



# **Riv Nut Recess**

## **Dimple Dies**

**RIV NUT RECESS DIMPLE DIES ARE DESIGNED TO MAKE THE SHOULDER OF A RIV NUT (NUT ZERT) FLUSH WITH THE SURFACE OF YOUR SHEET METAL PANEL. THIS ALLOWS A PANEL TO BE STACKED ON TOP WITHOUT THE RIV NUT INTERFERING WITH THE PANEL.**

### **TO INSTALL:**

- 1) PUNCH OR DRILL A 1/4" HOLE WHERE YOU WANT TO INSTALL THE RIV NUT,**
- 2) INSERT THE MALE DIE OVER THE 1/4-20 SHAFT OF OUR HF-D100 HYDRAULIC INSTALLATION TOOL (OR USE A 1/4-20 BOLT, NOT PROVIDED)**
- 3) INSERT 1/4-20 THREADED STUD THROUGH 1/4" HOLE IN PANEL,**
- 4) INSTALL THE FEMALE DIMPLE DIE ON THE BACK SIDE OF PANEL BY THREADING IT ON TO STUD,**
- 5) PUMP THE HF-D100 UNTIL THE DIMPLE IS COMPLETELY INSTALLED (DON'T OVER PUMP IT! THIS COULD BREAK THE MANDREL OR BLOW OUT THE SEAL IN THE TOOL)**
- 6) PRESS THE RELEASE BUTTON ON THE HF-D100,**
- 7) REMOVE FEMALE DIMPLE DIE, AND STUD FROM PANEL.**
- 8) NOW DRILL OUT THE 1/4" HOLE IN YOUR PANEL TO THE PROPER SIZE ACCORDING TO YOU SIZE RIV NUT YOU NEED TO INSTALL.**
- 9) NEXT, INSTALL THE RIV NUT USING THE PROPER MANDREL FOR THE HF-D100. PUMP UNTIL RIV NUT IS COMPLETELY INSTALLED AND THEN PRESS THE RELEASE BUTTON ON THE HF-D100. UNTHREAD THE MANDREL FROM THE INSTALLED RIV NUT AND REPEAT THIS PROCESS FOR THE NEXT RIV NUT.**

**THESE DIMPLE DIES ARE CNC MACHINED FROM 4140 STEEL AND ARE RATED FOR UP TO 16GA MILD STEEL OR 18GA STAINLESS STEEL. MADE IN TEXAS!**

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