



Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

10067 REV 1

Installation Instructions For:

#6 Rivnut (Nutsert)

Applicable Aircraft:

All aircraft using rivnuts

Required Tools:

- Pop rivet installation tool
- Rivnut installation tool
- Drill
- Drill bits (see instructions for sizes)

Introduction:

These instructions provide general guidelines for installing rivnuts into aluminum sheet.

Sections:

1. Rivnut Information
2. Installation Steps



Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

Section 1: Rivnut Information

There are many types of rivnuts. Our earlier products mostly use the smooth style rivnut. These are common in aviation and usually have a green protective coating.

On later products we changed to the larger diameter ribbed style. The larger diameter and ribbed barrel make them much less likely to loose grip and turn.

All of our products with customer installed rivnuts use the #6 scaw size. Here are the drill bit sizes for each type.

#6 Smooth Rivnut = 3/16"

#6 Ribbed Rivnut = 17/64"



Smooth Style Rivnuts



Ribbed Style Rivnuts



Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

To install rivnuts, a special tool is needed. We provide a basic rivnut installation tool with our products. It works in combination with a standard pop rivet installation tool.

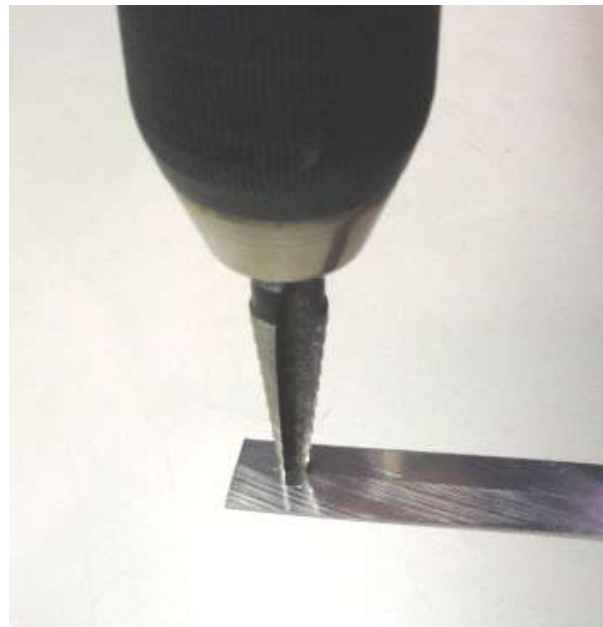


Rivnut Installation Tool

Section 2: Installation Steps

Step 1: Drill Hole

Drill a hole that is the same size as the body of the rivnut. It is also a good idea to deburr the hole.





Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

Step 2: Insert Installation Tool

Thread the rivnut onto the male threads of the installation tool. The two parts will resemble a standard pop rivet when they are threaded together. Thread them together until the end of the installation tool is flush with the end of the rivnut as shown in the picture (smooth type shown for the example).



Step 3: Change Nose Piece

Before setting the rivnut, ensure that the correct nose piece is on the pop rivet tool. The pop rivet tool should have a variety of nose pieces to fit pop rivets with different stem diameters. Test fit the rivnut installation tool into the various nose pieces to find the one with the best fit. Install that nose piece into the pop rivet tool.





Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

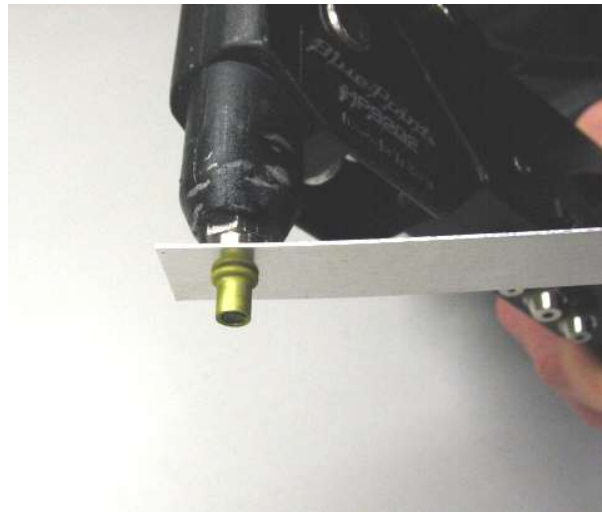
Step 4: Insert Rivnut

Now the rivnut and installation tool can be inserted into the pop rivet tool.



Step 5: Set The Rivnut

Insert the rivnut into the hole in the sheet metal. Make sure that the flange of the rivnut is held tightly against the sheet. Squeeze the handle of the pop rivet tool until it “bottoms” out. You will be able to feel an increase in resistance when the rivnut is fully set. Be careful not to over squeeze the rivnut. This will damage the threads, and require that a new rivnut be installed.





Classic Aero Designs

403 Aviation Way Albany, OR 97322 • 1-866-219-1087 • Fax 541-926-1373

Step 6: Remove The Tool

After the rivnut is set, you must remove the installation tool. First remove the installation tool from the pop rivet tool. Now unthread the rivnut installation tool from the rivnut. You may need to use a pair of pliers to twist the tool out of the rivnut. This is because the threads sometimes become deformed in the process of setting the rivnut. The rivnut should now be ready to accept a screw.

