35)	39					
		(X)LZS - 0410	.187-.250 (4.75-6.35)	.312 (7.92)	32					
		(X)LZS - 0412	.250-.312 (6.35-7.92)	.375 (9.52)	27					
	3/16" (4.8)	(X)LZS - 0605	.000-.062 (0.00-1.57)	.156 (3.96)	50	.191 (4.85)	.194 (4.93)	.1895 (4.82)	.396 (10.06)	.065 (1.66)
		(X)LZS - 0607	.062-.125 (1.57-3.17)	.219 (5.56)	38					
		(X)LZS - 0609	.125-.187 (3.17-4.75)	.281 (7.17)	33					
		(X)LZS - 0611	.187-.250 (4.75-6.35)	.344 (8.74)	28					
		(X)LZS - 0613	.250-.312 (6.35-7.92)	.406 (10.31)	24					
		(X)LZS - 0615	.312-.375 (7.92-9.52)	.469 (11.91)	21					
		(X)LZS - 0617	.375-.437 (9.52-11.10)	.531 (13.49)	19					
		(X)LZS - 0619	.437-.500 (11.10-12.70)	.594 (15.09)	17					

NOTE: SHEAR AND TENSILE DATA VARIES BASED ON HOLE SIZE, ACTUAL GRIP AND SUBSTRATE MATERIAL SELECTION. FOR REFERENCE DATA PLEASE CONTACT THE ENGINEERING DEPARTMENT. FOR CRITICAL APPLICATIONS, WE SUGGEST OUR ENGINEERING DEPARTMENT PERFORM TESTING ON THE ACTUAL MATERIALS TO BE RIVETED. RESULTING DATA WILL BE PROVIDED UPON REQUEST.

METRIC DIMENSIONS ARE IN PARENTHESIS

BUILDING A ZIPSHO PART NUMBER

DESIGNATION				SIZE			FINISH
A	D	ZS	-	04	06		BA

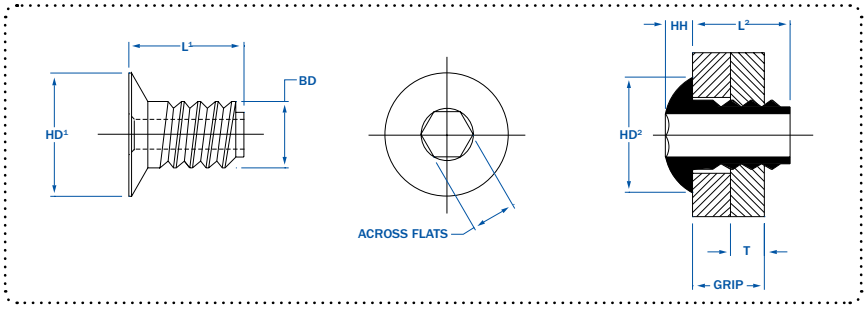
- **MATERIAL PREFIX**: A- Aluminum; S- Steel; B- Brass; F- Stainless Steal
- **HEAD STYLE**: D- Dome Head; U- Undersize Head; L- Low Profile Head
- **"ZS" ZIPSHO**
- **DIAMETER CODE** IN 32nds: 04 - 1/8"; 05 - 5/32"; 06 - 3/16"
- **GRIP CODE** PER CHART
- **FINISH**: SZ- Zinc ROHS; BA- Black Anodize; BZ- Black Zinc ROHS; TP- Tin Plated

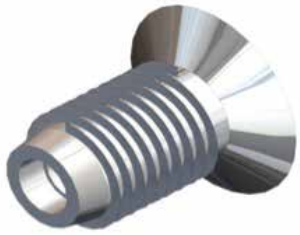
RIVETKING® ZIPSCREW®

THE FOLLOWING PRODUCT IS COVERED UNDER THE FOLLOWING PATENT/TRADEMARK: 3,668,000

ROHS COMPLIANT

The RivetKing® ZipScrew® is a unique fastener which allows for the continuos removal and replacement after it is installed. Most often its used in electronics where the removal and replacement of microchips, chipsets, mosfets, access doors and other areas where the removal of the rivet by the end user may be required. Often times the ZipScrew® is preferred over traditional screws since the user benefits from the installation speed of a rivet and the removability of a screw. Once installed, the user can use a standard hex key to remove the rivet, and later reinstall the rivet just like a screw. The ZipScrew® radial expands resulting in a vibration resistant assembly. Can be used in materials with less than 105 Hv5 hardness.

