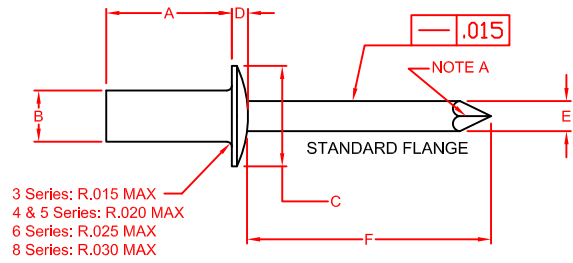
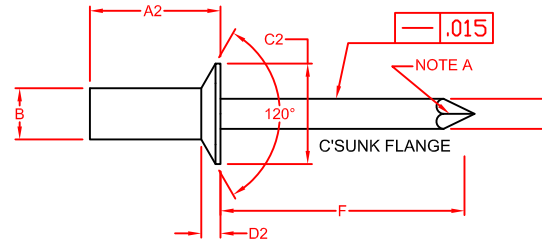


# RIVETKING® STANDARD BLIND RIVETS - ALUMINUM/ALUMINUM - CLOSED END



3 Series: R.015 MAX  
 4 & 5 Series: R.020 MAX  
 6 Series: R.025 MAX  
 8 Series: R.030 MAX

NOTE A: MANDREL POINT PER RIVETKING STANDARD



| SIZE         | GRIP RANGE  | A            |                | B RIVET DIA. | E MANDREL DIA. | F MANDREL PROTRUDE | PERFORMANCE  |                |              |              |              |              |             |             |
|--------------|-------------|--------------|----------------|--------------|----------------|--------------------|--------------|----------------|--------------|--------------|--------------|--------------|-------------|-------------|
|              |             | RIVET LENGTH | RIVET LENGTH   |              |                |                    | SHEAR LBS. F | TENSILE LBS. F |              |              |              |              |             |             |
| 1/8"         | .020   .062 | .297<br>MAX  | .332<br>.312   | .128<br>.122 | .074<br>.066   | 1.00<br>MIN.       | 100<br>MIN.  | 110<br>MIN.    |              |              |              |              |             |             |
|              | .063   .125 | .360<br>MAX  | .395<br>.375   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .126   .187 | .422<br>MAX  | .457<br>.437   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .188   .250 | .485<br>MAX  | .520<br>.500   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .251   .312 | .547<br>MAX  | .582<br>.562   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .313   .375 | .610<br>MAX  | .645<br>.625   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .376   .500 | .738<br>MAX  | .770<br>.750   |              |                |                    |              |                |              |              |              |              |             |             |
|              | 5/32"       | .020   .125  | .375<br>MAX    |              |                |                    |              |                | .425<br>.405 | .159<br>.153 | .092<br>.084 | 1.06<br>MIN. | 130<br>MIN. | 160<br>MIN. |
| .126   .187  |             | .437<br>MAX  | .487<br>.467   |              |                |                    |              |                |              |              |              |              |             |             |
| .188   .250  |             | .500<br>MAX  | .550<br>.530   |              |                |                    |              |                |              |              |              |              |             |             |
| .251   .312  |             | .562<br>MAX  | .612<br>.592   |              |                |                    |              |                |              |              |              |              |             |             |
| .313   .375  |             | .625<br>MAX  | .675<br>.655   |              |                |                    |              |                |              |              |              |              |             |             |
| .376   .500  |             | .750<br>MAX  | .800<br>.780   |              |                |                    |              |                |              |              |              |              |             |             |
| 3/16"        |             | .020   .125  | .406<br>MAX    | .471<br>.451 | .191<br>.183   | .110<br>.102       | 1.06<br>MIN. | 210<br>MIN.    | 250<br>MIN.  |              |              |              |             |             |
|              |             | .126   .187  | .468<br>MAX    | .538<br>.518 |                |                    |              |                |              |              |              |              |             |             |
|              | .188   .250 | .531<br>MAX  | .601<br>.581   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .251   .375 | .656<br>MAX  | .736<br>.716   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .376   .500 | .781<br>MAX  | .851<br>.831   |              |                |                    |              |                |              |              |              |              |             |             |
|              | .501   .625 | .906<br>MAX  | 1.026<br>1.006 |              |                |                    |              |                |              |              |              |              |             |             |
|              | .626   .750 | 1.026<br>MAX | 1.101<br>1.081 |              |                |                    |              |                |              |              |              |              |             |             |
|              | 1/4"        | .020   .125  | .445<br>MAX    | .525<br>.505 |                |                    |              |                |              | .255<br>.246 | .146<br>.138 | 1.25<br>MIN. | N/R         | N/R         |
| .126   .250  |             | .570<br>MAX  | .650<br>.630   |              |                |                    |              |                |              |              |              |              |             |             |
| .251   .375  |             | .695<br>MAX  | .775<br>.755   |              |                |                    |              |                |              |              |              |              |             |             |
| .376   .500  |             | .820<br>MAX  | .900<br>.880   |              |                |                    |              |                |              |              |              |              |             |             |
| .501   .625  |             | .945<br>MAX  | 1.025<br>1.005 |              |                |                    |              |                |              |              |              |              |             |             |
| .626   .750  |             | 1.070<br>MAX | 1.150<br>1.130 |              |                |                    |              |                |              |              |              |              |             |             |
| .751   .875  |             | 1.195<br>MAX | 1.275<br>1.255 |              |                |                    |              |                |              |              |              |              |             |             |
| .876   1.000 |             | 1.320<br>MAX | 1.400<br>1.380 |              |                |                    |              |                |              |              |              |              |             |             |

