

## CLOSE QUARTER DIE TIPS

Close quarter dies are to be used only in places that conventional dimple dies will not fit. These dies are designed to be pulled in a pop rivet tool and are not expected to make the same quality of dimple as conventional dies. These dies work best in .016" skin as in control surfaces, etc. They will work in thicker skins, but please pay attention to the tips below.

Included with the dies are 10 copper and 2 steel mandrels. The copper mandrels will closely fit the #40 hole in the skin and in the dies to allow for proper alignment. Pull carefully, they are much softer.

In .016" skin the copper mandrel alone is sufficient to set the dimple. Insert the female die over the mandrel then through the hole in the inside of your skin. Slip the male die over the mandrel and slide on your pop rivet tool with the closest fitting tip. Squeeze the handle slowly and you should feel the pressure change. At this point the metal stops being formed and the mandrel starts to stretch. Loosen your grip for a second and reach this same pressure again to ensure the dimple is set. Using this method your mandrels should last for dozens of dimples.

When dimpling thicker skins you should start as above but you will notice the dimple is not complete. Swap the copper mandrel for the steel and pull again. This time the beginning of the dimple will provide the alignment for the dies. Again you should feel the pressure change then repeat. This should result in a satisfactory dimple but don't expect the same results as with dimple dies used in a squeezer or c-frame.

**Note:** With 1/8" dies start with #40 hole and use same procedure. When dimple is complete drill to size with a #30 bit.