



*We're Holding  
Things Together!*

# 255/256

Riveting Machines

## Features

### High Production

- Less operator fatigue: solenoid operation of clutch trip mechanism permits placement of operating switch in the most comfortable / convenient position.
- Faster machine cycles with high speed roller clutch.
- Quick, positive delivery of rivet with every machine cycle assured by cut-off type escapement.
- Parts supply bins and spill trays can be placed inches from the setting tools.

### Greater Flexibility

- Electrical cycling facilitates installation of many options.
- Quick retooling for different rivet sizes with QC Raceways.
- Raceway interchangeable with Models 63 and 64.

### Less Downtime

- Clutch maintenance practically eliminated with roller clutch.
- Clutch trip adjustment never required.
- No hopper drive lubrication - totally enclosed cam clutch.

### Longer Life

- Power train toggle linkage made of hardened steel components.
- Slide rails of raceways spring steel; back rail stainless steel.
- Better lubrication through more grease fittings.

### Improved Safety

- Machine won't double trip, clutch trip operates by gravity.
- Full power train guarding without loss of production speed.
- Reduced noise level.



## Specifications

**Rivet Capacity** 1/8 inch (3.17mm) to 5/32 inch (3.96mm) diameter, max. length 3/4 inch (19.05mm)

**Throat Depth** 12 inches (304.80mm)

**Stroke** 2-1/2 inches (63.50mm)

**Anvil Height** 45 inches (1143mm) (average)

**Hopper** Rotary, intermittent drive

**Setting Mech.** Toggle, crank driven

**Crankshaft** Ductile iron, sleeve bearing mount

**Clutch** Roller type, single revolution

**Clutch Trip** Solenoid trip w/foot switch or palm buttons

**Flywheel** 188 rpm, tapered roller bearing mounted

**Motor** 1/3 hp, 1140 rpm, single phase, 60 Hz, 115V (motor options available)

**Weight** 550 lbs., approx. 650 lbs. w/crate

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*Forming, Fastening and Assembly Specialists*

### Titan-Tip Roll Sets

Titanium Nitride coating provides a harder, low-friction surface - reducing the coefficient between forming surfaces to one third that of uncoated tools. This ensures there is no tool deformation or base material characteristic change. Titan-Tip coating also increases tool face hardness to a Rockwell C<sub>80</sub>.

Milford Titan-Tip tools are fabricated for any make or model riveting machine. For better and smoother working clinching tools Titan-Tip is the solution!

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### Rebuilds

Milford can rebuild your riveting machines to "like new" condition. Rebuilding can be done at a cost significantly lower than a new machine, with quick turnaround. A factory rebuild of any Milford carries the same warranty as a new machine.

Rebuilding your equipment increases productivity and production flow, it also helps eliminate downtime due to machine failure caused by wear.

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### Operator Safety

Milford recommends all riveters be equipped with safety devices such as dual non-tie-down palm switches or safety ring guards. Call us for our brochure, "Safety in Riveting".

## REPLACEMENT TOOLING & REBUILDS *for all makes and models of machines*

Milford has over 70 years experience producing tooling for rivet setting machines. We supply highest quality exact replacement tooling. Send us a print or damaged tool - we'll get right back with a quote and delivery information.

Ask about our stock / blanket order programs to assure even faster response to your immediate needs.

**Drivers** - precision machined, shaped and polished to exact characteristics of rivet or fastener.

**Jaws** - also called "pockets" capture and position rivet prior to assembly. Designed to match rivet size and length.

**Roll Sets** - also called "anvils" roll or form the rivet clinch. Controlled clinching through tool shape, finish and surface lubricity is the key to tighter, more dependable and attractive fastenings.



### Orbitform Group

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