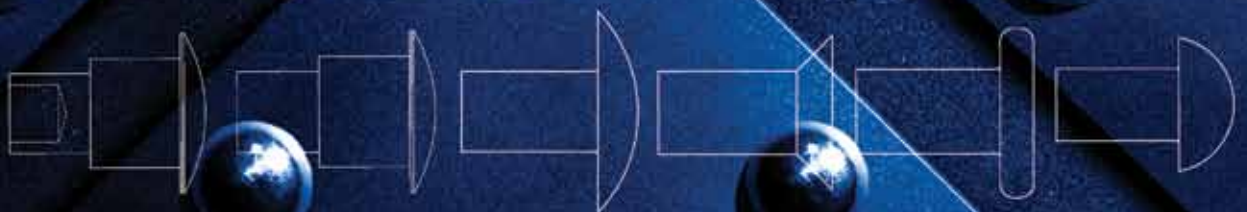




## **RIVETKING® IMPACT RIVET CATALOG**

**Semi Tubular Rivets • Solid Rivets: Steel, Brass, Stainless, Copper & Monel • Aluminum Rivets • Various Specials • Retainer Lock Pins • Setting Equipment**



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## U.S. Locations

- 1 Northvale, New Jersey
- 2 Los Angeles, California
- 3 Bristol, Connecticut
- 4 Denver, Colorado
- 5 Kansas City, Missouri
- 6 El Paso, Texas
- 7 Grand Prairie, Texas
- 8 Salt Lake City, Utah
- 9 Chicago, Illinois
- 10 Burlington, North Carolina

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- 11 Ontario, Canada
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- 13 Madrid, Spain
- 14 Tainan, Taiwan
- 15 Neumarkt, Germany
- 16 Shanghai, China
- 17 Milton Keynes, United Kingdom
- 18 Sydney, Australia

Stock is available for same day shipment from any one of our many locations. Sales representatives and technical support staff are available to our customers nationwide.

### Contact

To order our products, or if you have any questions, please contact our customer service team.

Phone: 1.800.Buy.Rivet (1.800.289.7483)

Fax: 201.750.1050

Website: [www.rivet.com](http://www.rivet.com)



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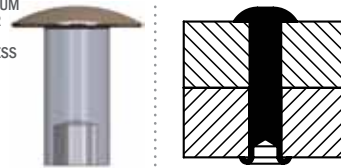
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# RIVETKING® RIVET TYPES

## SEMI TUBULAR OVAL/ TRUSS HEAD

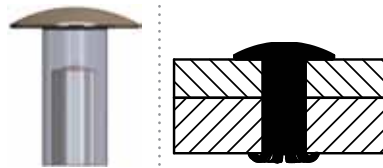
- STEEL
- ALUMINUM
- COPPER
- BRASS
- STAINLESS STEEL



To permanently fasten assemblies of metal, wood, plastic, ceramic, leather or composition materials with pre-punched or pre-drilled holes. Provides high strength and low unit cost. Fast easy clinching on high speed, automatic feed riveting machines provide high productivity using unskilled labor for a low installed cost.

PAGES 03,04,06

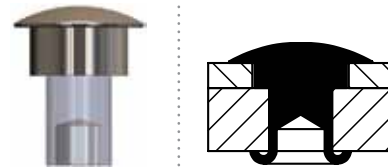
## SEMI TUBULAR DEEP-HOLE



To permanently fasten two or more pieces to relatively soft materials such as leather, cardboard, canvas, rubber, plastics or other similar materials with the rivet normally punching its own hole. Eliminates the cost of pre-punching or pre-drilling holes, which together with low unit cost and fast easy clinching on high speed automatic feed riveting machines, means high productivity and lowest total cost.

PAGE 02

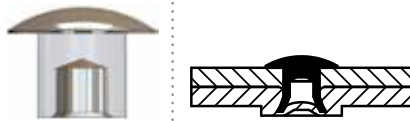
## SEMI TUBULAR SHOULDER RIVET



To permanently fasten assemblies of metal, wood, plastic, ceramic, leather or composition materials with pre-punched or pre-drilled holes. Provides high strength and low unit cost. Fast easy clinching on high speed, automatic feed riveting machines provide high productivity using unskilled labor for a low installed cost.

PAGES 02,03,04

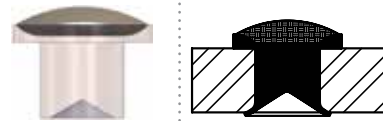
## METAL PIERCING



To join two or more sections of a sheet metal assembly permanently and without pre-punching or pre-drilling holes. Eliminates the cost of pre-punching or pre-drilling holes and reduces material handling. Low unit cost and applied by high speed automatic feed riveting machines to further reduce assembly time and cost. Setting can provide a leakproof seal.

PAGE 11

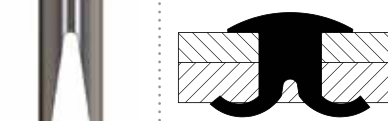
## SEMI TUBULAR ELECTRICAL CONTACT



To act as an electrical contact. Electrical contact rivets can be made with precious metals such as gold, silver, platinum, copper as well as silver-cadmium oxide materials. The manufacturing method is extremely economical because the contact face can be produced of high performance precious metals while the shank can be made of lower cost metals. Also known as Bi-Metal or Tri-Metal rivets.

PAGE 11

## SPLIT RIVETS (BIFURCATED)



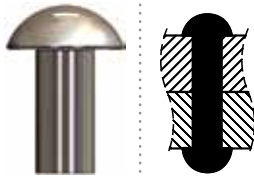
Split rivets are typically used in the luggage, case and leather goods industries to fasten soft materials such as plastics, animal hide and wood. With automatic setting equipment it can pierce through soft materials without a pre-punched hole. Typically offered in Steel or Brass material with a host of metal finishes such as zinc, nickel, or brass plating.

PAGES 02,03,11

## SOLID RIVETS

### SOLID SMALL DIAMETER:

- STEEL
- ALUMINUM
- COPPER
- BRASS
- STAINLESS STEEL



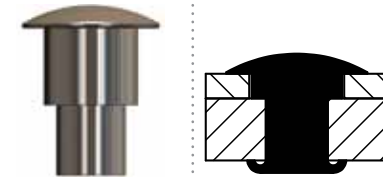
### SOLID LARGE DIAMETER:

- STEEL ONLY

To permanently fasten two or more pieces of metal with pre-punched or pre-drilled holes. Worked end of rivet may be spun to produce a finished appearance matching the head of the rivet.

PAGES 03,14,15

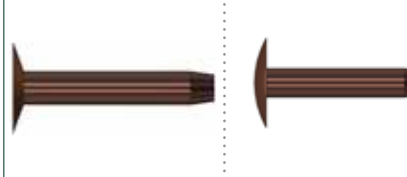
## SOLID SHOULDER RIVET



To act as a pivot, hinge pin or slide pin. Lower unit cost than similar screw machine parts and with the added benefit of being set on automatic feed riveting machines for minimal overall cost. Tenon may be completely solid or Semi Tubular as shown.

PAGES 02,03

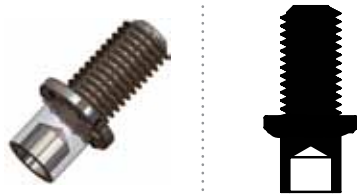
## COPPER BELT/ TRUNK RIVETS



Belt Rivets are used to repair antique machine belts. Trunk Rivets were once used as a way to rivet luggage, trunks or large cases. Both are also used in various decorative applications. They can be peened with a hammer or used together with a special washer called a riveting burr.

PAGE 20

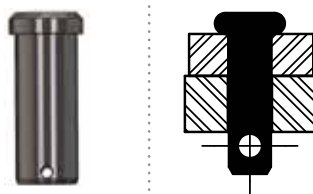
## COLLAR RIVETS



To act as a guide peg or anchor stud for a pivoting assembly. May be supplied completely solid or Semi Tubular as shown. Can be applied/ fed with auto feed machines.

PAGES 01,02

## CLEVIS PIN (CROSS DRILLED)



To act as a hinge pin or a semi-permanent fastener where the strength of a permanent fastener is required. Generally secured with a cotter pin.

PAGES 01,02

## LOCK PINS



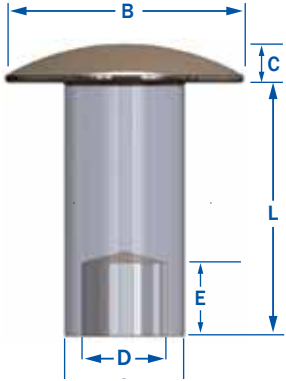

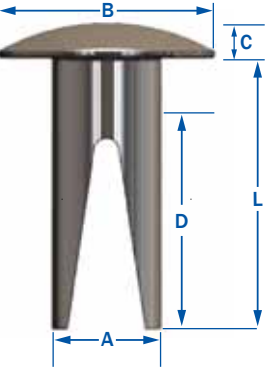
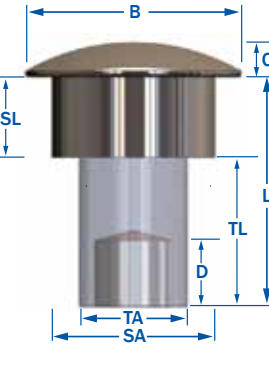
Used to secure the latch on a hitch assembly for tractors, trucks or trailers. Offered with or without a vinyl coated steel lanyard. Available in Steel with Zinc or high salt spray Zinc Nickel Plating.

PAGE 02





# RIVETKING® RIVET TYPES - GENERAL SPECIFICATIONS

SEMI TUBULAR	SOLID	BIFURCATED	SHOULDER
			
<p><b>A</b> — BODY DIAMETER  <b>B</b> — HEAD DIAMETER  <b>C</b> — HEAD THICKNESS  <b>D</b> — HOLE DEPTH TO APEX  <b>L</b> — RIVET LENGTH</p>	<p><b>A</b> — BODY DIAMETER  <b>B</b> — HEAD DIAMETER  <b>C</b> — HEAD THICKNESS  <b>L</b> — RIVET LENGTH</p>	<p><b>A</b> — BODY DIAMETER  <b>B</b> — HEAD DIAMETER  <b>C</b> — HEAD THICKNESS  <b>D</b> — HOLE DEPTH  <b>L</b> — RIVET LENGTH</p>	<p><b>B</b> — HEAD DIAMETER  <b>C</b> — HEAD THICKNESS  <b>SL</b> — SHOULDER LENGTH  <b>TL</b> — TENON LENGTH  <b>SA</b> — SHOULDER DIAMETER  <b>TA</b> — TENON DIAMETER  <b>D</b> — HOLE DEPTH TO APEX  <b>L</b> — RIVET LENGTH</p>

## HOW TO USE

Semi Tubular rivets can be used to join two or more pre-drilled or pre-punched components.	Used to join two or more pre-drilled or pre-punched components. Offered in a full range of diameters and lengths.	Used to permanently join soft material such as leather to fiber, rubber, wood, canvas and some plastics.	Used when a rivet or post is desired that is permanent by fastening and function as pivots. Ideal for applications on жалюзи, baby carriages, pulleys, shelving and automotive parts.
It is most economically set with an autofeed riveting machine	Also can be used as a pin.		

## HOW TO CLINCH

Use a roll or scored clinch. A roll clinch is stronger. For a uniform appearance, a cap may be used on the clinched end.	Can be impact set on a press or auto feed riveting machine. Can also be set on radial forming machines.	With anvils that spread the prongs flush with material or turned into the material. Can be used with caps or against washers to prevent clinch from tearing loose.	Clinching is similar to Semi Tubular rivet. Roll clinch or scored clinch. The roll clinch is stronger.
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## ADVANTAGES

High shear strength of solid rivet combined with ease of clinching on automatic, pneumatic and manually operated rivet setting machines.	Offered in diameters from 1/32" to 1". Length possibilities are unlimited. Offers the highest shear strength of any fastener and has excellent clamp up force. Used in applications from small electronics to bridge building.	Eliminate the cost of pre-punching or pre-drilling of holes in material without weakening the assembly by removing of material.	Shoulder rivets combine low cost with ease of assembly for permanent fastening with automatic rivet setting machines.
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**GENERAL**— These Semi Tubular rivet standards cover the complete general and dimensional data for oval head, truss head, flat head, 90° and 120° countersunk head rivets.

The inclusion of dimensional data in this standard is not intended to imply that all of the products described are stock production sizes.

**HEADS**— The bearing surface of flat, oval, and truss head rivets shall be at right angles to the axis of the body within 2°. Heads of all Semi Tubular rivets shall not be eccentric with the shank beyond a tolerance of 3% of the maximum head diameter. Because the heads are not machined or trimmed, the circumference may be slightly irregular and the edges rounded or flat.

**UNDERHEAD FILLETS**— Rivets, other than countersunk type, shall be furnished with a definite fillet under the head but radius of fillet shall not exceed 10% of maximum shank diameter.

**MATERIAL**— Semi Tubular rivets shall be low carbon steel, or brass, standard with manufacturer; or stainless steel, aluminum, copper or other metals as agreed upon between the purchaser and supplier.

**LENGTH**— Length of rivets shall be measured as indicated in the illustrations for each head style. Semi Tubular rivets are available in length increments specified.

**WORKMANSHIP**— Semi Tubular rivet end irregularities shall not be such that usability of rivet is impaired. Rivets shall be free from surface seams, splits, and all other defects that might affect their serviceability.

## WHEN IT DOESN'T HAVE TO COME APART A RIVET IS YOUR MOST LOGICAL FASTENER, HERE'S WHY...

### ONE OF THE LOWEST COST FASTENERS

Rivets are used in many major consumer and industrial products made today. Designers and assemblers have long recognized that riveting is one of the least expensive and most versatile assembly methods available.

### CAN BE USED WITH MOST ANY MATERIAL

Rivets have been successfully set in wood, metals, plastics, fiberboard, cloth and ceramics. It is a strong fastener. All other things being equal, no other fastener - for its size and simplicity - can equal the shear strength of a rivet.

### CAN BE USED FOR MANY PURPOSES

Rivets are not only used to fasten two or more parts but often provide a dual function. They have been used as pivots, hinges, levers, terminals, electrical contacts, cam followers, decorative items and in hundreds of other ways. The only limiting factor to the use of rivets is the designer's imagination.

### IS A LOW COST PRODUCTION METHOD

Compared to other assembly machines, rivet setting equipment is lowest in cost. Since the riveting operation is automatic, non-skilled operators can quickly perform the work and lengthy training is not necessary.

### IT'S GEARED TO MOST PRODUCTION REQUIREMENTS

Depending on the assembly, rivets can be set at extremely high speeds or to meet the optimum production capabilities of the operator. Machines have been built to feed several parts of the assembly simultaneously and to achieve most any degree of mechanization necessary.

### SOME LIMITATIONS

Tensile and fatigue strengths are lower than bolts. High tensile loads and extreme vibrations can pull out the set.

Once set with rivets, an assembly cannot be disassembled for maintenance purposes.

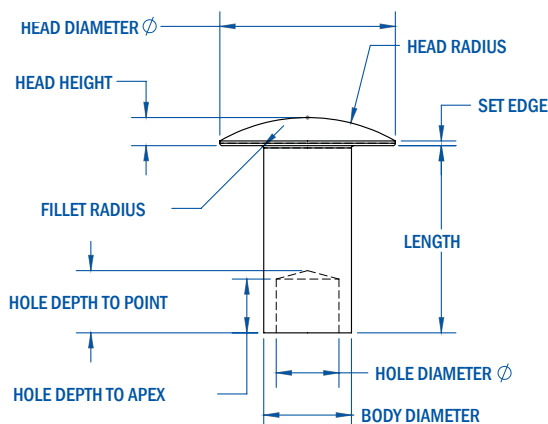
While rivets can be made to close tolerances, they are not usually as highly a precision fastener as a screw machine part may be. Where rivets are required for close tolerance assemblies, please consult our sales department.

### AVAILABLE IN A GREAT VARIETY OF FINISHES

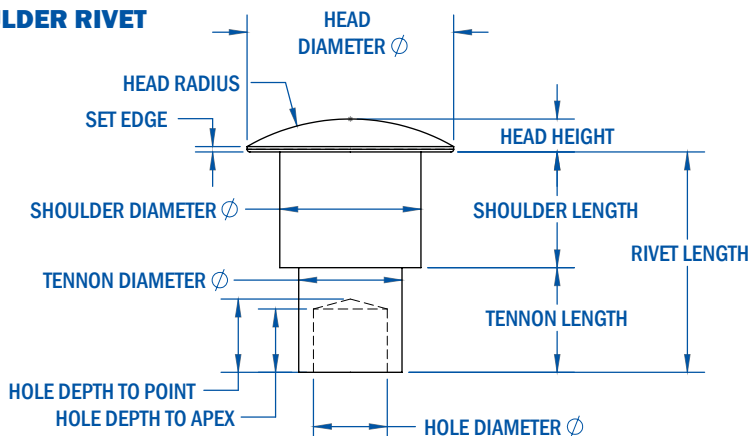
They can be made from copper, brass, steel, aluminum, stainless steel and any material that can be cold-heated. If color is desired, they are plated, Japanned or painted.

## ANATOMY OF THE SEMI TUBULAR RIVET

### SEMI TUBULAR RIVET



### SEMI TUBULAR SHOULDER RIVET





# RIVETKING® SEMI TUBULAR RIVETS DESIGN CONSIDERATIONS

## RIVET DESCRIPTIONS AND DIMENSIONS

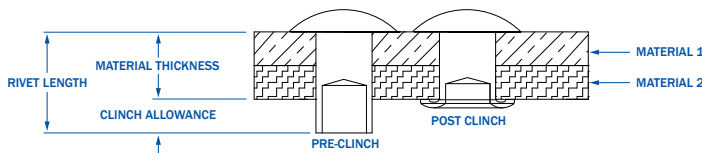
The standard Semi Tubular Rivet is made of 3 major components with 6 dimensional values, all of which are required in order to produce the rivet.

- 1) Body or Shank (Diameter & Length)
- 2) Head (Diameter & Height)
- 3) Hole (Diameter & Depth)

Custom rivets are sometimes produced with an additional component called a "shoulder". In this case, additional diameter and shoulder length dimensions are required for each shoulder. Rivets can be made with multiple shoulders, however, it is suggested that Semi Tubular rivets be designed with only one shoulder. When a shoulder rivet is required, the hole depth should not extend into or past the shoulder, as this causes problems in the manufacturing process and may adversely affect the functionality of the rivet.

## RIVET LENGTH AND CLINCH ALLOWANCE LENGTH

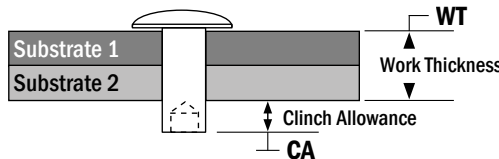
A portion of the rivet length is required for clinching the Semi Tubular rivet. As a general rule of thumb this is usually figured at about 55% of the rivet diameter. Because rivets have been standardized, we have calculated the required clinch allowances for standard rivets in the table below.



