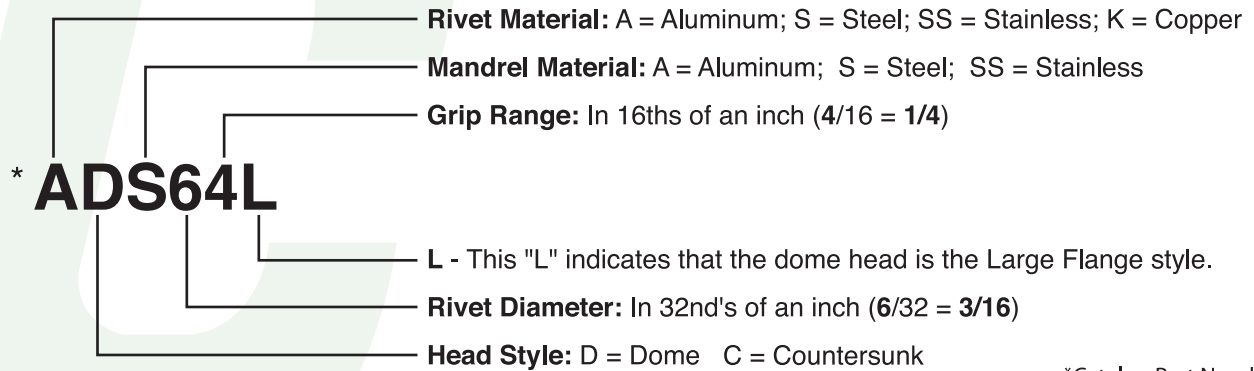


Application Data

Part Number Key

Rivets



*Catalog Part Number

Notes on Rivet Selection

Strength - The tensile and shear strengths required for an application must be determined and a rivet selected that meets those requirements.

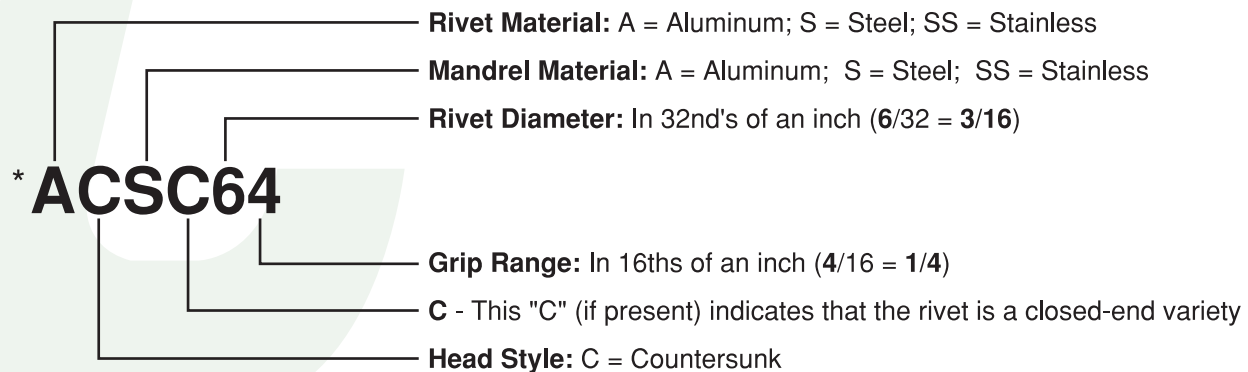
Materials - Choose a rivet that is made of a metal with similar mechanical and physical properties as the materials being joined. This is especially critical in assemblies where higher temperatures and/or corrosive elements are present. Metal compatibility helps reduce the risks of galvanic corrosion and material fatigue.

Grip Range - Measure the total thickness of the materials being fastened. This is known as the "rivet grip". The grip ranges of the most commonly available rivets are listed in the table below. Sufficient rivet length is necessary for proper formation of the secondary head on the blind side of the assembly. Multi-grip rivets have wider grip ranges than standard break-stem blind rivets.

APPLICATION DATA FOR STANDARD BREAK-STEM BLIND RIVETS -- PROTRUDING HEADS										SAE J-1200				
Rivet Number	Grip Range	Barrel Length	Recommended Hole Size		Drill Size	Rivet Number	Grip Range	Barrel Length	Recommended Hole Size		Drill Size			
			Max	Min					Max	Min				
31	.020-.062	.187	0.100	0.097	#41	62	.020-.125	.325	0.196	0.192	#11			
32	.020-.125	.250				63	.126-.187	.387						
33	.087-.187	.312				64	.188-.250	.450						
34	.126-.250	.375				66	.251-.375	.575						
40	.010-.030	.150	0.133	0.129	#30	68	.376-.500	.700				610	.501-.625	.825
41	.020-.062	.212				612	.626-.750	.950						
42	.063-.125	.275				614	.751-.875	1.075						
43	.126-.187	.337				616	.876-1.000	1.200						
44	.188-.250	.400				618	1.001-1.125	1.325						
45	.251-.312	.462				620	1.126-1.250	1.450						
46	.313-.375	.525				622	1.251-1.375	1.575						
48	.376-.500	.650				82	.020-.125	.375	0.261	0.257	F			
410	.501-.625	.775				84	.126-.250	.500						
52	.020-.125	.300				0.164	0.160	#20				86	.251-.375	.625
53	.126-.187	.362	88	.376-.500	.750									
54	.188-.250	.425	810	.501-.625	.875									
56	.251-.375	.550	812	.626-.750	1.000									
58	.376-.500	.675	814	.751-.875	1.125									
510	.501-.625	.800	816	.876-1.000	1.250									
512	.626-.750	.925												
516	.876-1.000	1.175												

Rivets

Part Number Key

Application
Data

*Catalog Part Number

Notes on Rivet Selection

Strength - The tensile and shear strengths required for an application must be determined and a rivet selected that meets those requirements.

Materials - Choose a rivet that is made of a metal with similar mechanical and physical properties as the materials being joined. This is especially critical in assemblies where higher temperatures and/or corrosive elements are present. Metal compatibility helps reduce the risks of galvanic corrosion and material fatigue.

Grip Range - Measure the total thickness of the materials being fastened. This is known as the "rivet grip". The grip ranges of the most commonly available rivets are listed in the table below. Sufficient rivet length is necessary for proper formation of the secondary head on the blind side of the assembly. Multi-grip rivets have wider grip ranges than standard break-stem blind rivets.

APPLICATION DATA FOR STANDARD BREAK-STEM BLIND RIVETS - COUNTERSUNK HEAD										SAE J-1200	
Rivet Number	Grip Range	Rivet Length	Recommended Hole Size		Drill Size	Rivet Number	Grip Range	Rivet Length	Recommended Hole Size		Drill Size
		Max	Max	Min				Max	Max	Min	
42	.092-.125	.275	0.133	0.129	#30	54	.188-.250	.425	0.164	0.160	#20
43	.126-.187	.337				56	.251-.375	.550			
44	.188-.250	.400				58	.376-.500	.675			
45	.251-.312	.462				64	.188-.250	.450	0.196	0.192	#11
46	.313-.375	.525				66	.251-.375	.575			
48	.376-.500	.650				68	.376-.500	.700			