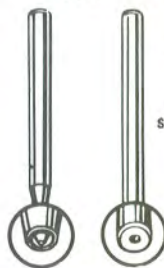


**INDIVIDUAL TOOLS AS SUPPLIED IN
"BASIC" AND "MASTER" KITS**

TOP SETTING TOOLS (Swager)

1/4" Diameter Tools



For Single End Terminals, Eyelets or Rivets

Cat. No.	For Shank Diam's.
1714	.062 to .098
1715	.110 to .125

For Dubl End (Feed-thru)

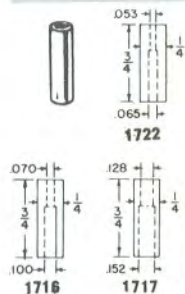
Hole in tool fits over Pin head and securely stakes the rivet part of terminal

Cat. No.	For Pin on Rivet end
1304	.051 Hole Diam.
1305	.063 Hole Diam.
1306	.073 Hole Diam.
1307	.086 Hole Diam.
1324	.098 Hole Diam.

BOTTOM ANVILS

For Single End or Dubl End Terminals

Anvils have different size of holes in each end and therefore will accept 2 sizes of Pins of either Single or Dubl end Turret type Terminals.



Cat. No.	Hole one end	Hole other end
1722	.053	.065
1716	.070	.100
1717	.128	.152

RECEDING PINS AND SPRING

Cat. No.

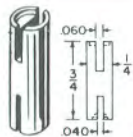
1315 Pin is .045 Diam. Use with No. 1722 anvil, ideal for 1/16" Diam. eyelets.

1316 Pin is .068 Diam. Use with No. 1716 Anvil, ideal for 3/32" eyelets or extruded lugs.

1321 Spring only (Pkg. of 2).



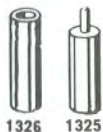
ANVIL FOR FORK TYPE TERMINALS



Will accept Diameters of 3/32 to 5/32 at one end and diam. of 3/16 at other end. .040 slot one end and .060 slot at other end.

CAT. NO. 1726

ANVIL FOR STANDOFF BUSHINGS



Cat. No.

1326 Holds Bushing with 5/32" O. D.

1325 For Bushing with No. 6-32 Thr'd

EYELET STAKING TOOLS

For 1/16" Eyelet **CAT. NO. 3075**

For 3/32" Eyelet **CAT. NO. 3076**

For 1/8" Eyelet **CAT. NO. 3077**

NOTE: SHANK DIAMETER OF TOOLS .312



**INDIVIDUAL TOOLS AS SUPPLIED IN
"IMPACT" STAKER KIT**

**"IMPACT" STAKER
(Less Tools)**



Automatic, Uniform striking action which is adjustable from light to heavy blows. Compact, simple one hand operated device. 1/2" diameter by 5" long—Accepts No. 3-56 threaded tips.

CAT. NO. 1302

TOP SETTING TOOLS (Swager)

Top Setting Tools For Impact Staker

Cat. No.	For Shank Diam's.
1312	.040 to .072
1313	.078 to .093



For Dubl end Terminals (Feed-thru)

Hole in tool fits over Pin head and Firmly Stakes the rivet part of terminal.

Cat. No.	Hole Diam.
1310	.053
1311	.062

TOOLHOLDER (BASE)

For 1/4" Diameter Anvils



This malleable iron base is ideal for use at the desk or can be mounted permanently—mounting holes are provided. A felt pad is glued to the base and prevents marring finished surfaces. Small, compact easily fits briefcase; or corner of tool box.

CAT. NO. 1301

TOOLHOLDER

For 1/4" Diameter Anvils



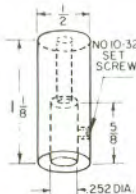
For use in Vise, Arbor, Kickpress, Punch Press, Drill Press, etc. Consists of: Holder, 2 washers and wing nut plus instructions.

CAT. NO. 1719



1/2" TOOL ADAPTER

For 1/4" Diameter Tools



A convenient accessory—used to protect top of tool when hammer staking; or in presses with 1/2" bore in ram.

