

SERVICE LETTER

Stinson Division
Consolidated Vultee Aircraft Corporation
Wayne, Michigan

TO: Distributors and Direct Factory Dealers

LETTER NO. 18

TITLE: Blind Rivets for Field Repairs

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Date: October 4, 1946

Gentlemen:

There are certain portions on the control surfaces of the Voyager 150 where driven rivets are used on the production line that will require the use of blind rivets for field repairs.

The Cherry rivet and the Huck rivet are the two most popular types of blind rivets for this purpose. Cherry rivets come in two types, hollow and self plugging. For strength purposes it is definitely recommended the self plugging type be used.

For general application use a rivet which has a nominal grip length as close as possible to the total thickness of the riveted sheets. The rivet will handle material which is .016 inch thicker or .047 thinner than the nominal grip .160 to .164 for 5/32" rivets. Use a pneumatic gun wherever possible, however, hand guns are available and catalog information is given below. Care should be taken to use a pulling head which fits the diameter and head design of the rivet.

Press the gun firmly against the rivet, and be sure the stem of the rivet is at the bottom of the slot in the gun. The rivet should be pulled until the stem breaks. The remaining portion of the stem should be trimmed flush with the head of the rivet. Do not lubricate the rivet before or after use.

Most of this type of repair work, which you will encounter, can be accomplished by the use of 1/8" and 5/32" blind rivets. It is recommended that the rivet head design be the same as the rivet being replaced. The make of rivet is a matter of choice, but we believe a blind rivet gun and an inventory of rivets should be considered an absolute "must" in your service shop.

The following ordering data is offered for your guidance:

Cherry Rivet Company - 1819 Barranca Street - Los Angeles, California

<u>Size</u>	<u>Head</u>	<u>Cherry Drawing</u>	
1/8" Rivets	Brazier Head	Data Sheet	CR163
5/32" Rivets	Brazier Head	Data Sheet	CR163
1/8" Rivets	Countersunk Head	Data Sheet	CR162
5/32" Rivets	Countersunk Head	Data Sheet	CR162

Hand Gun No. G-10 available with adapters and interchangeable pulling heads.

Huck Manufacturing Company - 2472 Bellevue Avenue, Detroit 7, Michigan

<u>Size</u>	<u>Head</u>	<u>Huck Drawing</u>	
1/8" Rivets	Brazier Head	Data Sheet	P4-100
5/32" Rivets	Brazier Head	Data Sheet	P5-100
1/8" Rivets	Countersunk Head	Data Sheet	100V4-100
5/32" Rivets	Countersunk Head	Data Sheet	100V5-100

An Air Gun No. CP350 is available through Chicago Pneumatic Tool, 8 East 44th Street, New York 17, New York.

We hope you will give every consideration to this provision for future possible emergencies.

Yours very truly,

Stinson Division
Consolidated Vultee Aircraft Corporation

George Martin
Service Manager

GM:LJA