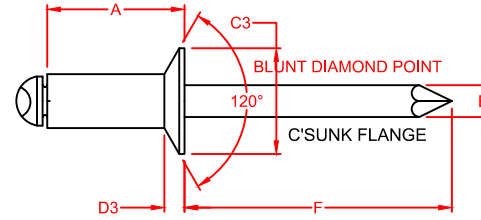
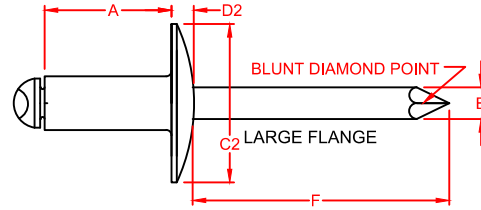
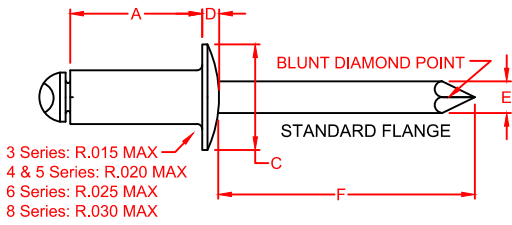


RIVETKING® BLIND RIVETS - OPEN END

ALUMINUM/STEEL



| RIVET DIA. | SIZE CODE | GRIP RANGE | | LENGTH | BODY DIA. | MANDREL DIA NOM. | MANDREL PROTRUDE MIN. | SHEAR LBS.F MIN. | TENSILE LBS.F MIN. | | | | | | |
|------------|-----------|------------|-------|--------|--------------|------------------|-----------------------|------------------|--------------------|------|--------------|------|------|-----|-----|
| | | MIN | MAX | | | | | | | | | | | | |
| 3/32" | 32 | .020 | .125 | .250 | .096 | .057 | 1.00 | 70 | 80 | | | | | | |
| | 34 | .126 | .250 | .375 | .090 | | | | | | | | | | |
| 1/8" | 41 | .020 | .062 | .212 | .128 .122 | .076 | 1.00 | 120 | 150 | | | | | | |
| | 42 | .063 | .125 | .275 | | | | | | | | | | | |
| | 43 | .126 | .187 | .337 | | | | | | | | | | | |
| | 44 | .126* | .250 | .400 | | | | | | | | | | | |
| | 45 | .251 | .312 | .462 | | | | | | | | | | | |
| | 46 | .251 | .375 | .525 | | | | | | | | | | | |
| | 48 | .376 | .500 | .650 | | | | | | | | | | | |
| | 410 | .501 | .625 | .775 | | | | | | | | | | | |
| 5/32" | 52 | .020 | .125 | .300 | .159 .153 | .096 | 1.06 | 190 | 230 | | | | | | |
| | 53 | .126 | .187 | .362 | | | | | | | | | | | |
| | 54 | .126* | .250 | .425 | | | | | | | | | | | |
| | 56 | .251 | .375 | .550 | | | | | | | | | | | |
| | 58 | .376 | .500 | .675 | | | | | | | | | | | |
| | 510 | .501 | .625 | .800 | | | | | | | | | | | |
| 3/16" | 62 | .020 | .125 | .325 | .191 .183 | .114 | 1.06 | 260 | 320 | | | | | | |
| | 63 | .126 | .187 | .387 | | | | | | | | | | | |
| | 64 | .126* | .250 | .450 | | | | | | | | | | | |
| | 66 | .251 | .375 | .575 | | | | | | | | | | | |
| | 68 | .376 | .500 | .700 | | | | | | | | | | | |
| | 610 | .501 | .625 | .825 | | | | | | | | | | | |
| | 612 | .626 | .750 | .950 | | | | | | | | | | | |
| | 614 | .751 | .875 | 1.075 | | | | | | | | | | | |
| | 616 | .876 | 1.000 | 1.200 | | | | | | | | | | | |
| | 620 | 1.126 | 1.250 | 1.450 | | | | | | | | | | | |
| | 1/4" | 82 | .020 | .125 | | | | | | .375 | .255 .246 | .151 | 1.25 | 460 | 560 |
| | | 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 | | | | | | | | | | | |
| 818 | | 1.001 | 1.125 | 1.375 | | | | | | | | | | | |
| 820 | | 1.126 | 1.250 | 1.500 | | | | | | | | | | | |

| STANDARD FLANGE - DOME HEAD | | |
|-----------------------------|-----------|---------------|
| PART NUMBER | C | D |
| | HEAD DIA. | HEAD HT. MAX. |
| ABS 32 /IR | .198 | .032 |
| ABS 34 /IR | .178 | |
| ABS 41 /IR | | |
| ABS 42 /IR | | |
| ABS 43 /IR | | |
| ABS 44 /IR | .262 | .040 |
| ABS 45 /IR | .238 | |
| ABS 46 /IR | | |
| ABS 48 /IR | | |
| ABS 410 /IR | | |
| ABS 52 /IR | | |
| ABS 53 /IR | | |
| ABS 54 /IR | | |
| ABS 56 /IR | .328 | .050 |
| ABS 58 /IR | .296 | |
| ABS 510 /IR | | |
| ABS 512 /IR | | |
| ABS 62 /IR | | |
| ABS 63 /IR | | |
| ABS 64 /IR | | |
| ABS 66 /IR | | |
| ABS 68 /IR | | |
| ABS 610 /IR | .394 | .060 |
| ABS 612 /IR | .356 | |
| ABS 614 /IR | | |
| ABS 616 /IR | | |
| ABS 620 /IR | | |
| ABS 82 /IR | | |
| ABS 84 /IR | | |
| ABS 86 /IR | | |
| ABS 88 /IR | | |
| ABS 810 /IR | .525 | .080 |
| ABS 812 /IR | .475 | |
| ABS 814 /IR | | |
| ABS 816 /IR | | |
| ABS 818 /IR | | |
| ABS 820 /IR | | |

