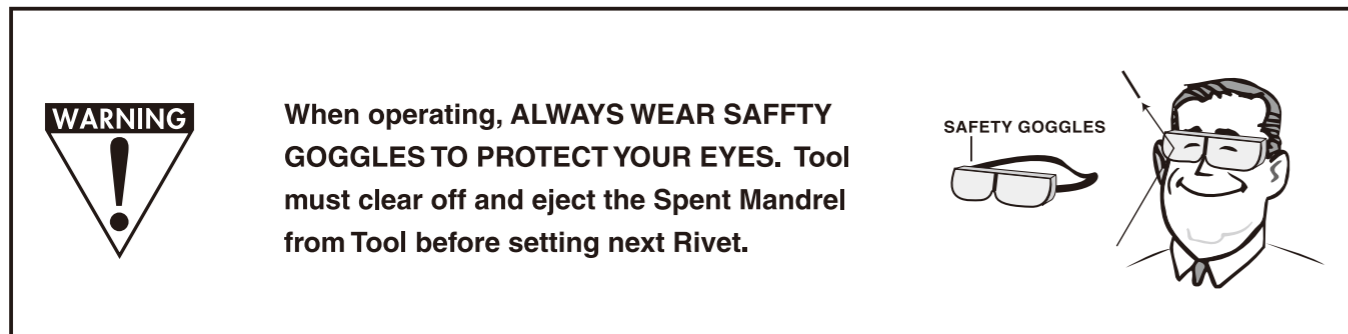


E. REASSEMBLY: NOTE: ALWAYS CHECK Fig. E CAREFULLY TO REASSEMBLE.

- 1) Position Rack Bearing Plate (9) through the rear of Aluminum Body (1) into the slot, then push Gear Rack (8) forward into the front of Aluminum Body (1).
- 2) Position the first tooth of Gear Sector (10) engaged with the first tooth of Gear Rack (8) <NOTE: Can use a screwdriver to adjust Gear Sector (10) position.>, the hole of Gear Sector (10) should align with the front Pivot Pin hole of Aluminum Body (1). When assembled correctly, the wider section (W) of Gear Sector (10) should face down to Lower Handle (12) position.
- 3) Swing Upper Handle (11) to the front and to position the first tooth of Driving Gear (11) engaged with the first tooth of Gear Sector (10) <NOTE: Can use a screwdriver to adjust Gear Sector (10) position.>, the hole of Driving Gear (11) should align with the rear Pivot Pin hole, install the second Pivot Pin (17) with Pivot Pin Washer (16) and Snap Ring (15) to the rear Pivot Pin hole of Aluminum Body (1).
- 4) Reassemble Jaws (5), Jaw Pusher (6) and Jaw Pusher Spring (7) back into Collet Cases (4), then screw Collet Cases (4) back to Gear Rack (8) firmly.
- 5) Reassemble Head (3) back to Aluminum Body (1) firmly.

