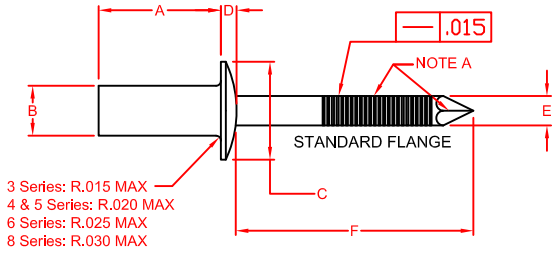
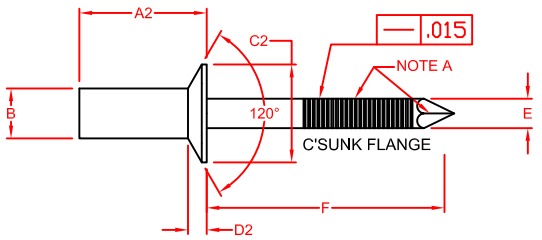
RIVETKING® STANDARD BLIND RIVETS - ALL STAINLESS STEEL - CLOSED END



NOTE A: MANDREL POINT AND GROOVE PATTERN PER RIVETKING STANDARD



NOTE A: MANDREL POINT AND GROOVE PATTERN PER RIVETKING STANDARD

	SIZE	GRIP RANGE		A RIVET LENGTH	A 2 RIVET LENGTH	B RIVET DIA.	E MANDREL DIA.	F MANDREL PROTRUDE	PERFORMANCE SHEAR LBS, F	PERFORMANCE TENSILE LBS, F
3/32"	32	.020	.125	.250 MAX	.280 MAX	.096 .090	.061 .053	1.00 MIN.	90 MIN.	120 MIN.
	34	.126	.250	.375 MAX	.400 MAX					
1/8"	41	.020	.062	.297 MAX	.332 MAX	.128 .122	.074 .066	1.00 MIN.	400 MIN.	450 MIN.
	42	.063	.125	.360 MAX	.395 MAX					
	43	.126	.187	.422 MAX	.457 MAX					
	44	.188	.250	.485 MAX	.520 MAX					
	45	.251	.312	.547 MAX	.582 MAX					
	46	.313	.375	.610 MAX	.645 MAX					
	48	.376	.500	.735 MAX	.770 MAX					
5/32"	52	.020	.125	.375 MAX	.425 MAX	.159 .153	.092 .084	1.06 MIN.	700 MIN.	800 MIN.
	53	.126	.187	.437 MAX	.487 MAX					
	54	.188	.250	.500 MAX	.550 MAX					
	55	.251	.312	.562 MAX	.612 MAX					
	56	.313	.375	.625 MAX	.675 MAX					
	58	.376	.500	.750 MAX	.800 MAX					
3/16"	62	.020	.125	.406 MAX	.471 MAX	.191 .183	.110 .102	1.06 MIN.	850 MIN.	900 MIN.
	63	.126	.187	.468 MAX	.538 MAX					
	64	.188	.250	.531 MAX	.601 MAX					
	66	.251	.375	.656 MAX	.736 MAX					
	68	.376	.500	.781 MAX	.851 MAX					
	610	.501	.625	.906 MAX	1.026 MAX					
	612	.626	.750	1.026 MAX	1.101 MAX					
1/4"	82	.020	.125	.445 MAX	.525 MAX	.255 .246	.146 .138	1.25 MIN.	900 MIN.	1100 MIN.
	84	.126	.250	.570 MAX	.650 MAX					
	86	.251	.375	.695 MAX	.775 MAX					
	88	.376	.500	.820 MAX	.900 MAX					
	810	.501	.625	.945 MAX	1.025 MAX					
	812	.626	.750	1.070 MAX	1.150 MAX					
	814	.751	.875	1.195 MAX	1.275 MAX					
	816	.876	1.000	1.320 MAX	1.400 MAX					

