

Compression Tools – Riveting – Selection



CP0214 – C Yoke

- Single and Tandem cylinder options
- Riveting Capacity –
 - ø 3.2mm (1/8") (single cylinder)
 - ø 4.8mm (3/16") (tandem cylinder)
- Lock-off throttle – reduces the risk of accidental operation



CP0341 – C Yoke

- Patented 'Pneudraulic™' air-hydraulic riveter
- Riveting Capacity –
 - ø 7.14mm (9/32")
- Lock-off throttle – reduces the risk of accidental operation
- Versatile – can accommodate various rivet lengths and joint thickness through the adjustment of air pressure (reducing setting times and eliminating the need to use set length spacer shims with the rivet sets)



CP0351 – C Yoke

- Single and Tandem cylinder options
- Riveting Capacity –
 - ø 4.8mm (3/16") (single cylinder)
 - ø 6.4mm (1/4") (tandem cylinder)
- Actuation throttle guard – reduces the risk of accidental operation
- Short stroke adjustment – aids positioning of the tool (limits the return travel of the moving set of the tool on the rivet to reduce the starting clearance between rivet and rivet sets)



CP0214 – Alligator Jaw

- Single and Tandem cylinder options
- Riveting Capacity –
 - ø 3.2mm (1/8") (single cylinder)
 - ø 4.8mm (3/16") (tandem cylinder)
- Lock-off throttle – reduces the risk of accidental operation



CP0351 – Alligator Jaw

- Single and Tandem cylinder options
- Riveting Capacity –
 - ø 4.0mm (5/32") (single cylinder)
 - ø 6.4mm (1/4") (tandem cylinder)
- Actuation throttle guard – reduces the risk of accidental operation
- Short stroke adjustment – aids positioning of the tool (limits the return travel of the moving set of the tool on the rivet to reduce the starting clearance between rivet and rivet sets)

Selection Criteria

• Type of Rivet

- Rivet material
- Rivet body diameter
- Rivet length before and after compression
- Force required to compress rivet (if known)

• What material is the rivet made from?

• What size is the rivet?

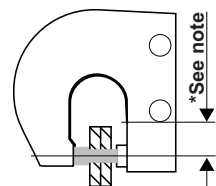
• What is the form of the rivet head?

• Components to assemble

- Access to rivet on assembly

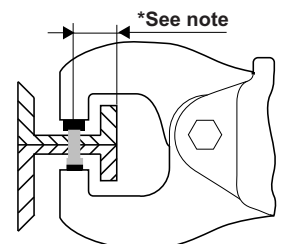
• Open access (up to 54mm (2 1/8") reach)

– 'C' Yoke tool



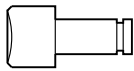
• Restricted access (up to 232mm (9 1/8") reach)

– 'Alligator' Jaw tool



- **Note:** the amount of reach required is determined by the distance from the rivet centerline to the accessible edge of the workpiece

Compression Tools – Riveting – Selection



Compression Rivet Sets

(Complete with retaining rings)

Minimum Order: 6 of any part number.

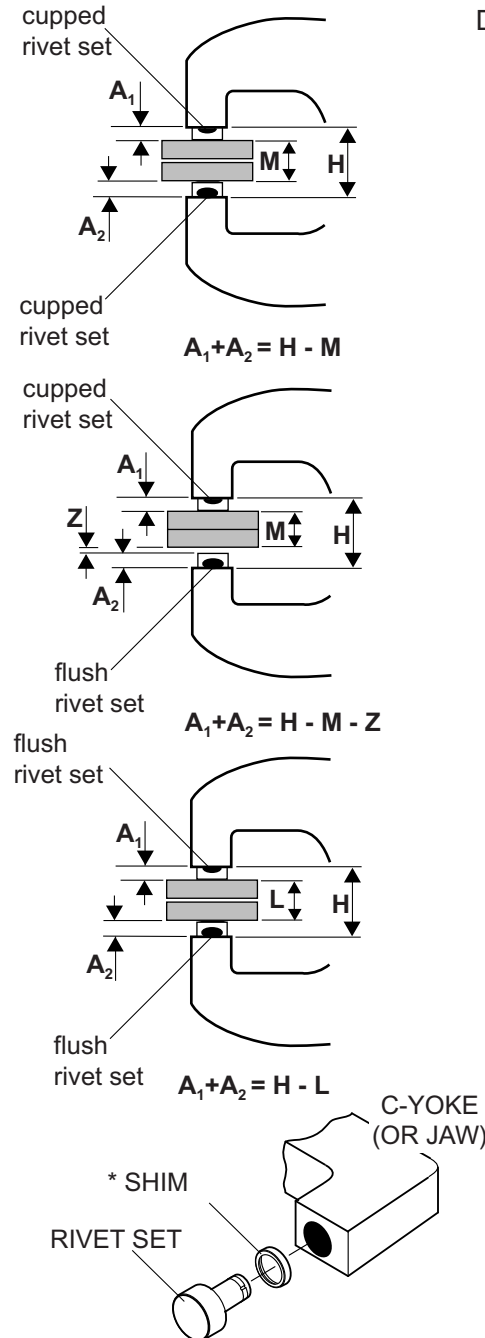
Note: The illustration above shows one rivet set. Two rivet sets are required to be used per tool. Part numbers are for one rivet set only.

