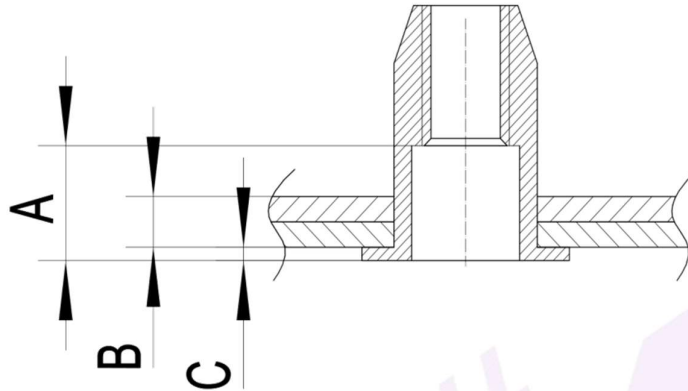


# BASIC SET-UP FOR THE DNP3212-2 RIVNUT TOOL – A ROUGH GUIDE

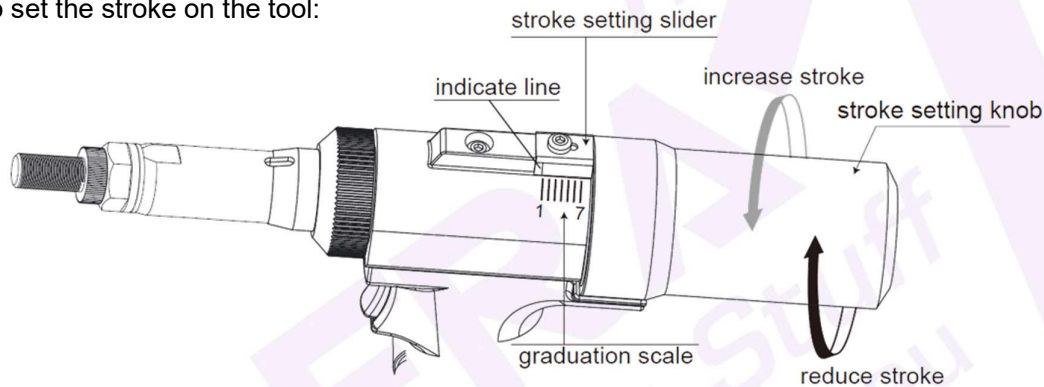
## STROKE SETTING

- 1) It is very important step to define the stroke to be set on the tool, by measuring the rivnut and calculating in formula:  $Stroke = A - (B + C)$

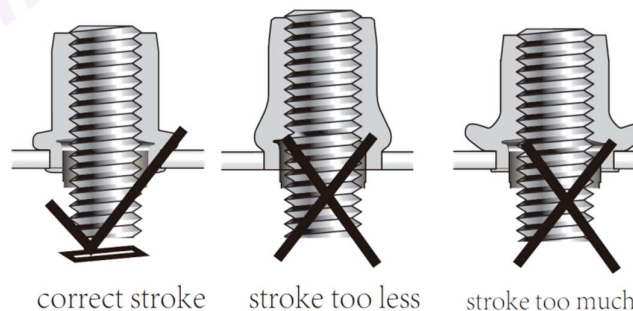


A = depth of the rivnut (inside of the rivnut non-threaded and no upset part of the rivnut when setting);  
B = total thickness of work piece(s);  
C = rivnut head thickness (if countersunk head rivnut, then C = 0);

- 2) To set the stroke on the tool:



- a) The tool stroke can be set from 1mm up to 7mm, and it shows by the indicate line pointing on to the graduation scale precisely;
  - b) To increase the stroke: slide the *stroke setting slider* in the direction of the tool front (*cap screw*), turning the *stroke setting knob* anti-clock wise, release the stroke setting slider back (to be sure the small needle tip seated back into the hole on the edge of the stroke setting knob) and checking the indicate line pointing. Repeat the operation until the indicate line pointing at the defined stroke. To reduce the stroke, operate in the same way but turning the *stroke setting knob* clock-wise.
- 3) Checking the set stroke by initial rivnuts setting. It is extremely important to have precise stroke setting and trial set on work piece and refer to the illustration below to see if you got a nice set up:



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