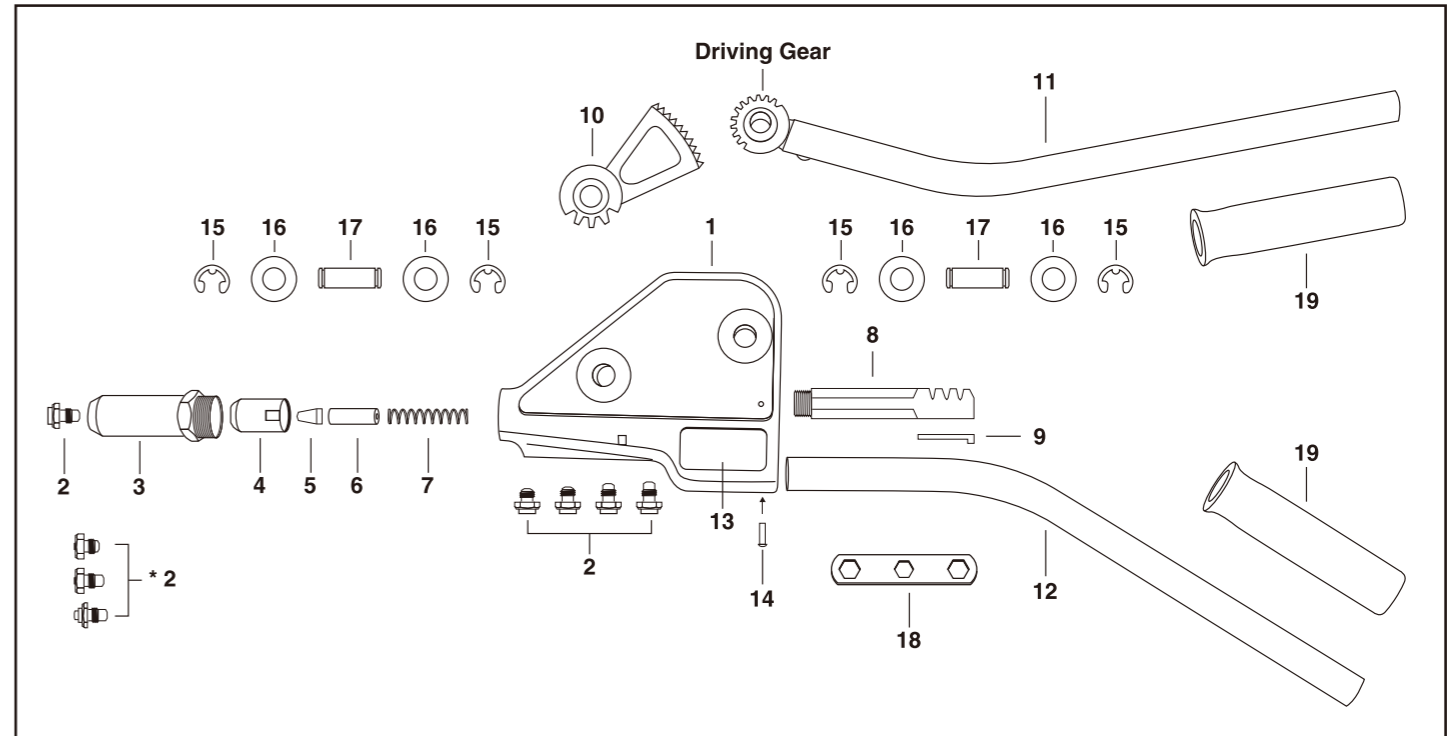
F. TROUBLE SHOOTING GUIDE:

- 1) PROBLEM - Rivet Mandrel can not be inserted into Working Nosepiece (2) or Spent Mandrel can not be ejected after setting.
 CAUSE 1 - Handles (11, 12) are not fully opened.
 CORRECTION 1 - Open Handles (11, 12) fully.
 CAUSE 2 - Working Nosepiece (2) is loose.
 CORRECTION 2 - Tighten Working Nosepiece (2) with service Wrench (18).
- 2) PROBLEM - Rivet Mandrel is not gripped or Tool requires more operations than normal to set Rivet.
 CAUSE 1 - Jaws (5) are dirty, worn or broken.
 CORRECTION 1 - Clean or replace Jaws (5).
 CAUSE 2 - Working Nosepiece (2) is loose.
 CORRECTION 2 - Tighten Working Nosepiece (2) with service Wrench (18).