SELECTING RIVET SETS TO FIT CP0214, CP0341 and CP0351 RIVETERS

To develop maximum power, the riveter must drive (set) the rivet at the end of the riveter's stroke (with the exception of the CP0341 which develops max power throughout its full stroke).

For maximum power the combined length of the two rivet sets must be of the correct length.

Determine the correct lengths as follows:



1) When two cupped rivet sets are used:

The length of the body dimensions of the rivet sets (A1, A2) should equal the closed height dimension of the yoke (H) minus the total thickness of material being riveted together.

2) When one cupped set and one flush set are used:

The length of the body dimensions of the two rivet sets (A1, A2) should equal the closed height dimension of the yoke (H) minus the total thickness of the material being riveted (M) and the height of the finished rivet head (Z) compressed by the flush set (A).

3) When two flush sets are used:

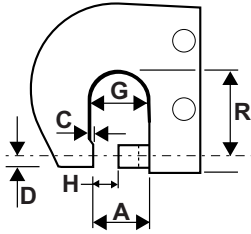
The length of the body dimensions of the two rivet sets (A1, A2) should equal the closed height dimension of the yoke (H) minus the overall length of the rivet (L) after it is compressed.

If necessary, select rivet sets a little short and shim to the correct length using spacer shims.

* Set Length Spacer Shims

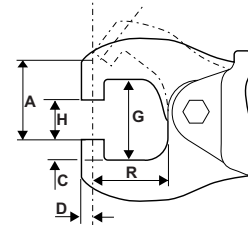
TYPE RIVET SET SHANK	PART NUMBERS OF HARDENED SHIMS		
	0.4mm thick (1/64")	0.8mm thick (1/32")	1.6mm thick (1/16")
CR-1	P083254	P083255	P083256
CR-2		P083257	P083258

Compression Tools – Technical Data



Jaw and Yoke Terminology:
(rivet sets are not in place in this illustration)

- A** Throat gap
- C** Anvil work clearance
- D** Lower offset
- G** Total yoke gap
- H** Closed height
- R** Reach