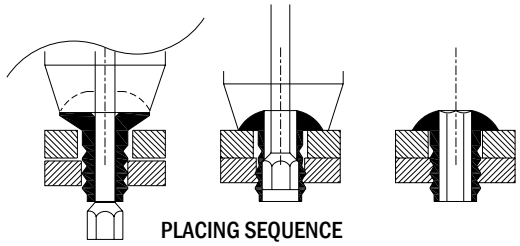




	PART NUMBER	GRIP RANGE	L1 LENGTH AS INSTALLED	L2 LENGTH AS INSTALLED	PCS/ POD	HOLE SIZE FRONT SHEET		HOLE SIZE REAR SHEET		BD BODY DIA	HD HEAD DIA AS SUPPLIED	HD2 BODY DIA AS INSTALLED	HH HEAD HEIGHT AS INSTALLED	T THICKESS REAR SHEET
		MAX	MAX	MAX	+/-1	MIN	MAX	MIN	MAX	MAX	MAX	MAX	MAX	MIN
3.0mm	SDZR - 3006	.112 (2.85)	.202 (5.2)	.157 (4.0)	62	.121 (3.07)	.124 (3.15)	.111 (2.82)	.114 (2.89)	.1107 (2.8)	.230 (5.7)	.240 (6.1)	.055 (1.4)	.064 (1.62)
	SDZR - 3007	.151 (3.85)	.241 (6.1)	.196 (5.0)	52									
	SDZR - 3009	.190 (4.83)	.280 (7.1)	.235 (6.0)	43									
	SDZR - 3010	.229 (5.82)	.319 (8.1)	.274 (7.0)	38									
	SDZR - 3011	.268 (6.81)	.359 (9.1)	.314 (8.0)	34									
	SDZR - 3012	.307 (7.80)	.397 (10.1)	.352 (9.0)	30									
	SDZR - 3016	.422 (10.72)	.515 (13.1)	.467 (11.9)	23									
3.5mm	SDZR - 3506	.112 (2.85)	.202 (5.2)	.157 (4.0)	62	.138 (3.50)	.141 (3.58)	.122 (3.10)	.125 (3.17)	.1215 (3.1)	.235 (5.8)	.240 (6.1)	.055 (1.4)	.064 (1.62)
	SDZR - 3507	.151 (3.85)	.241 (6.1)	.196 (5.0)	52									
	SDZR - 3509	.190 (4.83)	.280 (7.1)	.235 (6.0)	43									
	SDZR - 3510	.229 (5.82)	.319 (8.1)	.274 (7.0)	38									
	SDZR - 3511	.268 (6.81)	.359 (9.1)	.314 (8.0)	34									
	SDZR - 3512	.307 (7.80)	.397 (10.1)	.352 (9.0)	30									
	SDZR - 3517	.463 (11.76)	.553 (14.1)	.508 (12.9)	21									
4.0mm	SDZR - 4006	.112 (2.85)	.202 (5.2)	.157 (4.0)	62	.165 (4.19)		.142 (3.61)	.145 (3.68)	.1415 (3.6)	.235 (6.0)	.250 (6.4)	.055 (1.4)	.064 (1.62)
	SDZR - 4007	.151 (3.85)	.241 (6.1)	.196 (5.0)	52									
	SDZR - 4009	.190 (4.83)	.280 (7.1)	.235 (6.0)	43									
	SDZR - 4010	.229 (5.82)	.319 (8.1)	.274 (7.0)	38									
	SDZR - 4011	.268 (6.81)	.359 (9.1)	.314 (8.0)	34									
	SDZR - 4012	.307 (7.80)	.397 (10.1)	.352 (9.0)	30									
	SDZR - 4015	.385 (9.78)	.475 (12.1)	.430 (11.0)	25									

NOTE: SHEAR AND TENSILE DATA VARIES BASED ON HOLE SIZE, ACTUAL GRIP AND SUBSTRATE MATERIAL SELECTION. FOR REFERENCE DATA PLEASE CONTACT THE ENGINEERING DEPARTMENT. FOR CRITICAL APPLICATIONS, WE SUGGEST OUR ENGINEERING DEPARTMENT PERFORM TESTING ON THE ACTUAL MATERIALS TO BE RIVETED. RESULTING DATA WILL BE PROVIDED UPON REQUEST.

