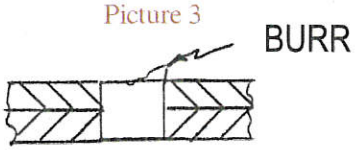
3. BURR ON THE HOLE

Picture 3



The hole in your work piece must be free of burrs. Burrs are caused by using drill bits that are not sharp and by forcing the drill too fast through the work piece. The burr is always on the upset side of the set blind rivet. When you set a blind rivet in a work piece that has a burr, the upset side of the blind rivet will press against the burr and the burr will cut into the upset of the rivet barrel. This burr will cut and crack the rivet upset and reduce the clamp locking pressure of the fastened work piece. This condition gives a weak fastened assembly.

Solution: Rivet holes should be free of burrs.

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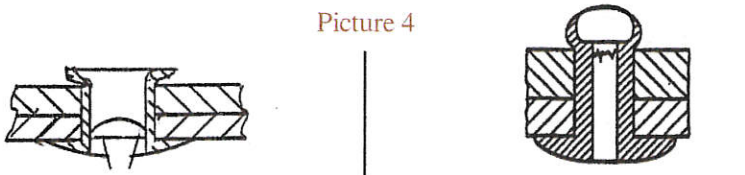
4. RIVET HOLE TOO LARGE

Picture 4



Blind rivet manufacturers list in their blind rivet catalogs the minimum and maximum hole diameters for all their sizes of blind rivets. When a blind rivet is set in a hole that is larger than the recommended hole diameter, the mandrel head will travel the complete length of the blind rivet body and come to rest at the flange of the rivet. This condition offers the following problems:

1. Mandrel head does not clamp the upset side of the rivet to the work piece.
2. Reduced clamping of the work pieces.
3. Mandrel head burr will extend outside of the flange giving a dangerous cutting edge to someone's hands.

Solution: Never have rivet holes diameters larger than what is recommended by the manufacturer.

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5. SETTING TOOL HELD AT AN ANGLE

Setting tools should be held approximately at a right angle to the work piece. The hole that the blind rivet is in, is at right angle in the work piece. When the blind rivet is in the hole to be set and the setting tool is at an angle, the mandrel of the blind rivet is then bent and when the blind rivet is set, the mandrel will bend even further. After the blind rivet is set, the setting tool then tries to eject the mandrel from the rear of the tool. In many cases the bent mandrel will not pass through the tool to eject and the setting tool now has to be serviced to clear the jammed bent spent mandrel.

Solution: Hold the setting tool as near as possible at a right angle to the work pieces.

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6. TOOL NOT SETTING THE BLIND RIVET IN ONE STROKE

When a blind rivet is set in a hole that is the recommended diameter and at the specified work thickness, the setting tool will set the blind rivet in one stroke. If, for whatever reason it is necessary to take more than one stroke, the setting tool needs service. When a setting tool strokes more than one time when setting a blind rivet, the setting tool pulling jaws teeth penetrate the mandrel in many places and can cause the mandrel to break where the jaws are gripping the mandrel rather at the designed break point below the mandrel head and you will have a long length of mandrel protruding from the set blind rivet.

Solution: Be sure that your setting tool is serviced with hydraulic fluid and have the recommended compress air pressure. ■