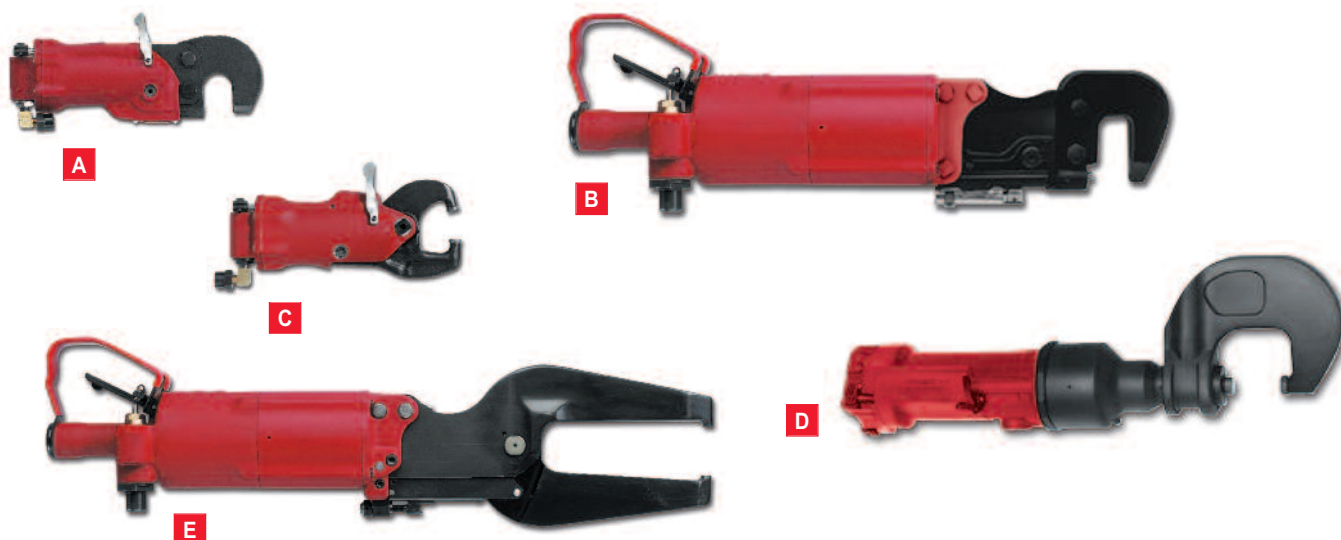
C Yoke Model	A		C		D		G		H		R	
	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.
CP0214CELEL	32	1 1/4	-	-	5	3/16	32	1 1/4	17.5	11/16	38	1 1/2
CP0214FALEL	32	1 1/4	-	-	5	3/16	32	1 1/4	17.5	11/16	38	1 1/2
CP0214SETEL	32	1 1/4	-	-	6.4	1/4	32	1 1/4	17.5	11/16	38	1 1/2
CP0214KETEL	32	1 1/4	-	-	6.4	1/4	32	1 1/4	17.5	11/16	38	1 1/2
CP0351CUDEL	39	1 17/32	-	-	5.5	7/32	29	1 5/32	20	25/32	54	2 1/8
CP0351FUDEL	39	1 17/32	-	-	5.5	7/32	29	1 5/32	20	25/32	54	2 1/8
CP0341CUDEL	57	2 1/4	3	1/8	9	11/32	70	2 3/4	25	1	54	2 1/8

Alligator Jaw Model	A		C		D		G		H		R	
	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.
CP0214ANGEL	54	2 1/8	-	-	5.5	7/32	54	2 1/8	22	7/8	76	3
CP0214ENGEL	54	2 1/8	-	-	5.5	7/32	54	2 1/8	22	7/8	76	3
CP0214ANFEL	48	1 7/8	-	-	5.5	7/32	54	2 1/8	22	7/8	57	2 1/4
CP0214ENFEL	48	1 7/8	-	-	5.5	7/32	54	2 1/8	22	7/8	57	2 1/4
CP0214ANBEL	38	1 1/2	-	-	5.5	7/32	41	1 5/8	22	7/8	38	1 1/2
CP0214ENBEL	38	1 1/2	-	-	5.5	7/32	41	1 5/8	22	7/8	38	1 1/2
CP0351ASVEL	62	2 7/16	-	-	5.5	7/32	56	2 3/16	19	3/4	232	9 1/8
CP0351ESVEL	62	2 7/16	-	-	5.5	7/32	56	2 3/16	19	3/4	232	9 1/8
CP0351ESREL	81	3 3/16	-	-	5.5	7/32	51	2	38	1 1/2	178	7
CP0351ASKEL	57	2 1/4	-	-	5.5	7/32	41	1 5/8	22	7/8	127	5
CP0351ESKEL	57	2 1/4	-	-	5.5	7/32	41	1 5/8	22	7/8	127	5
CP0351ASGEL	38	1 1/2	-	-	5.5	7/32	41	1 5/8	22	7/8	73	2 7/8
CP0351ESGEL	38	1 1/2	-	-	5.5	7/32	41	1 5/8	22	7/8	73	2 7/8

