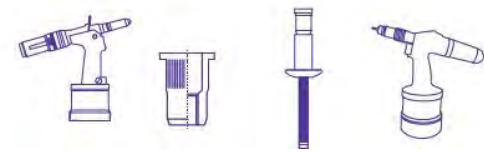


# Trouble Shooting Guide for Setting Rivets



**Pull Thru**



**Partial Pull Thru**



**Head Popper**



**Loose Set  
or  
Plate Freeze**



**High Mandrel Break**



**Sheared Secondary Head**



**PROPER SET**

Potential Cause	Problem Type						
	Pull Thru	Partial Pull Thru	Head Popper	Loose Set	Plate Freeze	High Mandrel Break	Sheared Secondary Head
Over maximum hole size	✓	✓					
Under minimum hole size			✓	✓		✓	✓
Over maximum grip range			✓	✓			✓
Under minimum grip range	✓			✓		✓	
<b>Improper Hole Condition</b>							
Excessive variation in size	✓	✓	✓	✓		✓	✓
Non-circular hole	✓	✓	✓	✓			✓
Tapered hole	✓	✓	✓	✓			✓
Burrs and sharp edges	✓	✓	✓	✓			✓
Material too soft	✓	✓	✓				
Non-perpendicular set / improper alignment of tool when setting	✓	✓	✓	✓	✓	✓	✓
Wrong nose-piece used	✓	✓		✓			
Gap between materials	✓	✓	✓	✓	✓		
Insufficient rear clearance				✓	✓		

= APPLICABLE

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