RIVET DIAMETER	1/16	3/32	1/8	9/64	5/32	3/16	7/32	1/4	9/32	5/16	3/8
MAX. CLINCH ALLOWANCE	.032	.045	.062	.093	.093	.110	.156	.156	.172	.187	.218

## LENGTH CALCULATION

$$CA + WT = \text{Rivet Length (RL)}(\text{Max.})$$



## RIVET LENGTH CALCULATION

$$WT = T_1 + T_2 + T_3 \dots$$

$$RL_{(\text{max})} = CA + WT$$

To calculate rivet length:

- a) Add up thicknesses,  $T_1 + T_2 + T_3 \dots =$  Work Thickness (WT)
- b) Select desired rivet diameter and locate the associated Clinch Allowance (CA)
- c) Add Work Thickness (WT) + Clinch Allowance (CA) = Maximum Rivet Length (RL)
- d) Select rivet below the Maximum Rivet Length to the nearest 1/32".

Example: Fasten 2 pieces of .125" thick steel with steel 3/16" (.375 head) rivets.

- a) .125 (T1) + .125 (T2) = .250 (WT)
- b) .110 (CA)
- c) .250 (WT) + .110 (CA) = .360 (RL) Max.
- d) .360 (RL) Max.,... Closest standard size .360" (RL)

Rivet Size: 3/16" x 11/32" Rivet King Part# XTT3750113Z

Adding the clinch allowance value to the total thickness of the assembly to be riveted, gives you the rivet shank length. If the rivet has a countersunk type head, the head thickness should be included in this length.

## PRESSURES TO UPSET A SEMI TUBULAR RIVET

To calculate the required pressure to set a Semi Tubular rivet, you will need to know the diameter and the material of the rivet.

A= Rivet Diameter

D= Rivet Hole I.D.

MTS= Material Tensile Strength (referenced in the same table as the formula)

$$\left( \left( \frac{A}{2} \right)^2 \pi - \left( \left( \frac{D}{2} \right)^2 \pi \right) \right) \times MTS \times 1.5$$

Typical Wire Tensile Strengths for Rivets: (Use as "MTS" for above calculation)

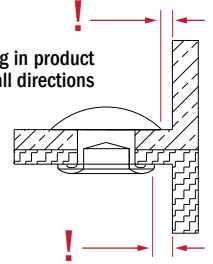
Steel: 80,000 psi	Stainless Steel: 100,000 psi	Aluminum: 50,000 psi
Copper: 40,000 psi	Brass: 70,000 psi	

## TOLERANCES

Tolerances should be considered as actually representing degree of error. Designs should start with zero tolerance (allowable error) being made only to fit the product designs into the manufacturing process. Many mechanical failures of product designs can be avoided. For example, the holes in two pieces to be assembled are deliberately made oversized so there will be no question of the rivet going through. However, these two pieces rotate separately around the rivet. Because of the sloppiness in the hole, an eventual elongation of the hole occurs resulting in the malfunction of the assembly.

## RIVET SETTING CLEARANCES

This is one of the most common oversights occurring in product designs. Sufficient clearances must be provided in all directions so that riveting equipment is able to get the rivet into the work piece for proper clinching. Axial access for clinching must be available both above and below the hole through which the rivet must pass. Clearances vary depending on the configuration of assembly, the thickness of assembly and the length of the rivet.



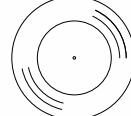
## HOLE CLEARANCES

Usually the smaller the rivet the less the clearances are required. As a general rule, the minimum hole clearance is .003" and the maximum is .008". When one rivet is set in an assembly, the minimum should be observed to assure the strongest clinch possible. If the two or more holes on an assembly are being set with rivets, clearances on the maximum side should be used. The amount of clearance depends largely on the ability of your production equipment to maintain close center to center hole location tolerances on the mating part to be riveted.

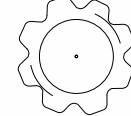
## CLINCH TYPE

There are two types of settings that are normally used in the clinching of Semi Tubular rivets; the Roll Clinch and the Scored Clinch. A Rolled Clinch gives the maximum strength when the rivets are set properly. When this clinch is used with soft materials, washers, (burrs) or caps will provide more bearing surface and a stronger clinch. A Scored Clinch holds best on soft materials since it can be turned into the material and spreads the clinch to provide a greater contact bearing surface.

Roll Clinch



Scored Clinch



## CORROSION PROTECTION

The corrosion factor of a particular rivet is dependent on the corrosion of the base metal, the protection layer (plating) and the conversion layer (chromate). Being that the most cost effective material to produce is steel, most prefer to protect the steel with a plating such as Zinc and a chromate. Rivets require a specialized plating and wax therefore it is highly suggested the manufacturer perform this task. For standard performance a SST rating (salt spray test) is about 48 hours until red rust. Other platings such as Zinc alloys (i.e. ZnNi, ZnFe and ZnTi) can extend the SST rating to 840 hours until red rust. Our in-house test facilities can test the rivet before and after setting according to the ASTM B117 standard.

## GALVANIC ACTION CORROSION

Galvanic Action is seldom considered in design but it can often be one of the hidden causes of failures. Galvanic corrosion is accelerated electromechanical corrosion created when a noble metal is in contact with another less noble metal, both being in a corroding medium (such as damp air). The less noble metal corrodes at a faster rate than normal while the noble metal acquires greater protection of corrosion. For example, an Aluminum (less noble metal) rivet in a copper (more noble metal) would cause aluminum to corrode at an accelerated rate while the copper would be virtually un-affected. Should you be in a position of having to join two dissimilar metals, be sure to refer to the Galvanic Series table.

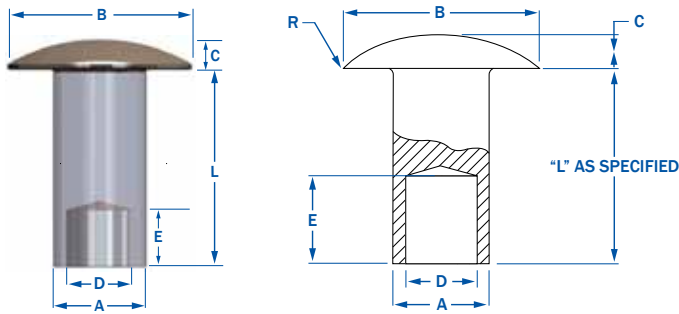
## RIVETING WITHOUT PREPARED HOLES

For some applications Semi Tubular rivets can be used without the need for preformed or pre drilled holes. Semi Tubular self-piercing rivets can be used with materials such as leather, some plastics, and light sheet metals. When piercing sheet metal, adjustments may be suggested to the rivet raw material, hole diameter and heat treatment. Self-piercing rivets can be used especially in difficult spot welding applications, piercing and fastening in just one step. They have excellent mechanical strength and fatigue performance. Since Semi Tubular self-piercing rivets can be automated, you can expect highly repeatable results.

# RIVETKING® OVAL/ TRUSS HEAD SEMI TUBULAR RIVET DIMENSIONS

SEMI TUBULAR RIVETS

COMMONLY MANUFACTURED & STOCKED IN MATERIALS:  
**STEEL, ALUMINUM, COPPER, BRASS**  
 PLATINGS: ZINC, NICKEL, ZNFE, ZNNI, COPPER FLASH, BRASS



RIVETKING® Semi Tubular Rivets are manufactured in accordance with internal standards and coated with a proprietary wax to insure a smooth rollover and clinch of the assembly.

To calculate the rivet length, add the material thicknesses to be riveted to the maximum clinch allowance "CA". The resulting value is the maximum allowed rivet length. Round off to the nearest 1/32" not exceeding the maximum allowed rivet length.

**JOINT STRENGTH TESTING CAN BE PERFORMED IN OUR LAB.**  
 Contact our applications engineering department for details.

PART CODE	RIVET SIZE	HEAD STYLE	A		B		C		D		E	L	R	CA	MIN. REF. HOLE SIZE
			MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	DEPTH TO APEX		REF.	REF.	
B-109	1/16"	OVAL	.061	.058	.114	.104	.019	.015	.044	.039	.046	As Specified by User	.16	.032	.067
B-125		TRUSS	.061	.058	.130	.120	.019	.015	.044	.039	.046		.13	.032	.067
F-147	3/32"	OVAL	.089	.085	.152	.142	.026	.020	.068	.062	.064		.22	.045	.093
F-156		TRUSS	.089	.085	.161	.151	.026	.022	.068	.062	.064		.22	.045	.093
G-187		OVAL	.099	.095	.192	.182	.032	.026	.076	.070	.077		.27	.055	.104
J-218	1/8"	OVAL	.123	.118	.223	.213	.038	.030	.090	.084	.094		.31	.062	.128
J-281		TRUSS	.123	.118	.286	.276	.038	.030	.090	.084	.094		.38	.062	.128
M-234	9/64"	OVAL	.146	.141	.239	.229	.045	.035	.107	.100	.126		.27	.093	.152
M-281			.146	.141	.286	.276	.045	.039	.107	.100	.126		.49	.093	.152
M-312		TRUSS	.146	.141	.318	.306	.045	.035	.107	.100	.126		.45	.093	.152
M-375			.146	.141	.381	.369	.065	.060	.107	.100	.126		.53	.093	.152
N-312	5/32"		.157	.152	.318	.306	.068	.058	.110	.103	.126		.31	.093	.165
T-312	3/16"	OVAL	.188	.182	.318	.306	.065	.055	.141	.134	.155		.25	.110	.196
T-375		TRUSS	.188	.182	.381	.369	.065	.055	.141	.134	.155		.53	.110	.196
U-437	7/32"	OVAL	.217	.210	.444	.430	.090	.085	.162	.154	.189		45	.140	.234
Y-437	1/4"		.252	.244	.444	.430	.075	.061	.184	.176	.219		.65	.156	.265
Y-500		OVAL	.252	.244	.507	.493	.085	.071	.184	.176	.219	.72	.156	.265	
V-437		TRUSS	.290	.280	.444	.430	.100	.090	.200	.190	.225	41	.175	.302	
Z-500	5/16"		.310	.302	.507	.493	.090	.085	.213	.206	.243	.59	.187	.328	
Z-562		OVAL	.310	.302	.570	.554	.100	.095	.219	.211	.243	.69	.187	.328	
W-562	3/8"		.377	.368	.570	.554	.100	.095	.286	.276	.312	.69	.218	.390	
W-625			.377	.368	.632	.618	.125	.115	.286	.276	.312	.63	.218	.390	

## SEMI TUBULAR LENGTH CALCULATION

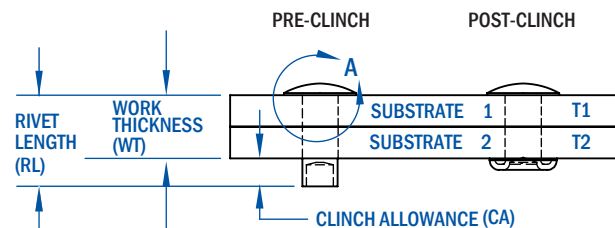
To calculate rivet length:

- Add up thicknesses, T1+T2+(T3...) = Work Thickness (WT)
- Select desired rivet diameter and locate the associated Clinch Allowance (CA)
- Add Work Thickness (WT) + Clinch Allowance (CA) = Maximum Rivet Length
- Select rivet below the Maximum Rivet Length to the nearest 1/32".

Example: Fasten 2 pieces of .125" thick steel with steel 3/16" (.375 head) rivets.

- .125 (T1) + .125 (T2) = .250 (WT)
- .110 (CA)
- .250 (WT) + .110 (CA) = .260 (RL) Max.
- .260 (RL) Max, ... Closest standard size .250" (RL)

Rivet Size: 3/16" x 1/4" Rivet King Part# XTT375008SZ





# RIVETKING® STEEL SEMI TUBULAR RIVET WEIGHT CHARTS

Pounds Per 1,000 Pieces

SEMI TUBULAR RIVETS

LENGTH	DIAMETER X HEAD DIAMETER							
	J-218	J-281	M-234	M-312	T-312	T-375	Y-437	Y-500
	1/8"	1/8"	9/64"	9/64"	3/16"	3/16"	1/4"	1/4"
0.125	0.43	0.65	-	-	-	-	-	-
0.140	0.48	0.69	-	-	-	-	-	-
0.156	0.53	0.75	0.71	0.93	-	-	-	-
0.187	0.63	0.85	0.86	1.07	1.54	1.86	-	-
0.219	0.73	0.95	1.00	1.21	1.80	2.11	-	-
0.250	0.83	1.04	1.14	1.35	2.03	2.35	4.00	4.61
0.281	0.93	1.14	1.29	1.50	2.27	2.59	4.44	5.05
0.312	1.03	1.24	1.43	1.64	2.51	2.83	4.89	5.49
0.344	1.13	1.34	1.57	-	2.76	3.07	5.35	5.94
0.375	1.22	1.44	1.71	1.92	3.00	3.32	5.79	6.38
0.406	1.32	1.54	1.86	2.07	3.24	3.55	6.22	6.83
0.437	1.42	1.64	2.00	2.21	3.48	3.80	6.66	7.27
0.469	1.52	1.74	2.14	2.36	3.73	4.04	7.12	7.73
0.500	1.62	1.84	2.29	2.50	3.97	4.29	7.56	8.17
0.531	1.72	1.94	2.43	2.64	4.21	4.52	8.01	8.60
0.562	1.82	2.03	2.57	2.78	4.45	4.77	8.45	9.04
0.594	1.92	2.14	2.71	2.93	4.70	5.01	8.90	9.50
0.625	2.02	2.23	2.86	3.07	4.94	5.25	9.34	9.95
0.656	2.12	2.32	3.00	-	5.18	5.49	9.78	10.39
0.687	2.21	2.43	3.14	3.36	5.42	5.73	10.22	10.83
0.719	2.32	2.54	-	3.51	5.67	5.98	10.68	11.28
0.750	2.42	2.64	3.43	3.64	5.90	6.22	11.12	11.72
0.781	2.51	2.74	-	-	6.15	6.46	11.56	12.16
0.812	2.61	2.83	3.72	3.93	6.39	6.70	12.00	12.60
0.844	2.72	2.93	3.86	4.08	6.64	6.95	12.45	13.06
0.875	2.82	3.03	4.00	4.21	6.88	7.19	12.89	13.51
0.906	2.92	3.13	4.14	4.35	7.12	7.43	13.33	13.94
0.937	3.02	3.23	4.29	4.50	7.36	7.67	13.78	14.38
0.969	3.11	3.33	4.43	4.65	7.60	7.91	14.23	14.83
1.000	3.21	3.43	4.57	4.78	7.85	8.16	14.67	15.27
1.031	3.31	3.53	-	4.93	8.08	8.40	15.11	15.72
1.062	3.41	3.63	4.86	5.07	8.33	8.64	15.55	16.16
1.094	3.51	3.73	5.00	5.22	8.57	8.88	16.01	16.61
1.125	3.61	3.83	5.14	5.35	8.82	9.13	16.45	17.05
1.156	3.71	3.92	5.29	5.50	9.05	9.37	16.89	17.49
1.187	3.81	4.02	5.43	5.64	9.30	9.61	17.33	17.93
1.219	3.91	4.12	5.58	5.79	9.54	9.86	17.79	18.39
1.250	4.01	4.22	5.71	5.93	9.79	10.10	18.23	18.84
1.281	4.10	4.32	5.86	6.07	10.02	10.34	18.67	19.27
1.312	4.20	4.42	6.00	6.21	10.26	10.58	19.11	19.71
1.344	4.30	4.52	6.15	6.36	10.51	10.83	19.56	20.17
1.375	4.40	4.62	6.38	6.50	10.75	11.06	20.01	20.61
1.406	4.50	4.72	6.43	6.64	10.99	11.31	20.45	21.05
1.437	4.60	4.82	6.57	6.79	11.23	11.54	20.89	21.49
1.469	4.70	4.91	6.72	6.93	11.48	11.80	21.34	21.95
1.500	4.80	5.01	6.86	7.07	11.72	12.03	21.78	22.39
1.531	4.90	5.11	7.00	7.21	11.96	12.28	22.22	22.83
1.562	5.00	5.21	7.15	7.36	12.20	12.51	22.67	23.27
1.594	5.09	5.31	7.29	7.51	12.45	12.77	23.12	23.72
1.625	5.19	5.41	7.43	7.65	12.69	13.00	23.56	24.16
1.656	5.29	5.51	7.57	7.78	12.93	13.24	24.00	24.60
1.687	5.39	5.61	7.72	7.93	13.17	13.48	24.44	25.05
1.718	5.49	5.71	7.86	8.07	13.41	13.72	24.88	25.49
1.750	5.59	5.81	8.00	8.22	13.66	13.97	25.33	25.94
1.812	5.79	6.00	8.29	8.50	14.14	14.45	26.22	26.82
1.875	5.99	6.21	8.57	8.79	14.63	14.94	27.11	27.72
1.937	6.18	6.40	8.86	9.07	15.11	15.42	27.99	28.60
2.000	6.39	6.61	9.14	9.36	15.59	15.90	28.90	29.50
2.125	-	-	-	-	16.56	16.87	30.67	31.28
2.187	-	-	-	-	-	17.36	-	32.16
2.250	-	-	-	-	17.53	17.85	32.45	33.05
2.375	-	-	-	-	18.50	18.82	34.22	34.83
2.437	-	-	-	-	-	19.30	35.11	35.71
2.500	-	-	-	-	19.47	19.79	36.00	36.60
2.625	-	-	-	-	-	20.76	37.78	38.38
2.750	-	-	-	-	21.40	21.72	39.56	40.17
3.000	-	-	-	-	23.34	23.66	43.11	43.72