Air inlet: 1/4" NPTF

MODEL	CYLINDER TYPE	RIVET SET TYPE	LENGTH		WEIGHT		SOUND LEVEL	SOUND POWER
			mm	in.	kg	lb		
CP0214ANBEL	Single	CR-1 (ø 4.8mm 3/16")	233	9 3/16	1.7	3 3/4	90	101
CP0214ANFEL	Single	CR-1 (ø 4.8mm 3/16")	254	10	1.9	4 1/4	90	101
CP0214ANGEL	Single	CR-1 (ø 4.8mm 3/16")	273	10 3/4	2.0	4 1/2	90	101
CP0214CELEL	Single	CR-1 (ø 4.8mm 3/16")	262	10 5/16	2.0	4 1/2	90	101
CP0214ENBEL	Tandem	CR-1 (ø 4.8mm 3/16")	303	11 15/16	2.2	4 3/4	90	101
CP0214ENFEL	Tandem	CR-1 (ø 4.8mm 3/16")	324	12 3/4	2.4	5 1/4	90	101
CP0214ENGEL	Tandem	CR-1 (ø 4.8mm 3/16")	343	13 1/2	2.5	5 1/2	90	101
CP0214FALEL	Tandem	CR-1 (ø 4.8mm 3/16")	356	14	2.5	5 1/2	90	101
CP0214KETEL	Tandem	CR-2 (ø 6.4mm 1/4")	356	14	2.5	5 1/2	90	101
CP0214SETEL	Single	CR-2 (ø 6.4mm 1/4")	262	10 5/16	2.0	4 1/2	90	101
CP0341CUDEL	Pneudraulic™	CR-2 (ø 6.4mm 1/4")	505	19 7/8	6.1	13 1/2	85	-
CP0351ASGEL	Single	CR-1 (ø 4.8mm 3/16")	495	19 1/2	7.1	15 3/4	96	107
CP0351ASKEL	Single	CR-1 (ø 4.8mm 3/16")	549	21 5/8	9.0	19 3/4	96	107
CP0351ASVEL	Single	CR-1 (ø 4.8mm 3/16")	654	25 3/4	11.9	26 1/4	96	106
CP0351CUDEL	Single	CR-1 (ø 4.8mm 3/16")	445	17 1/2	5.7	12 1/2	96	107
CP0351ESGEL	Tandem	CR-1 (ø 4.8mm 3/16")	603	23 3/4	8.4	18 1/2	96	107
CP0351ESKEL	Tandem	CR-1 (ø 4.8mm 3/16")	657	25 7/8	10.2	22 1/2	96	107
CP0351ESREL	Tandem	CR-1 (ø 4.8mm 3/16")	708	27 7/8	12.2	27	96	107
CP0351ESVEL	Tandem	CR-1 (ø 4.8mm 3/16")	762	30	13.2	29	96	107
CP0351FUDEL	Tandem	CR-1 (ø 4.8mm 3/16")	552	21 3/4	6.9	15 1/4	96	107
CP0351PU	Single	n/a	546	21 1/2	9.3	20 1/2	96	107
CP0351CABHDY	Single	n/a	445	17 1/2	9.2	20 5/16	96	107

Compression Tools – Riveting



For applications requiring the special 'Alligator Jaws or C-Yokes'



Alligator Jaws mounting versions

PART NUMBER	MODEL	EQUIVALENT STANDARD MODEL
T019138	CP0214ANPEL	CP0214ANBEL/ANFEL/ANGEL without jaws
T018997	CP0214ENPEL	CP0214ENBEL/ENFEL/ENGEL without jaws
T025405	CP0351ASNEL	CP0351ASKEL without jaws

C Yoke mounting versions

PART NUMBER	MODEL	EQUIVALENT STANDARD MODEL
T018677	CP0214CENEL	CP0214CELEL without yoke
T018430	CP0214FANEL	CP0214FALEL without yoke
T022493	CP0341CUNEL	CP0341CUDEL without yoke
T007772	CP0351CUNEL	CP0351CUDEL without yoke

