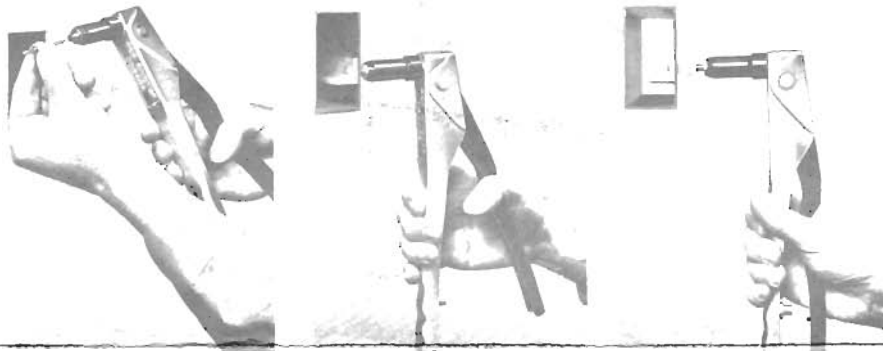


# OPERATING INSTRUCTIONS

## PRG 402 H.D.

### Heavy Duty Hand "POP"® Riveter



Place mandrel of rivet in nosepiece of tool with handles open.

Insert rivet in predrilled hole and squeeze handles until mandrel breaks.

Result . . . a permanent, vibration proof assembly-rivet is installed and set from same side.

- 1 Open handle completely. Insert rivet mandrel into nosepiece until rivet head is in contact with face of nosepiece.
- 2 Close handle lightly until contact is made between rivet mandrel and Riveter jaw. At this point using Riveter as a guide, insert rivet into hole of unit to be riveted.
- 3 Note bottom face of rivet head and outer surface of unit to be riveted **MUST** be in contact at this time.
- 4 Squeeze movable handle down until rivet is set.
- 5 Open handles to their extremes and expendable rivet mandrel will eject at back of nose section.
- 6 If two strokes are necessary to set the rivet, the movable handle must be reopened completely, and the Riveter moved down so that the nosepiece is again in contact with the head of the rivet.
- 7 Now squeeze movable handle down and rivet should set.

#### Installing Handle Return Spring

Open tool. Push Spring PRG402-102, coiled section, toward front of tool. Legs of spring should rest against staked section of handle and support.

**NOTE: Do not install spring onto Fulcrum Pin PRP-40.**

#### TO CHANGE OR CLEAN JAWS

- 1 Remove Nosepiece Housing PRG 402-11 along with nosepiece.
  - (A) Remove Jaw Guide PRH 820-11A, Jaws PRG 402-8A and Jaw Pusher PRG 520-33.
  - (B) Clean Jaw Guide and Jaw Pusher. Clean serrations in Jaws with wire brush. Install new Jaws if needed.
  - (C) Apply a light oil to Jaw Guide and Jaw Pusher. Put a light grease on the tapered faces of the Jaws.

**NOTE: Do not allow any grease to get on the serration of the Jaws since this will hinder ejection of spent mandrel.**

- 2 Reassemble and stroke tool a few times to check operation before using.
  - (A) Make sure Nosepiece Housing PRG 402-11 and nosepiece are securely fastened.



**PRG 402 H.D. WILL SET ONLY THE "POP" RIVETS LISTED IN THIS CHART**

RIVET	MANDREL	3/32	7/64	1/8	5/32	3/16
<b>OPEN END RIVETS</b>						
alum.	alum.	•		•	•	•
alum.	steel	•		•	•	•
steel	steel	•		•	•	
monel	steel		•	•	•	
stainless	stainless			•		
<b>CLOSED END RIVETS</b>						
alum.	alum.			•	•	•
alum.	steel			•	•	



