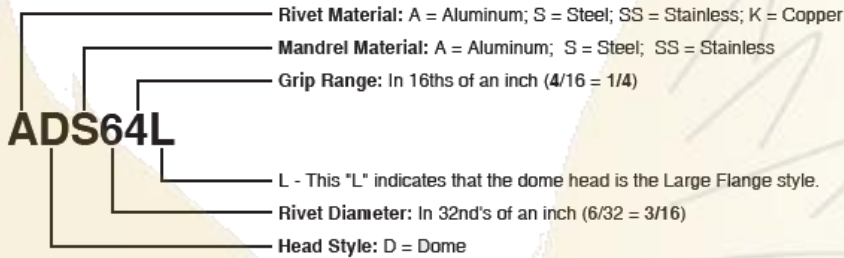


RIVET SELECTION KEY



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 which are listed on pages 178-188.

APPLICATION DATA FOR STANDARD BREAK-STEM BLIND RIVETS						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												
41	.020-.062	.212	0.133	0.129	#30	68	.376-.500	.700						
42	.063-.125	.275												
43	.126-.187	.337												
44	.188-.250	.400												
45	.251-.312	.462												
46	.313-.375	.525												
48	.376-.500	.650												
52	.020-.125	.300				0.164	0.160	#20				610	.510-.625	.825
53	.125-.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												
									84	.126-.250	.500	0.261	0.257	F
									86	.251-.375	.625			
						88	.376-.500	.750						
						810	.501-.625	.875						
						812	.626-.750	.990						
						816	.751-1.000	1.240						
						620	1.126-1.250	1.450						
						622	1.251-1.375	1.575						