*CR1 **CR2

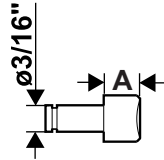
PIC REF	MODEL	PART NUMBER	CAPACITY				STANDARD YOKE DIMENSIONS				MAX FORCE		MOVING PLUNGER			
			ALUM.		STEEL		REACH		CLOSED HEIGHT		(90 psi/6.2 bar)		MAX. TRAVEL		FINAL PART OF STROKE AT MAX. FORCE	
			mm	in.	mm	in.	mm	in.	mm	in.	kN	lb	mm	in.	mm	in.
C-Yoke (single cylinder)																
A	CP0214CELEL*	T012344	3.2	1/8	2.4	3/32	38.1	1 1/2	17.5	11/16	13.35	3,000	14.3	9/16	1.3	0.050
A	CP0214SETEL**	T023474	3.2	1/8	2.4	3/32	38.1	1 1/2	17.5	11/16	13.35	3,000	14.3	9/16	1.3	0.050
B	CP0351CUDEL*	T008955	4.8	3/16	4.0	5/32	54.0	2 1/8	19.8	25/32	26.70	6,000	14.3	9/16	3.2	0.125
C-Yoke (tandem cylinder)																
A	CP0214FALEL*	T013152	4.8	3/16	4.0	5/32	38.1	1 1/2	17.5	11/16	26.70	6,000	14.3	9/16	1.6	0.063
A	CP0214KETE**	T023475	4.8	3/16	4.0	5/32	38.1	1 1/2	17.5	11/16	26.70	6,000	14.3	9/16	1.6	0.063
B	CP0351FUDEL*	T012608	6.4	1/4	5.6	7/32	54.0	2 1/8	19.8	25/32	53.40	12,000	14.3	9/16	3.2	0.125
C-Yoke (pneudraulic™)																
D	CP0341CUDEL**	T022512	7.1	9/32	6.4	1/4	54.0	2 1/8	25.4	1	60.10	13,500	31.8	1 1/4	Full stroke	
Alligator (single cylinder)																
C	CP0214ANBEL*	T012343	3.2	1/8	2.4	3/32	38.1	1 1/2	22.2	7/8	13.35	3,000	15.9	5/8	1.3	0.050
C	CP0214ANFEL*	T018671	2.4	3/32	2.4	3/32	57.1	2 1/4	22.2	7/8	9.79	2,200	22.2	7/8	2.4	0.094
C	CP0214ANGEL*	T018672	2.4	3/32	1.6	1/16	76.2	3	22.2	7/8	8.01	1,800	31.8	1 1/4	1.4	0.056
E	CP0351ASGEL*	T007783	4.0	5/32	3.2	1/8	73.0	2 7/8	22.2	7/8	23.14	5,200	15.9	5/8	3.2	0.125
E	CP0351ASKEL*	T007773	3.2	1/8	2.4	3/32	127.0	5	22.2	7/8	15.13	3,400	34.0	1 3/8	4.8	0.188
E	CP0351ASVEL*	T009582	3.2	1/8	2.4	3/32	232.0	9 1/8	19.1	3/4	13.35	3,000	42.9	1 11/16	1.6	0.063
Alligator (tandem cylinder)																
C	CP0214ENGEL*	T018164	3.2	1/8	2.4	3/32	76.2	3	22.2	7/8	15.13	3,400	31.8	1 1/4	2.6	0.104
C	CP0214ENFEL*	T018163	4.0	5/32	3.2	1/8	57.1	2 1/4	22.2	7/8	19.14	4,300	22.2	7/8	2.4	0.094
C	CP0214ENBEL*	T018678	4.8	3/16	4.0	5/32	38.1	1 1/2	22.2	7/8	26.70	6,000	15.9	5/8	1.6	0.06
E	CP0351ESKEL*	T012603	4.8	3/16	4.0	5/32	127.0	5	22.2	7/8	30.26	6,800	34.0	1 3/8	4.8	0.188
E	CP0351ESREL*	T012604	4.8	3/16	4.0	5/32	178.0	7	38.1	1 1/2	26.70	6,000	42.9	1 11/16	4.8	0.188
E	CP0351ESVEL*	T012605	4.8	3/16	4.0	5/32	232.0	9 1/8	19.1	3/4	26.70	6,000	42.9	1 11/16	1.6	0.063
E	CP0351ESGEL*	T012602	6.4	1/4	4.8	3/16	73.0	2 7/8	22.2	7/8	46.28	10,400	15.9	5/8	3.2	0.125

Compression Tools – Riveting - Rivet Sets

RIVET DIAMETER		'A' BODY LENGTH		AN-435 BUTTON	AN-430 ROUND	AN-455 BRAZIER	AN-456 MODIFIED BRAZIER	AN-470 UNIVERSAL	AN-442 FLAT
mm	in.	mm	in.	part no.	part no.	part no.	part no.	part no.	part no.