# RIVETKING® ALUMINUM SEMI TUBULAR RIVET WEIGHT CHARTS

Pounds Per 1,000 Pieces

SEMI TUBULAR RIVETS

LENGTH	DIAMETER X HEAD DIAMETER							
	J-218	J-281	M-234	M-312	T-312	T-375	Y-437	Y-500
	1/8"	1/8"	9/64"	9/64"	3/16"	3/16"	1/4"	1/4"
0.125	0.15	0.23	-	-	-	-	-	-
0.140	0.17	0.24	-	-	-	-	-	-
0.156	0.19	0.26	0.25	0.33	-	-	-	-
0.187	0.23	0.30	0.30	0.38	0.55	0.66	-	-
0.219	0.26	0.33	0.35	0.43	0.63	0.74	-	-
0.250	0.30	0.37	0.40	0.48	0.71	0.83	1.42	1.63
0.281	0.32	0.41	0.45	0.53	0.80	0.91	1.57	1.79
0.312	0.36	0.44	0.51	0.58	0.89	1.00	1.73	1.94
0.344	0.40	0.48	0.55	-	0.98	1.09	1.89	2.10
0.375	0.43	0.51	0.61	0.68	1.06	1.18	2.04	2.26
0.406	0.47	0.55	0.65	0.74	1.15	1.26	2.20	2.41
0.437	0.50	0.58	0.71	0.78	1.23	1.34	2.35	2.57
0.469	0.54	0.61	0.75	0.84	1.32	1.43	2.52	2.73
0.500	0.58	0.65	0.81	0.88	1.40	1.51	2.67	2.89
0.531	0.61	0.68	0.86	0.93	1.49	1.60	2.83	3.04
0.562	0.64	0.72	0.91	0.98	1.57	1.68	2.99	3.20
0.594	0.68	0.76	0.96	1.04	1.66	1.78	3.15	3.36
0.625	0.71	0.79	1.01	1.09	1.75	1.86	3.30	3.51
0.656	0.75	0.83	1.06	-	1.83	1.95	3.46	3.67
0.687	0.78	0.86	1.11	1.19	1.92	2.03	3.61	3.83
0.719	0.82	0.90	-	1.24	2.00	2.12	3.77	3.98
0.750	0.86	0.93	1.21	1.29	2.09	2.20	3.93	4.15
0.781	0.89	0.96	-	-	2.17	2.28	4.09	4.30
0.812	0.93	1.00	1.32	1.39	2.26	2.37	4.24	4.45
0.844	0.96	1.04	1.36	1.44	2.35	2.45	4.41	4.62
0.875	1.00	1.07	1.42	1.49	2.43	2.54	4.56	4.77
0.906	1.03	1.11	1.46	1.54	2.52	2.62	4.71	4.92
0.937	1.06	1.14	1.52	1.59	2.60	2.71	4.87	5.09
0.969	1.10	1.18	1.56	1.64	2.69	2.80	5.03	5.24
1.000	1.13	1.22	1.62	1.69	2.77	2.89	5.18	5.40
1.031	1.17	1.24	-	1.74	2.86	2.97	5.35	5.56
1.062	1.21	1.28	1.72	1.79	2.94	3.06	5.50	5.71
1.094	1.24	1.31	1.77	1.84	3.03	3.14	5.66	5.88
1.125	1.28	1.35	1.82	1.90	3.11	3.22	5.82	6.03
1.156	1.31	1.39	1.87	1.94	3.21	3.31	5.97	6.18
1.187	1.34	1.42	1.92	2.00	3.29	3.39	6.12	6.34
1.219	1.38	1.46	1.97	2.04	3.37	3.49	6.29	6.50
1.250	1.41	1.49	2.02	2.10	3.46	3.57	6.44	6.65
1.281	1.45	1.53	2.07	2.14	3.54	3.66	6.60	6.82
1.312	1.49	1.57	2.13	2.20	3.63	3.74	6.76	6.97
1.344	1.52	1.60	2.17	2.24	3.71	3.83	6.91	7.13
1.375	1.56	1.63	2.23	2.30	3.80	3.91	7.08	7.29
1.406	1.59	1.67	2.27	2.35	3.88	4.00	7.23	7.44
1.437	1.63	1.70	2.33	2.40	3.97	4.08	7.38	7.59
1.469	1.67	1.74	2.37	2.45	4.06	4.17	7.55	7.76
1.500	1.70	1.77	2.43	2.50	4.15	4.26	7.70	7.91
1.531	1.73	1.81	2.47	2.55	4.23	4.34	7.85	8.07
1.562	1.76	1.85	2.53	2.60	4.31	4.43	8.02	8.23
1.594	1.80	1.88	2.58	2.65	4.40	4.51	8.17	8.39
1.625	1.84	1.92	2.63	2.70	4.48	4.60	8.33	8.54
1.656	1.87	1.94	2.68	2.75	4.57	4.68	8.49	8.70
1.687	1.91	1.98	2.73	2.81	4.65	4.77	8.64	8.85
1.718	1.94	2.02	2.78	2.85	4.74	4.85	8.79	9.01
1.750	1.98	2.05	2.83	2.91	4.83	4.94	8.96	9.17
1.812	2.04	2.12	2.93	3.01	5.00	5.11	9.27	9.48
1.875	2.12	2.20	3.04	3.11	5.17	5.28	9.59	9.80
1.937	2.19	2.27	3.13	3.21	5.34	5.45	9.90	10.11
2.000	2.26	2.33	3.24	3.31	5.52	5.62	10.21	10.43
2.125	-	-	-	-	5.86	5.97	10.84	11.06
2.187	-	-	-	-	-	6.14	-	11.37
2.250	-	-	-	-	6.19	6.31	11.47	11.68
2.375	-	-	-	-	6.54	6.66	12.10	12.32
2.437	-	-	-	-	-	6.82	12.41	12.62
2.500	-	-	-	-	6.88	6.99	12.73	12.94
2.625	-	-	-	-	-	7.34	13.35	13.57
2.750	-	-	-	-	7.57	7.68	13.99	14.20
3.000	-	-	-	-	8.25	8.37	15.24	15.46





# RIVETKING® STAINLESS STEEL SEMI TUBULAR RIVET WEIGHT CHARTS

Pounds Per 1,000 Pieces

SEMI TUBULAR RIVETS

LENGTH	DIAMETER X HEAD DIAMETER							
	J-218	J-281	M-234	M-312	T-312	T-375	Y-437	Y-500
	1/8"	1/8"	9/64"	9/64"	3/16"	3/16"	1/4"	1/4"
0.125	0.43	0.66	-	-	-	-	-	-
0.140	0.49	0.70	-	-	-	-	-	-
0.156	0.54	0.76	0.72	0.94	-	-	-	-
0.187	0.64	0.86	0.86	1.08	1.56	1.88	-	-
0.219	0.74	0.95	1.01	1.22	1.81	2.12	-	-
0.250	0.84	1.05	1.15	1.37	2.05	2.37	4.05	4.66
0.281	0.94	1.15	1.30	1.51	2.29	2.61	4.49	5.10
0.312	1.04	1.25	1.44	1.66	2.54	2.86	4.93	5.55
0.344	1.14	1.36	1.59	-	2.79	3.10	5.40	6.01
0.375	1.24	1.46	1.73	1.95	3.04	3.35	5.85	6.45
0.406	1.34	1.56	1.88	2.09	3.27	3.59	6.29	6.90
0.437	1.44	1.66	2.01	2.24	3.52	3.84	6.73	7.34
0.469	1.54	1.76	2.16	2.38	3.77	4.09	7.19	7.80
0.500	1.64	1.85	2.31	2.52	4.01	4.32	7.64	8.25
0.531	1.74	1.95	2.46	2.67	4.25	4.57	8.08	8.70
0.562	1.84	2.06	2.59	2.81	4.49	4.81	8.52	9.14
0.594	1.94	2.16	2.74	2.96	4.75	5.07	8.99	9.60
0.625	2.04	2.26	2.89	3.10	4.99	5.30	9.44	10.04
0.656	2.14	2.36	3.03	-	5.24	5.55	9.88	10.49
0.687	2.24	2.46	3.17	3.39	5.47	5.79	10.32	10.93
0.719	2.34	2.56	-	3.53	5.72	6.04	10.78	11.40
0.750	2.44	2.66	3.47	3.68	5.97	6.29	11.23	11.84
0.781	2.54	2.76	-	-	6.21	6.52	11.67	12.29
0.812	2.64	2.86	3.75	3.97	6.45	6.77	12.12	12.73
0.844	2.75	2.96	3.90	4.11	6.70	7.02	12.58	13.19
0.875	2.84	3.06	4.04	4.26	6.95	7.27	13.03	13.64
0.906	2.94	3.16	4.19	4.40	7.19	7.50	13.47	14.08
0.937	3.04	3.26	4.33	4.54	7.44	7.75	13.92	14.52
0.969	3.14	3.37	4.48	4.69	7.68	8.00	14.37	14.99
1.000	3.24	3.47	4.62	4.83	7.92	8.24	14.82	15.43
1.031	3.34	3.56	-	4.98	8.17	8.49	15.26	15.88
1.062	3.44	3.66	4.90	5.12	8.41	8.72	15.72	16.32
1.094	3.55	3.76	5.05	5.27	8.66	8.98	16.17	16.78
1.125	3.65	3.86	5.20	5.41	8.90	9.22	16.62	17.22
1.156	3.74	3.96	5.35	5.56	9.15	9.47	17.06	17.67
1.187	3.84	4.06	5.48	5.69	9.39	9.70	17.51	18.12
1.219	3.94	4.17	5.63	5.84	9.64	9.95	17.96	18.58
1.250	4.04	4.27	5.78	5.99	9.88	10.20	18.41	19.02
1.281	4.15	4.37	5.92	6.14	10.12	10.44	18.85	19.47
1.312	4.25	4.46	6.06	6.27	10.37	10.69	19.31	19.91
1.344	4.35	4.56	6.21	6.42	10.62	10.93	19.76	20.37
1.375	4.45	4.66	6.35	6.57	10.86	11.18	20.21	20.81
1.406	4.55	4.76	6.50	6.71	11.10	11.42	20.65	21.26
1.437	4.64	4.86	6.64	6.85	11.35	11.67	21.10	21.71
1.469	4.75	4.97	6.79	7.00	11.60	11.91	21.56	22.17
1.500	4.85	5.07	6.93	7.15	11.83	12.15	22.00	22.61
1.531	4.95	5.17	7.07	7.29	12.08	12.40	22.44	23.06
1.562	5.05	5.27	7.30	7.43	12.32	12.64	22.90	23.50
1.594	5.15	5.36	7.36	7.58	12.58	12.89	23.36	23.96
1.625	5.25	5.46	7.51	7.72	12.82	13.13	23.80	24.40
1.656	5.35	5.56	7.65	7.87	13.06	13.38	24.24	24.85
1.687	5.45	5.67	7.79	8.01	13.30	13.62	24.69	25.30
1.718	5.54	5.77	7.94	8.15	13.55	13.87	25.13	25.75
1.750	5.65	5.87	8.09	8.30	13.80	14.11	25.59	26.21
1.812	5.85	6.07	8.37	8.58	14.28	14.60	26.49	27.09
1.875	6.05	6.27	8.67	8.88	14.78	15.09	27.39	28.00
1.937	6.25	6.47	8.95	9.16	15.26	15.58	28.28	28.89
2.000	6.45	6.67	9.24	9.46	15.75	16.07	29.18	29.80
2.125	-	-	-	-	16.73	17.05	30.98	31.59
2.187	-	-	-	-	-	17.53	-	32.48
2.250	-	-	-	-	17.71	18.03	32.77	33.39
2.375	-	-	-	-	18.69	19.01	34.57	35.18
2.437	-	-	-	-	-	19.49	35.46	36.07
2.500	-	-	-	-	19.66	19.98	36.36	36.98
2.625	-	-	-	-	-	20.96	38.16	38.77
2.750	-	-	-	-	21.62	21.94	39.96	40.57
3.000	-	-	-	-	23.58	23.89	43.55	44.16

# RIVETKING® BRASS SEMI TUBULAR RIVET WEIGHT CHARTS

Pounds Per 1,000 Pieces

SEMI TUBULAR RIVETS

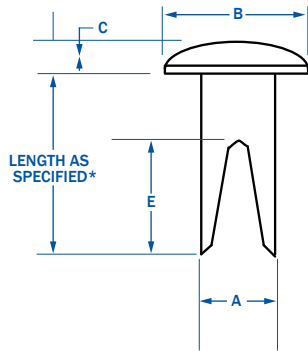
LENGTH	DIAMETER X HEAD DIAMETER							
	J-218	J-281	M-234	M-312	T-312	T-375	Y-437	Y-500
	1/8"	1/8"	9/64"	9/64"	3/16"	3/16"	1/4"	1/4"
0.125	0.47	0.70	-	-	-	-	-	-
0.140	0.52	0.76	-	-	-	-	-	-
0.156	0.58	0.81	0.86	1.00	-	-	-	-
0.187	0.68	0.91	0.92	1.15	1.67	2.01	-	-
0.219	0.79	1.03	1.09	1.32	1.94	2.27	-	-
0.250	0.90	1.13	1.23	1.46	2.20	2.54	4.33	4.98
0.281	1.00	1.23	1.39	1.62	2.45	2.79	4.81	5.46
0.312	1.11	1.34	1.55	1.78	2.72	3.06	5.28	5.93
0.344	1.22	1.45	1.70	-	2.98	3.33	5.78	6.43
0.375	1.32	1.56	1.85	2.08	3.24	3.58	6.25	6.90
0.406	1.43	1.67	2.01	2.24	3.51	3.84	6.73	7.38
0.437	1.54	1.77	2.16	2.39	3.76	4.10	7.20	7.85
0.469	1.65	1.88	2.32	2.55	4.03	4.37	7.70	8.35
0.500	1.76	1.99	2.47	2.70	4.30	4.63	8.17	8.82
0.531	1.86	2.10	2.62	2.85	4.55	4.89	8.65	9.30
0.562	1.97	2.21	2.78	3.01	4.81	5.15	9.13	9.78
0.594	2.08	2.31	2.93	3.16	5.08	5.41	9.62	10.27
0.625	2.19	2.42	3.09	3.32	5.34	5.68	10.09	10.74
0.656	2.29	2.52	3.24	-	5.60	5.94	10.57	11.22
0.687	2.39	2.63	3.39	3.62	5.86	6.19	11.05	11.70
0.719	2.50	2.74	-	3.78	6.13	6.47	11.54	12.19
0.750	2.61	2.84	3.71	3.94	6.38	6.72	12.02	12.67
0.781	2.72	2.95	-	-	6.65	6.98	12.49	13.14
0.812	2.83	3.06	4.01	4.24	6.91	7.25	12.97	13.62
0.844	2.93	3.17	4.17	4.40	7.17	7.51	13.46	14.11
0.875	3.04	3.28	4.32	4.55	7.44	7.77	13.94	14.59
0.906	3.15	3.38	4.48	4.71	7.69	8.03	14.41	15.06
0.937	3.26	3.49	4.63	4.86	7.95	8.29	14.89	15.54
0.969	3.37	3.60	4.79	5.02	8.22	8.55	15.38	16.03
1.000	3.47	3.71	4.94	5.17	8.48	8.82	15.86	16.51
1.031	3.57	3.81	-	5.33	8.74	9.08	16.33	16.98
1.062	3.68	3.92	5.25	5.48	9.00	9.33	16.81	17.46
1.094	3.79	4.02	5.41	5.64	9.27	9.61	17.30	17.95
1.125	3.90	4.13	5.56	5.79	9.52	9.87	17.78	18.43
1.156	4.01	4.24	5.71	5.94	9.79	10.12	18.26	18.91
1.187	4.11	4.35	5.87	6.10	10.05	10.39	18.73	19.38
1.219	4.22	4.46	6.03	6.26	10.31	10.65	19.22	19.87
1.250	4.33	4.56	6.18	6.41	10.58	10.91	19.70	20.35
1.281	4.44	4.67	6.33	6.56	10.83	11.18	20.18	20.83
1.312	4.55	4.78	6.49	6.72	11.09	11.43	20.65	21.30
1.344	4.65	4.89	6.64	6.87	11.36	11.70	21.15	21.80
1.375	4.76	5.00	6.80	7.03	11.62	11.96	21.62	22.27
1.406	4.86	5.09	6.95	7.18	11.88	12.22	22.10	22.75
1.437	4.97	5.20	7.10	7.33	12.14	12.48	22.57	23.22
1.469	5.08	5.31	7.26	7.49	12.41	12.75	23.07	23.72
1.500	5.18	5.42	7.42	7.65	12.67	13.01	23.54	24.19
1.531	5.29	5.53	7.57	7.80	12.93	13.26	24.02	24.67
1.562	5.40	5.63	7.72	7.95	13.19	13.53	24.50	25.15
1.594	5.51	5.74	7.88	8.11	13.45	13.79	24.99	25.64
1.625	5.62	5.85	8.03	8.26	13.71	14.05	25.46	26.11
1.656	5.72	5.96	8.19	8.42	13.98	14.32	25.94	26.59
1.687	5.83	6.07	8.34	8.57	14.23	14.57	26.42	27.07
1.718	5.93	6.17	8.49	8.72	14.49	14.83	26.89	27.54
1.750	6.05	6.28	8.65	8.88	14.76	15.10	27.39	28.04
1.812	6.26	6.49	8.96	9.19	15.28	15.62	28.34	28.99
1.875	6.47	6.71	9.27	9.49	15.81	16.15	29.31	29.96
1.937	6.69	6.92	9.58	9.81	16.33	16.67	30.26	30.91
2.000	6.90	7.14	9.89	10.12	16.85	17.19	31.23	31.88
2.125	-	-	-	-	17.90	18.25	33.15	33.80
2.187	-	-	-	-	-	18.76	-	34.75
2.250	-	-	-	-	18.95	19.29	35.07	35.72
2.375	-	-	-	-	19.99	20.33	36.99	37.64
2.437	-	-	-	-	-	20.86	37.95	38.59
2.500	-	-	-	-	21.05	21.39	38.91	39.56
2.625	-	-	-	-	-	22.43	40.84	41.48
2.750	-	-	-	-	23.13	23.47	42.76	43.41
3.000	-	-	-	-	25.23	25.57	46.60	47.25





# RIVETKING® OTHER RIVETS

## SPLIT RIVETS OR BIFURCATED RIVETS



Split rivets are typically used in the luggage, case and leather goods industries to fasten soft materials such as plastics, animal hide and wood. With automatic setting equipment it can pierce through soft materials without a pre-punched hole. Typically offered in Steel or Brass material with a host of metal finishes such as zinc, nickel, or brass plating.

Note: 3/16", Bag Studs and custom sizes can be made upon request.

SIZE	A		B		C		CLINCH ALLOWANCE
	SHANK Max.	SHANK Min.	HEAD DIA. Max.	HEAD DIA. Min.	HEAD THICKNESS Max.	HEAD THICKNESS Min.	
0.092	0.092	0.085	0.152	0.142	0.026	0.020	.119
0.125	0.125	0.113	0.223	0.213	0.035	0.027	.119
0.152	0.152	0.144	0.318	0.306	0.045	0.035	.146
0.190	0.190	0.180	0.349	0.337	0.055	0.045	.146

## METAL PIERCING



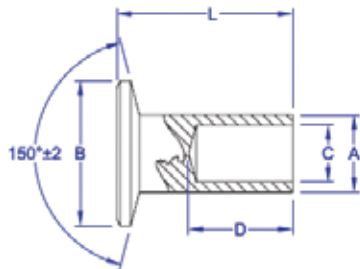
To join two or more sections of a sheet metal assembly permanently and without pre-punching or pre-drilling holes. Eliminates the cost of pre-punching or pre-drilling holes and reduces material handling. Low unit cost and applied by high speed automatic feed riveting machines to further reduce assembly time and cost. Setting can provide a leak proof seal.

## ELECTRICAL CONTACT



To act as an electrical contact. Electrical contact rivets can be made with precious metals such as gold, silver, platinum, copper as well as silver-cadmium oxide materials. The manufacturing method is extremely economical because the contact face can be produced of high performance precious metals while the shank can be made of lower cost metals. Also known as Bi-Metal or Tri-Metal rivets.

