



## Cleaveland Aircraft Tool

2225 First St. Boone, IA 50036  
(515) 432-6794 (515) 432-7804 (FAX)  
mail@cleavelandtool.com  
www.cleavelandtool.com

# Hand Squeezer Instructions

Thank you for choosing the Cleaveland rivet squeezer.

The squeezer you have chosen is the finest on the market today and will last for a very long time, provided you read the following instructions.

You can destroy the squeezer if you do not follow the rules below. If you ignore the rules below, damage will not be covered under warranty. There are things that you can do to/with the squeezer that are not mentioned (or usually even that we can't imagine) that I feel are common sense and will not be covered under the warranty (dragging behind car, using as hammer, using while submerged in acid...) If you have an odd use, please give us a call and we will advise if it would be acceptable under the warranty.

1. Never set rivet larger in diameter than 1/8" ( -4 )
2. Never set a steel rivet ( or any other alloy that is harder than aluminum )
3. Never force the handles ( either direction ) or attach longer handles.  
\* There is a built in tension indicator to red flag tools that have exceeded 4000# of force at the ram.
4. Never extend the ram beyond the maximum allowable extension length. See diagram and guidelines below for ram adjustment tips. Use the ram adjustment for fine tuning only.
5. DO NOT DISASSEMBLE. If at any time for any reason any part other than the yoke is removed from the squeezer, the warranty is void. Minimum Repair fee is \$35 plus parts and shipping.

### Very Important Setup Criteria

The following measurements are to be taken with the handles completely closed.

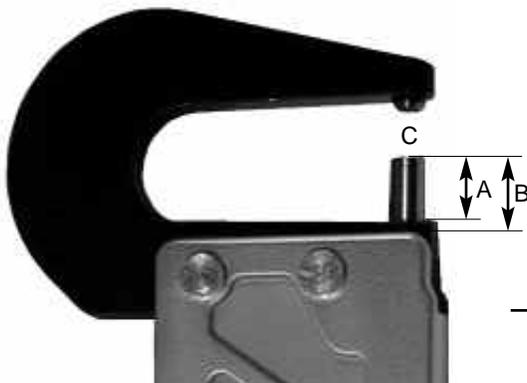
The distance "A" from the top of the yoke base to the end of the ram should never exceed 1" or there will not be enough ram left in the yoke to maintain rigidity.

The distance "B" from the top of the squeezer body to the end of the ram should never exceed 1 1/8". Beyond this there will not be enough thread engagement to absorb the force required to set a rivet.

If either of these measurements is at maximum and distance "C" is still too great you need to use thicker flat or cup sets in the ram and in the yoke to close the gap. Over extension will break the tool.

The ram threads are designed to close tolerance to prevent unwanted adjustment during use.

If you can't turn by hand, use 5/16" wrench on flats to adjust.



Dimpling setup: Insert the dies in the yoke and ram (orient for most comfortable use). Thread the ram out until the dies touch with about an inch of space between the handles. This assumes there is no material between the dies and no pressure on the handles. This is the correct setup for dimpling.

Rivet setup: Start by adding the correct sets to end up with gap "C" being close to the finished rivet length dimension. Squeeze one, adjust, and re-try.

---

Special thanks to Mike Cencula for 2007 Engineering Consultation