

ASAP FASTENING SYSTEMS, INC.

SUPPLIES FOR INDUSTRY AND CONSTRUCTION

2013 SOUTH 37TH STREET • MILWAUKEE, WISCONSIN 53215

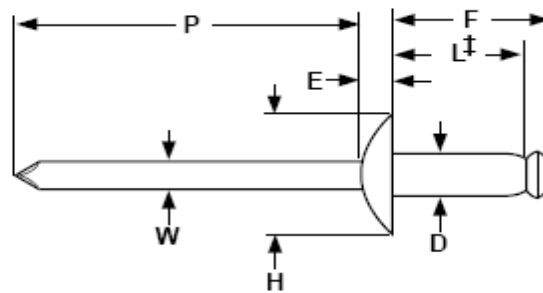
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Rivets

**Aluminum/Aluminum
Aluminum/Steel
Steel/Steel**

**Large Flange
Blind Rivet**



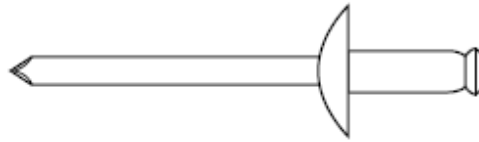
LARGE FLANGE BREAK-STEM BLIND RIVETS								SAE J-1200
Nominal Rivet Diameter	D		H		E	W	P	F
	Rivet Shank Diameter		Head Diameter		Head Height	Mandrel Diameter	Mandrel Protrusion	Blind Side Protrusion
	Max	Min	Max	Min	Max	Nom	Min	Max
1/8	0.128	0.122	.390	.360	.065	0.076	1.00	L + 0.120
3/16	0.191	0.183	.650	.600	.092	0.114	1.06	L + 0.160

Description	A blind fastener which has a self-contained mandrel which permits the formation of an upset on the blind end of the rivet and expansion of the rivet shank during rivet setting to join the component parts of an assembly. The mandrel is pulled into or against the rivet body, breaking at or near the junction of the mandrel shank and its upset end. The large flange head has twice the under-head bearing surface of comparably sized dome head rivets.
Applications/ Advantages	Large flange rivets are preferred where extra brittle or soft materials are being assembled to a rigid surface.
Material	Rivet: <i>Aluminum</i> -- Aluminum Alloy 5050, 5052, 5056 or 5154. <i>Steel</i> -- Low carbon steel, plated zinc. Mandrel: <i>Aluminum</i> -- Aluminum Alloy 7178, 5056 or 2024. <i>Steel</i> -- Carbon steel 1006 or equivalent. May be furnished plain or with a protective coating, at the option of the manufacturer.
Shear Strength (Min)	Aluminum Rivet/Aluminum Mandrel -- 1/8: 120 lbs.; 3/16: 260 lbs. Aluminum Rivet/Steel Mandrel -- 1/8: 170 lbs.; 3/16: 380 lbs. Steel Rivet/Steel Mandrel -- 3/16: 540 lbs.
Tensile Strength (Min)	Aluminum Rivet/Aluminum Mandrel -- 1/8: 150 lbs.; 3/16: 320 lbs. Aluminum Rivet/Steel Mandrel -- 1/8: 220 lbs.; 3/16: 500 lbs. Steel Rivet/Steel Mandrel -- 3/16: 680 lbs.
Mandrel Break Load	Aluminum Rivet/Aluminum Mandrel -- 1/8: 400 lbs. max, 250 lbs. min; 3/16: 825 lbs. max, 625 lbs. min. Aluminum Rivet/Steel Mandrel -- 1/8: 600 lbs. max, 400 lbs. min; 3/16: 1050 lbs. max, 750 lbs. min. Steel Rivet/Steel Mandrel -- 3/16: 1450 lbs. max, 1150 lbs. min.

**Large Flange
Blind Rivet**

**Aluminum/Aluminum
Aluminum/Steel
Steel/Steel**

Rivets



PART NUMBER COMPARISON - LARGE FLANGE ALUMINUM RIVET/ALUMINUM MANDREL							
Kanebridge	Huck-Automatic	Pop®	Marson/Creative	Star	Celus®	Cherry	Gesipa®
ADA44L	ABA44L	AD44ABSLF	ABL4-4A	4-4AALF	A/A44LF	AAL-44	GAML44A
ADA64L	ABA64L	AD64ABSLF	ABL6-4A	-	A/A64LF	AAL-64	GAML64A
ADA66L	ABA66L	AD66ABSLF	ABL6-6A	6-6AALF	A/A66LF	AAL-66	GAML66A
ADA68L	ABA68L	AD68ABSLF	ABL6-8A	6-8AALF	A/A68LF	AAL-68	GAML68A
ADA610L	ABA610L	AD610ABSLF	ABL6-10A	6-10AALF	A/A610LF	AAL-610	GAML610A