## BRAKE LINING RIVETS



PART CODE	RIVET SIZE	L		B		A		C		D	
		LENGTH Max.	LENGTH Min.	HEAD DIA. Max.	HEAD DIA. Min.	BODY DIA. Max.	BODY DIA. Min.	HOLE DIA. Max.	HOLE DIA. Min.	HOLE DEPTH Max.	HOLE DEPTH Min.
XB-3MM	3mm	.245	.260	.225	.245	.121	.125	.086	.090	.125	.135
XB-6MM	6mm	.365	.385	.458	.478	.235	.240	.170	.174	.240	.260
XB-4-4		.245	.260								
XB-4-4.5		.274	.288	.285	.305						
XB-4-5	9/64"	.312	.328			.141	.146	.099	.104	.136	.150
XB-5-4		.245	.260								
XB-5-4.5	13/64"	.274	.288	.349	.369						
XB-5-5		.312	.328								
XB-6-4	3/16"	.245	.260								
XB-6-4.5		.274	.288								
XB-6-5	1/4"	.312	.328	.349	.369	.182	.188	.133	.139	.187	.200
XB-6-5.5		.335	.350								
XB-6-6		.375	.390								
XB-7-4		.245	.260								
XB-7-4.5		.274	.288								
XB-7-5		.312	.328								
XB-7-5.5		.336	.350	.349	.369						
XB-7-6		.375	.390								
XB-7-6.5		.406	.421								
XB-7-7		.437	.452								
XB-8-4		.245	.260								
XB-8-5		.312	.328								
XB-8-6		.375	.390								
XB-8-7		.435	.450	.458	.478						
XB-8-8		.500	.515								
XB-8-9		.560	.575								
XB-10-6		.375	.390								
XB-10-7		.435	.450								
XB-10-8		.500	.515	.458	.478	.244	.252	.173	.183	.245	.255
XB-10-10		.620	.635								
XB-10-12		.745	.760								

# RIVETKING® SMALL DIAMETER SOLID RIVETS

SOLID RIVETS

**WHEN IT DOESN'T HAVE TO COME APART  
A RIVET IS YOUR MOST LOGICAL FASTENER, HERE'S WHY...**

**ONE OF THE LOWEST COST FASTENERS**

Rivets are used in many major consumer and industrial products made today. Designers and production people have long recognized that riveting is one of the least expensive and most versatile assembly methods available to them.

**CAN BE USED WITH MOST ANY MATERIAL**

Rivets have been successfully set in wood, metals, plastics, fiberboard, cloth and ceramics. It's a strong fastener. All other things being equal, no other fastener - for it's size and simplicity - can equal the shear strength of a rivet.

**CAN BE USED FOR MANY PURPOSES**

Rivets are not only used to fasten two or more parts but often provide a dual function. They have been used as pivots, hinges, levers, terminals, electrical contacts, cam followers, for decoration and in hundreds of other ways. The only limiting factor to the use of rivets is the designer's imagination.

**AVAILABLE IN A GREAT VARIETY OF FINISHES**

They can be made from copper, brass, steel, aluminum, stainless steel and any material that can be cold-heated. If color is desired, they are plated, Japanned or painted.

**IS A LOW COST PRODUCTION METHOD**

Compared to other assembly machines, rivet setting equipment is lowest in cost. Since the riveting operation is automatic, non-skilled operators can quickly perform the work and lengthy training is not necessary.

**IT'S GEARED TO MOST PRODUCTION REQUIREMENTS**

Depending on the assembly, rivets can be set at extremely high speeds or to meet the optimum production capabilities of the operator. Machines have been built to feed several parts of the assembly simultaneously and to achieve most any degree of mechanization necessary.

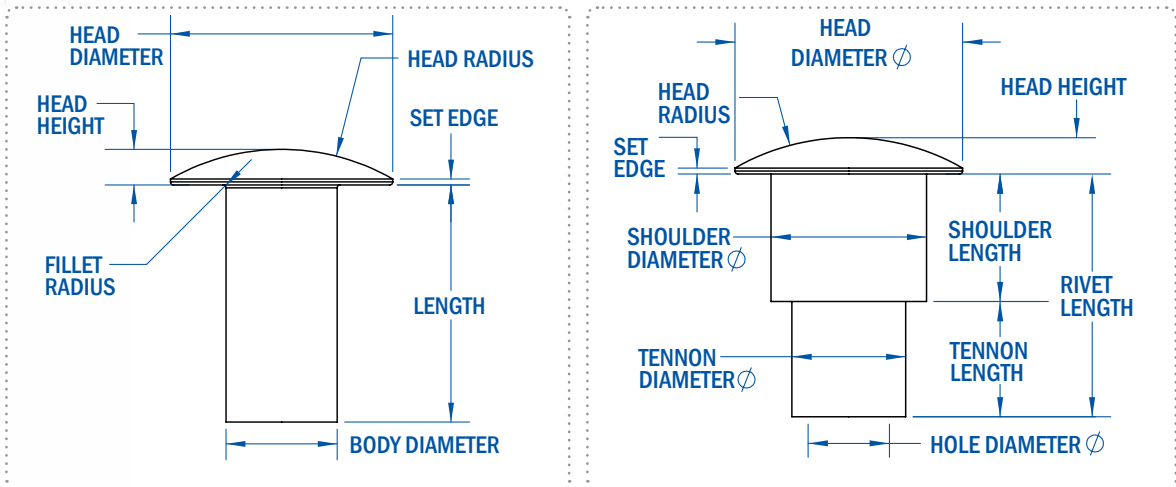
**SOME LIMITATIONS**

Tensile and fatigue strengths are lower than bolts. High tensile loads and extreme vibrations can pull out the set.

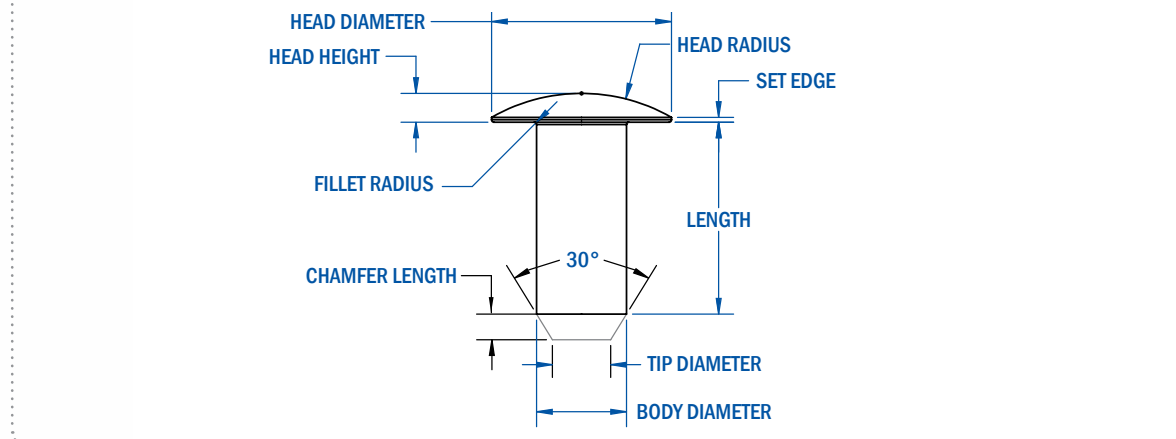
Once set with rivets, an assembly cannot be easily disassembled for maintenance purposes.

While rivets can be made to close tolerances, they are not usually as highly a precision fastener as a screw machined part might be. Where rivets are required for highly critical assemblies, consult our sales department.

**ANATOMY OF THE SOLID RIVET**



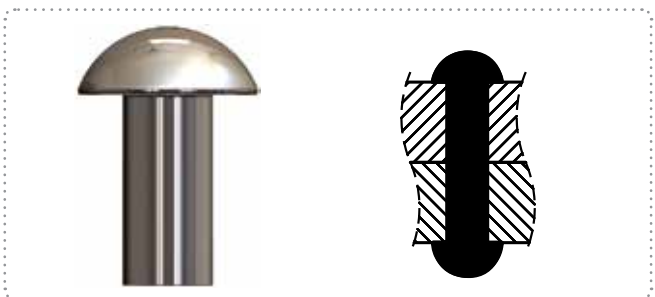
**OPTIONAL CHAMFER POINTS**





# RIVETKING® COLD HEADED SOLID RIVETS

SOLID RIVETS



The popular use of mechanical fasteners in the fabrication of all types of metal structures continues because of the rivet's relative design simplicity, low cost, and ease of assembly. The cold headed solid rivet is a unique one-piece fastener that offers advantages and properties found in no other connection system:

- A connection stronger than the material being riveted and stronger than the rivet itself
- Remarkable uniform results from fastener to fastener
- Energy savings
- Lower house cleaning cost – no stubs, washers or discards
- Noise pollution reduced – no loud pneumatic bucking tools

The rivet is cold-worked from low carbon steel, then cold-driven in the piece with one quick, quiet squeeze of a hydraulic piston. The rivet actually over-fills the rivet hole, rounding out the sharp edges and results in a superior connection. Sharp hole edges are the main cause of connection failure when fatigue loading is applied. This should be of particular interest to the design engineer.

Shear movement is eliminated. The rivet system overfills and actually expands the rivet hole. In short, the properly driven rivet is so tight that it acts almost as a dowel. It can only be removed by drilling and collapsing.

Cold driving a conventional un-heated rivet pushes the rivet shank through the head. Consequently, to relieve stress it must be annealed.

## THE POWER REQUIREMENTS

The power requirements to produce cold-made rivets increase in direct proportion to the shank area. This factor escalates by squaring the cross-section diameter. These power requirements increase markedly with rivet size. The possibility of grain growth in annealing the metal becomes proportionately greater due to these higher stresses. Cold-driving conventional rivets over 1/2" in diameter is not recommended.

## STANDARD RIVET-HOLE DRILL SIZES & NOMINAL HOLE DIAMETERS

RIVET SIZE, INCHES	1/16"	3/32"	1/8"	5/32"	3/16"	1/4"	5/16"	3/8"
DRILL NUMBER	51	41	30	21	11	F	P	W
NOMINAL HOLE DIA., INCHES	0.067	0.096	0.1285	0.159	0.191	0.257	0.323	0.386

Engineering practices for installation of rivets (reference only)

NOTES: Hole tolerance to be established by user company

## PRESSURES TO DRIVE RIVETS

Recommendation of Safe Practice to Form Steel Rivet Heads

DIAMETER	TONS PRESSURE COLD	TONS PRESSURE HOT
3/16"	4.5	-
1/4"	7	-
5/16"	12	-
3/8"	16	-
7/16"	22	-
1/2"	29	13
5/8"	44	19
3/4"	64	28
7/8"	87	38
1"	112	50
1-1/8"	-	63
1-1/4"	-	77

### MANUFACTURED HEADS

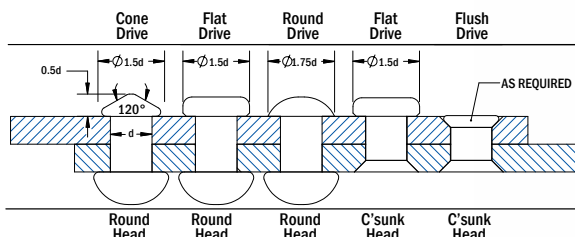
The driven heads represent what is considered good practice for riveting. Rivets used for cold riveting should be cold formed and must be annealed after forming before driving.

The pressure required to cold form the heads will, of course, depend on the material in the rivet. For the commonly used carbon steel rivet, the above listed pressures are needed.

### FORMULA:

$$DIA^2 \times 88.36 = \text{TONS OF PRESSURE TO DRIVE RIVETS}$$

### DRIVEN HEADS



## PURPOSE AND QUALITY OF THE RIVET

The rivet has been an important part of construction and metal fabrication for many years. The use of rivet technology has many advantages and remains a popular mechanical fastener because:

- It offers multi-faceted applications
- It allows high production rates
- It is a permanent fastener
- Can be used on assemblies of varying complexities
- It is easy to inspect
- It requires no maintenance
- It is a low cost fastener
- Its simple, one piece design

## JOINT STRENGTH, SHEAR STRENGTH

Shearing is one of the recognized causes of failure in a connected metal joint. If the area is not quite filled by the fastener in its hole, movement (moment) is possible – particularly in non-static connections. This is the beginning point of shear failure. Factors to consider when calculating shear are: Strength of the metal shank of the fastener, the number of planes upon which shear occurs, and the diameter of the "in place" fastener. In rivets this latter dimension can vary with the conditions prevailing in the joint construction such as driving pressure and temperature, tooling, alignment and other closure elements.

## BEARING STRENGTH

The more the fastened joint is subject to bearing forces, the more hole-filling becomes desirable since bearing failure calculations consider the size of the fastener hole. By filling (or over-filling) the hole, compressive distortion force is transmitted into the connected material. As a result, either tear-out of the plate edge or progressive elongation of the grip dimension may occur.

## TENSILE STRENGTH

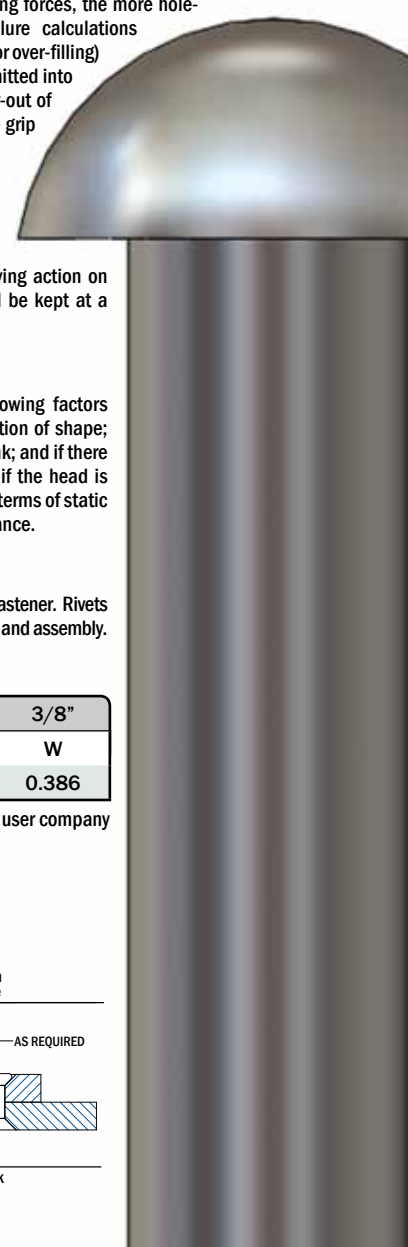
Rivets are not recommended for transmitting loads in tension. Permanent failure may result when loads exert movements that cause a prying action on the head of a rivet. Tensile load stress should be kept at a minimum when using rivets.

## RIVET INSPECTION

When inspecting a driven rivet, take the following factors into consideration: the dimensions and perfection of shape; whether the driven head is coaxial with the shank; and if there is excessive cracking of the head. Note: Even if the head is severely cracked, the rivet still is satisfactory in terms of static strength, fatigue strength, and corrosion resistance.

## RIVET HISTORY

The rivet is a reliable and effective mechanical fastener. Rivets are a suitable fastener when used for construction and assembly.

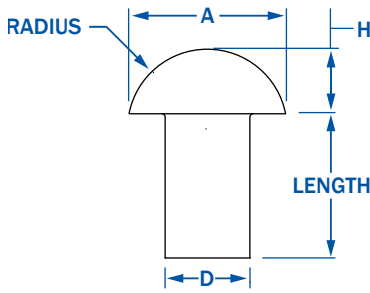


# RIVETKING® SMALL DIAMETER SOLID RIVET DIMENSION FOR STEEL, BRASS, COPPER, STAINLESS AND MONEL

IFI STANDARD

SOLID RIVETS

## ROUND HEAD RIVETS

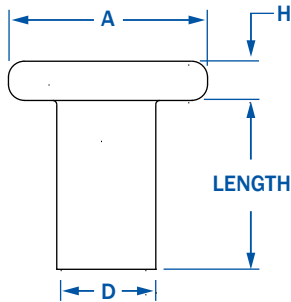


APPROXIMATE PROPORTIONS:  
 A = 1.750 X D  
 H = 0.750 X D  
 R = 0.885 X D

NOMINAL	D DIAMETER OF BODY			A HEAD DIAMETER			H HEAD HEIGHT			R HEAD RADIUS	L LENGTH UNDER HEAD
	MAX.	MIN.		NOM.	MAX.	MIN.	NOM.	MAX.	MIN.		
3/32 - .094	0.096	0.090		0.166	0.182	0.162	0.071	0.077	0.065	0.084	ORDERED LENGTH UNDER HEAD TO END.
1/8 - .125	0.127	0.121		0.219	0.235	0.215	0.094	0.100	0.088	0.111	
5/32 - .156	0.158	0.152		0.273	0.290	0.268	0.117	0.124	0.110	0.138	
3/16 - .188	0.191	0.182		0.327	0.348	0.322	0.140	0.147	0.133	0.166	
7/32 - .219	0.222	0.213		0.385	0.405	0.379	0.165	0.172	0.158	0.195	
1/4 - .250	0.253	0.244		0.438	0.460	0.430	0.188	0.196	0.180	0.221	
9/32 - .281	0.285	0.273		0.492	0.518	0.484	0.211	0.220	0.202	0.249	
5/16 - .313	0.316	0.304		0.546	0.572	0.538	0.234	0.243	0.225	0.276	
11/32 - .344	0.348	0.336		0.600	0.630	0.592	0.257	0.267	0.247	0.304	
3/8 - .375	0.380	0.365		0.656	0.684	0.646	0.281	0.291	0.271	0.332	
7/16 - .438	0.443	0.428		0.765	0.798	0.754	0.328	0.339	0.317	0.387	

ALL DIAMETERS GIVEN IN INCHES

## FLAT HEAD RIVETS

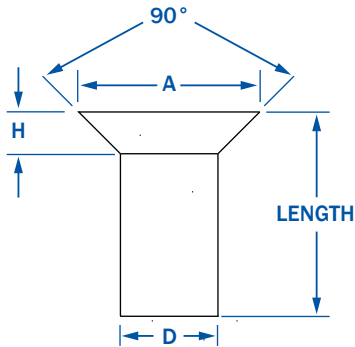


APPROXIMATE PROPORTIONS:  
 A = 2.00 X D  
 H = 0.33 X D

NOMINAL	D DIAMETER OF BODY			A HEAD DIAMETER			H HEAD HEIGHT			L LENGTH UNDER HEAD
	MAX.	MIN.		NOM.	MAX.	MIN.	NOM.	MAX.	MIN.	
3/32 - .094	0.096	0.090		0.190	0.200	0.180	0.032	0.038	0.026	ORDERED LENGTH UNDER HEAD TO END.
1/8 - .125	0.127	0.121		0.250	0.260	0.240	0.042	0.048	0.036	
5/32 - .156	0.158	0.152		0.312	0.323	0.301	0.052	0.059	0.045	
3/16 - .188	0.191	0.182		0.374	0.387	0.361	0.062	0.069	0.055	
7/32 - .219	0.222	0.213		0.440	0.453	0.427	0.073	0.080	0.065	
1/4 - .250	0.253	0.244		0.500	0.515	0.485	0.083	0.091	0.075	
9/32 - .281	0.285	0.273		0.562	0.579	0.545	0.094	0.103	0.085	
5/16 - .312	0.316	0.304		0.624	0.641	0.607	0.104	0.113	0.095	
11/32 - .344	0.348	0.336		0.686	0.705	0.667	0.114	0.124	0.104	
3/8 - .375	0.380	0.365		0.750	0.769	0.731	0.125	0.135	0.115	
7/16 - .438	0.443	0.428		0.874	0.896	0.852	0.146	0.157	0.135	

