



RIVET-NUT INSTALLATION

A460-8182
02/09/04
Rev. A Date: 3/11/09

This instruction sheet is supplemental to *420-A instruction sheet*, and is developed for *Unity's 8181 Rivet-Nut Installation Tool*. Read these instruction sheets carefully before proceeding with your installation.

If you choose to use your existent rivet-nut installation tool instead of *Unity's 8181 Rivet-Nut Installation Tool*, use this instruction as a reference, and follow the instructions of your existent tool to properly install the rivet-nuts.

1. Carry out Steps 1-6 described in the 420-A sheet.
2. Open two 1/8" holes to 19/64".
3. Lubricate the threads of Driving Screw before use.

4. Slide Gripper Nut onto Driving Screw with its flat end against the screw head, & its recessed end toward the screw tip (Fig. 1).
5. Install Rivet-Nut on to Driving Screw and engage all threads by using your fingers until head of Rivet-Nut is tight against the recessed end of Gripper Nut.
Please make sure that Rivet Nut is engaged with the recessed end of Gripper Nut.

6. Place Rivet-Nut along with the tool into the 19/64" hole.
7. With a box wrench holding Gripper Nut stationary and at right angle to the vehicle-mounting surface, turn Driving Screw clockwise with another box wrench.
8. Continue to turn the screw until firm resistance is felt, indicating that the rivet-nut is compressed to the sheet metal (see Fig. 2, about 6 to 7 complete turns are required).

9. While still holding Gripper Nut stationary, turn Driving Screw counter clockwise to remove the tool from the installed rivet-nut.
10. Return to Step 7 in the 420-A sheet and complete the rest of the installation steps.

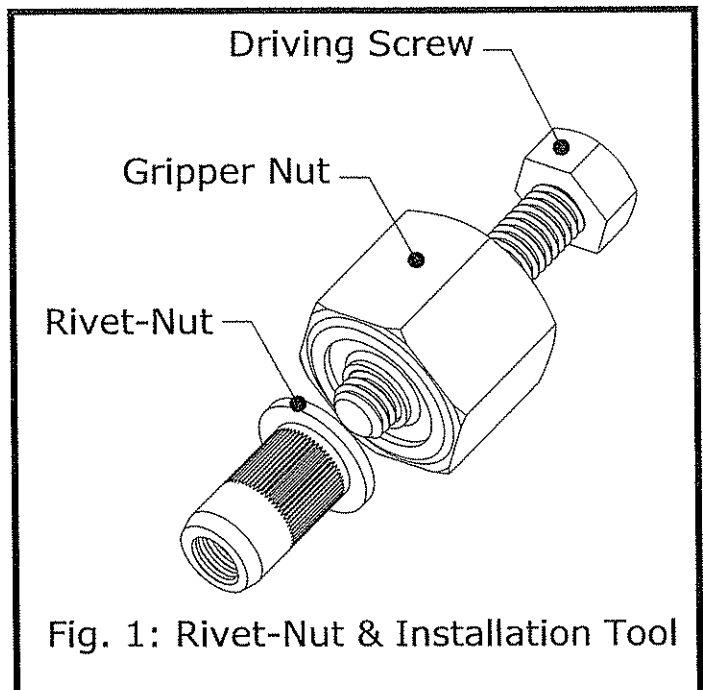


Fig. 1: Rivet-Nut & Installation Tool

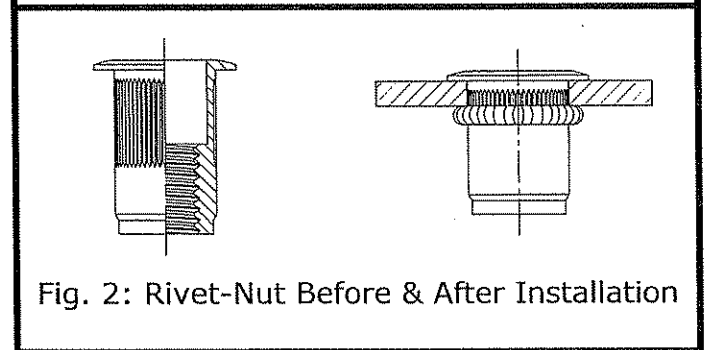


Fig. 2: Rivet-Nut Before & After Installation