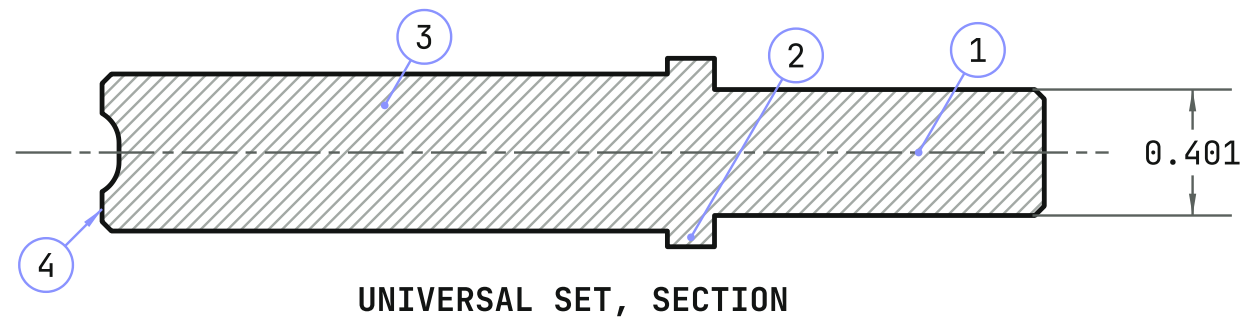
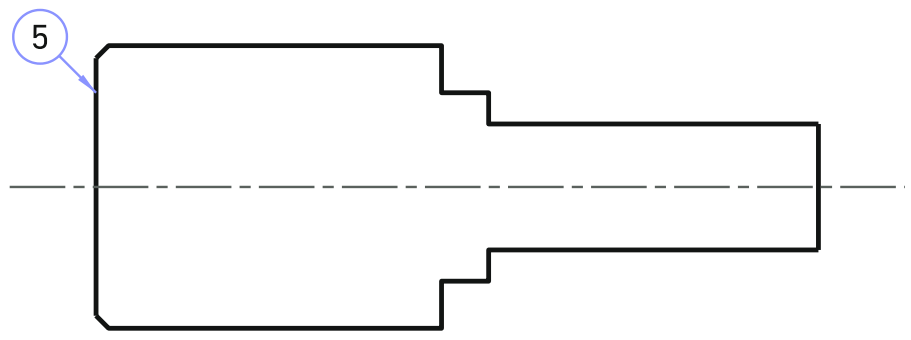
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Rivet Sets: Universal, Flush, Offset and Long Reach

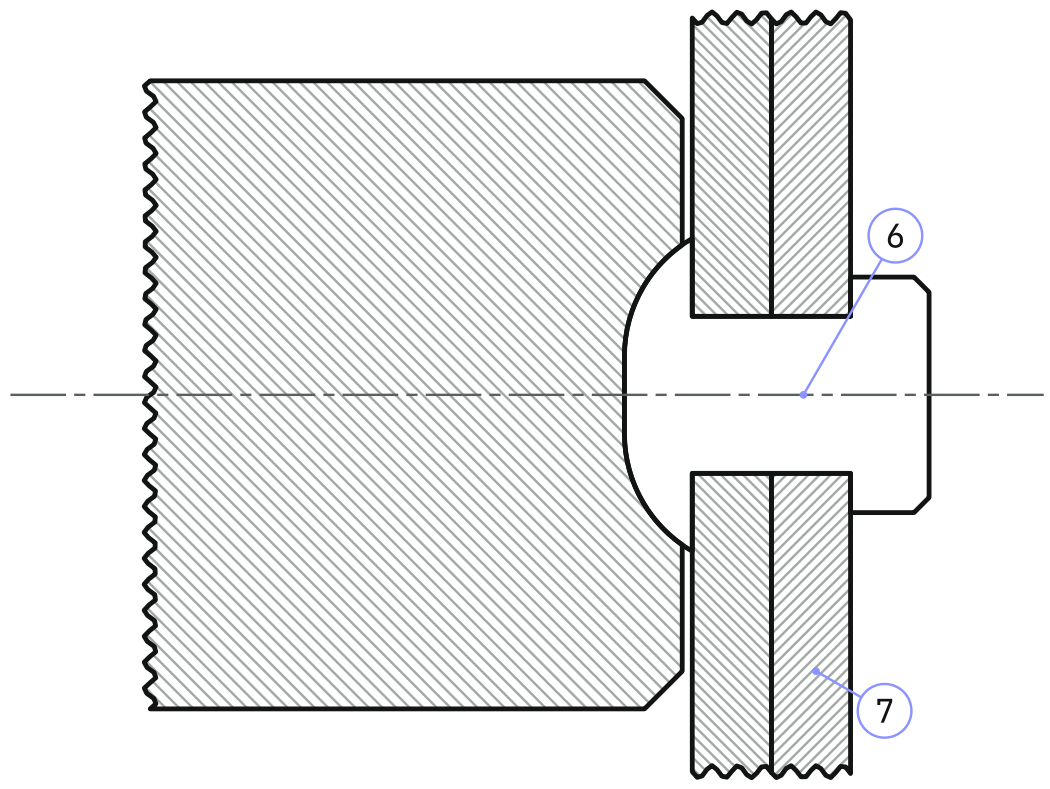
The rivet set sits in the rivet gun and passes every blow to the rivet head.