ALL DIAMETERS GIVEN IN INCHES

## 90° COUNTERSUNK HEAD RIVETS

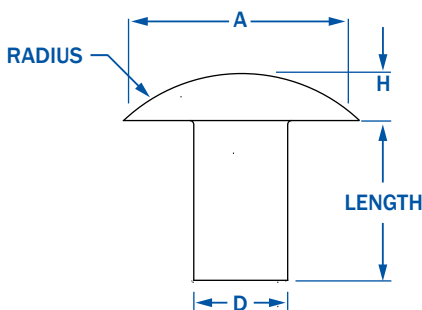


APPROXIMATE PROPORTIONS:  
 A = 2.500 X D  
 H = 0.330 X D  
 R = 2.512 X D

NOMINAL	D DIAMETER OF BODY			A HEAD DIAMETER			H HEAD HEIGHT	INCLUDED ANGLE	L OVERALL LENGTH
	MAX.	MIN.		NOM.	MAX.	MIN.			
3/32 - .094	0.096	0.090		0.169	0.176	0.163	0.040	90	ORDERED LENGTH.
1/8 - .125	0.127	0.121		0.231	0.235	0.217	0.053	90	
5/32 - .156	0.158	0.152		0.289	0.293	0.272	0.066	90	
3/16 - .188	0.191	0.182		0.346	0.351	0.326	0.079	90	
7/32 - .219	0.222	0.213		0.407	0.413	0.384	0.094	90	
1/4 - .250	0.253	0.244		0.463	0.469	0.437	0.106	90	
9/32 - .281	0.285	0.273		0.520	0.528	0.491	0.119	90	
5/16 - .313	0.316	0.304		0.577	0.588	0.547	0.133	90	
11/32 - .344	0.348	0.336		0.635	0.646	0.602	0.146	90	
3/8 - .375	0.380	0.365		0.694	0.704	0.656	0.159	90	
7/16 - .438	0.443	0.428		0.808	0.823	0.765	0.186	90	

ALL DIAMETERS GIVEN IN INCHES

## TRUSS HEAD RIVETS



APPROXIMATE PROPORTIONS:  
 A = 1.850 X D  
 H = 0.425 X D

NOMINAL SIZE OR BASIC SHANK DIAMETER	D SHANK DIAMETER		A HEAD DIAMETER		H HEAD HEIGHT		R HEAD RADIUS	L OVERALL LENGTH
	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	APPROX.	
3/32 - .094	0.096	0.090	0.226	0.206	0.038	0.026	0.239	ORDERED LENGTH.
1/8 - .125	0.127	0.121	0.297	0.277	0.048	0.036	0.314	
5/32 - .156	0.158	0.152	0.368	0.348	0.059	0.045	0.392	
3/16 - .188	0.191	0.182	0.442	0.422	0.069	0.055	0.470	
7/32 - .219	0.222	0.213	0.515	0.495	0.080	0.066	0.555	
1/4 - .250	0.253	0.244	0.590	0.560	0.091	0.075	0.628	
9/32 - .281	0.285	0.273	0.661	0.631	0.103	0.085	0.706	
5/16 - .313	0.316	0.304	0.732	0.702	0.113	0.095	0.784	
11/32 - .344	0.348	0.336	0.806	0.776	0.124	0.104	0.862	
3/8 - .375	0.380	0.365	0.878	0.848	0.135	0.115	0.942	
13/32 - .406	0.411	0.396	0.949	0.919	0.145	0.123	1.028	
7/16 - .438	0.443	0.428	1.020	0.990	0.157	0.135	1.098	

ALL DIAMETERS GIVEN IN INCHES



# RIVETKING® STEEL ROUND HEAD RIVET WEIGHT CHART

Pounds Per 1,000 Pieces

Available in: Steel, Brass, Copper, Stainless and Monel



### To Find Pieces Per Pound:

Divide lbs. per thousand into 1,000. i.e. > Round Head  
Steel 3/16 X 1/2; 1,000 / 6.07 = 165 pcs. per lb. to  
determine the number of pieces per pound for materials  
listed multiply steel count by factors indicated.

#2017 ALUM ALLOY	2.81
#6061 ALUM ALLOY	2.90
BRASS	1.082
COPPER	1.145
INCONEL	1.127
18 0/0 NICKEL SILVER	.90
MONEL	.89
HASTELLOY "C"	.88
STAINLESS STEEL 18-8	1.02
STAINLESS STEEL 400	1.00

SOLID RIVETS

LENGTH OF SHANK IN INCHES	7/16"	3/8"	5/16"	9/32"	1/4"	3/16"	5/32"	1/8"	3/32"
	.437	.375	.312	.281	.250	.187	.156	.125	.095
1/16								.87	.40
1/8								1.09	.53
3/16						3.66	2.29	1.31	.65
1/4				11.85	8.71	4.14	2.62	1.52	.77
5/16			17.01	12.93	9.57	4.62	2.96	1.74	.89
3/8		29.39	18.35	14.02	10.43	5.10	3.29	1.96	1.02
7/16	46.68	31.32	19.69	15.11	11.29	5.58	3.63	2.18	1.14
1/2	49.31	33.25	21.03	16.20	12.14	6.07	3.96	2.40	1.26
9/16	51.94	35.18	22.37	17.28	13.00	6.55	4.30	2.61	1.39
5/8	54.57	37.12	23.72	18.37	13.86	7.03	4.63	2.83	1.51
11/16	57.20	39.05	25.06	19.46	14.72	7.51	4.97	3.05	1.63
3/4	59.84	40.98	26.40	20.55	15.58	7.99	5.30	3.27	1.75
13/16	62.46	42.91	27.75	21.63	16.43	8.47	5.64	3.49	1.88
7/8	65.09	44.85	29.09	22.72	17.29	8.95	5.97	3.70	2.00
15/16	67.73	46.78	30.43	23.81	18.15	9.43	6.31	3.92	2.12
<b>1</b>	70.36	48.71	31.78	24.90	19.01	9.91	6.64	4.14	2.24
1/16	72.99	50.64	33.12	25.98	19.87	10.39	6.98	4.36	
1/8	75.62	52.57	34.46	27.07	20.73	10.87	7.31	4.58	
3/16	78.25	54.50	35.81	28.16	21.59	11.35	7.65	4.79	
1/4	80.88	56.44	37.15	29.25	22.45	11.83	7.98	5.01	
5/16	83.51	58.37	38.50	30.33	23.31	12.31	8.32	5.23	
3/8	86.14	60.30	39.84	31.42	24.17	12.79	8.65	5.45	
7/16	88.77	62.24	41.18	32.51	25.03	13.28	8.99	5.67	
1/2	91.41	64.17	42.53	33.60	25.88	13.76	9.32	5.89	
9/16	94.04	66.10	43.87	34.68	26.74	14.24	9.66	6.10	
5/8	96.67	68.03	45.21	35.77	27.60	14.72	9.99	6.32	
11/16	99.30	69.97	46.55	36.86	28.46	15.20	10.33	6.54	
3/4	101.94	71.90	47.90	37.95	29.32	15.68	10.66	6.76	
13/16	104.57	73.83	49.24	39.03	30.18	16.16	11.00	6.98	
7/8	107.20	75.77	50.58	40.12	31.04	16.64	11.33	7.19	
15/16	109.83	77.70	51.92	41.21	31.90	17.12	11.67	7.41	
<b>2</b>	112.46	79.63	53.27	42.30	32.75	17.60	12.00	7.63	
1/8	117.72	83.49	55.95	44.47	34.46	18.56	12.67	8.07	
1/4	122.99	87.36	58.64	46.65	36.18	19.52	13.34	8.50	
3/8	128.25	91.22	61.33	48.82	37.90	20.48	14.01	8.94	
1/2	133.51	95.09	64.02	51.00	39.62	21.45	14.68	9.38	
5/8	138.77	98.95	66.70	53.17	41.33	22.41	15.35	9.81	
3/4	144.04	102.82	69.39	55.35	43.05	23.37	16.02	10.25	
7/8	149.30	106.68	72.07	57.52	44.77	24.33	16.69	10.68	
<b>3</b>	154.56	110.55	74.76	59.70	46.49	25.29	17.36	11.12	
1/8	159.82	114.41	77.44	61.87	48.20	26.25			
1/4	165.09	118.28	80.13	64.05	49.92	27.21			
3/8	170.35	122.14	82.82	66.22	51.64	28.17			
1/2	175.61	126.01	85.51	68.40	53.36	29.14			
5/8	180.87	129.87	88.19	70.57	55.07	30.10			
3/4	186.14	133.74	90.88	72.75	56.79	31.06			
7/8	191.40	137.60	93.56	74.92	58.51	32.02			
<b>4</b>	196.66	141.47	96.25	77.10	60.23	32.98			
1/8	201.92	145.33	98.93	79.27	61.94	33.94			
1/4	207.19	149.20	101.62	81.45	63.66	34.90			
3/8	212.45	153.06	104.31	83.62	65.38	35.86			
1/2	217.71	156.93	107.00	85.80	67.10	36.83			
5/8	222.97	160.79	109.68	87.97	68.81	37.79			
3/4	228.24	164.66	112.37	90.15	70.53	38.75			
7/8	233.50	168.52	115.05	92.32	72.25	39.71			
<b>5</b>	238.76	172.39	117.74	94.50	73.97	40.67			
1/8	244.02	176.25	120.42	96.67	75.68	41.63			
1/4	249.29	180.12	123.11	98.85	77.40	42.59			
3/8	254.55	183.98	125.80	101.02	79.12	43.55			
1/2	259.81	187.85	128.49	103.20	80.84	44.52			
5/8	265.07	191.71	131.17	105.37	82.55	45.48			
3/4	270.34	195.58	133.86	107.55	84.27	46.44			
7/8	275.60	199.44	136.54	109.72	85.99	47.40			
<b>6</b>	280.86	203.31	139.23	111.90	87.71	48.36			
1/8	286.12	207.17	141.91	114.07	89.42	49.32			
1/4	291.39	211.04	144.60	116.25	91.14	50.28			
3/8	296.65	214.90	147.29	118.42	92.86	51.24			
1/2	301.91	218.77	149.98	120.60	94.58	52.21			
5/8	307.17	222.63	152.66	122.77	96.29	53.17			
3/4	312.44	226.50	155.35	124.95	98.01	54.13			
7/8	317.70	230.36	158.03	127.12	99.73	55.09			
<b>7</b>	322.96	234.23	160.72	129.30	101.45	56.05			

# RIVETKING® STEEL FLAT HEAD RIVET WEIGHT CHART

Pounds Per 1,000 Pieces

Available in: Steel, Brass, Copper, Stainless and Monel

SOLID RIVETS



### To Find Pieces Per Pound:

Divide lbs. per thousand into 1,000. i.e. > Round Head Steel 3/16 X 1/2; 1,000 / 6.07 = 165 pcs. per lb. to determine the number of pieces per pound for materials listed multiply steel count by factors indicated.

#2017 ALUM ALLOY	2.81
#6061 ALUM ALLOY	2.90
BRASS	1.082
COPPER	1.145
INCONEL	1.127
18 0/0 NICKEL SILVER	.90
MONEL	.89
HASTELLOY "C"	.88
STAINLESS STEEL 18-8	1.02
STAINLESS STEEL 400	1.00

LENGTH OF SHANK IN INCHES	7/16"	3/8"	5/16"	9/32"	1/4"	3/16"	5/32"	1/8"	3/32"
	.437	.375	.312	.281	.250	.187	.156	.125	.095
1/16								.85	.40
1/8								1.07	.53
3/16						3.56	2.23	1.29	.65
1/4				11.50	8.46	4.04	2.56	1.50	.77
5/16			16.52	12.58	9.32	4.52	2.90	1.72	.89
3/8		28.54	17.86	13.67	10.18	5.00	3.23	1.94	1.02
7/16	45.31	30.47	19.20	14.76	11.04	5.48	3.57	2.16	1.14
1/2	47.94	32.40	20.54	15.85	11.89	5.97	3.90	2.38	1.26
9/16	50.57	34.33	21.88	16.93	12.75	6.45	4.24	2.59	1.39
5/8	53.20	36.27	23.23	18.02	13.61	6.93	4.57	2.81	1.51
11/16	55.83	38.20	24.57	19.11	14.47	7.41	4.91	3.03	1.63
3/4	58.47	40.13	25.91	20.20	15.33	7.89	5.24	3.25	1.75
13/16	61.09	42.06	27.26	21.28	16.18	8.37	5.58	3.47	1.88
7/8	63.72	44.00	28.60	22.37	17.04	8.85	5.91	3.68	2.00
15/16	66.36	45.93	29.94	23.46	17.90	9.33	6.25	3.90	2.12
<b>1</b>	68.99	47.86	31.29	24.55	18.76	9.81	6.58	4.12	2.24
1/16	71.62	49.79	32.63	25.63	19.62	10.29	6.92	4.34	
1/8	74.25	51.72	33.97	26.72	20.48	10.77	7.25	4.56	
3/16	76.88	53.65	35.32	27.81	21.34	11.25	7.59	4.77	
1/4	79.51	55.59	36.66	28.90	22.20	11.73	7.92	4.99	
5/16	82.14	57.52	38.01	29.98	23.06	12.21	8.26	5.21	
3/8	84.77	59.45	39.35	31.07	23.92	12.69	8.59	5.43	
7/16	87.40	61.39	40.69	32.16	24.78	13.18	8.93	5.65	
1/2	90.04	63.32	42.04	33.25	25.63	13.66	9.26	5.87	
9/16	92.67	65.25	43.38	34.33	26.49	14.14	9.60	6.08	
5/8	95.30	67.18	44.72	35.42	27.35	14.62	9.93	6.30	
11/16	97.93	69.12	46.06	36.51	28.21	15.10	10.27	6.52	
3/4	100.57	71.05	47.41	37.60	29.07	15.58	10.60	6.74	
13/16	103.20	72.98	48.75	38.68	29.93	16.06	10.94	6.96	
7/8	105.83	74.92	50.09	39.77	30.79	16.54	11.27	7.17	
15/16	108.46	76.85	51.43	40.86	31.65	17.02	11.61	7.39	
<b>2</b>	111.09	78.78	52.78	41.95	32.50	17.50	11.94	7.61	
1/8	116.35	82.64	55.46	44.12	34.21	18.46	12.61	8.05	
1/4	121.62	86.51	58.15	46.30	35.93	19.42	13.28	8.48	
3/8	126.88	90.37	60.84	48.47	37.65	20.38	13.95	8.92	
1/2	132.14	94.24	63.53	50.65	39.37	21.35	14.62	9.36	
5/8	137.40	98.10	66.21	52.82	41.08	22.31	15.29	9.79	
3/4	142.67	101.97	68.90	55.00	42.80	23.27	15.96	10.23	
7/8	147.93	105.83	71.58	57.17	44.52	24.23	16.63	10.66	
<b>3</b>	153.19	109.70	74.27	59.35	46.24	25.19	17.30	11.10	
1/8	158.45	113.56	76.95	61.52	47.95	26.15			
1/4	163.72	117.43	79.64	63.70	49.67	27.11			
3/8	168.98	121.29	82.33	65.87	51.39	28.07			
1/2	174.24	125.16	85.02	68.05	53.11	29.04			
5/8	179.50	129.02	87.70	70.22	54.82	30.00			
3/4	184.77	132.89	90.39	72.40	56.54	30.96			
7/8	190.03	136.75	93.07	74.57	58.26	31.92			
<b>4</b>	195.29	140.62	95.76	76.75	59.98	32.88			
1/8	200.55	144.48	98.44	78.92	61.69	33.84			
1/4	205.82	148.35	101.13	81.10	63.41	34.80			
3/8	211.08	152.21	103.82	83.27	65.13	35.76			
1/2	216.34	156.08	106.51	85.45	66.85	36.73			
5/8	221.60	159.94	109.19	87.62	68.56	37.69			
3/4	226.87	163.81	111.88	89.80	70.28	38.65			
7/8	232.13	167.67	114.56	91.97	72.00	39.61			
<b>5</b>	237.39	171.54	117.25	94.15	73.72	40.57			
1/8	242.65	175.40	119.93	96.32	75.43	41.53			
1/4	247.92	179.27	122.62	98.50	77.15	42.49			
3/8	253.18	183.13	125.31	100.67	78.87	43.45			
1/2	258.44	187.00	128.00	102.85	80.59	44.42			
5/8	263.70	190.86	130.68	105.02	82.30	45.38			
3/4	268.97	194.73	133.37	107.20	84.02	46.34			
7/8	274.23	198.59	136.05	109.37	85.74	47.30			
<b>6</b>	279.49	202.46	138.74	111.55	87.46	48.26			
1/8	284.75	206.32	141.42	113.72	89.17	49.22			
1/4	290.02	210.19	144.11	115.90	90.89	50.18			
3/8	295.28	214.05	146.80	118.07	92.61	51.14			
1/2	300.54	217.92	149.49	120.25	94.33	52.11			
5/8	305.80	221.78	152.17	122.42	96.04	53.07			
3/4	311.07	225.65	154.86	124.60	97.76	54.03			
7/8	316.33	229.51	157.54	126.77	99.48	54.99			
<b>7</b>	321.59	233.38	160.23	128.95	101.20	55.95			





# RIVETKING® STEEL TRUSS HEAD RIVET WEIGHT CHART

Pounds Per 1,000 Pieces

Available in: Steel, Brass, Copper, Stainless and Monel



### To Find Pieces Per Pound:

Divide lbs. per thousand into 1,000. i.e. > Round Head  
Steel 3/16 X 1/2; 1,000 / 6.07 = 165 pcs. per lb. to  
determine the number of pieces per pound for materials  
listed multiply steel count by factors indicated.

