

POWERFUL

USER FRIENDLY

VERSATILE

**PULL FORCE
ADJUSTABLE**

**Ideal for Armor Kit
Installation**

**High Production Blind
Nut & Ribbed Insert
Applications**



Typical Blind Rivet Nut/Inserts



The D-7421-MIL-1 Blind Rivet Nut/Insert Tool Kit combines the PT-7421, the latest in air operated, spin, pull to pressure tooling with the popular D-100 hand hydraulic riveter. The expandable kit comes standard with the blind nut and insert setting capability for the popular 10-24, 10-32, 1/4-20, and 5/16-18 thread sizes used on most U.S.A. made commercial and military trucks, trailers, buses, vans, containers and light rail vehicles. It is also well suited for projects such as the attachment of armor onto military ground vehicles including the HMMWV and FMTV's. The Kit can easily be expanded to incorporate other UNC, UNF (thru 5/16-24) and Metric thread sizes (thru M8) for aerospace and Aircraft Ground Support Equipment (AGSE) applications.

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D-7421-MIL-1 Tool Components

AIR HYDRAULIC



PT-7421 Spin Pull to Pressure Nutsetter

PT-7421 Nutsetter Specifications:

Pull Force:	3,960 @ 75 psi
Stroke:	.275"
Air Pressure:	75 to 100 psi
CFM Required @ 75 PSI:	.264
Motor Speed: Spin On/Spin Off:	2,000 RPM
Cycle Time:	2.5 seconds
Noise Level:	75 dB (A)
Vibration:	Less than 2.5 M/S ²
Placing Features:	4-40 thru 5/16-24; 3M thru 8M
Tool Dimensions:	11.61" H x 11.81" L x 3.95" W
Kit Dimensions:	5.5" H x 16.5" L x 12.0" W

Weighing less than 5 lbs, the **PT-7421 Air Operated Spin Pull to Pressure Nutsetter** has evolved from the production tested reliable stroke adjustable version, the 7420. With pull force adjustment capability the PT-7421 allows the user to insure that the force imparted to the fastener will not exceed the bearing strength of the material it is being installed into (i.e. fiberglass, wood, composites) or the thread of the fastener itself. This feature significantly reduces the potential for damage or excessive wear to the pull up stud (mandrel) and anvil assembly due to material thickness variations. Affording a .275" stroke, the PT-7421 is capable of installing virtually all blind nuts and inserts within its capacity range in one stroke, including Rivnuts® (NAS1329, NAS1330, MS27130), Plusnuts®, AVK ribbed inserts and Blind Nuts, Avdel Nutserts® and Thin Sheet Nutserts (TSN)®. Importantly, if the user inadvertently recycles the riveter after installation, the fastener threads and/or parent material remain unaffected. Utilizing standard Grade 8 Socket Head Cap Screws as pull-up studs (mandrels) reduces replacement cost and permits wide flexibility for adapting to different fastener lengths. The driving anvil assembly is adjustable to permit quick adaption to most all standard blind rivet nuts or inserts.

D-100 Nutsetter Specifications:

Pulling Force:	4,200 lbs
Stroke Maximum:	.625"
Overall Dimensions:	6.25" H x 5.375" L x 1.75" W
Weight:	20.5 oz
Power Source:	Hand Operated, Two Valve, Cylindrical hydraulic pump assembly, with pressure relief valve

MANUAL



D-100 Hand Hydraulic Nutsetter

The **D-100 Hand Hydraulic Nutsetter** supplied in the D-742-MIL-1 kit provides up to 4,200 lbs of pulling force over a .625" stroke. In the event there are limited access areas where the larger air operated tool will not fit, or if compressed air is unavailable, the sheet metal technician has the capability to perform needed installations. Provided in the nutsetting configuration, the D-100 is supplied with all the same thread sizes and pull-up stud lengths as the PT-7421 air operated riveter. Of course additional pull-up studs can be provided for future sizes as required (ie. Metric and other UNC and UNF threads).