

### Introduction

This Heavy-Duty Air Riveter is suitable for most jobs using up to  $\frac{3}{16}$ " standard blind rivets, and has a maximum operating pressure of 90 PSI.



Figure 1. Model H6136.

### Inventory

- A. Heavy-Duty Air Riveter..... 1
- B.  $\frac{1}{4}$ " NPT Air Fitting..... 1
- C. Mandrel Fittings  $\frac{3}{32}$ ",  $\frac{1}{8}$ ",  $\frac{5}{32}$ ",  $\frac{3}{16}$ " ..... 1 ea
- D. Spare Riveter Jaws ..... 3
- E. Spent Mandrel Collection Cup ..... 3
- F. Special Box Wrench 12/15/24mm..... 1
- G. Special Wrench 14/16mm ..... 1

### Setup

Ensure that the setup for the line from your air compressor to your riveter matches **Figure 2**. If you do not have an in-line lubricator, we recommend putting 3-4 drops of light oil directly into the air fitting before each round of use.

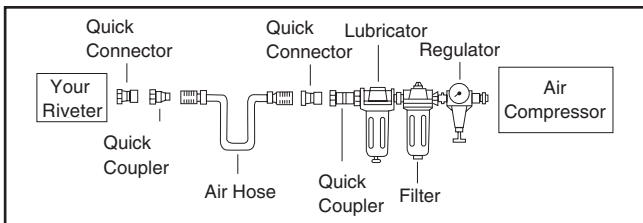


Figure 2. Installing your riveter.

### ⚠ WARNING

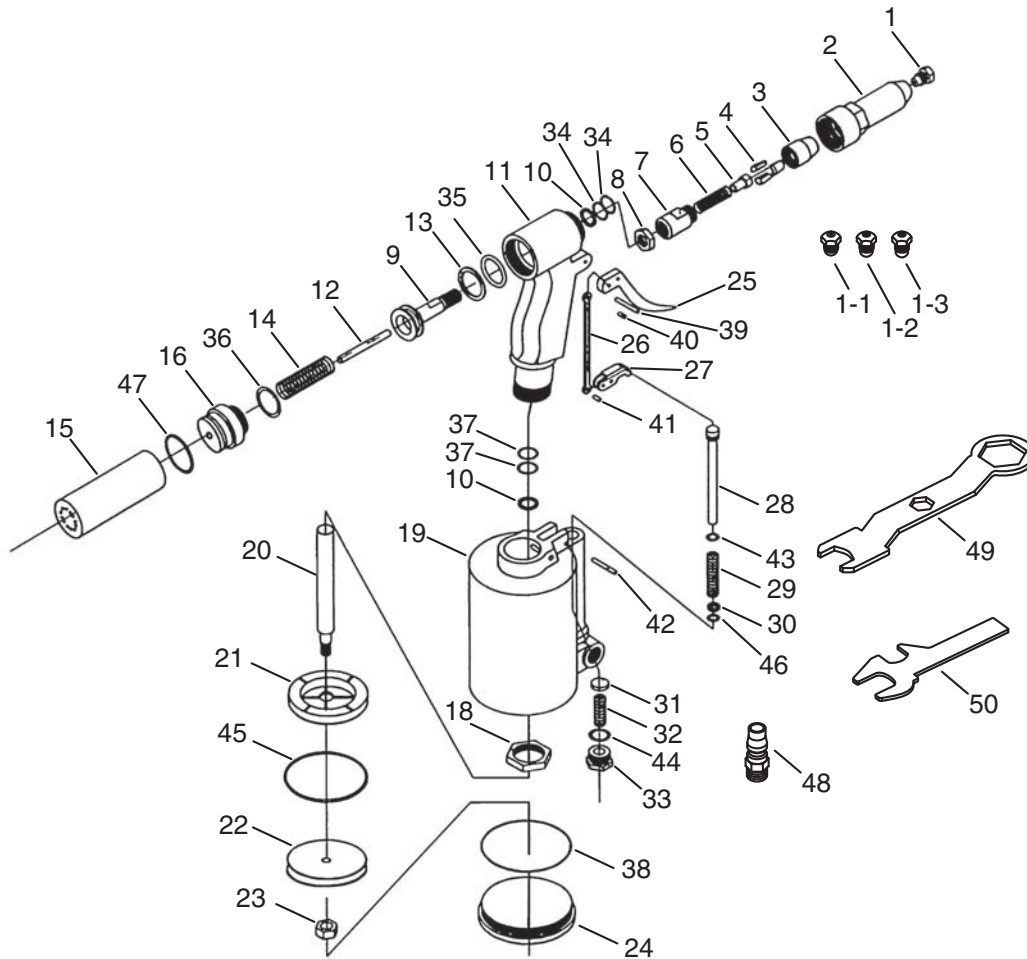
	<p><b>EYE/EAR INJURY HAZARD!</b> Always wear safety glasses and hearing protection during use of this tool!</p>
	<p><b>INJURY HAZARD!</b> Always disconnect tool from air before any service procedures!</p>
	<p><b>EXPLOSION HAZARD!</b> Exceeding the maximum operating pressure may cause the riveter to explode! DO NOT exceed 90 PSI, or serious injury and property damage may result!</p>