| PART NUMBER | STANDARD FLANGE - DOME HEAD |               | COUNTERSUNK FLANGE |                |              |              |              |              |              |
|-------------|-----------------------------|---------------|--------------------|----------------|--------------|--------------|--------------|--------------|--------------|
|             | C HEAD DIA.                 | D HEAD HEIGHT | C2 HEAD DIA.       | D2 HEAD HEIGHT |              |              |              |              |              |
| ABA 41 CE   | .252<br>.224                | .050<br>.040  | ACA 41 CE          | .245<br>.221   | .042<br>MAX. |              |              |              |              |
| ABA 42 CE   |                             |               | ACA 42 CE          |                |              |              |              |              |              |
| ABA 43 CE   |                             |               | ACA 43 CE          |                |              |              |              |              |              |
| ABA 44 CE   |                             |               | ACA 44 CE          |                |              |              |              |              |              |
| ABA 45 CE   |                             |               | ACA 45 CE          |                |              |              |              |              |              |
| ABA 46 CE   |                             |               | ACA 46 CE          |                |              |              |              |              |              |
| ABA 48 CE   |                             |               | ACA 48 CE          |                |              |              |              |              |              |
| ABA 52 CE   |                             |               | .328<br>.296       |                |              | .065<br>.055 | ACA 52 CE    | .328<br>.296 | .051<br>MAX. |
| ABA 53 CE   | ACA 53 CE                   |               |                    |                |              |              |              |              |              |
| ABA 54 CE   | ACA 54 CE                   |               |                    |                |              |              |              |              |              |
| ABA 55 CE   | ACA 55 CE                   |               |                    |                |              |              |              |              |              |
| ABA 56 CE   | ACA 56 CE                   |               |                    |                |              |              |              |              |              |
| ABA 58 CE   | ACA 58 CE                   |               |                    |                |              |              |              |              |              |
| ABA 62 CE   | .394<br>.356                | .080<br>.070  |                    | ACA 62 CE      | .394<br>.356 |              | .060<br>MAX. |              |              |
| ABA 63 CE   |                             |               |                    | ACA 63 CE      |              |              |              |              |              |
| ABA 64 CE   |                             |               | ACA 64 CE          |                |              |              |              |              |              |
| ABA 66 CE   |                             |               | ACA 66 CE          |                |              |              |              |              |              |
| ABA 68 CE   |                             |               | ACA 68 CE          |                |              |              |              |              |              |
| ABA 610CE   |                             |               | ACA 610CE          |                |              |              |              |              |              |
| ABA 612CE   |                             |               | ACA 612CE          |                |              |              |              |              |              |
| ABA 82 CE   |                             |               | .525<br>.475       | .100<br>.090   |              | ACA 82 CE    |              | .525<br>.475 | .080<br>MAX. |
| ABA 84 CE   | ACA 84 CE                   |               |                    |                |              |              |              |              |              |
| ABA 86 CE   | ACA 86 CE                   |               |                    |                |              |              |              |              |              |
| ABA 88 CE   | ACA 88 CE                   |               |                    |                |              |              |              |              |              |
| ABA 810CE   | ACA 810CE                   |               |                    |                |              |              |              |              |              |
| ABA 812CE   | ACA 812CE                   |               |                    |                |              |              |              |              |              |
| ABA 814CE   | ACA 814CE                   |               |                    |                |              |              |              |              |              |
| ABA 816CE   | ACA 816CE                   |               |                    |                |              |              |              |              |              |

|                                 |  |   |  |                                 |  |      |
|---------------------------------|--|---|--|---------------------------------|--|------|
| DRAWN: SBS                      |  | DATE: 4-1-08  | CHECKED: JGE                             | SHEET 1 OF 1                    | DESCRIPTION: ALUMINUM/ALUMINUM BLIND RIVETS - CLOSED END |      |
| LIMITS UNLESS STATED            |  | DECIMAL ±.015   | ANGULAR ±2°                              | SURFACE TEXTURE (RA)            | REVISIONS  | DATE |
| INDUSTRIAL RIVET & FASTENER Co. |  | 200 PARTS AVENUE<br>NORTHVALE, NJ, 07647<br>TEL: (201) 750 1040<br>info@rivet.com |  | REVISED, ERROR CORRECTION       |  |      |
| DRAWING NUMBER:                 |  | BR-0E-2008-1  | LOCN: SER/REV/BLUEPRINTS/4-INTERNAL/MAST | REVISED, ERROR CORRECTION       |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | REVISED, ERROR CORRECTION       |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | ANGLE TOLERANCE FROM 1° TO 2°   |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | CORRECTED SHEAR AND TENSILE     |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | REVISED, COUNTERSUNK LENGTH A.V |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | INITIAL RELEASE                 |  |      |
| DRAWING NUMBER:                 |  | ABA-ACA/ CLOSED END SERIES  |  | DESCRIPTION                     |  |      |