METRIC DIMENSIONS ARE IN PARENTHESIS



BUILDING A ZIPSCREW PART NUMBER

DESIGNATION				SIZE			FINISH	
S	D	ZR	-	35	07		SZ	

- S - MATERIAL PREFIX: S- Steel
- D - HEAD STYLE: D- Dome Head, P- Pre-Formed Head
- ZR - "ZR" ZIPSCREW
- 35 - DIAMETER CODE: 30 - 3mm, 35 - 3.5mm, 40 - 4mm
- 07 - GRIP CODE PER CHART
- SZ - FINISH: SZ- Zinc ROHS, BZ- Black Zinc ROHS, TP- Tin Plated

RIVETKING® Mandrel & Spring Consumables

PRODUCT	RIVET DIAMETER	MANDREL PART NUMBER	DESCRIPTION	MINIMUM APPLICATION HOLE SIZE	TIP COLOR IDENTIFIER	DIMENSIONS		SPRING PART NUMBER
						TD	L	
ZipRiv® Alu./ StÅeel/Brass	3/32" (2.4)	ZRTM-093-S	Standard Tip, Standard Length	.093" (2.36)	Green	.072" (1.83)	19" (483)	ZSTS-093
		ZRTM-093-1	#1 Oversize Tip, Standard Length	.097" (2.46)	Yellow	.076" (1.93)		
		ZRTM-093-2	#2 Oversize Tip, Standard Length	.101" (2.56)	Blue	.079" (2.01)		
ZipRiv® Alu./ Steel/Brass	1/8" (3.2)	ZRTM-125-S	Standard Tip, Standard Length	.1285" (3.26)	Green	.092" (2.34)	19" (483)	ZRTS-125
		ZRTM-125-1	#1 Oversize Tip, Standard Length	.1335" (3.39)	Yellow	.097" (2.46)		
		ZRTM-125-2	#2 Oversize Tip, Standard Length	.1385" (3.51)	Blue	.102" (2.59)		
ZipRiv® Alu./ Steel/Brass	5/32" (4.0)	ZRTM-156-S	Standard Tip, Standard Length	.1562" (3.97)	Green	.110" (2.79)	19" (483)	ZRTS-156
		ZRTM-156-1	#1 Oversize Tip, Standard Length	.1612" (4.1)	Yellow	.115" (2.92)		
		ZRTM-156-2	#2 Oversize Tip, Standard Length	.1662" (4.22)	Blue	.120" (3.05)		
ZipRiv® Alu./ Steel/Brass	3/16" (4.8)	ZRTM-187-S	Standard Tip, Standard Length	.191" (4.85)	Green	.140" (3.58)	19" (483)	ZRTS-187
		ZRTM-187-1	#1 Oversize Tip, Standard Length	.196" (4.98)	Yellow	.145" (3.71)		
		ZRTM-187-2	#2 Oversize Tip, Standard Length	.201" (5.1)	Blue	.151" (3.84)		
		ZRTM-187-3	#3 Oversize Tip, Standard Length	.203" (5.15)	Red	.153" (3.85)		
ZipRiv® Stainless Steel	All Sizes	Contact our application engineering department. A broachload test must be conducted by RivetKing staff to determine the best mandrel for the application. Warning: Use of standard mandrels in stainless steel ZipRiv® can cause a potentially hazardous condition.						
ZipSho®	3/32" (2.4)	ZSTM-093-S	Standard Tip, Standard Length	.098 (2.49)	Green	.0725" (1.84)	19" (483)	ZRTS-093
		ZSTM-093-1	#1 Oversize Tip, Standard Length	.0995 (2.53)	Yellow	.074" (1.88)		
		ZSTM-093-2	#2 Oversize Tip, Standard Length	.1015 (2.58)	Blue	.076" (1.93)		
ZipSho®	1/8" (3.2)	ZSTM-125-S	Standard Tip, Standard Length	.129 (3.28)	Green	.088" (2.24)	19" (483)	ZRTS-125
		ZSTM-125-1	#1 Oversize Tip, Standard Length	.133 (3.38)	Yellow	.092" (2.34)		
		ZSTM-125-2	#2 Oversize Tip, Standard Length	.139 (3.53)	Blue	.098" (2.49)		
		ZSTM-125-3	#3 Oversize Tip, Standard Length	.143 (3.63)	Red	.102" (2.59)		
ZipSho®	5/32" (4.0)	ZSTM-156-S	Standard Tip, Standard Length	.161 (4.09)	Green	.107" (2.72)	19" (483)	ZRTS-156
		ZSTM-156-1	#1 Oversize Tip, Standard Length	.169 (4.29)	Yellow	.115" (2.92)		
		ZSTM-156-2	#2 Oversize Tip, Standard Length	.176 (4.47)	Blue	.122" (3.10)		
		ZSTM-156-3	#3 Oversize Tip, Standard Length	.186 (4.72)	Red	.132" (3.35)		
ZipSho®	3/16" (4.8)	ZSTM-187-S	Standard Tip, Standard Length	.191 (4.85)	Green	.132" (3.35)	19" (483)	ZRTS-187
		ZSTM-187-1	#1 Oversize Tip, Standard Length	.205 (5.2)	Yellow	.146" (3.71)		
		ZSTM-187-2	#2 Oversize Tip, Standard Length	.215 (5.45)	Blue	.156" (3.96)		
ZipScrew®	3.0mm	ZWTM-300-S	Standard Tip, Standard Length	See ZipScrew®	Green	.065" (1.65)	19" (483)	ZWTS-300
ZipScrew®	3.5mm	ZWTM-350-S	Standard Tip, Standard Length	See ZipScrew®	Yellow	.0825" (2.10)		ZWTS-350
ZipScrew®	4.0mm	ZWTM-400-S	Standard Tip, Standard Length	See ZipScrew®	Blue	.103" (2.62)		ZWTS-400

