

Holes & Rivets

Diameter	3	4	5	6	
Width (fract)	3 / 32	1 / 8	5 / 32	3 / 16	
Width (inch)	0,09375	0,125	0,15625	0,1875	
Width (mm)	2,38125	3,175	3,96875	4,7625	
Drill	#40	#30	#20	#10	#8
Cleco	Silver	Copper	Black	Gold	
Squeeze (bar)	2,4	2,8	4,1		

Rivet Style

Format	AN MS	426 470	AD	Diameter	Length
Description		Head style 426 Flush 470 Universal	Alloy type	in 1 / 32 set x 1,5	in 1 / 16 fit x 1,5 set x 0,5
Example	AN	426	AD	4	4

Compressor

Task	Drill	Squeeze	Rivet	Paint	
Pressure (bar)	3,1	6,2	3,1	1,8	
Pressure (psi)	45	90	45	28	

Torque

AN Size	Inch.Pounds	Foot.Pounds	Nm	Kg (12.3 cm)
AN3	20 – 25	1.6 – 2.0	2.3 – 2.8	1.9 – 2.4
AN4	50 – 70	4.2 – 5.8	5.6 – 7.9	4.8 – 6.7
AN5	100 – 140	8.3 – 11.6	11.3 – 15.8	9.6 – 13.4
AN6	160 – 190	13.3 – 15.8	18.1 – 21.5	15.4 – 18.2
AN7	450 – 500	37.5 – 41.7	50.8 – 56.5	-
AN8	480 – 690	40.0 – 57.5	54.2 – 78.0	-
AN9	800 – 1000	66.6 – 83.3	90.4 – 113.0	-
AN10	1100 – 1500	91.6 – 125.0	124.3 – 169.5	-

Mistakes

Task	Solution
Annotate	De-blue before writing on parts (use Sharpie)
	Write part orientation (Left/Right/Top/Bottom) and relation to others
Air Tools	CHECK air pressure
Drill	Double CHECK the diameter
	Use foam underlayer while drilling
	Use template to guide drilling stress relief notches
Dimple	Double CHECK dimpling the correct side (outside is flush)
Counter-Sink	Pilot must go through hole and have space to pierce through
	Fasten the ring on the cage
	Do NOT push too hard, be gentle
Prime	Degrease before prime
Rivet	Cleco the parts when rivetting
	Rivet gauge should fit chop head tight (not too wide/flat)
	Use tape on flush rivets
	Look at rivet gun NOT at bucking bar
	Push rivet gun and bucking bar hard, Rivet softly
	Back Rivet CHECK stay perpendicular during rivetting (prevent dents)

Procedure

Match	Prime	Assemble	Paint
Strip de-blueing	Dimple	Fit	De-blueing
Fit	De-blueing	Cleco	
Match Drill	Counter Sink	Rivet	
Deburr Light	Clean/Degrease		
Scuff Minimal	Prime		