#2017 ALUM ALLOY	2.81
#6061 ALUM ALLOY	2.90
BRASS	1.082
COPPER	1.145
INCONEL	1.127
18 0/0 NICKEL SILVER	.90
MONEL	.89
HASTELLOY "C"	.88
STAINLESS STEEL 18-8	1.02
STAINLESS STEEL 400	1.00

SOLID RIVETS

LENGTH OF SHANK IN INCHES	7/16"	3/8"	5/16"	9/32"	1/4"	3/16"	5/32"	1/8"	3/32"
	.437	.375	.312	.281	.250	.187	.156	.125	.095
1/16								.80	.40
1/8								1.02	.53
3/16								1.24	.65
1/4				10.88	8.03	3.38	2.12	1.45	.77
5/16			15.68	11.96	8.89	4.34	2.45	1.67	.89
3/8		27.08	17.02	13.05	9.75	4.82	3.12	1.89	1.02
7/16	43.00	29.01	18.36	14.14	10.61	5.30	3.46	2.11	1.14
1/2	45.63	30.94	19.70	15.23	11.46	5.79	3.79	2.33	1.26
9/16	48.26	32.87	21.04	16.31	12.32	6.27	4.13	2.54	1.39
5/8	50.89	34.81	22.39	17.40	13.18	6.75	4.46	2.76	1.51
11/16	53.52	36.74	23.73	18.49	14.04	7.23	4.80	2.98	1.63
3/4	56.16	38.67	25.07	19.58	14.90	7.71	5.13	3.20	1.75
13/16	58.78	40.60	26.42	20.66	15.75	8.19	5.47	3.42	1.88
7/8	61.41	42.54	27.76	21.75	16.61	8.67	5.80	3.63	2.00
15/16	64.05	44.47	29.10	22.84	17.47	9.15	6.14	3.85	2.12
<b>1</b>	66.68	46.40	30.45	23.93	18.33	9.63	6.47	4.07	2.24
1/16	69.31	48.33	31.79	25.01	19.19	10.11	6.81	4.29	
1/8	71.94	50.26	33.13	26.10	20.05	10.59	7.14	4.51	
3/16	74.57	52.19	34.48	27.19	20.91	11.07	7.48	4.72	
1/4	77.20	54.13	35.82	28.28	21.77	11.55	7.81	4.94	
5/16	79.83	56.06	37.17	29.36	22.63	12.03	8.15	5.16	
3/8	82.46	57.99	38.51	30.45	23.49	12.51	8.48	5.38	
7/16	85.09	59.93	39.85	31.54	24.35	13.00	8.82	5.60	
1/2	87.73	61.86	41.20	32.63	25.20	13.48	9.15	5.82	
9/16	90.36	63.79	42.54	33.71	26.06	13.96	9.49	6.03	
5/8	92.99	65.72	43.88	34.80	26.92	14.44	9.82	6.25	
11/16	95.62	67.66	45.22	35.89	27.78	14.92	10.16	6.47	
3/4	98.26	69.59	46.57	36.98	28.64	15.40	10.49	6.69	
13/16	100.89	71.52	47.91	38.06	29.50	15.88	10.83	6.91	
7/8	103.52	73.46	49.25	39.15	30.36	16.36	11.16	7.12	
15/16	106.15	75.39	50.59	40.24	31.22	16.84	11.50	7.34	
<b>2</b>	108.78	77.32	51.94	41.33	32.07	17.32	11.83	7.56	
1/8	114.04	81.18	54.62	43.50	33.78	18.28	12.50	8.00	
1/4	119.31	85.05	57.31	45.68	35.50	19.24	13.17	8.43	
3/8	124.57	88.91	60.00	47.85	37.22	20.20	13.84	8.87	
1/2	129.83	92.78	62.69	50.03	38.94	21.17	14.51	9.31	
5/8	135.09	96.64	65.37	52.20	40.65	22.13	15.18	9.74	
3/4	140.36	100.51	68.06	54.38	42.37	23.09	15.85	10.18	
7/8	145.62	104.37	70.74	56.55	44.09	24.05	16.52	10.61	
<b>3</b>	150.88	108.24	73.43	58.73	45.81	25.01	17.19	11.05	
1/8	156.14	112.10	76.11	60.90	47.52	25.97			
1/4	161.41	115.97	78.80	63.08	49.24	26.93			
3/8	166.67	119.83	81.49	65.25	50.96	27.89			
1/2	171.93	123.70	84.18	67.43	52.68	28.86			
5/8	177.19	127.56	86.86	69.60	54.39	29.82			
3/4	182.46	131.43	89.55	71.78	56.11	30.78			
7/8	187.72	135.29	92.23	73.95	57.83	31.74			
<b>4</b>	192.98	139.16	94.92	76.13	59.55	32.70			
1/8	198.24	143.02	97.60	78.30	61.26	33.66			
1/4	203.51	146.89	100.29	80.48	62.98	34.62			
3/8	208.77	150.75	102.98	82.65	64.70	35.58			
1/2	214.03	154.62	105.67	84.83	66.42	36.55			
5/8	219.29	158.48	108.35	87.00	68.13	37.51			
3/4	224.56	162.35	111.04	89.18	69.85	38.47			
7/8	229.82	166.21	113.72	91.35	71.57	39.43			
<b>5</b>	235.08	170.08	116.41	93.53	73.29	40.39			
1/8	240.34	173.94	119.09	95.70	75.00	41.35			
1/4	245.61	177.81	121.78	97.88	76.72	42.31			
3/8	250.87	181.67	124.47	100.05	78.44	43.27			
1/2	256.13	185.54	127.16	102.23	80.16	44.24			
5/8	261.39	189.40	129.84	104.40	81.87	45.20			
3/4	266.66	193.27	132.53	106.58	83.59	46.16			
7/8	271.92	197.13	135.21	108.75	85.31	47.12			
<b>6</b>	277.18	201.00	137.90	110.93	87.03	48.08			
1/8	282.44	204.86	140.58	113.10	88.74	49.04			
1/4	287.71	208.73	143.27	115.28	90.46	50.00			
3/8	292.97	212.59	145.96	117.45	92.18	50.96			
1/2	298.23	216.46	148.65	119.63	93.90	51.93			
5/8	303.49	220.32	151.33	121.80	95.61	52.89			
3/4	308.76	224.19	154.02	123.98	97.33	53.85			
7/8	314.02	228.05	156.70	126.15	99.05	54.81			
<b>7</b>	319.28	231.92	159.39	128.33	100.77	55.77			

# RIVETKING® STEEL 90° COUNTERSUNK HEAD WEIGHT CHART

Pounds Per 1,000 Pieces

Available in: Steel, Brass, Copper, Stainless and Monel

SOLID RIVETS



### To Find Pieces Per Pound:

Divide lbs. per thousand into 1,000. i.e. > Round Head  
Steel 3/16 X 1/2; 1,000 / 6.07 = 165 pcs. per lb. to  
determine the number of pieces per pound for materials  
listed multiply steel count by factors indicated.

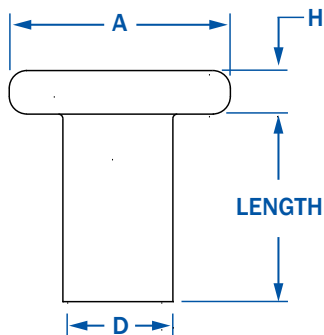
#2017 ALUM ALLOY	2.81
#6061 ALUM ALLOY	2.90
BRASS	1.082
COPPER	1.145
INCONEL	1.127
18 O/O NICKEL SILVER	.90
MONEL	.89
HASTELLOY "C"	.88
STAINLESS STEEL 18-8	1.02
STAINLESS STEEL 400	1.00

LENGTH OF SHANK IN INCHES	7/16"	3/8"	5/16"	9/32"	1/4"	3/16"	5/32"	1/8"
	.437	.375	.312	.281	.250	.187	.156	.125
1/16								.42
1/8								.64
3/16								.83
1/4				6.69	5.08	2.14	1.41	1.07
5/16			9.91	7.77	5.94	3.10	2.08	1.29
3/8		17.13	11.25	8.86	6.80	3.58	2.41	1.51
7/16	27.19	19.06	12.59	9.95	7.66	4.06	2.75	1.73
1/2	29.82	20.99	13.93	11.04	8.51	4.55	3.08	1.95
9/16	32.45	22.92	15.27	12.12	9.37	5.03	3.42	2.16
5/8	35.08	24.86	16.62	13.21	10.23	5.51	3.75	2.38
11/16	37.71	26.79	17.96	14.30	11.09	5.99	4.09	2.60
3/4	40.35	28.72	19.30	15.39	11.95	6.47	4.42	2.82
13/16	42.97	30.65	20.65	16.47	12.80	6.95	4.76	3.04
7/8	45.60	32.59	21.99	17.56	13.66	7.43	5.09	3.25
15/16	48.24	34.52	23.33	18.65	14.52	7.91	5.43	3.47
<b>1</b>	50.87	36.45	24.68	19.74	15.38	8.39	5.76	3.69
1/16	53.50	38.38	26.02	20.82	16.24	8.87	6.10	3.91
1/8	56.13	40.31	27.36	21.91	17.10	9.35	6.43	4.13
3/16	58.76	42.24	28.71	23.00	17.96	9.83	6.77	4.34
1/4	61.39	44.18	30.05	24.09	18.82	10.31	7.10	4.56
5/16	64.02	46.11	31.40	25.17	19.68	10.79	7.44	4.78
3/8	66.65	48.04	32.74	26.26	20.54	11.27	7.77	5.00
7/16	69.28	49.98	34.08	27.35	21.40	11.76	8.11	5.22
1/2	71.92	51.91	35.43	28.44	22.25	12.24	8.44	5.44
9/16	74.55	53.84	36.77	29.52	23.11	12.72	8.78	5.65
5/8	77.18	55.77	38.11	30.61	23.97	13.20	9.11	5.87
11/16	79.81	57.71	39.45	31.70	24.83	13.68	9.45	6.09
3/4	82.45	59.64	40.80	32.79	25.69	14.16	9.78	6.31
13/16	85.08	61.57	42.14	33.87	26.55	14.64	10.12	6.53
7/8	87.71	63.51	43.48	34.96	27.41	15.12	10.45	6.74
15/16	90.34	65.44	44.82	36.05	28.27	15.60	10.79	6.96
<b>2</b>	92.97	67.37	46.17	37.14	29.12	16.08	11.12	7.18
1/8	98.23	71.23	48.85	39.31	30.83	17.04	11.79	7.62
1/4	103.50	75.10	51.54	41.49	32.55	18.00	12.46	8.05
3/8	108.76	78.96	54.23	43.66	34.27	18.96	13.13	8.49
1/2	114.02	82.83	56.92	45.84	35.99	19.93	13.80	8.93
5/8	119.28	86.69	59.60	48.01	37.70	20.89	14.47	9.36
3/4	124.55	90.56	62.29	50.19	39.42	21.85	15.14	9.80
7/8	129.81	94.42	64.97	52.36	41.14	22.81	15.81	10.23
<b>3</b>	135.07	98.29	67.66	54.54	42.86	23.77	16.48	10.67
1/8	140.33	102.15	70.34	56.71	44.57	24.73		
1/4	145.60	106.02	73.03	58.89	46.29	25.69		
3/8	150.86	109.88	75.72	61.06	48.01	26.65		
1/2	156.12	113.75	78.41	63.24	49.73	27.62		
5/8	161.38	117.61	81.09	65.41	51.44	28.58		
3/4	166.65	121.48	83.78	67.59	53.16	29.54		
7/8	171.91	125.34	86.46	69.76	54.88	30.50		
<b>4</b>	177.17	129.21	89.15	71.94	56.60	31.46		
1/8	182.43	133.07	91.83	74.11	58.31	32.42		
1/4	187.70	136.94	94.52	76.29	60.03	33.38		
3/8	192.96	140.80	97.21	78.46	61.75	34.34		
1/2	198.22	144.67	99.90	80.64	63.47	35.31		
5/8	203.48	148.53	102.58	82.81	65.18	36.27		
3/4	208.75	152.40	105.27	84.99	66.90	37.23		
7/8	214.01	156.26	107.95	87.16	68.62	38.19		
<b>5</b>	219.27	160.13	110.64	89.34	70.34	39.15		
1/8	224.53	163.99	113.32	91.51	72.05	40.11		
1/4	229.80	167.86	116.01	93.69	73.77	41.07		
3/8	235.06	171.72	118.70	95.86	75.49	42.03		
1/2	240.32	175.59	121.39	98.04	77.21	43.00		
5/8	245.58	179.45	124.07	100.21	78.92	43.96		
3/4	250.85	183.32	126.76	102.39	80.64	44.92		
7/8	256.11	187.18	129.44	104.56	82.36	45.88		
<b>6</b>	261.37	191.05	132.13	106.74	84.08	46.84		
1/8	266.63	194.91	134.81	108.91	85.79	47.80		
1/4	271.90	198.78	137.50	111.09	87.51	48.76		
3/8	277.16	202.64	140.19	113.26	89.23	49.72		
1/2	282.42	206.51	142.88	115.44	90.95	50.69		
5/8	287.68	210.37	145.56	117.61	92.66	51.65		
3/4	292.95	214.24	148.25	119.79	94.38	52.61		
7/8	298.21	218.10	150.93	121.96	96.10	53.57		
<b>7</b>	303.47	221.97	153.62	124.14	97.82	54.53		



# RIVETKING® OTHER SOLID RIVETS

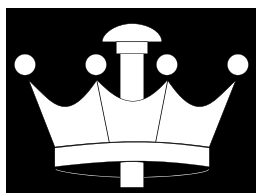
## TINNERS' RIVETS



SIZE OR NUMBER	D		A		H		L	
	SHANK DIAMETER		HEAD DIAMETER		HEAD HEIGHT		LENGTH	
	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.
6 oz.	0.081	0.075	0.213	0.193	0.028	0.016	0.135	0.115
8 oz.	0.091	0.085	0.225	0.205	0.036	0.024	0.166	0.146
10 oz.	0.097	0.091	0.250	0.230	0.037	0.025	0.182	0.162
12 oz.	0.107	0.101	0.265	0.245	0.037	0.025	0.198	0.178
14 oz.	0.111	0.105	0.275	0.255	0.038	0.026	0.198	0.178
1 lb.	0.113	0.107	0.285	0.265	0.040	0.028	0.213	0.193
1-1/4 lb.	0.122	0.116	0.295	0.275	0.045	0.033	0.229	0.209
1-1/2 lb.	0.132	0.126	0.316	0.294	0.046	0.034	0.244	0.224
1-3/4 lb.	0.136	0.130	0.331	0.309	0.049	0.035	0.260	0.240
2 lb.	0.146	0.140	0.341	0.319	0.050	0.036	0.276	0.256
2-1/2 lb.	0.150	0.144	0.311	0.289	0.069	0.055	0.291	0.271
3 lb.	0.163	0.154	0.329	0.303	0.073	0.059	0.323	0.303
3-1/2 lb.	0.168	0.159	0.348	0.322	0.074	0.060	0.338	0.318
4 lb.	0.179	0.170	0.368	0.342	0.076	0.062	0.354	0.334
5 lb.	0.190	0.181	0.388	0.362	0.084	0.070	0.385	0.365
6 lb.	0.206	0.197	0.419	0.393	0.090	0.076	0.401	0.381
7 lb.	0.223	0.214	0.431	0.405	0.094	0.080	0.416	0.396
8 lb.	0.227	0.218	0.475	0.445	0.101	0.085	0.448	0.428
9 lb.	0.241	0.232	0.490	0.460	0.103	0.087	0.463	0.443
10 lb.	0.241	0.232	0.505	0.475	0.104	0.088	0.479	0.459
12 lb.	0.263	0.251	0.532	0.498	0.108	0.090	0.510	0.490
14 lb.	0.288	0.276	0.577	0.543	0.113	0.095	0.525	0.505
16 lb.	0.304	0.292	0.597	0.563	0.128	0.110	0.541	0.521
18 lb.	0.347	0.335	0.706	0.668	0.156	0.136	0.603	0.583

SOLID RIVETS

R I V E T



K I N G®

If you have any comments, questions, or would like to order, please contact us toll free or visit our website.

PHONE: 800-BUY-RIVET (800-289-7483)

FAX: 201-750-1050

WWW.RIVET.COM

# RIVETKING® COPPER BELT RIVETS AND BURRS

CONFORMS TO MANUFACTURER'S STANDARDS - NOT IFI STANDARDS

SOLID RIVETS

## COPPER BELT RIVETS AND BURRS

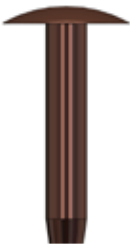


SIZE OR NUMBER	HEAD DIAMETER	HEAD THICKNESS	SHANK DIAMETER	TIP OF SHANK DIA
4	15/16"	.110	.270	.240
5	7/8"	.105	.250	.207
6	11/16"	.090	.228	.190
7	9/16"	.070	.191	.160
8	1/2"	.063	.181	.150
9	15/32"	.058	.161	.130
10	7/16"	.055	.151	.122
11	13/32"	.050	.141	.112
12	3/8"	.045	.137	.108
13	11/32"	.040	.118	.090
14	5/16"	.030	.102	.077
15	1/4"	.025	.090	.070

All diameters given in inches

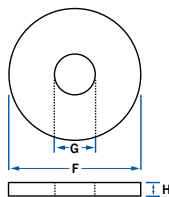
LENGTH OVERALL	SIZE	1/4"	2/5"	1/2"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-3/8"	1-1/2"
APPROXIMATE NUMBER PER LB.	4							34		29		24
	5			55	50	47	43	39	37	35	33	30
	6			93	83	73	64	57	54	49	47	42
	7			143	127	112	99	89	80	74	68	62
	8	255	206	180	150	133	120	105	94	86	81	75
	9	313	260	208	183	160	143	129	115	108	98	93
	10	386	302	256	216	192	165	147	136	121	116	104
	11	455	350	290	250	215	190	170	164	140	132	125
	12	525	412	330	287	244	212	191	174	160	156	136
	13	650	510	420	360	300	275	250				
	14	871	702	579	490	435	377	336				
	15	1263	934	755	628	540	480	420				

## COPPER TRUNK RIVETS – OVAL HEAD



SIZE OR NUMBER	LENGTH UNDER HEAD, INCHES			APPROXIMATE NUMBER OF PIECES PER POUND										
	HEAD DIA.	HEAD UNDER DIA.	TIP OF SHANK DIA.	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1"	1-1/4"	1-1/2"	1-3/4"	2"
9	.406	.161	.144	247	215	178	162	141	130	116	98	84	74	66
12	.434	.137	.122	411	342	284	248	219	205	176	147	126	110	98

## COPPER BURRS ONLY



F= Outside Diameter  
G= Inside Diameter  
H= Thickness

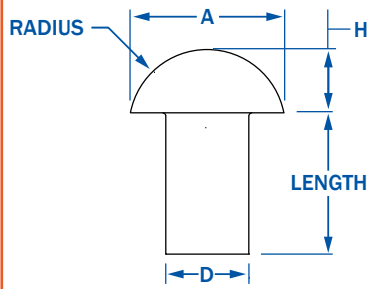
SIZE OR NUMBER	O.D. INCHES	I.D. INCHES	THICKNESS INCHES	APPROXIMATE NUMBER PER LB.
3	.922	.290	.081	64
4	.875	.256	.071	76
5	.813	.223	.064	102
6	.656	.206	.057	184
7	.500	.176	.051	380
8	.469	.166	.045	465
9	.438	.146	.040	580
10	.406	.138	.036	750
11	.391	.128	.031	950
12	.360	.124	.028	1240
13	.344	.106	.025	1350
14	.313	.093	.022	2050
15	.281	.086	.020	2950
16	.250	.067	.018	3825



# RIVETKING® STEEL LARGE DIAMETER RIVETS

SOLID RIVET LARGE DIAMETER

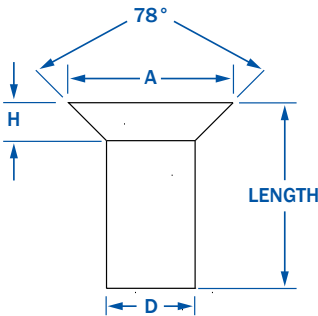
## ROUND HEAD RIVETS



	D BODY DIAMETER			A HEAD DIAMETER			H HEAD HEIGHT		G HEAD RADIUS
	Nominal	Max.	Min.	Basic	Max.	Min.	Max.	Min.	
1/2"	0.500	0.520	0.478	0.875	0.938	0.844	0.406	0.375	0.443
5/8"	0.625	0.655	0.600	1.094	1.157	1.063	0.500	0.469	0.553
3/4"	0.750	0.780	0.725	1.312	1.390	1.281	0.593	0.562	0.664
7/8"	0.875	0.905	0.850	1.531	1.609	1.500	0.687	0.656	0.775
1"	1.000	1.030	0.975	1.750	1.828	1.719	0.781	0.750	0.885
1-1/8"	1.125	1.160	1.098	1.969	2.063	1.938	0.891	0.844	0.996
1-1/4"	1.250	1.285	1.223	2.188	2.282	2.157	0.985	0.938	1.107
1-3/8"	1.375	1.415	1.345	2.406	2.500	2.375	1.078	1.031	1.217
1-1/2"	1.500	1.540	1.470	2.625	2.719	2.594	1.188	1.125	1.328
1-5/8"	1.625	1.665	1.588	2.844	2.938	2.813	1.282	1.219	1.439
1-3/4"	1.750	1.790	1.713	3.062	3.171	3.031	1.375	1.312	1.549

ALL DIAMETERS GIVEN IN INCHES

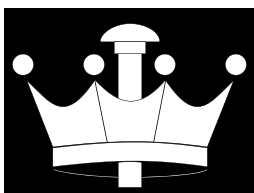
## 78° COUNTERSUNK HEAD RIVETS



NOMINAL SIZE OR BASIC SHANK DIAMETER	D SHANK DIAMETER		A HEAD DIAMETER		H HEAD HEIGHT	
	Max.	Min.	Max.	Min.	Ref.	
1/2"	0.500	0.520	0.478	0.936	0.872	0.260
5/8"	0.625	0.655	0.600	1.194	1.112	0.339
3/4"	0.750	0.780	0.725	1.421	1.322	0.400
7/8"	0.875	0.905	0.850	1.647	1.532	0.460
1"	1.000	1.030	0.975	1.873	1.745	0.520
1-1/8"	1.125	1.160	1.098	2.114	1.973	0.589
1-1/4"	1.250	1.285	1.223	2.340	2.199	0.650
1-3/8"	1.375	1.415	1.345	2.567	2.426	0.710
1-1/2"	1.500	1.540	1.470	2.793	2.652	0.771
1-5/8"	1.625	1.665	1.588	3.019	2.878	0.831
1-3/4"	1.750	1.790	1.713	3.262	3.121	0.901

ALL DIAMETERS GIVEN IN INCHES

R I V E T



K I N G®

If you have any comments, questions, or would like to order, please contact us toll free or visit our website.