RIVET KING RK-93 Professional & Heavy Duty Gear Type Riveting Tool

■ PARTS LIST



No.	Part No.	Part Name
1	RK93-01	Aluminum Body
● 2-32	RK93-0232	Nosepiece, for \varnothing 3.0/3.2 mm or 1/8" Rivet
● 2-40	RK93-0240	Nosepiece, for \varnothing 4.0 mm or 5/32" Rivet
● 2-48	RK93-0248	Nosepiece, for \varnothing 4.8/5.0 mm or 3/16" Rivet
● 2-60	RK93-0260	Nosepiece, for \varnothing 6.0 mm
● 2-64	RK93-0264	Nosepiece, for \varnothing 6.4 mm or 1/4" Rivet
● 2-48M	RK93-0248M	Nosepiece, for \varnothing 4.8/5.0 mm or 3/16" *Monobolt Rivet
● 2-64M	RK93-0264M	Nosepiece, for \varnothing 6.4 mm or 1/4" *Monobolt Rivet
● 2-64T	RK93-0264T	Nosepiece, for \varnothing 6.4 mm or 1/4" *T Rivet
3	RK93-03	Head, Standard
4	RK93-04	Collet Case

No.	Part No.	Part Name
● 5	RK93-05	Jaws, 3-pc Type
● 6	RK93-06	Jaw Pusher
● 7	RK93-07	Jaw Pusher Spring
8	RK93-08	Gear Rack
● 9	RK93-09	Rack Bearing Plate
10	RK93-10	Gear Sector
11	RK93-11	Driving Gear & Upper Handle Assembly
12	RK93-12	Lower Handle
13	RK93-13	Name Plate
14	RK93-14	Drive Pin
● 15	RK93-15	Snap Ring
● 16	RK93-16	Pivot Pin Washer
17	RK93-17	Pivot Pin
● 18	RK93-18	Wrench, W-3
● 19	RK93-19	Grip

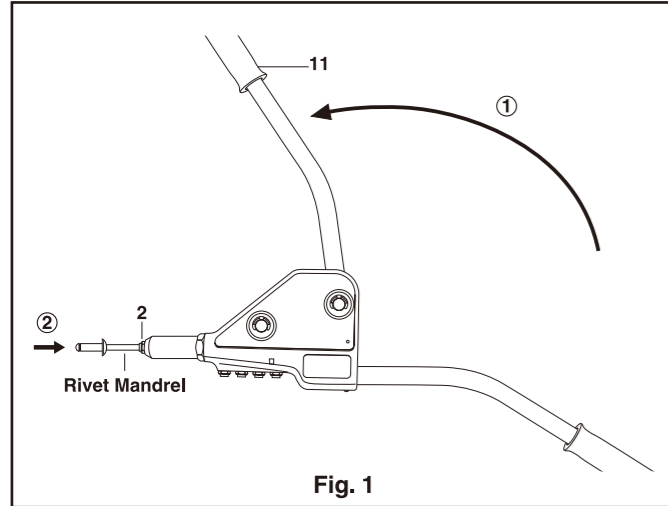
■ REMARKS:

- 1) ● means Wearing Parts or Possible Missing Parts.
- 2) RK-93 Riveting Tool can set \varnothing 4.8 mm (3/16") & \varnothing 6.4 mm (1/4") *Monobolt Rivets and \varnothing 6.4 mm (1/4") *T Rivet.
- 3) RK-93 Riveting Tool may install various Nosepieces for different applications on request.
- 4) RK-93 Riveting Tool can be packed in a Steel Carry Case on request.
- 5) *Monobolt Rivet and *T Rivet are the registered trademark of Cherry, Textron, Inc.