CR-1 SHANK RIVET SETS FOR CP0214 and CP0351 – CUPPED SETS

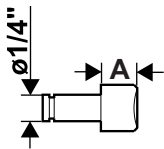
(C-Yoke tools – CP0214 CELEL, FALEL, CUDEL, FUEDEL + all Alligator Yoke tools)



2.4	3/32"	6.4	1/4"	P091601	P089370	P089390	P089410	P089430	P091621
2.4	3/32"	9.5	3/8"	P091602	P089371	P089391	P089411	P089431	P091622
2.4	3/32"	12.7	1/2"	–	–	–	P089412	P089432	P091623
3.2	1/8"	6.4	1/4"	P091606	P089375	P089395	P053826	P089435	P091626
3.2	1/8"	9.5	3/8"	P091607	P089376	–	P053827	P089436	P091627
3.2	1/8"	12.7	1/2"	P091608	P089377	P089397	–	P089437	P091628
4.0	5/32"	6.4	1/4"	P091611	P089380	P089400	P053831	P089440	P091631
4.0	5/32"	9.5	3/8"	P091612	P089381	P089401	P053832	P089441	P091632
4.0	5/32"	12.7	1/2"	P091613	P089382	P089402	P053833	P089442	P091633
4.8	3/16"	6.4	1/4"	P091616	P089385	P089405	P053836	P089445	P091636
4.8	3/16"	9.5	3/8"	P091617	P089386	P089406	P053837	P089446	P091637
4.8	3/16"	12.7	1/2"	P091618	P089387	P089407	P053838	P089447	P091638

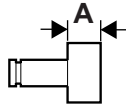
CR-2 SHANK RIVET SETS FOR CP0214 and CP0341 – CUPPED SETS

(C-Yoke tools – CP0214 SETEL, KETEL + CP0341 CUDEL)



3.2	1/8"	6.4	1/4"	–	–	–	–	P089510	P091661
3.2	1/8"	9.5	3/8"	P091642	–	–	–	P089511	–
3.2	1/8"	12.7	1/2"	–	–	–	–	P089512	P091663
4.0	5/32"	6.4	1/4"	–	P089455	–	–	P089515	–
4.0	5/32"	9.5	3/8"	–	–	–	–	P089516	P091667
4.0	5/32"	12.7	1/2"	P091648	–	–	–	P089517	P091668
4.8	3/16"	6.4	1/4"	–	P089460	P089480	–	P089520	P091671
4.8	3/16"	9.5	3/8"	–	P089461	P089481	–	P089521	P491672
4.8	3/16"	12.7	1/2"	P091653	–	P089482	–	P089522	P091673
6.4	1/4"	6.4	1/4"	–	P089465	P089485	–	P089525	P091676
6.4	1/4"	9.5	3/8"	–	P089466	P089486	–	P089526	–
6.4	1/4"	12.7	1/2"	–	P089467	–	–	P089527	P091678

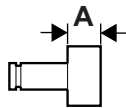
SHANK SIZE	'A' BODY LENGTH					
	3.2mm (1/8")	6.4mm (1/4")	9.5mm (3/8")	12.7mm (1/2")	15.8mm (5/8")	19mm (3/4")



FLUSH SETS for any rivet size

CR-1 (ø 4.8mm 3/16")	P089495	P089496	P089497	P089498	P089499	P089500
CR-2 (ø 6.4mm 1/4")	–	P089501	P089502	P089503	P089504	P089505

TYPE OF RIVET SET SHANK	'A' LENGTH		BODY DIAMETER		PART NUMBER
	mm	in.	mm	in.	



