

ASAP FASTENING SYSTEMS, INC.

SUPPLIES FOR INDUSTRY AND CONSTRUCTION

2013 SOUTH 37TH STREET • MILWAUKEE, WISCONSIN 53215

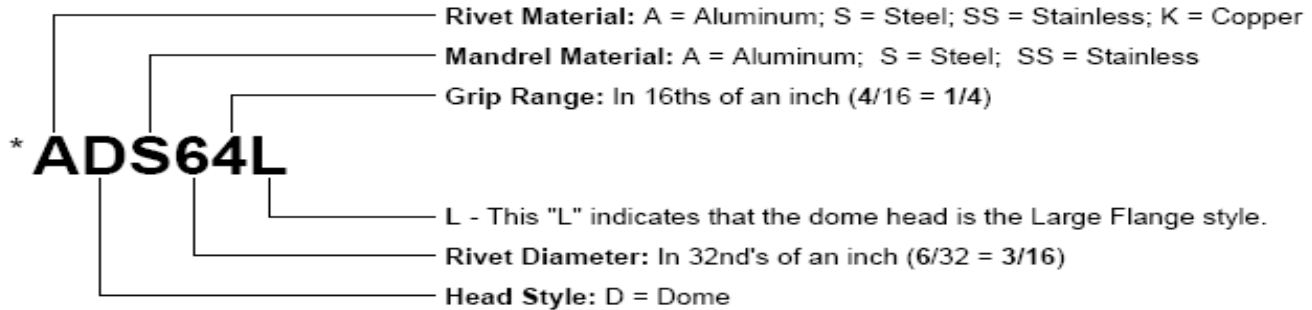
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**Application
Data**

Part Number Key

Rivets



*Kanebridge 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 blind rivets which are listed on pages 144-154.

APPLICATION DATA FOR STANDARD BREAK-STEM BLIND RIVETS

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	516	.876-1.000	1.175	0.164	0.160	#20
32	.020-.125	.250				62	.020-.125	.325	0.196	0.192	#11
33	.087-.187	.312				64	.188-.250	.450			
34	.126-.250	.375				66	.251-.375	.575			
41	.020-.062	.212	68	.376-.500	.700						
42	.063-.125	.275	610	.510-.625	.825						
43	.126-.187	.337	612	.626-.750	.950						
44	.188-.250	.400	614	.751-.875	1.075						
45	.251-.312	.462	616	.876-1.000	1.200						
46	.313-.375	.525	618	1.001-1.125	1.325	0.261	0.257	F			
48	.376-.500	.650	620	1.126-1.250	1.450						
52	.020-.125	.300	622	1.251-1.375	1.575						
53	.125-.187	.362	84	.126-.250	.500						
54	.188-.250	.425	86	.251-.375	.625						
56	.251-.375	.550	88	.376-.500	.750						
58	.376-.500	.675	810	.501-.625	.875						
510	.501-.625	.800	812	.626-.750	.990						
512	.626-.750	.925	816	.751-1.000	1.240						