| LARGE FLANGE - DOME HEAD | | |
|--------------------------|-----------|---------------|
| PART NUMBER | C2 | D2 |
| | HEAD DIA. | HEAD HT. MAX. |
| ABS 32LF /IR | .293 | .040 |
| ABS 34LF /IR | .269 | |
| ABS 41LF /IR | | |
| ABS 42LF /IR | | |
| ABS 43LF /IR | | |
| ABS 44LF /IR | .390 | .065 |
| ABS 45LF /IR | .360 | |
| ABS 46LF /IR | | |
| ABS 48LF /IR | | |
| ABS 410LF /IR | | |
| ABS 52LF /IR | | |
| ABS 53LF /IR | | |
| ABS 54LF /IR | | |
| ABS 56LF /IR | .488 | .075 |
| ABS 58LF /IR | .448 | |
| ABS 510LF /IR | | |
| ABS 512LF /IR | | |
| ABS 62LF /IR | | |
| ABS 63LF /IR | | |
| ABS 64LF /IR | | |
| ABS 66LF /IR | | |
| ABS 68LF /IR | | |
| ABS 610LF /IR | .650 | .092 |
| ABS 612LF /IR | .600 | |
| ABS 614LF /IR | | |
| ABS 616LF /IR | | |
| ABS 620LF /IR | | |
| ABS 82LF /IR | | |
| ABS 84LF /IR | | |
| ABS 86LF /IR | | |
| ABS 88LF /IR | | |
| ABS 810LF /IR | .780 | .107 |
| ABS 812LF /IR | .720 | |
| ABS 814LF /IR | | |
| ABS 816LF /IR | | |
| ABS 818LF /IR | | |
| ABS 820LF /IR | | |

| COUNTERSUNK HEAD | | |
|------------------|-----------|---------------|
| PART NUMBER | C3 | D3 |
| | HEAD DIA. | HEAD HT. REF. |
| ACS 32 /IR | .187 | |
| ACS 34 /IR | .161 | .027 |
| ACS 41 /IR | | |
| ACS 42 /IR | | |
| ACS 43 /IR | | |
| ACS 44 /IR | .233 | .031 |
| ACS 45 /IR | .207 | |
| ACS 46 /IR | | |
| ACS 48 /IR | | |
| ACS 410 /IR | | |
| ACS 52 /IR | | |
| ACS 53 /IR | | |
| ACS 54 /IR | | |
| ACS 56 /IR | .294 | .040 |
| ACS 58 /IR | .268 | |
| ACS 510 /IR | | |
| ACS 512 /IR | | |
| ACS 62 /IR | | |
| ACS 63 /IR | | |
| ACS 64 /IR | | |
| ACS 66 /IR | | |
| ACS 68 /IR | | |
| ACS 610 /IR | .361 | .050 |
| ACS 612 /IR | .335 | |
| ACS 614 /IR | | |
| ACS 616 /IR | | |
| ACS 620 /IR | | |
| ACS 82 /IR | | |
| ACS 84 /IR | | |
| ACS 86 /IR | | |
| ACS 88 /IR | | |
| ACS 810 /IR | .484 | .060 |
| ACS 812 /IR | .456 | |
| ACS 814 /IR | | |
| ACS 816 /IR | | |
| ACS 818 /IR | | |
| ACS 820 /IR | | |

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| | | | | | | | | | | | | | |
|----------------------|--|---|----------------|--------------|--|-----------------|--|---------------|---|---|--|--|--|
| DRAWN: S. SHERMAN | | DATE: 4-1-08 | CHECKED: ZAISS | SHEET 1 OF 1 | 5052 ALUMINUM/STEEL OPEN END BLIND RIVETS | | | | 200 PARIS AVENUE NORTHVALE, NJ, 07647 TEL: (201) 750 1040 info@rivet.com | | ABS-ACS/5052 SERIES I MASTER DWG: BR-02-2008-1 LOCK: SERVER/BLUEPRINTS/4-INTERNAL/MAST | | |
| SURFACE TREATMENT | | RIVET: Bright Polish MANDREL: Zinc ROHS Cr3+ or PHOS | | | | | | | | | | | |
| HEAT TREATMENT: | | N/R | | | | | | | | | | | |
| MATERIAL: | | RIVET: 5052M Aluminum per MS-01 MANDREL: C1022-1045M Steel per MS-02 SPEC# IFT Grade 18 RIVETKING# MS-01/02 | | | | | | | | | | | |
| MTL RCPT | | COLDFORM1 | | FINISH | | PROCESSING | | STRAIN RELIEF | | FQC | | PACK | |
| COLDFORM2 | | FINISH | | ASS'LY | | FQC | | PACK | | REV: | | | |
| LIMITS UNLESS STATED | | ±.015 | | ANGULAR ±2° | | SURFACE TEXTURE | | | | DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED DIMENSIONS IN PARENTHESES REMOVE ALL BURRS AND SHARP EDGES ORIGINAL SHEET SIZE 8.5" X 11" | | Industrial Rivet & Fastener Co. | |
| DESCRIPTION: | | | | | | | | | | | | | |
| DRAWING NUMBER: | | | | | | | | | | | | | |
| REV: | | | | | | | | | | | | | |
| H | | 2022 REVIEW, IFT ALIGNMENT, TYPO CORRECTION | | | | | | | | | | | |
| DATE | | 1-1-2022 | | | | | | | | | | | |