### Operation

1. Fit the mandrel cup over the O-ring located at the rear of the riveter.
2. Using the provided wrench, install the appropriate size mandrel fitting at the front of your riveter.
3. Insert the mandrel end of the rivet into the riveter.
4. With both workpiece sections secured, guide the rivet head into the predrilled rivet hole.
5. Squeeze the riveter trigger to set the rivet. Continue squeezing until the rivet mandrel snaps.
6. Tip the riveter nose-up until the spent mandrel falls into the mandrel cup. Empty the mandrel cup when full.

*If you need help with your new air riveter, call our Tech Support at: (570) 546-9663.*

# H6136 Parts Breakdown and List



REF	PART #	DESCRIPTION
1	PH6136001	MANDREL FITTING 1/8"
1-1	PH6136001-1	MANDREL FITTING 3/32"
1-2	PH6136001-2	MANDREL FITTING 5/32"
1-3	PH6136001-3	MANDREL FITTING 3/16"
2	PH6136002	BARREL
3	PH6136003	CHUCK
4	PH6136004	CHUCK JAW
5	PH6136005	JAW PUSHER
6	PH6136006	COMPRESSION SPRING
7	PH6136007	CHUCK JAW COLLET
8	PH6136008	HEX NUT
9	PH6136009	PISTON
10	PH6136010	PLASTIC O-RING
11	PH6136011	RIVETER BODY
12	PH6136012	PISTON ROD
13	PH6136013	PLASTIC O-RING
14	PH6136014	COMPRESSION SPRING
15	PH6136015	MANDREL CUP
16	PH6136016	END CAP
18	PH6136018	HEX NUT
19	PH6136019	CYLINDER BODY
20	PH6136020	PISTON ROD
21	PH6136021	PISTON CUSHION
22	PH6136022	PISTON FACE
23	PH6136023	HEX NUT
24	PH6136024	CYLINDER END CAP

REF	PART #	DESCRIPTION
25	PH6136025	TRIGGER
26	PH6136026	TRIGGER ROD
27	PH6136027	VALVE LEVER
28	PH6136028	VALVE ROD
29	PH6136029	COMPRESSION SPRING
30	PH6136030	FLAT WASHER
31	PH6136031	VALVE CAP
32	PH6136032	COMPRESSION SPRING
33	PH6136033	VALVE END CAP
34	PH6136034	O-RING
35	PH6136035	O-RING
36	PH6136036	O-RING
37	PH6136037	O-RING
38	PH6136038	O-RING
39	PH6136039	ROLL PIN 22 X 3.5
40	PH6136040	ROLL PIN 6 X 3.5
41	PH6136041	ROLL PIN 6 x 3.5
42	PH6136042	ROLL PIN 18 x 3
43	PH6136043	O-RING
44	PH6136044	O-RING
45	PH6136045	O-RING
46	PH6136046	O-RING
47	PH6136047	O-RING
48	PH6136048	1/4" NPT AIR FITTING
49	PH6136049	SPECIAL WRENCH 12/15/24MM
50	PH6136050	SPECIAL WRENCH 14/16MM