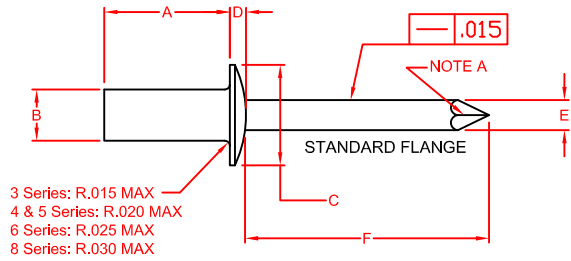
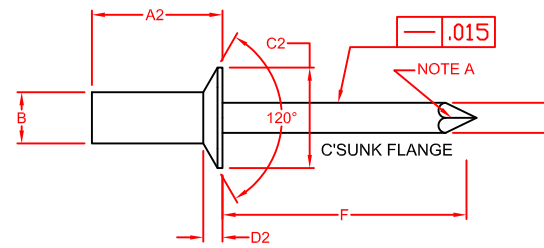


RIVETKING® STANDARD BLIND RIVETS - ALUMINUM/ALUMINUM - CLOSED END



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

NOTE A: MANDREL POINT PER RIVETKING STANDARD



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

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

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

DATE: 4-1-08	CHECKED: JGE	SHEET 1 OF 1	DESCRIPTION: ALUMINUM/ALUMINUM BLIND RIVETS - CLOSED END
DRAWN: SBS	DATE: 4-1-08	CHECKED: JGE	SHEET 1 OF 1
LIMITS UNLESS STATED	DECIMAL ±.015	ANGULAR ±2°	SURFACE TEXTURE (RMS)
DIMENSIONS IN INCHES UNLESS OTHERWISE STATED. METRIC DIMENSIONS IN PARENTHESES. ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE TO BE TAKEN TO THE CLOSEST EDGE. ORIGINAL SHEET SIZE 8.5" X 11"			
PROCESSING: COLDFORM1, COLDFORM2, FINISH, ANNEAL, ASS'LY, FOC, FINISH PACK			
SURFACE TREATMENT: RIVET: Bright Polish MANDREL: Bright Polish			
HEAT TREATMENT: RIVET: Belt Anneal @ 660°F for 90 Minutes MANDREL: None			
MATERIAL: RIVET: Aluminum MANDREL: Aluminum			
INDUSTRIAL RIVET & FASTENER CO. 200 PARTS AVENUE NORTHVALE, NJ, 07647 TEL: (201) 750 1040 info@rivet.com			
DRAWING NUMBER:	ABA-ACA/ CLOSED END SERIES	REV: F	DATE: 09-09-09
MASTER DWG: BR-0E-2008-1	LOCN: SER/REV/BLUEPRINTS/4-INTERNAL/MAST	DESCRIPTION	DATE
		REV	DATE
		F	11-8-2016
		E	5-18-2016
		D	3-18-2016
		C	12-18-2014
		B	4-12-11
		A	09-09-09
		REV	DATE