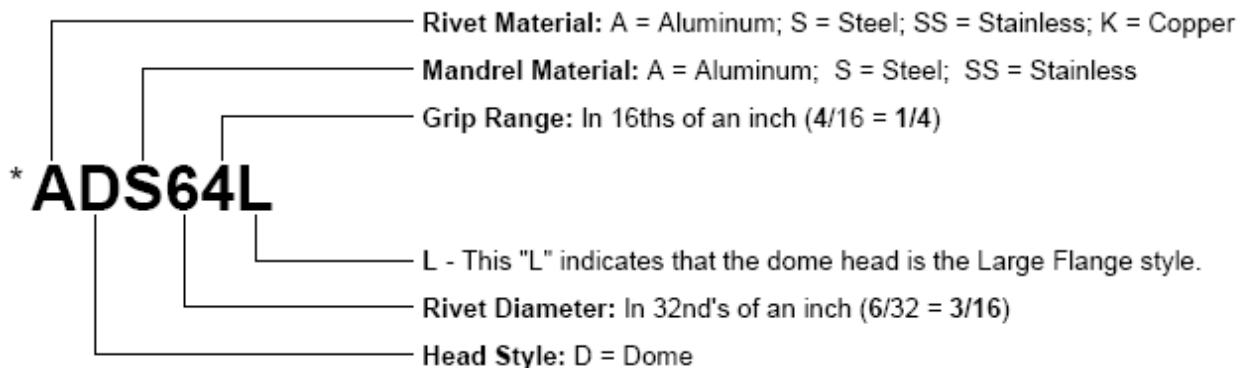
PART NUMBER COMPARISON - LARGE FLANGE ALUMINUM/STEEL MANDREL							
Kanebridge	Huck/Automatic	Pop®	Marson/Creative	Star	Celus®	Cherry	Gesipa®
ADS46L	-	-	-	-	A/S 46LF	BSL-46	GSML46A
ADS48L	-	-	-	-	-	BSL-48	-
ADS64L	ABS64L	AD64BSLF	ABL6-4	-	A/S 64LF	BSL-64	GSML64A
ADS66L	ABS66L	AD66BSLF	ABL6-6	6-6ASLF	A/S 66LF	BSL-66	GSML66A
ADS68L	ABS68L	AD68BSLF	ABL6-8	6-8ASLF	A/S 68LF	BSL-68	GSML68A
ADS610L	ABS610L	AD610BSLF	ABL6-10	6-10ASLF	A/S610LF	BSL-610	GSML610A

PART NUMBER COMPARISON - LARGE FLANGE STEEL RIVET/STEEL MANDREL							
Kanebridge	Huck/Automatic	Pop®	Marson/Creative	Star	Celus®	Cherry	Gesipa®
SDS64L	SBS64L	SD64BSLF	SBL6-4	-	S/S 64LF	SSL-64	GSML64S
SDS66L	SBS66L	SD66BSLF	SBL6-6	6-6SSLF	S/S 66LF	SSL-66	GSML66S
SDS68L	SBS68L	SD68BSLF	SBL6-8	6-8SSLF	S/S 68LF	SSL-68	GSML68S
SDS610L	SBS610L	SD610BSLF	SBL6-10	6-10SSLF	S/S610LF	SSL-610	GSML610S

®Celus is a registered trademark of Celus Fasteners Manufacturing Inc..

®Gesipa is a registered trademark of Gesipa Fasteners USA Inc..

®Pop is a registered trademark of Pop Fastening Systems, Emhart Fastening Technologies, a Black & Decker Company.
Kanebridge's rivets are not manufactured by or connected with the producers of Gesipa® or Pop® 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 compatability 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											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												
41	.020-.062	.212	0.133	0.129	#30	68	.376-.500	.700						
42	.063-.125	.275												
43	.126-.187	.337												
44	.188-.250	.400												
45	.251-.312	.462												
46	.313-.375	.525												
48	.376-.500	.650												
52	.020-.125	.300				0.164	0.160	#20	610	.510-.625	.825			
53	.125-.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												
									612	.626-.750	.950	0.261	0.257	F
									614	.751-.875	1.075			
						616	.876-1.000	1.200						
						618	1.001-1.125	1.325						
						620	1.126-1.250	1.450						
						622	1.251-1.375	1.575						
						84	.126-.250	.500						
						86	.251-.375	.625						
						88	.376-.500	.750						
						810	.501-.625	.875						
						812	.626-.750	.990						
						816	.751-1.000	1.240						