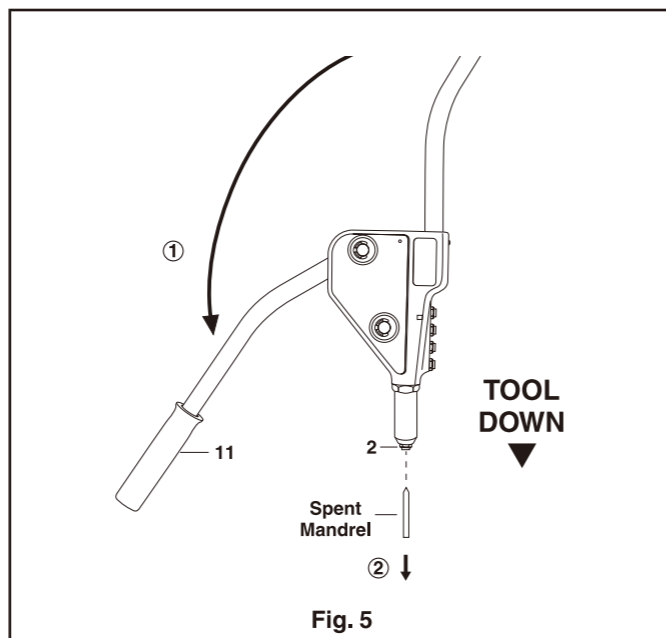
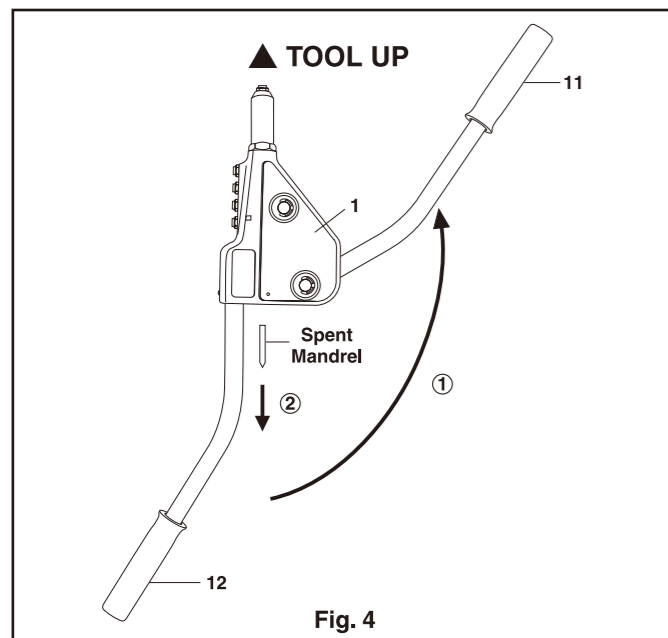
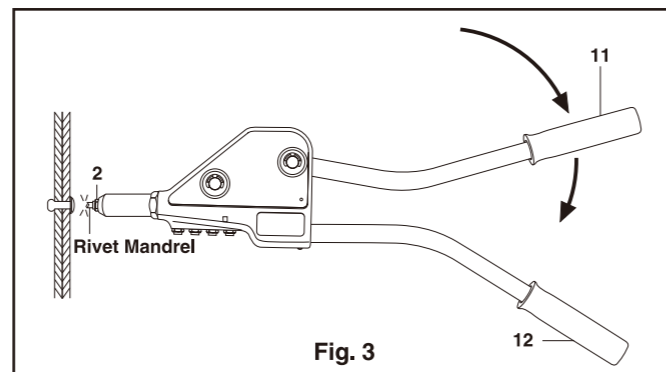
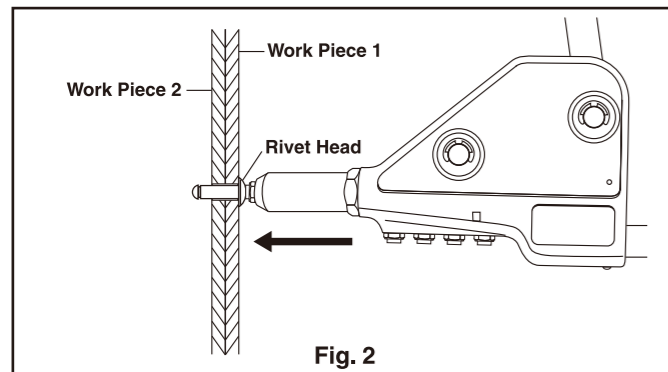
A. FEATURES:

RIVET KING RK-93 Heavy-Duty Rivet Tool has advanced Gear & Lever Dual System offering powerful riveting capacity, 3-Jaw System provides not only stronger riveting power but also Rivet Mandrel easy loading and Spent Mandrel easy ejection. Powerful riveting capacity can set 3.0/3.2, 4.0, 4.8/5.0, 6.0, 6.4 mm or 1/8", 5/32", 3/16", 1/4" diameter Blind Rivets in all materials (Aluminum, Steel, Copper, Stainless Steel/Inox), also can set 4.8/5.0 & 6.4 mm or 3/16" & 1/4" diameter *Monobolt rivets and set 6.4 mm or 1/4" diameter *T-Rivet. Quick-Maintain Head is easy to clean or replace Jaws, Jaw Pusher and Jaw Pusher Spring. No adjustment is required after reassembling the parts.

B. HOW TO OPERATE GR-1 TOOL TO SET BLIND RIVET:

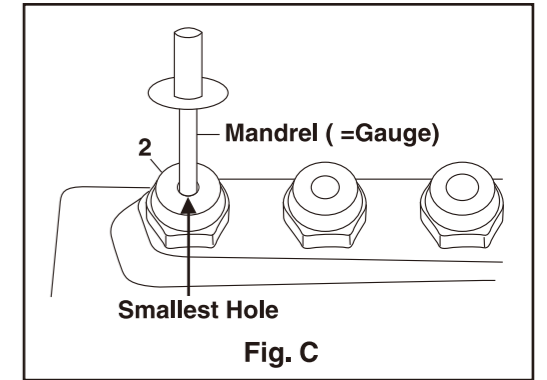


- 1) Open Upper Handle (11) fully and insert Rivet Mandrel all the way into Working Nosepiece (2) (Fig. 1).
- 2) Hold Rivet Mandrel in the Tool, insert Rivet Body into the prepared hole of work pieces to be fastened, and press Blind Rivet firmly to assure the Rivet Head is in contact with the work piece (Fig. 2).
- 3) Squeeze Upper Handle (11) toward Lower Handle (12) until Rivet Mandrel breaks off (Fig. 3). If more than one squeeze is required to break off Rivet Mandrel, open Upper Handle (11) fully, push Working Nosepiece (2) to contact Rivet Head and squeeze Upper Handle (11) again.
- 4) Open Upper Handle (11) fully and tilt Tool up to eject the Spent Mandrel from the rear of Aluminum Body (1) (Fig. 4), or open Upper Handle (11) fully and tilt Tool down to eject the Spent Mandrel from the Working Nosepiece (2) (Fig. 5).



C. HOW TO SELECT AND CHANGE NOSEPIECES (2):

- 1) Use the Mandrel of Blind Rivet to be applied as a Gauge, select the Working Nosepiece (2) with the smallest hole that Mandrel can insert into easily (Fig. C).
- 2) Close Tool Handles (11, 12) completely. **CAUTION:** If Tool Handles (11, 12) are not completely closed before loosening the Working Nosepiece (2) installed in Head (3), the Working Nosepiece (2) may be forcibly ejected by the Jaw Pusher Spring (7). **Do Not point Tool at anyone when changing Nosepieces!**
- 3) Remove Working Nosepiece (2) from Head (3) and store it into Aluminum Body (1) with service Wrench (18).
- 4) Install and tighten the selected Working Nosepiece (2) to Head (3) with service Wrench (18).