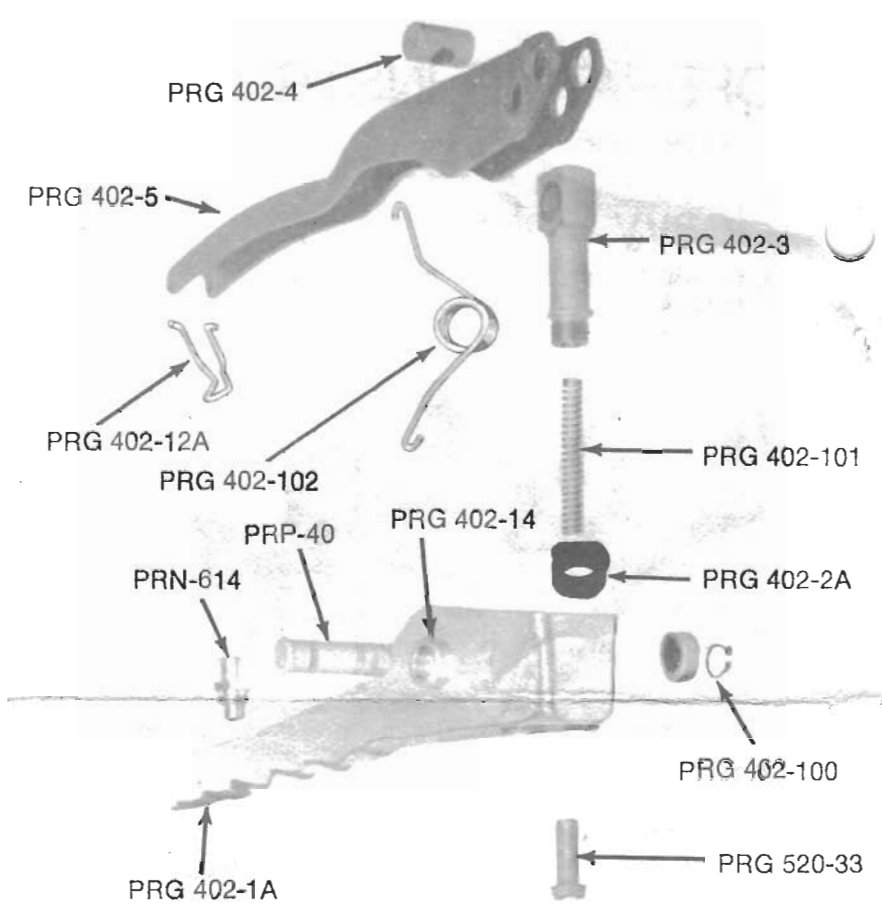
**USM Corporation**  
"POP" Rivet Division

Shelton, Connecticut 06484

Phone (203) 735-9341 • TWX 710-451-3734

## TO DISASSEMBLE THE TOOL

- (1) Remove Nosepiece Housing, Jaw Guide, Jaws and Jaw Pusher as outlined on reverse side along with Jaw Pusher Spring PRG 402-101.
  - (A) Remove Fulcrum Pin Retainer PRG 402-100.
  - (B) Remove Fulcrum Pin PRP-40 being careful not to lose the two Bushings PRG 402-14.
  - (C) Remove Handle PRG 402-5 along with Pulling Head PRG 402-3.
  - (D) Push out Pulling Head Fulcrum PRG 402-4.
  - (E) Reassemble in reverse order, making sure Jaw Pusher Spring is inserted in hole in Pulling Head Fulcrum PRG 402-4 to allow for rear ejection of mandrel.



## SPARE PARTS LIST

### Model PRG 402 H.D. Heavy Duty Hand "POP" Riveter

PART NO. *	DESCRIPTION	PART NO.	DESCRIPTION
PRG 402-1A	Riveter Support	PRN-614	Nosepiece 3/16" Open End
PRG 402-2A	Nosepiece Housing Insert	PRN-424*	Nosepiece 1/8" Closed End Aluminum Rivet with Steel Mandrel
PRG 402-3	Pulling Head	PRN-524*	Nosepiece 5/32" Closed End Aluminum Rivet with Steel Mandrel
PRG 402-4	Pulling Head Fulcrum	PRN-434*	Nosepiece 1/8" Closed End Aluminum Rivet with Aluminum Mandrel
PRG 402-5	Handle	PRN-534*	Nosepiece 5/32" Closed End Aluminum Rivet with Aluminum Mandrel
PRG 402-7†	Jaw Guide—Small	PRN-634*	Nosepiece 3/16" Closed End Aluminum Rivet with Aluminum Mandrel
PRG 402-8A	Jaws	PRG402-100	Fulcrum Pin Retainer
PRG 402-10†	Nosepiece Housing—Small	PRP-40	Fulcrum Pin
PRG 402-11	Nosepiece Housing—Large	PRG402-101	Jaw Pusher Spring
PRG 402-12A	Handle Latch	PRG402-102	Handle Return Spring
PRG 402-14	Bushing		
PRG 520-33	Jaw Pusher		
PRH 820-11A	Jaw Guide—Large		
PRN-314*	Nosepiece 3/32" Open End		
PRN-414	Nosepiece 7/64" & 1/8" Open End		
PRN-514*	Nosepiece 5/32" Open End		

\*Not sent unless ordered separately.

†For use in restricted area applications as a unit and not individually.