NOTE: LONG MANDRELS AND LONG SPRINGS ARE AVAILABLE. FOR LONG MANDRELS AND SPRINGS ADD THE FOLLOWING TO THE PART NUMBER.

Standard Mandrels 19" (483) or Standard Springs: Specified Above
Long Mandrels 20" (508) or Long Springs: Add "L" to the Part Number
Extra Long Mandrels 21" (533): Add "XL" to the Part Number

METRIC DIMENSIONS ARE IN PARENTHESIS

ZIPRIV® MANDREL

ZIPSHO® MANDREL

ZIPSHO® SHORT REACH MANDREL **** SPECIAL ORDER **** FOR SHORT REACH MANDRELS ADD "SR" AS A SUFFIX TO THE PART NUMBER.

ZIPSCREW® MANDREL

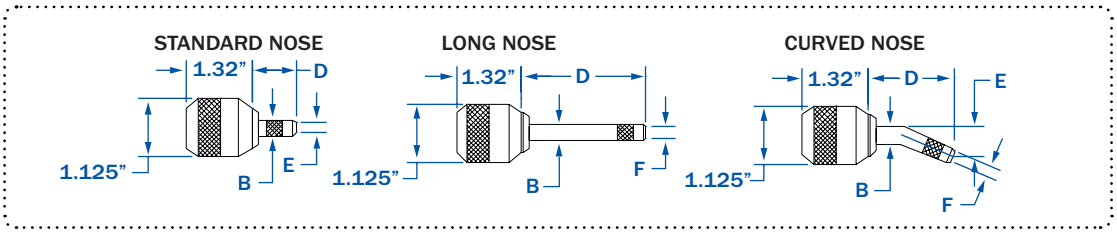
SPRING

CLOSE UP OF ZIPSCREW® MANDREL

RIVETKING® NOSE JAW SELECTION

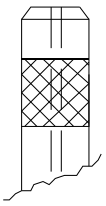
ROHS COMPLIANT

The nose jaw is an integral part of the QuickRiveting System®. The type of nose jaw you select is application dependent. While the flat end form is most common, the recessed end form allows for high clamp up or can be used to deform a countersunk head into a dome head. Long nose jaws are used in hard to reach or limited access areas. Nose jaws can be designed to fit your application. Contact our applications engineering department for custom designs and application assistance.