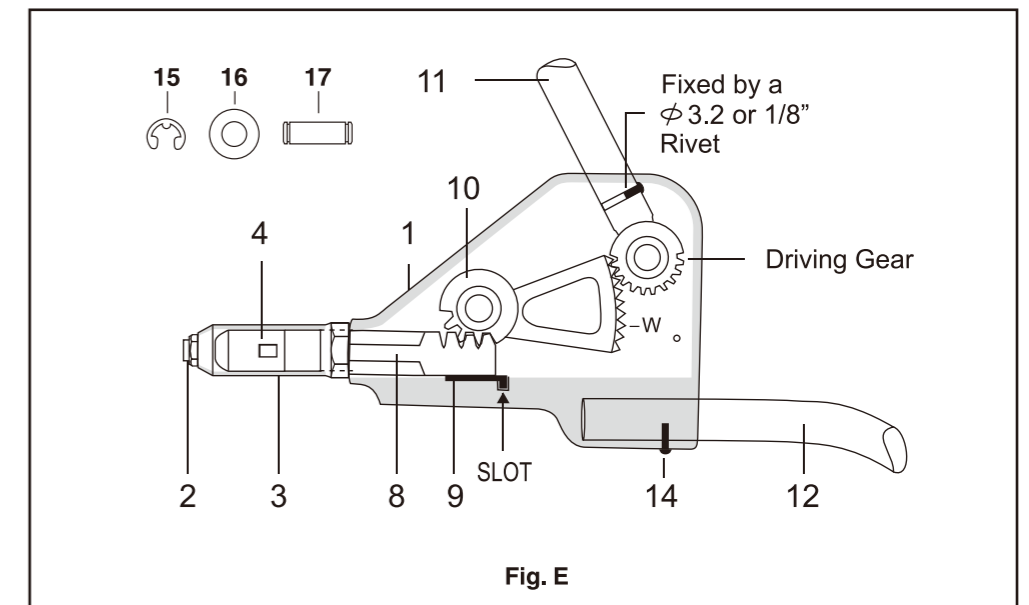
D. HOW TO CLEAN AND REPLACE JAWS (5), JAW PUSHER (6) AND JAW PUSHER SPRING (7):

NOTE: If Jaws (5) can not bite or slip on the Rivet Mandrel, it is suggested to clean teeth of Jaws or replace new Jaws (5). When Tool Handles (11, 12) are fully opened, but Jaws (5) are still not open completely, it is suggested to check and replace new Jaw Pusher (6), Jaw Pusher Spring (7) and Nosepiece (2).

- 1) Close Tool Handles (11, 12) completely.
- 2) Remove Head (3) from Aluminum Body (1).
- 3) Remove Collet Case (4), take out Jaws (5), Jaw Pusher (6) and Jaw Pusher Spring (7) from Collet Case (4) and Gear Rack (8). Clean teeth of Jaws with a wire brush, inspect Jaws for worn or broken teeth. Replace new Jaws (5), Jaw Pusher (6) and Jaw Pusher Spring (7) if needed.
- 4) Lubricate outside surface of Jaws (5) and inside surface of Collet Case (4) with a film of light machine oil. Reverse above steps to reassemble, making sure Collet Case (4) and Head (3) are tightened firmly.

E. HOW TO REPLACE GEAR RACK (8), RACK BEARING PLATE (9), GEAR SECTOR (10), AND DRIVING GEAR & UPPER HANDLE ASSEMBLY (11):

NOTE: Carefully check the Fig. E and follow instructions, otherwise damage might be caused to the Tool.



E. A DISASSEMBLY:

- 1) Remove Head (3).
- 2) Remove Collet Cases (4), take out Jaws (5), Jaw Pusher (6) and Jaw Pusher Spring (7).
- 3) Remove the rear Snap Ring (15) and rear Pivot Pin Washer (16) from one side of Aluminum Body (1), then press out rear Pivot Pin (17). Now the Driving Gear & Upper Handle Assembly (11) can be removed.
- 4) Remove front Snap Ring (15) and front Pivot Pin Washer (16) from one side of Aluminum Body (1), then press out front Pivot Pin (17). Now the Gear Sector (10), Gear Rack (8) and Rack Bearing Plate (9) can be removed from the rear of Aluminum Body (1). Replace the worn or broken Part(s).

