ADJUSTING THE ANVIL FOR INSERT FASTENER LENGTH:

Insert threads may be damaged or stripped if the pull-up stud does not engage all threads in the insert. The L6000/L7000 has an adjustable anvil, which allows the user to adjust to suit the insert being installed. The illustration demonstrates the proper relation between the face of the anvil and the end of the pull-up stud.

FIG 3.

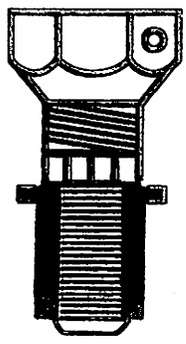
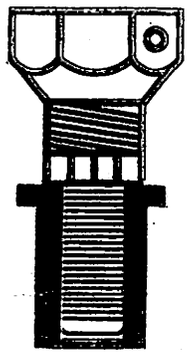


FIG 4.



OPEN END INSERT (Fig 3):

End of the pull-up stud should extend slightly beyond the end of the insert.

CLOSED END INSERT (Fig 4):

Insert should be threaded onto the pull-up stud until end of stud is even with insert, then insert needs to be turned back one complete turn so insert extends beyond pull-up stud.

NOTE:

Face of the anvil must be snug to the end of the insert so that all threads of pull-up stud can engage and avoid stripping threads.

OPERATING RANGE:

Rivet Material	#4	#6	#8	#10	1/4"	5/16"	3/8"	1/2"
Aluminum	■	■	■	■	○			
Brass & Steel	■	■	■	○				
Stainless & Steel	■	■	○					
Rivet Material	**M3**	**M4**	**M5**	**M6**	**M7**	**M8**	**M10**	**M12**
Aluminum	■	■	■	■				
Brass & Steel	■	■	■					
Stainless & Steel	■	■						

■ Recommended
○ Adequate but borderline strength

LEM TOOLS

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INSTRUCTIONS FOR THE L-6000/L7000 SPEED HEADER

The L-6000/L-7000 is a hand operated rivet header tool for use with the following insert thread sizes:
*Inch thread sizes: 4-40, 6-32, 8-32, 10/32, 10/24, 1/4-20, & 1/4-28.
*Metric thread sizes: 4MM, 5MM, & 6MM.

OPERATING INSTRUCTIONS:

(REFER TO FIG. 1)

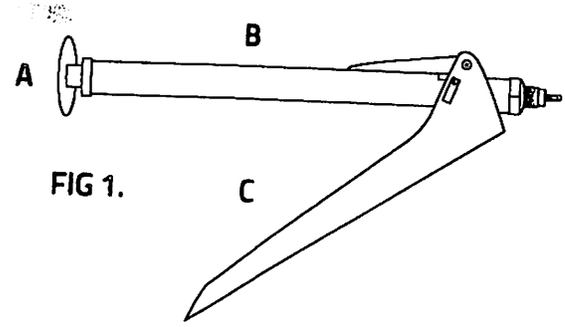


FIG 1.

Pull knob (A) completely out and place insert onto pull-up stud. Holding insert stationary, push knob until it is all the way into the barrel (B). The insert should now have all threads engaged onto the pull-up stud. Hold tool at a 90-degree angle to work properly, and place insert into the hole in work piece. Squeeze handle (C) toward barrel (B) until resistance is felt. The handle will not touch the barrel. DO NOT apply excessive force or that threads will be stripped. Release handle (C) and pull knob (A) completely out, this will release pull-up stud from the insert.

REPLACING BROKEN OR DAMAGED PULL-UP STUDS:

(REFER TO FIG. 2)

1. Unscrew anvil sleeve, L28 and remove.
2. Loosen 3 set screws, L-5 using the access hole with hex key (included), by rotating knob to expose set screws.
3. Loosen 2 set screws at access hole located below L-32 on barrel, again rotate knob.
4. Unscrew pull-up stud by holding it firmly in place, a vice may be necessary to hold the pull-up stud. Turn the entire tool counter clockwise to remove from coupling, L-20.
5. Replace pull-up stud by reversing instructions.

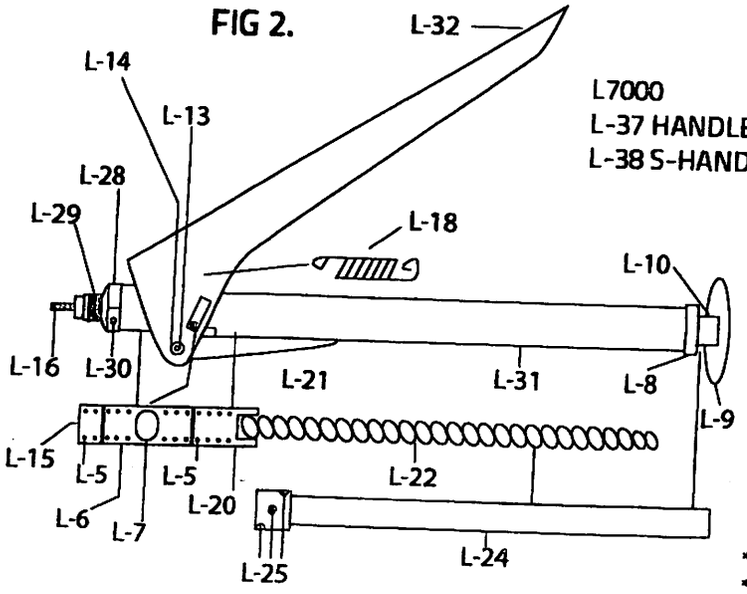
DO NOT DAMAGE OR SCAR THE PULL UP STUD, THIS WILL PREVENT SMOOTH OPERATION WHILE STUD ROTATES IN THE ADJUSTABLE ANVIL.

NOTE: If replacing pull-up stud with a different thread size, it requires changing adjustable anvil, L-29; collar, L-15 and in some cases, the coupling L-20.

OILING: A drop of oil at set screw openings on the barrel will keep the tool operating smoothly.

PARTS FOR L6000/L7000 SPEED HEADER TOOL

FIG 2.



L7000
L-37 HANDLE
L-38 S-HANDLE

Part No. Unfied	Part No. Metric	Name (Description)	Qty.
L-5	L-5	SET SCREW B-32 X 1/8"	5
L-6	L-6	PLUNGER	1
L-7	L-7	CROSS PIN	1
L-8	L-8	SLIDE BUSING	1
L-9	L-9	KNOB	1
L-10	L-10	KNOB PIN	1
L-13	L-13	HINGE PIN	1
L-14	L-14	WASHER FOR L-13	2
L-15	L-39	*COLLAR	1
L-16	L-40	*PULL-UP STUD	1
L-18	L-18	SPRING	1
L-20	L-20	**COUPLING	1
L-21	L-21	PIN	1
L-22	L-22	OPERATING SCREW	1
L-24	L-24	OPERATING TUBE	1
L-25	L-25	BEARINGS	6
L-28	L-28	ANVIL SLEEVE	1
L-29	L-40	ADJUSTABLE ANVIL	1
L-30	L-30	NYLON TIP SET SCREW	1
L-31	L-31	HANDLE	1
L-32	L-32	SQUEEZE HANDLE	1

*These parts must be changed with each different size insert
**Change only when insert size is greater than #10 thread pitch