CAT. NO. 1327



**INSTRUCTIONS
For STAKING TOOLS**

**For MANUAL USE and ADAPTABLE TO ANY ARBOR PRESS
KICKPRESS — DRILL PRESS
Stakes—Eyelets—Rivets—Terminals**

- **Make Prototypes at Your Desk**
- **Repair Circuits**
- **Uniformity Assured**
- **Produce Professional Results**

The unskilled Operator can produce Professional looking assemblies quickly and with little effort. Designed originally for use in Drill Press (WITHOUT POWER ON) it is adaptable for use in a VISE, KICKPRESS, PUNCH or AIR PRESS, ETC. TOOLS are made of Steel, Precision contoured, Heat Treated to proper hardness and plated. They will produce rolls which are professional in appearance to give Long Lasting Wear and Satisfactory Service.

INSTRUCTIONS

BASIC KIT No. 1721

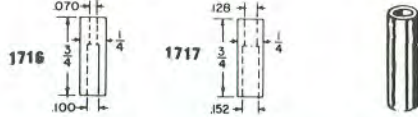
NOTE: For Staking Eyelets, Rivets or Terminals you must know dimensions of **shank** diameters and **pin** diameters in order to choose proper staking tools.

TOP STAKING TOOLS (Place into Chuck or Ram of Press).

FOR SINGLE END TERMINALS, EYELETS, OR RIVETS—When you know size of the Shank diameter choose tool with contour that is larger than this diameter, i.e.—For shank dia. of .112 you should use No. 1715 tool, which is for diameters from .110 to .125.

ANVILS (Place into Toolholder and tighten screw). Anvils are drilled with different diameter holes in each end. The Terminal Pin should fit snugly into one of these holes; must not be force-fitted.

NOTE: Terminals are always inserted into the Anvil in an inverted position as pictured here.



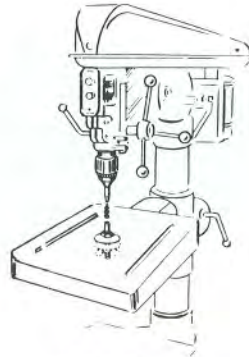
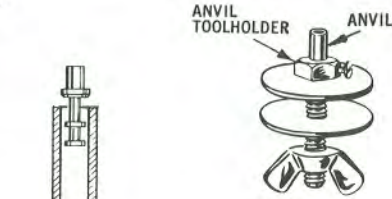
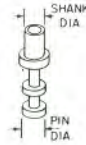
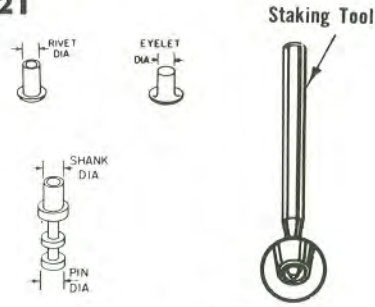
TOOLHOLDER with Anvil installed is assembled to the Platen or Base of device used. When Drill Press is used **POWER IS NOT TURNED ON** (use same as you would an arbor press).

MOST IMPORTANT IS ALIGNMENT OF TOOLS: The appearance of swaged roll is governed by the care exercised here.

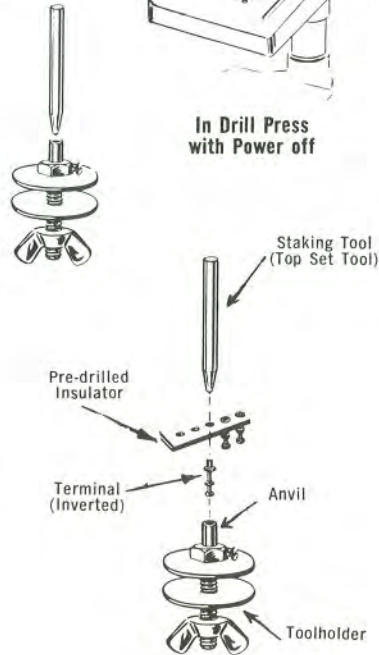
1. Lower Top Set Tool and rest lightly directly over the Anvil. They must be in a perfectly straight line.
2. While Tools are in this position tighten wing nut. Be sure Tools did not shift and will not loosen during staking operation.

