

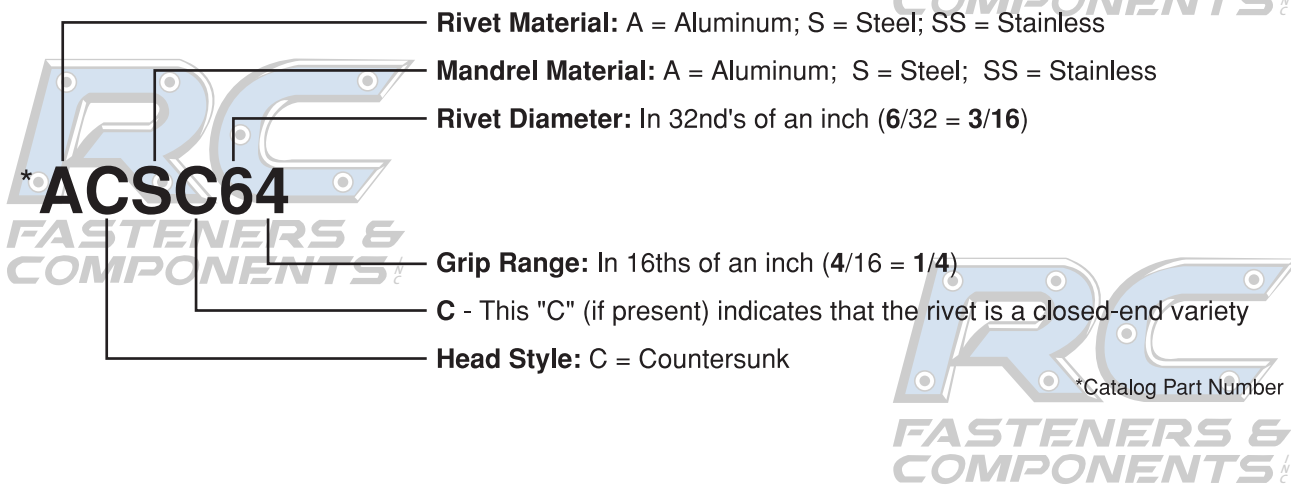
Notes on Rivet Selection

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



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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			#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	0.133	0.129		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				