SOFT SET BLANKS

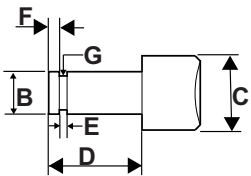
CR-1 (ø 4.8mm 3/16")	19.1	3/4"	15.9	5/8"	P093672
CR-2 (ø 6.4mm 1/4")	19.1	3/4"	19.1	3/4"	P093673

SET LENGTH SPACER SHIMS

TYPE RIVET SET SHANK	PART NUMBERS OF HARDENED SHIMS		
	0.4mm (1/64")	0.8mm (1/32")	1.6mm (1/16")
CR-1	P083254	P083255	P083256
CR-2	–	P083257	P083258

RIVET SET RETAINER RING

TYPE RIVET SET SHANK	PART NUMBER
CR-1	P071916
CR-2	P071917



* 'C' dimension is for flush set only. 'C' varies on cupped sets according to rivet size and type of head.

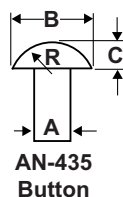
TYPE OF RIVET SET SHANK	B		C*		D		E		F		G	
	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.

SHANK DIMENSIONS FOR RIVET SETS

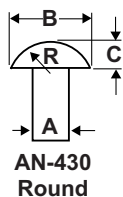
For CP0214, CP0351 and CP0341 Compression Riveters

CR-1 (ø 4.8mm 3/16")	4.75-4.72	0.187-0.186	12.7	1/2	12.7	1/2	3.45-3.38	0.136-0.133	1.6	1/16	3.23-3.12	0.127-0.123
CR-2 (ø 6.4mm 1/4")	6.42-6.40	0.249-0.248	15.9	5/8	15.9	5/8	3.45-3.38	0.136-0.133	2.4	3/32	4.80-4.70	0.189-0.185

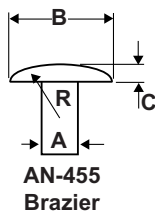
Compression Tools – Rivet Sizes (Reference)



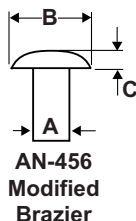
A		B		C		R	
mm	in.	mm	in.	mm	in.	mm	in.
AN-435 A.S.A. BUTTON							
2.4	3/32"	4.22	0.166	1.78	0.070	2.13	0.084
3.2	1/8"	5.56	0.219	2.39	0.094	2.82	0.111
4.0	5/32"	6.93	0.273	4.32	0.117	3.51	0.138
4.8	3/16"	8.33	0.328	3.58	0.141	4.22	0.166
6.4	1/4"	11.10	0.437	4.78	0.188	5.61	0.221
7.9	5/16"	13.87	0.546	5.94	0.234	7.01	0.276



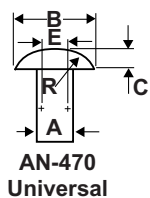
A		B		C		R	
mm	in.	mm	in.	mm	in.	mm	in.
AN-430 ROUND							
2.4	3/32"	4.75	0.187	1.78	0.070	2.49	0.098
3.2	1/8"	6.45	0.250	2.39	0.094	3.30	0.130
4.0	5/32"	7.92	0.312	2.97	0.117	4.11	0.162
4.8	3/16"	9.53	0.375	3.58	0.141	4.95	0.195
6.4	1/4"	12.70	0.500	4.78	0.188	6.60	0.260
7.9	5/16"	16.46	0.648	5.94	0.234	8.26	0.325



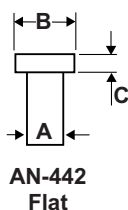
A		B		C		R	
mm	in.	mm	in.	mm	in.	mm	in.
AN-455 BRAZIER							
2.4	3/32"	5.94	0.234	1.19	0.047	4.32	0.170
3.2	1/8"	7.92	0.312	1.60	0.063	5.74	0.226
4.0	5/32"	9.90	0.390	1.98	0.078	7.19	0.283
4.8	3/16"	11.89	0.468	2.39	0.094	8.64	0.340
6.4	1/4"	15.83	0.625	3.18	0.125	11.51	0.453
7.9	5/16"	19.84	0.781	3.96	0.156	14.35	0.565



A		B		C	
mm	in.	mm	in.	mm	in.
AN-456 MODIFIED BRAZIER					
2.4	3/32"	3.96	0.156	0.79	0.031
3.2	1/8"	5.97	0.235	1.19	0.047
4.0	5/32"	7.92	0.312	1.60	0.063
4.8	3/16"	9.91	0.390	1.98	0.078
6.4	1/4"	11.89	0.468	2.39	0.094
7.9	5/16"	15.88	0.625	3.18	0.125