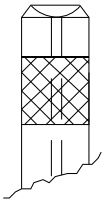


RIVET DIA.	PART NUMBER	NOSE TYPE & FORM	DIMENSIONS		
			B	D	E
3/32" (2.4)	Z-7150-3003	Standard Flat	.36" (9.14)	1.3" (33.02)	.16" (4.06)
	Z-7150-4003	Long Flat	.41" (10.41)	2.3" (58.42)	.16" (4.06)
	Z-7150-5003	Curved Long Flat	.41" (10.41)	2.28" (57.91)	.16" (4.06)
1/8" (3.2)	Z-7150-3004	Standard Flat	.41" (10.41)	1.18" (29.97)	.20" (5.08)
	Z-7170-3004	Standard Recessed	.41" (10.41)	1.20" (30.48)	.30" (7.62)
	Z-7150-4004	Long Flat	.41" (10.41)	2.18" (55.37)	.20" (5.08)
	Z-7170-3204	Long Recessed	.41" (10.41)	2.18" (55.37)	.30" (7.62)
	Z-7150-5004	Curved Long Flat	.41" (10.41)	2.22" (56.39)	.20" (5.08)
	Z-7170-3304	Curved Long Recessed	.41" (10.41)	2.22" (56.39)	.30" (7.62)
5/32" (4.0)	Z-7150-3005	Standard Flat	.48" (12.19)	1.30 (33.02)	.24" (6.10)
	Z-7170-3005	Standard Recessed	.48" (12.19)	1.32" (35.53)	.41" (10.41)
	Z-7150-4005	Long Flat	.48" (12.19)	2.30" (58.42)	.24" (6.10)
	Z-7170-3205	Long Recessed	.48" (12.19)	2.30" (58.42)	.41" (10.41)
	Z-7150-5005	Curved Long Flat	.48" (12.19)	2.23" (56.64)	.24" (6.10)
	Z-7170-3305	Curved Long Recessed	.48" (12.19)	2.23" (56.64)	.41" (10.41)
3/16" (4.8)	Z-7150-3006	Standard Flat	.56" (14.22)	1.18" (29.97)	.33" (8.38)
	Z-7170-3006	Standard Recessed	.56" (14.22)	1.20" (30.48)	.47" (11.94)
	Z-7150-4006	Long Flat	.56" (14.22)	2.30" (58.42)	.33" (8.38)
	Z-7170-3206	Long Recessed	.56"(14.22)	2.30" (58.42)	.47" (11.94)
	Z-7150-5006	Curved Long Flat	.56" (14.22)	2.21" (56.13)	.33" (8.38)
	Z-7170-3306	Curved Long Recessed	.56"(14.22)	2.21" (56.13)	.47" (11.94)

FLAT END FORM



RECCESSED END FORM



METRIC DIMENSIONS ARE IN PARENTHESIS

CONSUMABLE TOOLING - MISCELLANEOUS

REF. NO.	PART NUMBER	NOSE TYPE & FORM
1	ZRTM-IC	CURSOR
2	ZRTM-VJ	VICE JAWS
3	ZRTM-HO	HYDRAULIC OIL

CURSOR

VICE JAWS

HYDRAULIC OIL

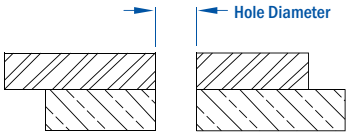
RIVETKING® FASTENER & TOOLING SELECTION

			—			/	
A	**D**	**Z**		**05**	**08**		**BA**
RIVET MATERIAL	HEAD STYLE	RIVET TYPE		NOMINAL HOLE Ø	GRIP RANGE		SURFACE FINISH
A- ALUMINUM **S-** STEEL **B-** BRASS **(F)-** STAINLESS	**D-** DOME **C-** C'SUNK **L-** LOW PROFILE **U-** UNDERSIZED	**Z-** ZIPRIV **ZS-** ZIPSHO **ZR-** ZIPSCREW		**3/32"** (2.4) **1/8"** (3.2) **5/32"** (4.0) **3/16"** (4.8)	SEE SPECIFICATION SHEET FOR ZIPRIV®, ZIPSHO®, ZIPSCREW®		**P-** PLAIN **SZ-** ZINC **BA-** BLACK ANODIZE **BZ-** BLACK ZINC **TP-** TIN

STEP 1:
Determine rivet type and rivet material preference.

