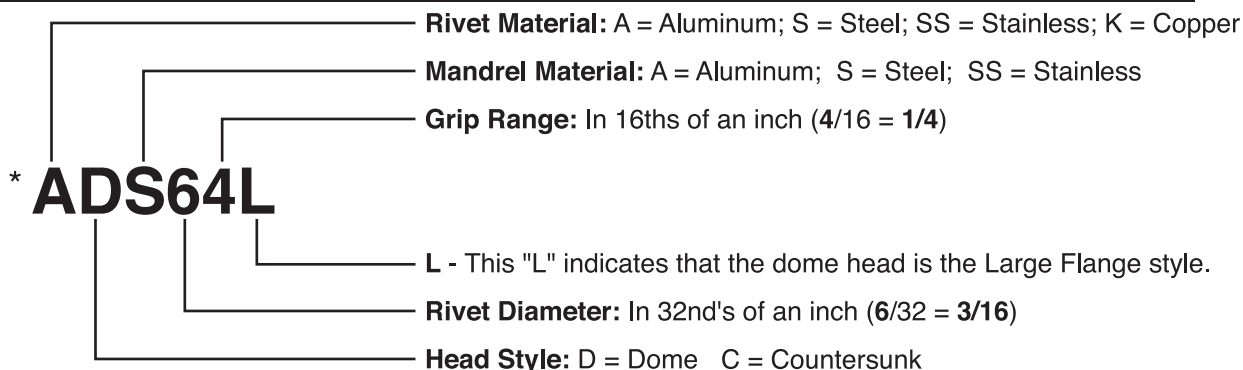




\*Catalog Part Number

## 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.

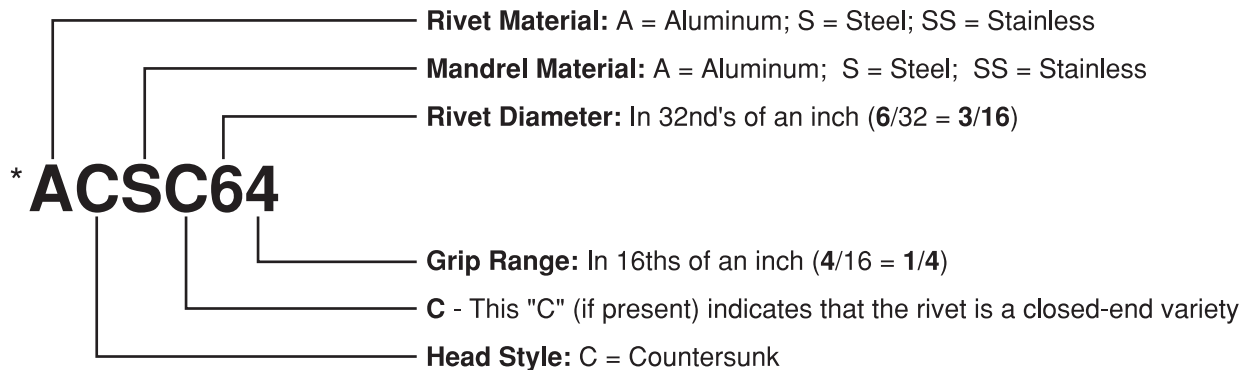
**Materials** - Choose a rivet that is made of a metal with similar mechanical and physical properties as the materials being joined. This is especially critical in assemblies where higher temperatures and/or corrosive elements are present. Metal compatibility helps reduce the risks of galvanic corrosion 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           | Max                   | Min   |            |              |             | Max           | 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          |                       |       |            |
| 41           | .020-.062  | .212          |                       |       |            | 610          | .501-.625   | .825          |                       |       |            |
| 42           | .063-.125  | .275          |                       |       |            | 612          | .626-.750   | .950          |                       |       |            |
| 43           | .126-.187  | .337          |                       |       |            | 614          | .751-.875   | 1.075         |                       |       |            |
| 44           | .188-.250  | .400          |                       |       |            | 616          | .876-1.000  | 1.200         |                       |       |            |
| 45           | .251-.312  | .462          |                       |       |            | 618          | 1.001-1.125 | 1.325         |                       |       |            |
| 46           | .313-.375  | .525          |                       |       |            | 620          | 1.126-1.250 | 1.450         |                       |       |            |
| 48           | .376-.500  | .650          |                       |       |            | 622          | 1.251-1.375 | 1.575         |                       |       |            |
| 410          | .501-.625  | .775          | 0.164                 | 0.160 | #20        | 82           | .020-.125   | .375          | 0.261                 | 0.257 | F          |
| 52           | .020-.125  | .300          |                       |       |            | 84           | .126-.250   | .500          |                       |       |            |
| 53           | .126-.187  | .362          |                       |       |            | 86           | .251-.375   | .625          |                       |       |            |
| 54           | .188-.250  | .425          |                       |       |            | 88           | .376-.500   | .750          |                       |       |            |
| 56           | .251-.375  | .550          |                       |       |            | 810          | .501-.625   | .875          |                       |       |            |
| 58           | .376-.500  | .675          |                       |       |            | 812          | .626-.750   | 1.000         |                       |       |            |
| 510          | .501-.625  | .800          |                       |       |            | 814          | .751-.875   | 1.125         |                       |       |            |
| 512          | .626-.750  | .925          |                       |       |            | 816          | .876-1.000  | 1.250         |                       |       |            |
| 516          | .876-1.000 | 1.175         |                       |       |            |              |             |               |                       |       |            |



\*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<br>J-1200 |            |
|--------------------------------------------------------------------------|---------------|-----------------|--------------------------|-------|------------|--|-----------------|---------------|-----------------|--------------------------|---------------|------------|
| Rivet<br>Number                                                          | Grip<br>Range | Rivet<br>Length | Recommended<br>Hole Size |       | Drill Size |  | Rivet<br>Number | Grip<br>Range | Rivet<br>Length | Recommended<br>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            |                          |               |            |