PROCEDURE for staking is:

1. Terminal is placed into Anvil with Pin dia. down as pictured here. (Inverted.)
2. Pre-drilled insulator hole is placed over the terminal shank.
3. Light pressure of Top Set Tool will cause metal to form tight, round stake.

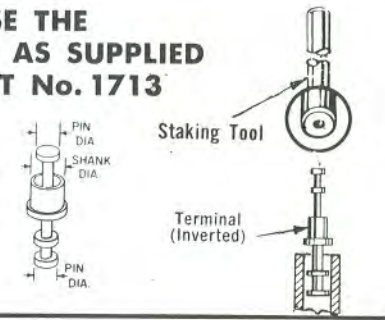


In Drill Press
with Power off



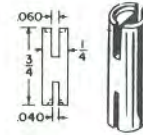
HOW TO USE THE ADDITIONAL TOOLS AS SUPPLIED WITH MASTER KIT No. 1713

TOOLS FOR DOUBLE END TERMINALS—Choose tool with hole drilled large enough to fit over the Pin dia. of terminal. (This tool is not supplied in the No. 1721 Kit.)

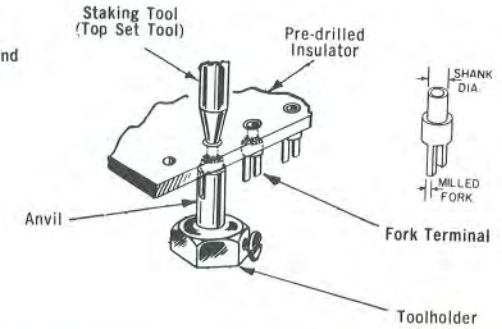


TOOLS FOR MILLED FORK TERMINALS

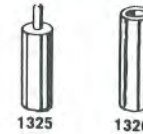
Will accept Diameters of 3/32 to 5/32 at one end and diam. of 3/16 at other end. .040 slot one end and .060 slot at other end.



CAT. NO. 1726

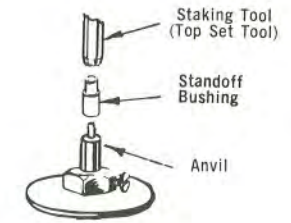


TOOLS FOR STANDOFF BUSHINGS



1325 1326

Cat. No.
1326 Holds Bushing with 5/32" O. D.
1325 For Bushing with No. 6-32 Thr'd



TOOLS FOR EYELETS AND EXTRUDED LUGS

Holds Eyelets and Extruded Lugs, Pin retracts when engaged by Swaging tool.

NOTE: Designed for use with Nos. 1722 and 1716 Anvils and Nos. 1719 and 1301 Toolholders. Spring is placed in Toolholder. Pin is inserted into Anvil, then placed over the spring.

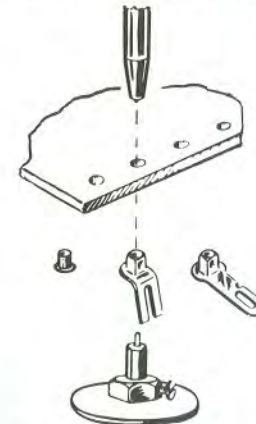
Cat. No.

1315 Pin is .045 Diam. Use with No. 1722 anvil, ideal for 1/16" Diam. eyelets.

1316 Pin is .068 Diam. Use with No. 1716 Anvil, ideal for 3/32" eyelets or extruded lugs.

1321 Spring only (Pkg. of 2).

RECEDING PIN,
ANVIL AND SPRING
ASSEMBLED IN
TOOL HOLDER



The right angle bend type of terminal can only be staked while held in place by a receding pin.

Eyelets are placed over the receding pin and easily staked.