A		B		C		R		E	
mm	in.	mm	in.	mm	in.	mm	in.	mm	in.
AN-470 UNIVERSAL									
2.4	3/32"	4.75	0.187	1.04	0.041	2.08	0.082	1.19	0.047
3.2	1/8"	6.45	0.250	1.37	0.054	2.74	0.108	1.60	0.063
4.0	5/32"	7.92	0.312	1.70	0.067	3.43	0.135	1.98	0.078
4.8	3/16"	9.53	0.375	2.08	0.082	4.17	0.164	2.39	0.094
6.4	1/4"	12.70	0.500	2.72	0.107	5.51	0.217	3.18	0.125
7.9	5/16"	16.46	0.648	3.45	0.136	6.91	0.272	3.96	0.156



A		B		C	
mm	in.	mm	in.	mm	in.
AN-442 FLAT					
2.4	3/32"	4.75	0.187	0.94	0.037
3.2	1/8"	6.45	0.250	1.27	0.050
4.0	5/32"	7.92	0.312	1.57	0.062
4.8	3/16"	9.53	0.375	1.91	0.075
6.4	1/4"	12.70	0.500	2.54	0.100
7.9	5/16"	16.46	0.648	3.18	0.125

Compression Tools – Sheet Metal Punch



CP0351-PU

- Punching Capacity:
 ø 4.8mm (3/16") in aluminum
 through 4.8mm (3/16") material thickness
- Actuation throttle guard:
 reduces the risk of accidental operation
- Use for a wide range of punching operations where it is preferable to take the tool to the job.
 e.g. large structures such as truck trailers

Capacity:

Maximum hole is ø 13mm (1/2") relative to material and thickness.
 Within maximum force of 24.0 kN – 5,400 lbs, material thickness should not exceed hole diameter.

To determine force required use formula: $F = 3.14 \times D \times T \times S$

where 'F' is force (lbs); 'D' is hole diameter (in.); 'T' is thickness of material (in.); 'S' is tensile strength of material (psi) or 'F' is force (kN); 'D' is hole diameter (mm); 'T' is thickness of material (mm); 'S' is tensile strength of material (N/mm²).

Accessories supplied with tool

HOLE SIZE IN ALUMINUM	PUNCH	DIE	COLLAR
ø 4.8mm (3/16")	P041307	P043009	P041309
ø 5.2mm (13/64")	P112836	P112837	P112838

MODEL	PART NUMBER	MAX. MATERIAL THICKNESS ALUM.		HOLE DIAMETER		MAX. DISTANCE EDGE OF SHEET TO HOLE CENTRELINE		MAX. PUNCHING FORCE (90 psi/6.2 bar)		WORK CLEARANCE PUNCH RETRACTED	
		mm	in.	mm	in.	mm	in.	kN	lb	mm	in.
CP0351PU	T013417	4.8	3/16	4.8	3/16	47.6	17/8	24.0	5400	12.7	1/2
CP0351PU	205 146 721 4	4.8	3/16	5.2	13/64	47.6	17/8	24.0	5400	12.7	1/2

Compression Tools – Edge Former



CP0351-CABH-DY

- Forming Capacity (max material thickness) – \varnothing 6.4mm (1/4")
- Rotary Suspension Bail fitted – eases handling and orientation of tool
- Use for a wide range of flattening of spot welded flanges and removing bends
- Custom yokes and dies can be used for crimping and staking operations
- Automatic cycling frequency is adjustable from 1 cycle per throttle actuation to up to 200 cycles per minute whilst the throttle actuation is maintained.

Accessories supplied with tool

	PART NUMBER
• Yoke	P059557
• Die	P059556
• Ball bearing Suspension Bail	P102451

MODEL	PART NUMBER	MAX. MATERIAL THICKNESS ALUM.		MAX. CYCLES PER MINUTE	REACH		MAX. COMPRESSIVE FORCE (90 psi/6.2 bar)	
		mm	in.		mm	in.	kN	lb
CP0351-CABH-DY	T020475	6.4	1/4	200	14.4	9/16	26.7	6000