STANDARD FLANGE - DOME HEAD		
PART NUMBER	C HEAD DIA.	D HEAD HEIGHT
FBF 32 CE	.198 .178	.032 .022
FBF 34 CE		
FBF 41 CE	.252 .224	.050 .040
FBF 42 CE		
FBF 43 CE		
FBF 44 CE		
FBF 45 CE		
FBF 46 CE		
FBF 48 CE		
FBF 52 CE	.328 .296	.065 .055
FBF 53 CE		
FBF 54 CE		
FBF 55 CE		
FBF 56 CE		
FBF 58 CE		
FBF 62 CE	.394 .356	.080 .070
FBF 63 CE		
FBF 64 CE		
FBF 66 CE		
FBF 68 CE		
FBF 610CE		
FBF 612CE		
FBF 82 CE	.525 .475	.100 .090
FBF 84 CE		
FBF 86 CE		
FBF 88 CE		
FBF 810CE		
FBF 812CE		
FBF 814CE		
FBF 816CE		

COUNTERSUNK FLANGE		
PART NUMBER	C2 HEAD DIA.	D2 HEAD HEIGHT
FCF 32 CE	.187 .161	.027 MAX.
FCF 34 CE		
FCF 41 CE	.245 .221	.042 MAX.
FCF 42 CE		
FCF 43 CE		
FCF 44 CE		
FCF 45 CE		
FCF 46 CE		
FCF 48 CE		
FCF 52 CE	.328 .296	.051 MAX.
FCF 53 CE		
FCF 54 CE		
FCF 55 CE		
FCF 56 CE		
FCF 58 CE		
FCF 62 CE	.394 .356	.060 MAX.
FCF 63 CE		
FCF 64 CE		
FCF 66 CE		
FCF 68 CE		
FCF 610CE		
FCF 612CE		
FCF 82 CE	.525 .475	.080 MAX.
FCF 84 CE		
FCF 86 CE		
FCF 88 CE		
FCF 810CE		
FCF 812CE		
FCF 814CE		
FCF 816CE		

REV		DESCRIPTION	DATE
E		REVISED, ERROR CORRECTION	5-18-2016
D		ANGLE TOLERANCE PROM 1° TO 2°	3-18-2016
C		REVISED, COUNTERSUNK LENGTH A.V	4-12-11
B		CORRECTED TYPO	01-29-10
A		INITIAL RELEASE	09-29-09

SURFACE TREATMENT	RIVET: Bright Polish MANDREL: Bright Polish
HEAT TREATMENT:	RIVET: Belt Anneal@2000°F for 20 Minutes&Cool EYELET: Vacuum Anneal @ 1900°F for 3 Hours MANDREL: None
MATERIAL:	RIVET: 18-8 Stainless Steel per MS-03 MANDREL: 400 Series Stainless Steel PER RIVETKING SPEC# MS-03 & IFI Grade 51

PROCESSING

MTL RCPT → COLDFORM1 → ANNEAL → FINISH → COLDFORM2 → FINISH → ASS'LY → FQC → PACK

DESCRIPTION: ALL STAINLESS BLIND RIVETS

DRAWN: SBS | DATE: 4-1-08 | CHECKED: JGE | SHEET 1 OF 1

DIMENSIONS IN INCHES UNLESS OTHERWISE STATED. METRIC DIMENSIONS IN PARENTHESIS REMOVE ALL BURRS AND SHARP EDGES

ORIGINAL SHEET SIZE 8.5" X 11"

LIMITS UNLESS STATED: DECIMAL ±.015 ANGULAR ±2° SURFACE TEXTURE

Industrial Rivet & Fastener Co.

200 PARIS AVENUE
NORTHVALE, NJ. 07647
TEL: (201) 750 1040
info@rivet.com

DRAWING NUMBER: FBF-FCF/ CLOSED END SERIES

REV: E

MASTER DWG: BR-OE-2008-1 | LOCN: SERVER/BLUEPRINTS/4-INTERNAL/MAST