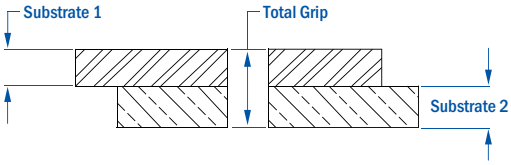
STEP 2:
Determine the closest nominal rivet diameter via your hole size. Then record the actual hole diameter in the box to the right.

SMALLEST HOLE Ø



STEP 3:
Determine rivet grip range via total grip thickness. Record the actual total grip thickness of your assembly to the right.

TOTAL GRIP

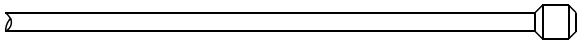


STEP 4:
Determine the rivet part number by using the chart above, and record it to the right.

RIVET PART # _ _ _ — _ _ _ _ / _ _

STEP 5:
Determine proper mandrel size by referencing the actual hole diameter to the chart. Record the mandrel Part# to the right.

MANDREL PART #

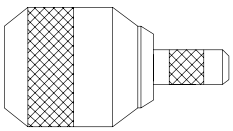


STEP 6:
Determine proper spring size by referencing the chart. Record the spring part# to the right.

SPRING PART #

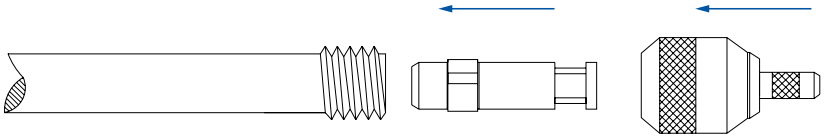
STEP 7:
Depending on the type of clinch you prefer, choose the proper Nose Jaw. If you are not sure, choose standard, flat. Record the Nose Jaw part# to the right.

NOSE JAW

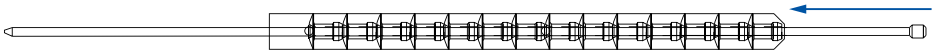


RIVETKING® SET-UP & ASSEMBLY PROCESS

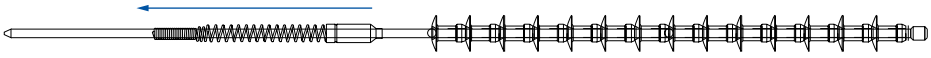
STEP 1:
Install the indexing cursor into the barrel portion of the rivet tool making sure it is facing the proper direction. Then screw on the Nose Jaw assembly on to the barrel.



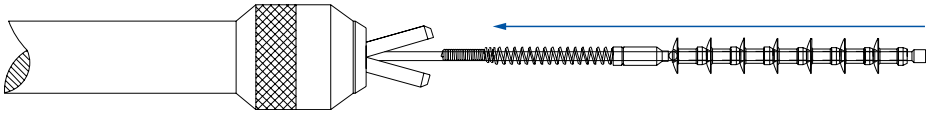
STEP 2:
Insert the mandrel into the hole of the podded rivets. Then tear off and dispose of the podding paper.



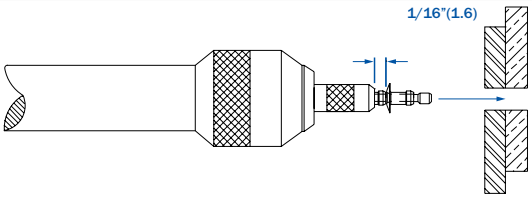
STEP 3:
Insert the mandrel spring onto the mandrel in the proper direction.



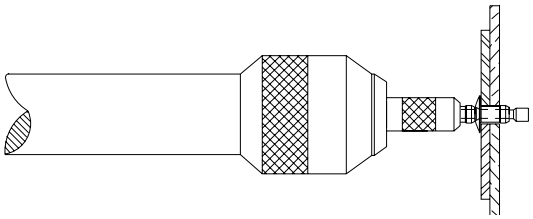
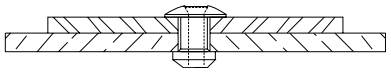
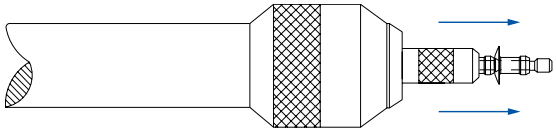
STEP 4:
Split the nose jaw open and insert the mandrel assembly (mandrel, spring and rivets), inside the nose jaw until the last rivet remains outside of the nose jaw.



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 work piece 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.