

*Catalog Part Number

Notes on Rivet Selection

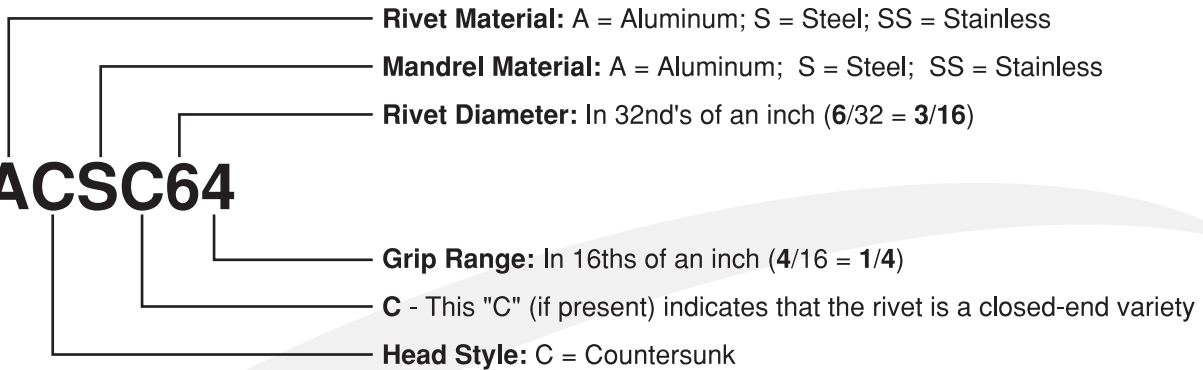
Strength - The tensile and shear strengths required for an application must be determined and a rivet selected that meets those requirements.

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									
33	.087-.187	.312									
34	.126-.250	.375									
40	.010-.030	.150	0.133	0.129	#30	66	.251-.375	.575			
41	.020-.062	.212									
42	.063-.125	.275									
43	.126-.187	.337									
44	.188-.250	.400									
45	.251-.312	.462									
46	.313-.375	.525									
48	.376-.500	.650									
410	.501-.625	.775	0.164	0.160	#20	68	.376-.500	.700			
52	.020-.125	.300									
53	.126-.187	.362									
54	.188-.250	.425									
56	.251-.375	.550									
58	.376-.500	.675									
510	.501-.625	.800									
512	.626-.750	.925									
516	.876-1.000	1.175									
									82	.020-.125	.375
						84	.126-.250	.500			
						86	.251-.375	.625			
						88	.376-.500	.750			
						810	.501-.625	.875			
						812	.626-.750	1.000			
						814	.751-.875	1.125			
						816	.876-1.000	1.250			

* **ACSC64**



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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	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			