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# RIVETKING® STEEL LARGE DIAMETER WEIGHT CHART

Pounds Per 1,000 Pieces

SOLID RIVET LARGE DIAMETER

LENGTH OF SHANK IN INCHES	1/2"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-3/8"	1-1/2"	1-5/8"	1-3/4"
1/2	67.4	120.8	-	-	-	-	-	-	-	-	-
5/8	74.3	131.6	-	-	-	-	-	-	-	-	-
3/4	81.2	142.3	227.2	-	-	-	-	-	-	-	-
7/8	88.1	153.1	242.7	-	-	-	-	-	-	-	-
<b>1</b>	94.9	163.8	258.1	382.4	-	-	-	-	-	-	-
1-1/8	101.8	174.6	273.6	403.5	566.1	-	-	-	-	-	-
1-1/4	108.7	185.3	289	424.6	593.5	-	-	-	-	-	-
1-3/8	115.5	196.1	304.5	445.6	621	-	-	-	-	-	-
1-1/2	122.4	206.8	319.9	466.7	648.5	871.8	-	-	-	-	-
1-5/8	129.3	217.6	335.4	487.8	675.9	906.6	-	-	-	-	-
1-3/4	136.2	228.3	350.8	508.9	703.4	941.4	1223	-	-	-	-
1-7/8	143	239.1	366.3	529.9	73.8	976.2	1266	-	-	-	-
<b>2</b>	149.9	249.8	381.7	551	758.3	1011	1309	1663	-	-	-
2-1/8	156.8	260.6	397.2	572.1	785.8	1046	1352	1715	-	-	-
2-1/4	163.7	271.3	412.6	593.2	813.2	1081	1395	1767	-	-	-
2-3/8	170.5	282.1	428.1	614.2	840.7	1115	1438	1819	-	-	-
2-1/2	177.4	292.8	443.5	635.3	868.2	1150	1481	1871	2322	-	-
2-5/8	184.3	303.6	459	656.4	895.6	1185	1523	1923	2384	-	-
2-3/4	191.2	314.3	474.4	677.5	923.1	1220	1566	1976	2447	-	-
2-7/8	198	325.1	489.9	698.5	950.5	1255	1609	2028	2509	-	-
<b>3</b>	204.9	335.8	505.3	719.6	978	1290	1652	2080	2571	3117	3710
3-1/8	211.8	346.6	520.8	740.7	1006	1324	1695	2132	2633	3189	3794
3-1/4	218.7	357.3	536.2	761.8	1033	1359	1738	2184	2696	3262	3877
3-3/8	225.5	368.1	551.7	782.8	1060	1394	1781	2236	2758	3335	3961
3-1/2	232.4	378.8	567.1	803.9	1088	1429	1824	2288	2820	3408	4045
3-5/8	239.3	389.6	582.6	825	1115	1464	1867	2341	2883	3481	4128
3-3/4	246.2	400.3	598	846.1	1143	1498	1910	2393	2945	3554	4212
3-7/8	253	411.1	613.4	867.1	1170	1533	1953	2445	3007	3627	4295
<b>4</b>	259.9	421.8	628.9	888.2	1198	1568	1995	2497	3070	3700	4379
4-1/8	266.8	432.6	644.4	909.3	1225	1603	2038	2549	3132	3773	4462
4-1/4	273.7	443.3	659.8	930.4	1253	1638	2081	2601	3194	3846	4546
4-3/8	280.5	454.1	675.3	951.4	1280	1672	2124	2653	3257	3919	4630
4-1/2	287.4	464.8	690.7	972.5	1308	1707	2167	2706	3319	3992	4713
4-5/8	294.3	475.6	706.2	993.6	1335	1742	2210	2758	3381	4065	4797
4-3/4	301.2	486.3	721.6	1015	1363	1777	2253	2810	3444	4138	4880
4-7/8	308	497.1	737.1	1036	1390	1812	2296	2862	3506	4211	4964
<b>5</b>	314.9	507.8	752.5	1057	1417	1847	2339	2914	3568	4284	5047
5-1/8	321.8	518.6	768	1078	1445	1881	2382	2966	3630	4356	5131
5-1/4	328.7	529.3	783.4	1099	1472	1916	2425	3018	3693	4429	5215
5-3/8	335.5	540.1	798.9	1120	1500	1951	2467	3070	3755	4502	5298
5-1/2	342.4	550.8	814.3	1141	1527	1986	2510	3123	3817	4575	5382
5-5/8	349.3	561.6	829.8	1162	1555	2021	2553	3175	3880	4648	5465
5-3/4	356.2	572.3	845.2	1183	1582	2055	2596	3227	3942	4721	5549
5-7/8	363	583.1	860.7	1204	1610	2090	2639	3279	4004	4794	5632
<b>6</b>	369.9	593.8	876.1	1225	1637	2125	2682	3331	4067	4867	5716
6-1/8	376.8	604.6	891.6	1247	1665	2160	2725	3383	4129	4940	5800
6-1/4	383	615.3	907	1268	1692	2195	2768	3435	4191	5013	5883
6-3/8	390.5	626.1	922.5	1289	1720	2229	2811	3488	4254	5086	5967
6-1/2	397.4	636.8	937.9	1310	1747	2264	2854	3540	4316	5159	6050
6-5/8	404.3	647.6	953.4	1331	1774	2299	2897	3592	4378	5232	6134
6-3/4	411.2	658.3	968.8	1352	1802	2334	2940	3644	4441	5305	6218
6-7/8	418	669.1	984.3	1373	1829	2369	2982	3696	4503	5378	6301
<b>7</b>	424.9	679.8	999.7	1394	1857	2404	3025	3748	4565	5451	6385
7-1/8	431.8	690.6	1015	1415	1884	2438	3068	3800	4627	5523	6468
7-1/4	438.7	701.3	1031	1436	1912	2473	3111	3853	4690	5596	6552
7-3/8	445.5	712.1	1046	1457	1939	2508	3154	3905	4752	5669	6635
7-1/2	452.4	722.8	1062	1478	1967	2543	3197	3957	4814	5742	6719
7-5/8	459.3	733.6	1077	1499	1994	2578	3240	4009	4877	5815	6803
7-3/4	466.2	744.3	1092	1521	2022	2612	3283	4061	4939	5888	6886
7-7/8	473	755.1	1108	1542	2049	2647	3326	4113	5001	5961	6970
<b>8</b>	479.9	765.8	1123	1563	2077	2682	3369	4165	5064	6034	7053

## STYLE OF HEAD

Approximate difference in weight between 1000 Steel Round Head Rivets and 1000 Steel Rivets with other standard types of heads.

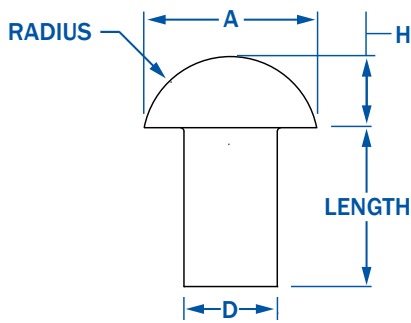
Diameter of Rivet	High Button	Cone	Flat-Top Countersunk	Round-Top Countersunk	Pan
	Number of pounds lighter than round head rivets	Number of pounds lighter than round head rivets	Number of pounds lighter than round head rivets	Number of pounds lighter than round head rivets	Number of pounds lighter than round head rivets
1/2"	0	5.5	25.4	16.7	2
5/8"	3.9	10.8	49.5	32.5	4
3/4"	14.2	18.7	85.5	56.2	6.9
7/8"	29.7	29.5	136	89.3	11
1"	52.9	44.2	203	133	16.6
1-1/8"	79	63	289	190	23
1-1/4"	115	87	395	260	2
1-3/8"	178	116	528	346	43
1-1/2"	252	150	686	450	55
1-5/8"	322	192	870	572	70
1-3/4"	355	236	996	714	88



# RIVETKING® ALUMINUM SOLID RIVET HEAD STYLES

ALUMINUM RIVETS

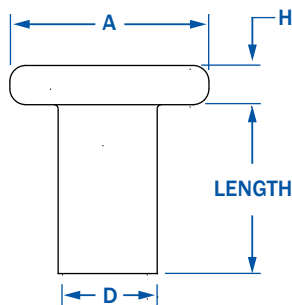
## ROUND HEAD



APPROXIMATE PROPORTIONS:  
 $A = 2.00 \times D$   
 $H = 0.75 \times D$   
 $R = 1.042 \times D$

D		A	H	R
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT	HEAD RADIUS
FRACTION	DECIMAL			
3/32	0.094	0.187	0.070	0.098
1/8	0.125	0.250	0.094	0.130
5/32	0.156	0.312	0.117	0.163
3/16	0.187	0.375	0.141	0.195
1/4	0.250	0.500	0.188	0.260
5/16	0.312	0.625	0.234	0.326
3/8	0.375	0.750	0.281	0.391

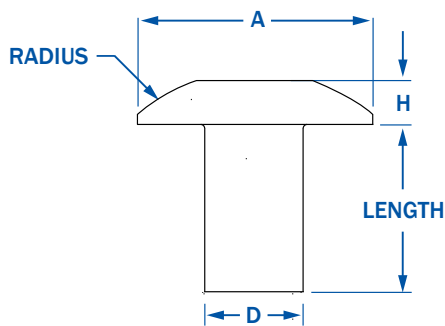
## FLAT HEAD



APPROXIMATE PROPORTIONS:  
 $A = 2.00 \times D$   
 $H = 0.40 \times D$

D		A	H
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT
FRACTION	DECIMAL		
3/32	0.094	0.187	0.038
1/8	0.125	0.250	0.050
5/32	0.156	0.312	0.062
3/16	0.187	0.375	0.075
1/4	0.250	0.500	0.100
5/16	0.312	0.625	0.125
3/8	0.375	0.750	0.150

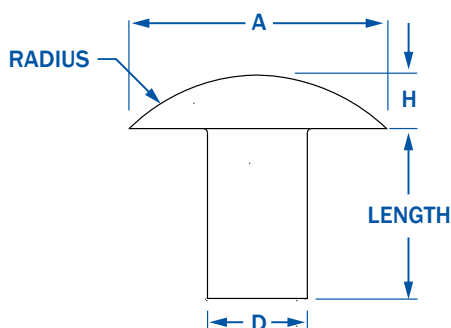
## UNIVERSAL HEAD



APPROXIMATE PROPORTIONS:  
 $A = 2.000 \times D$   
 $H = 0.465 \times D$   
 $R = 0.872 \times D$

D		A	H	R
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT	HEAD RADIUS
FRACTION	DECIMAL			
3/32"	0.094	0.187	0.045	0.082
1/8"	0.125	0.250	0.059	0.108
5/32"	0.156	0.312	0.072	0.135
3/16"	0.187	0.375	0.085	0.164
1/4"	0.250	0.500	0.112	0.217
5/16"	0.312	0.625	0.138	0.272
3/8"	0.375	0.750	0.166	0.328

## BRAZIER HEAD



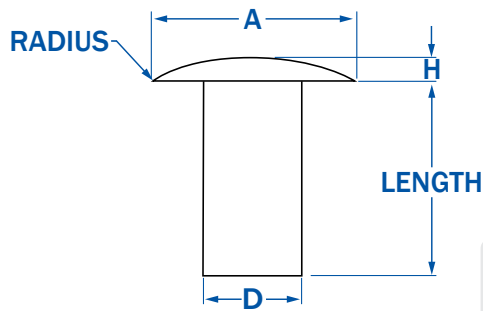
APPROXIMATE PROPORTIONS:  
 $A = 2.50 \times D$   
 $H = 0.50 \times D$   
 $R = 1.8125 \times D$

D		A	H	R
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT	HEAD RADIUS
FRACTION	DECIMAL			
3/32"	0.094	0.234	0.047	0.170
1/8"	0.125	0.312	0.062	0.227
5/32"	0.156	0.391	0.078	0.283
3/16"	0.187	0.469	0.094	0.340
1/4"	0.250	0.625	0.125	0.453
5/16"	0.312	0.781	0.156	0.566
3/8"	0.375	0.937	0.187	0.680

# RIVETKING® ALUMINUM SOLID RIVET HEAD STYLES

ALUMINUM RIVETS

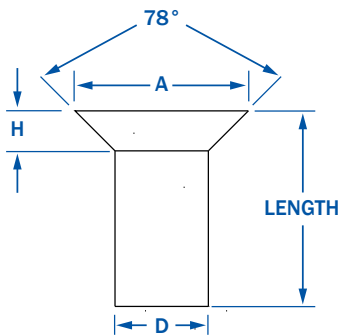
## MODIFIED BRAZIER HEAD



APPROXIMATE PROPORTIONS:  
 $A = 1.94 \times D$   
 $H = 0.33 \times D$

D		A	H
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT
FRACTION	DECIMAL		
3/32"	0.094	0.156	0.031
1/8"	0.125	0.235	0.047
5/32"	0.156	0.312	0.063
3/16"	0.187	0.390	0.078
1/4"	0.250	0.468	0.094
5/16"	0.312	0.625	0.125
3/8"	0.375	0.781	0.156

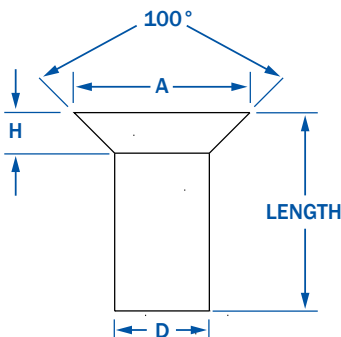
## 78° COUNTERSUNK HEAD



APPROXIMATE PROPORTIONS:  
 $A = 2.81 \times D$   
 $H = 0.50 \times D$

D		A	H
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT
FRACTION	DECIMAL		
3/32	0.094	0.170	0.047
1/8	0.125	0.225	0.065
5/32	0.156	0.282	0.078
3/16	0.187	0.339	0.094
1/4	0.250	0.452	0.125
5/16	0.312	0.565	0.156
3/8	0.375	0.678	0.187

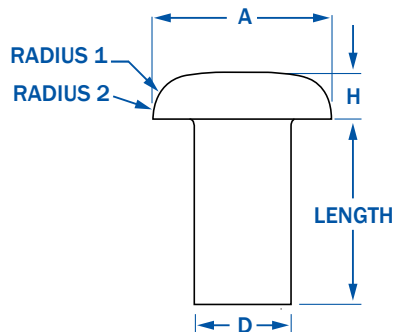
## 100° COUNTERSUNK HEAD



APPROXIMATE PROPORTIONS:  
 $A = 1.54 \times D$   
 $H = 0.26 \times D$

D		A	H
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT
FRACTION	DECIMAL		
3/32	0.094	0.170	0.036
1/8	0.125	0.216	0.042
5/32	0.156	0.278	0.055
3/16	0.187	0.344	0.070
1/4	0.250	0.467	0.095
5/16	0.312	0.555	0.106
3/8	0.375	0.685	0.134

## MUSHROOM HEAD



APPROXIMATE PROPORTIONS:  
 $A = 2.00 \times D$   
 $H = 0.625 \times D$   
 $R = 1.634 \times D$   
 $R_1 = 0.050 \times D$

D		A	H	R	R <sub>1</sub>
NOMINAL DIAMETER		HEAD DIAMETER	HEAD HEIGHT	HEAD RADIUS	HEAD RADIUS <sub>1</sub>
FRACTION	DECIMAL				
3/32"	0.094	0.187	0.059	0.153	0.147
1/8"	0.125	0.250	0.078	0.204	0.062
5/32"	0.156	0.312	0.098	0.255	0.078
3/16"	0.187	0.375	0.117	0.306	0.094
1/4"	0.250	0.500	0.156	0.408	0.125
5/16"	0.312	0.625	0.195	0.511	0.156
3/8"	0.375	0.750	0.234	0.613	0.187





# RIVETKING® ALUMINUM SOLID RIVET WEIGHT CHARTS

ALUMINUM RIVETS

## ROUND HEAD



BODY DIA.	Pounds Per 1,000 Pieces																									
	LENGTH																									
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2	
1/16	0.072	0.081	0.091	0.100	0.110	0.128	0.147	0.167	0.186	0.205	0.224	0.243	0.263	0.281	0.300	0.319	0.338									
3/32	0.185	0.207	0.228	0.251	0.273	0.316	0.360	0.404	0.448	0.492	0.535	0.573	0.623	0.667	0.711	0.755	0.798	0.877	0.974	1.056	1.149					
1/8	0.364	0.417	0.456	0.494	0.532	0.611	0.688	0.766	0.843	0.921	0.998	1.076	1.153	1.232	1.309	1.387	1.464	1.618	1.770	1.927	2.083	2.252	2.392	2.551	2.703	
5/32		0.646	0.803	0.864	0.924	1.041	1.163	1.271	1.404	1.527	1.647	1.770	1.890	2.012	2.132	2.252	2.375	2.618	2.849	3.106	3.333	3.584	3.831	4.065	4.310	
3/16			1.300	1.385	1.475	1.650	1.818	1.992	2.169	2.342	2.545	2.688	2.865	3.040	3.215	3.390	3.559	3.906	4.255	4.608	4.950	5.291	5.650	6.061	6.329	
1/4					3.135	3.448	3.759	4.065	4.386	4.739	5.000	5.319	5.650	5.952	6.250	6.579	6.849	7.519	8.130	8.772	9.346	9.709	10.638	11.236	11.905	
5/16						6.135	6.623	7.092	7.634	8.065	8.621	9.009	9.524	10.000	10.526	10.989	11.494	12.346	13.514	14.286	15.385	16.129	17.241	18.182	19.231	
3/8							10.101	11.494	12.195	12.987	13.699	14.286	15.152	15.873	16.393	16.949	17.857	19.231	20.833	22.222	23.256	25.000	26.316	27.778	29.412	

