

**Rivet Material:** A = Aluminum; S = Steel; SS = Stainless; K = Copper

**Mandrel Material:** A = Aluminum; S = Steel; SS = Stainless

**Grip Range:** In 16ths of an inch ( $4/16 = 1/4$ )

\* **ADS64L**

**L** - This "L" indicates that the dome head is the Large Flange style.

**Rivet Diameter:** In 32nd's of an inch ( $6/32 = 3/16$ )

**Head Style:** D = Dome C = Countersunk

\*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												
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												
52	.020-.125	.300				0.164	0.160	#20	68	.376-.500	.700	0.261	0.257	F
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**

**Rivet Material:** A = Aluminum; S = Steel; SS = Stainless

**Mandrel Material:** A = Aluminum; S = Steel; SS = Stainless

**Rivet Diameter:** In 32nd's of an inch ( $6/32 = 3/16$ )

**Grip Range:** In 16ths of an inch ( $4/16 = 1/4$ )

**C** - This "C" (if present) indicates that the rivet is a closed-end variety

**Head Style:** C = Countersunk

\*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	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			