UNIVERSAL SET, SECTION
SCALE 1:1



FLUSH SET, ELEVATION
SCALE 1:1



DETAIL, FACE ON THE HEAD
SCALE 4:1

SHANK SIZE	
GUN	SHANK, IN (MM)
STANDARD	0.401 (10.2)
LARGE	0.498 (12.6)

FACE TO THE HEAD	
HEAD	SET
UNIVERSAL	CUPPED, BY SIZE
FLUSH 100°	FLAT
TIGHT ACCESS	OFFSET, LONG REACH
FACE POLISHED	

NOTES
1. FACE TO MATCH THE RIVET HEAD, POLISHED.
2. RETAINER SPRING ALWAYS FITTED.
3. NEVER FIRE THE GUN WITHOUT THE SET ON THE WORK.
4. STORE SETS IN A RACK.

ITEM	DESCRIPTION
7	SKIN, TWO SHEETS (REF)
6	RIVET, MS20470 (REF)
5	FACE, FLAT
4	FACE, CUPPED
3	BODY
2	COLLAR
1	SHANK

SET, RIVET, PNEUMATIC GUN, UNIVERSAL AND FLUSH	
SHEET 1 OF 1	
DWG TAP-TG-079	REV A
SCALE 1:1	

Types and sizes

Set	Face	Use
Universal	Cupped, by size	Universal (MS20470) heads; one set per rivet diameter.
Flush	Flat, polished	Flush 100° heads; the flat face covers the head and does not mark the skin.
Flush with guard	Flat, inside a rubber or plastic guard	Flush heads on painted or clad skin.
Offset	Cupped or flat, body bent to one side	Rivets next to a flange, a frame or a stiffener.
Long reach	Cupped or flat, long straight body	Rivets deep in a channel or behind a lip.
Shank 0.401 in (10.2 mm)	Any	Most rivet guns.
Shank 0.498 in (12.6 mm)	Any	Larger guns for larger rivets.

What to check when buying

Check	What to look for
Shank	0.401 in (10.2 mm) or 0.498 in (12.6 mm), the size of your gun barrel.
Face	Cup size marked for the rivet diameter and head style; flush faces flat and polished.
Collar	Fits the retainer spring of your gun.
Hardness	Hardened face and shank end, a tough body; no burrs or tool marks.
Length	Short sets for open work, offset and long-reach sets for the places your aircraft needs.
Storage	Sets sold with a rack or a case, so faces do not knock together.

Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.

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Accessories

Item	What it is for
Retainer spring	One per set length and shank size; keep spares.
Set rack	Keeps faces apart and sets sorted by size.
Guard for flush sets	Protects painted and clad skin.
Polishing cloth and fine abrasive	Keeps the face polished.
Wood block	To set and test the hit of the gun, never against metal.

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