## FLAT HEAD



BODY DIA.	Pounds Per 1,000 Pieces																								
	LENGTH																								
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2
1/16	0.178	0.197	0.219	0.236	0.256	0.307	0.348	0.397	0.444	0.490	0.531	0.572	0.612	0.653	0.699	0.745	0.789	0.886	0.982	1.080	1.179	1.272	1.328	1.451	1.522
3/32	0.373	0.420	0.461	0.502	0.538	0.605	0.672	0.742	0.822	0.903	0.983	1.058	1.138	1.221	1.294	1.374	1.449	1.621	1.812	1.969	2.141	2.342	2.513	2.688	2.857
1/8		0.652	0.716	0.782	0.845	0.985	1.085	1.209	1.323	1.433	1.560	1.681	1.812	1.931	2.049	2.188	2.331	2.571	2.717	3.135	3.436	3.731	4.049	4.425	4.902
5/32			1.186	1.267	1.351	1.517	1.689	1.859	2.033	2.232	2.398	2.591	2.770	2.950	3.125	3.322	3.497	3.876	4.255	4.630	5.128	5.435	5.814	6.250	7.042
3/16					2.387	2.703	3.067	3.390	3.802	4.167	4.545	5.000	5.348	5.780	6.211	6.667	7.143	7.407	8.000	8.621	9.259	10.000	11.111	11.236	12.821
1/4						5.000	5.556	6.250	6.944	7.407	8.197	8.475	9.259	10.000	10.309	10.753	11.628	12.346	13.889	15.385	17.241	17.857	18.519	19.231	20.000
5/16							9.901	11.236	11.905	12.658	13.333	13.889	14.706	15.385	16.129	16.667	17.241	18.519	20.000	21.277	22.222	23.810	25.000	26.316	27.778
3/8							8.475	9.174	9.901	10.526	11.236	11.905	12.658	13.333	14.085	14.706	15.385	16.949	18.182	19.608	21.277	22.727	23.810	25.641	27.027

## UNIVERSAL HEAD



BODY DIA.	Pounds Per 1,000 Pieces																								
	LENGTH																								
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2
1/16	0.178	0.197	0.219	0.236	0.256	0.307	0.348	0.397	0.444	0.490	0.531	0.572	0.612	0.653	0.699	0.745	0.789	0.886	0.982	1.080	1.179	1.272	1.328	1.451	1.522
3/32	0.373	0.420	0.461	0.502	0.538	0.605	0.672	0.742	0.822	0.903	0.983	1.058	1.138	1.221	1.294	1.374	1.449	1.621	1.812	1.969	2.141	2.342	2.513	2.688	2.857
1/8		0.652	0.716	0.782	0.845	0.985	1.085	1.209	1.323	1.433	1.560	1.681	1.812	1.931	2.049	2.188	2.331	2.571	2.717	3.135	3.436	3.731	4.049	4.425	4.902
5/32			1.186	1.267	1.351	1.517	1.689	1.859	2.033	2.232	2.398	2.591	2.770	2.950	3.125	3.322	3.497	3.876	4.255	4.630	5.128	5.435	5.814	6.250	7.042
3/16					2.387	2.703	3.067	3.390	3.802	4.167	4.545	5.000	5.348	5.780	6.211	6.667	7.143	7.407	8.000	8.621	9.259	10.000	11.111	11.236	12.821
1/4						5.000	5.556	6.250	6.944	7.407	8.197	8.475	9.259	10.000	10.309	10.753	11.628	12.346	13.889	15.385	17.241	17.857	18.519	19.231	20.000
5/16							9.901	11.236	11.905	12.658	13.333	13.889	14.706	15.385	16.129	16.667	17.241	18.519	20.000	21.277	22.222	23.810	25.000	26.316	27.778
3/8							8.475	9.174	9.901	10.526	11.236	11.905	12.658	13.333	14.085	14.706	15.385	16.949	18.182	19.608	21.277	22.727	23.810	25.641	27.027

## BRAZIER HEAD

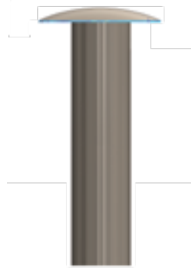


BODY DIA.	Pounds Per 1,000 Pieces																								
	LENGTH																								
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2
1/16	0.076	0.086	0.096	0.105	0.115	0.134	0.154	0.173	0.192	0.211	0.231	0.250	0.269	0.289	0.308	0.327	0.346								
3/32	0.200	0.222	0.243	0.265	0.287	0.330	0.374	0.417	0.461	0.504	0.548	0.591	0.635	0.678	0.722	0.765	0.808	0.895	0.982	1.071	1.156				
1/8	0.422	0.461	0.499	0.538	0.577	0.654	0.732	0.809	0.887	0.964	1.042	1.119	1.196	1.274	1.351	1.429	1.506	1.661	1.815	1.972	2.128	2.283	2.439	2.591	2.747
5/32		0.824	0.885	0.945	1.006	1.126	1.247	1.368	1.488	1.610	1.730	1.852	1.972	2.092	2.212	2.336	2.457	2.695	2.941	3.185	3.425	3.663	3.906	4.149	4.386
3/16			1.418	1.506	1.592	1.767	1.942	2.119	2.294	2.463	2.639	2.817	2.994	3.165	3.344	3.509	3.690	4.032	4.386	4.739	5.076	5.435	5.780	6.135	6.494
1/4					3.356	3.663	3.968	4.310	4.587	4.902	5.208	5.525	5.814	6.135	6.452	6.757	7.092	7.692	8.333	8.929	9.524	10.204	10.753	11.364	12.048
5/16						6.536	7.042	7.519	8.000	8.475	9.009	9.434	9.901	10.417	10.870	11.364	11.765	12.821	13.889	14.925	15.873	16.667	17.857	18.868	19.608
3/8							11.364	12.048	12.821	13.514	14.085	14.925	15.625	16.393	16.949	17.857	18.519	20.000	21.277	23.256	24.390	26.316	27.778	29.412	30.303

# RIVETKING® ALUMINUM SOLID RIVET WEIGHT CHARTS

ALUMINUM RIVETS

## MODIFIED BRAZIER HEAD



BODY DIA.	Pounds Per 1,000 Pieces																									
	LENGTH																									
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2	
1/16	0.123	0.145	0.167	0.189	0.211	0.254	0.298	0.341	0.385	0.429	0.472	0.516	0.560	0.603	0.647	0.691	0.734									
3/32	0.274	0.313	0.352	0.390	0.429	0.507	0.584	0.661	0.739	0.816	0.894	0.971	1.048	1.125	1.203	1.280	1.359	1.486	1.667	1.821	1.976					
1/8		0.577	0.637	0.697	0.758	0.879	0.999	1.120	1.241	1.361	1.481	1.603	1.724	1.842	1.965	2.083	2.203	2.445	2.688	2.933	3.175	3.413	3.650	3.891	4.132	
5/32			1.042	1.129	1.215	1.389	1.563	1.736	1.908	2.083	2.257	2.427	2.604	2.778	2.950	3.125	3.300	3.636	3.984	4.329	4.673	5.025	5.376	5.714	6.061	
3/16					2.155	2.463	2.770	3.086	3.390	3.704	4.016	4.329	4.630	4.950	5.263	5.556	5.882	6.494	7.092	7.813	8.333	9.009	9.615	10.204	10.870	
1/4						4.525	5.025	5.495	5.988	6.452	6.944	7.407	7.937	8.403	8.929	9.346	9.804	10.753	11.765	12.658	13.699	14.706	15.625	16.667	17.544	
5/16							7.246	8.065	8.772	9.615	10.417	11.236	12.048	12.821	13.699	14.493	15.152	16.667	18.182	19.608	20.833	22.222	23.810	25.000	26.316	
3/8								8.475	9.174	9.901	10.526	11.236	11.905	12.658	13.333	14.085	14.706	15.385	16.949	18.182	19.608	21.277	22.727	23.810	25.641	27.027

## 100° COUNTERSUNK HEAD



BODY DIA.	Pounds Per 1,000 Pieces																									
	LENGTH																									
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2	
1/16	0.043	0.053	0.062	0.072	0.081	0.101	0.120	0.139	0.158	0.177	0.196	0.215	0.234	0.253	0.272	0.291	0.310									
3/32	0.112	0.134	0.156	0.178	0.200	0.244	0.288	0.331	0.375	0.419	0.463	0.507	0.550	0.594	0.638	0.682	0.726	0.813	0.901	0.988	1.076					
1/8	0.201	0.240	0.279	0.317	0.356	0.433	0.511	0.588	0.666	0.743	0.820	0.898	0.976	1.053	1.130	1.208	1.325	1.441	1.595	1.751	1.905	2.062	2.217	2.370	2.525	
5/32		0.393	0.454	0.514	0.578	0.694	0.816	0.927	1.057	1.178	1.299	1.420	1.541	1.661	1.783	1.901	2.024	2.268	2.506	2.747	2.985	3.226	3.460	3.704	3.937	
3/16			0.664	0.750	0.837	1.009	1.182	1.355	1.529	1.701	1.873	2.049	2.217	2.392	2.564	2.740	2.915	3.257	3.610	3.953	4.292	4.630	5.000	5.348	5.682	
1/4					1.767	2.079	2.387	2.695	3.003	3.322	3.623	3.953	4.255	4.566	4.878	5.181	5.495	6.135	6.711	7.353	8.000	8.621	9.259	9.901	10.526	
5/16						3.257	3.745	4.237	4.717	5.181	5.682	6.173	6.623	6.944	7.576	8.130	8.621	9.524	10.526	11.494	12.500	13.514	14.493	15.385	16.393	
3/8							5.917	6.623	7.299	8.000	8.696	9.434	10.101	10.753	11.494	12.195	12.987	14.286	15.625	16.949	18.519	20.000	21.277	22.727	23.810	

## 78° COUNTERSUNK HEAD



BODY DIA.	Pounds Per 1,000 Pieces																									
	LENGTH																									
	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	1 7/8	2	
1/16	0.049	0.059	0.069	0.078	0.088	0.107	0.126	0.145	0.164	0.183	0.202	0.221	0.240	0.259	0.278	0.297	0.316									
3/32	0.125	0.147	0.168	0.190	0.212	0.256	0.300	0.344	0.387	0.432	0.475	0.519	0.563	0.606	0.650	0.694	0.738	0.825	0.913	1.000	1.088					
1/8	0.228	0.267	0.305	0.344	0.383	0.460	0.538	0.615	0.693	0.770	0.847	0.925	1.002	1.080	1.147	1.224	1.302	1.458	1.613	1.767	1.923	2.079	2.232	2.387	2.545	
5/32		0.458	0.518	0.578	0.639	0.759	0.881	1.001	1.121	1.242	1.362	1.484	1.605	1.727	1.845	1.969	2.088	2.336	2.571	2.817	3.058	3.333	3.534	3.788	4.016	
3/16			0.777	0.864	0.951	1.125	1.297	1.471	1.645	1.818	1.992	2.165	2.342	2.513	2.688	2.857	3.030	3.378	3.774	4.082	4.425	4.785	5.128	5.464	5.814	
1/4					1.887	2.193	2.506	2.817	3.125	3.436	3.745	4.049	4.367	4.673	4.975	5.291	5.618	6.211	6.849	7.463	8.130	8.696	9.346	10.000	10.638	
5/16						4.878	5.319	5.848	6.329	6.803	7.299	7.813	8.264	8.772	9.259	9.709	10.204	11.236	12.195	13.158	14.085	15.152	16.129	16.949	18.182	
3/8							8.475	9.174	9.901	10.526	11.236	11.905	12.658	13.333	14.085	14.706	15.385	16.949	18.182	19.608	21.277	22.727	23.810	25.641	27.027	



If you have any comments, questions, or would like to order, please contact us toll free or visit our website.

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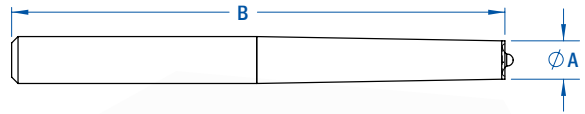
# RIVETKING® RIVET SETTING EQUIPMENT

## HANDSETS

Handsets are used for prototyping or low volume installation of Semi Tubular rivets. Handsets can be used with a hammer or they can be modified by the user to fit in a press.

Diameter of Rivet	A	B
	Tip Diameter	Length
Nominal	Nominal	Nominal
3/32 - .094	0.166	0.071
1/8 - .125	0.219	0.094
5/32 - .156	0.273	0.117
3/16 - .188	0.327	0.140
7/32 - .219	0.385	0.165
1/4 - .250	0.438	0.188
9/32 - .281	0.492	0.211

All diameters given in inches



## RIVETING HAMMERS

Rivet Hammers are used as an economical way to apply soft solid rivets in diameters less than 3/16". The patented shock reducing air hammer will apply rivets with a hardness less than Rb65 max. The air hammer delivers more than 1000 blows per minute to insure the rivet is set properly. The riveter comes in a blow mold kit equipped with 3/32", 1/8", 5/32", 3/16" round face punches. The quick change feature is convenient and is ergonomically designed for operator comfort.

Diameter of Rivet	A	B
	Tip Diameter	Length
Nominal	Nominal	Nominal
3/32 - .094	0.166	0.071
1/8 - .125	0.219	0.094
5/32 - .156	0.273	0.117
3/16 - .188	0.327	0.140
7/32 - .219	0.385	0.165
1/4 - .250	0.438	0.188
9/32 - .281	0.492	0.211

All diameters given in inches



## AUTO FEED RIVETING MACHINES

The RivetKing ESI Riveter is one of the most modern and efficient riveters designed. The ESI series is designed to apply Semi Tubular rivets, however, depending on the diameter and material, it also has the capacity to handle self piercing rivets and solid rivets. The machines is simple to maintain; having only 8 moving parts, and a choice of feed systems depending on the size and shape of the rivets. It is built around a steel weldment, and is available as a pedestal or bench model, with several anvil brackets to accommodate a versatile range of parts.

Machine	Rivet Diameter Capacity	Rivet Length Capacity	Stroke	Standard Throat Depth	Optional Throat Depth	Bench Model	Pedestal Model	Applied Force
Model#	Min - Max	Min - Max	Inches	Standard	Optional	W" x D" x H"	W" x D" x H"	Configuration
P-125	.040" - .140"	.090" - .500"	2"	9"	18" or 24"	10" x 22" x 24"	28" x 20" x 61"	Pneumatic
P-250	.125" - .250"	.125" - 1.625"	3"	12"	18" or 24"	18" x 22" x 32"	18" x 24" x 34"	Pneumatic
P-255	.140" - .250"	.125" - 3.250"	5"	16"	18" or 24"	18" x 36" x 34"	24" x 36" x 78"	Pneumatic
P-312	.250" - .312"	.250" - 3.250"	5"	12"	-	-	30" x 36" x 80"	Air / Oil

ALL DIAMETERS GIVEN IN INCHES

### OPTIONAL EQUIPMENT:

- Footswitch
- Double Palm Buttons
- FingerGuard
- Air Operated Anvil Pin
- Vibe Bowl

Can be designed as a multiple head system.



P-125 Bench Model w/ Vibe Bowl

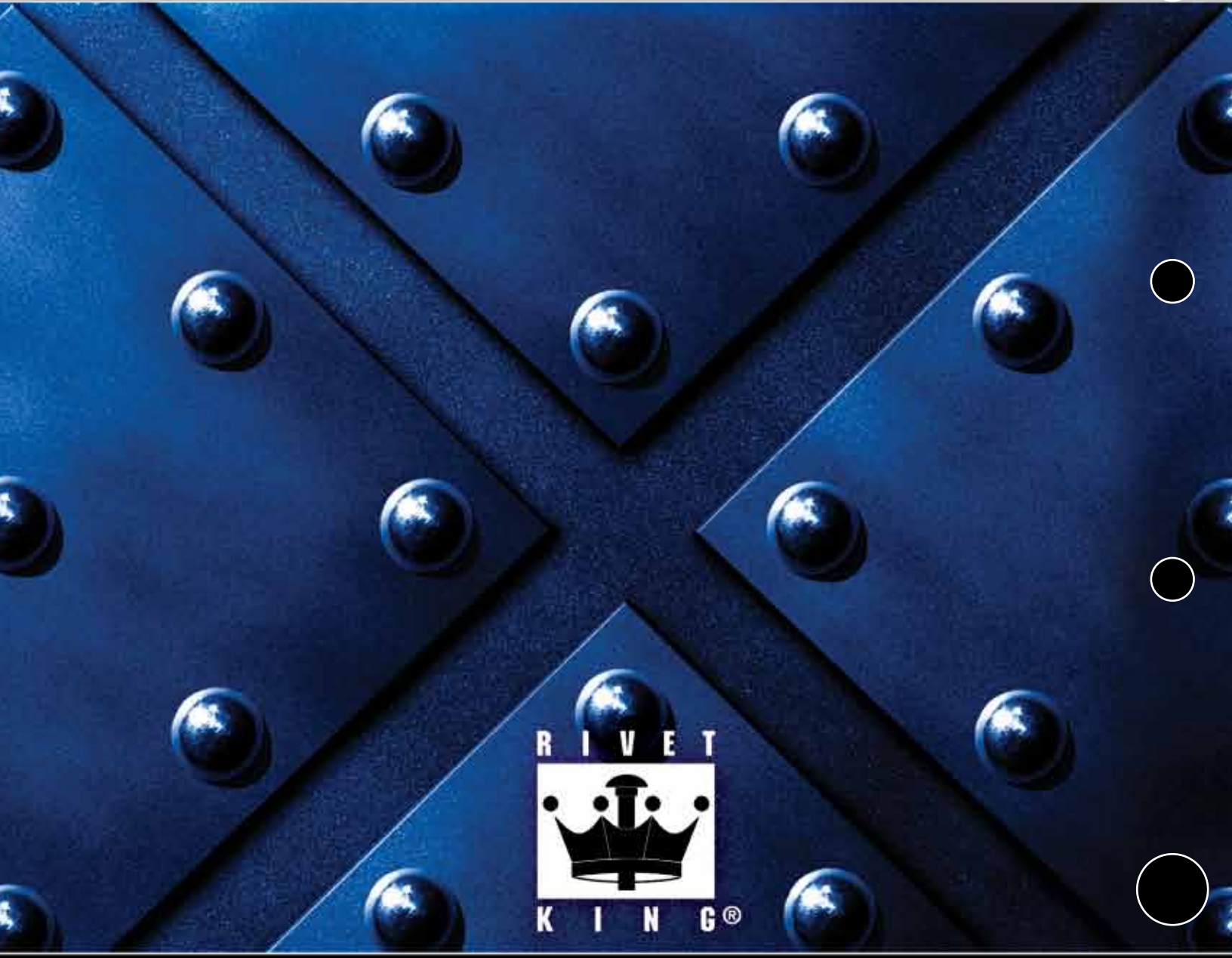
P250-P-24 Deep Throat Pedestal w/ Rotary Hopper

P255-P Pedestal w/ Vibe Bowl and Air Operated Anvil Pin

Vibratory Bowl Feeder

Air Operated Anvil Pin Option





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