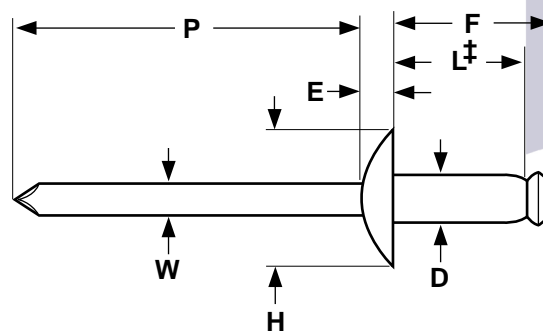


Rivets

**Aluminum/Aluminum
Aluminum/Steel
Steel/Steel**

**Large Flange
Blind Rivet**



SUPPLY CORP.

est. / 1946

| FITTING | | LARGE FLANGE BREAK-STEM BLIND RIVETS | | | | | | SAE J-1200 |
|------------------------|----------------------|--------------------------------------|---------------|------|-------------|------------------|--------------------|-----------------------|
| Nominal Rivet Diameter | Rivet Shank Diameter | | Head Diameter | | Head Height | Mandrel Diameter | Mandrel Protrusion | Blind Side Protrusion |
| | Max | Min | Max | Min | Max | Nom | Min | Max |
| | 1/8 | 0.128 | 0.122 | .390 | .360 | .065 | 0.076 | 1.00 |
| 3/16 | 0.191 | 0.183 | .650 | .600 | .092 | 0.114 | 1.06 | L + 0.160 |

**Jet
FITTING**

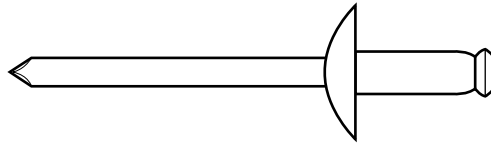
| | |
|--------------------------------|---|
| Description | A blind fastener which has a self-contained mandrel which permits the formation of an upset on the blind end of the rivet and expansion of the rivet shank during rivet setting to join the component parts of an assembly. The mandrel is pulled into or against the rivet body, breaking at or near the junction of the mandrel shank and its upset end. The large flange head has twice the under-head bearing surface of comparably sized dome head rivets. |
| Applications/Advantages | Large flange rivets are preferred where extra brittle or soft materials are being assembled to a rigid surface. |
| Material | Rivet: <i>Aluminum</i> -- Aluminum Alloy 5050, 5052, 5056 or 5154. <i>Steel</i> -- Low carbon steel, plated zinc. Mandrel: <i>Aluminum</i> -- Aluminum Alloy 7178, 5056 or 2024. <i>Steel</i> -- Carbon steel 1006 or equivalent. May be furnished plain or with a protective coating, at the option of the manufacturer. |
| Shear Strength (Min) | <i>Aluminum Rivet/Aluminum Mandrel</i> -- 1/8: 120 lbs.; 3/16: 260 lbs. <i>Aluminum Rivet/Steel Mandrel</i> -- 1/8: 170 lbs.; 3/16: 380 lbs. <i>Steel Rivet/Steel Mandrel</i> -- 3/16: 540 lbs. |
| Tensile Strength (Min) | <i>Aluminum Rivet/Aluminum Mandrel</i> -- 1/8: 150 lbs.; 3/16: 320 lbs. <i>Aluminum Rivet/Steel Mandrel</i> -- 1/8: 220 lbs.; 3/16: 500 lbs. <i>Steel Rivet/Steel Mandrel</i> -- 3/16: 680 lbs. |
| Mandrel Break Load | <i>Aluminum Rivet/Aluminum Mandrel</i> -- 1/8: 400 lbs. max, 250 lbs. min; 3/16: 825 lbs. max, 625 lbs. min. <i>Aluminum Rivet/Steel Mandrel</i> -- 1/8: 600 lbs. max, 400 lbs. min; 3/16: 1050 lbs. max, 750 lbs. min. <i>Steel Rivet/Steel Mandrel</i> -- 3/16: 1450 lbs. max, 1150 lbs. min. |

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Large Flange
Blind Rivet

Aluminum/Aluminum
Aluminum/Steel
Steel/Steel

Rivets
N G



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PART NUMBER COMPARISON - LARGE FLANGE ALUMINUM RIVET/ALUMINUM MANDREL

| Kanebridge | Huck-Automatic | Pop® | Marson/Creative | Star | Celus® | Cherry | Gesipa® |
|------------|----------------|------------|-----------------|----------|----------|---------|----------|
| ADA44L | ABA44L | AD44ABSLF | ABL4-4A | 4-4AALF | A/A44LF | AAL-44 | GAML44A |
| ADA64L | ABA64L | AD64ABSLF | ABL6-4A | - | A/A64LF | AAL-64 | GAML64A |
| ADA66L | ABA66L | AD66ABSLF | ABL6-6A | 6-6AALF | A/A66LF | AAL-66 | GAML66A |
| ADA68L | ABA68L | AD68ABSLF | ABL6-8A | 6-8AALF | A/A68LF | AAL-68 | GAML68A |
| ADA610L | ABA610L | AD610ABSLF | ABL6-10A | 6-10AALF | A/A610LF | AAL-610 | GAML610A |

SUPPLY CORP.

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PART NUMBER COMPARISON - LARGE FLANGE ALUMINUM/STEEL MANDREL

| Kanebridge | Huck/Automatic | Pop® | Marson/Creative | Star | Celus® | Cherry | Gesipa® |
|------------|----------------|-----------|-----------------|----------|----------|---------|----------|
| ADS46L | - | - | - | - | A/S 46LF | BSL-46 | GSML46A |
| ADS48L | - | - | - | - | - | BSL-48 | - |
| ADS64L | ABS64L | AD64BSLF | ABL6-4 | - | A/S 64LF | BSL-64 | GSML64A |
| ADS66L | ABS66L | AD66BSLF | ABL6-6 | 6-6ASLF | A/S 66LF | BSL-66 | GSML66A |
| ADS68L | ABS68L | AD68BSLF | ABL6-8 | 6-8ASLF | A/S 68LF | BSL-68 | GSML68A |
| ADS610L | ABS610L | AD610BSLF | ABL6-10 | 6-10ASLF | A/S610LF | BSL-610 | GSML610A |

est. / 1946

PART NUMBER COMPARISON - LARGE FLANGE STEEL RIVET/STEEL MANDREL

| Kanebridge | Huck/Automatic | Pop® | Marson/Creative | Star | Celus® | Cherry | Gesipa® |
|------------|----------------|-----------|-----------------|----------|----------|---------|----------|
| SDS64L | SBS64L | SD64BSLF | SBL6-4 | - | S/S 64LF | SSL-64 | GSML64S |
| SDS66L | SBS66L | SD66BSLF | SBL6-6 | 6-6SSLF | S/S 66LF | SSL-66 | GSML66S |
| SDS68L | SBS68L | SD68BSLF | SBL6-8 | 6-8SSLF | S/S 68LF | SSL-68 | GSML68S |
| SDS610L | SBS610L | SD610BSLF | SBL6-10 | 6-10SSLF | S/S610LF | SSL-610 | GSML610S |

SUPPLY CORP.

®Celus is a registered trademark of Celus Fasteners Manufacturing Inc..

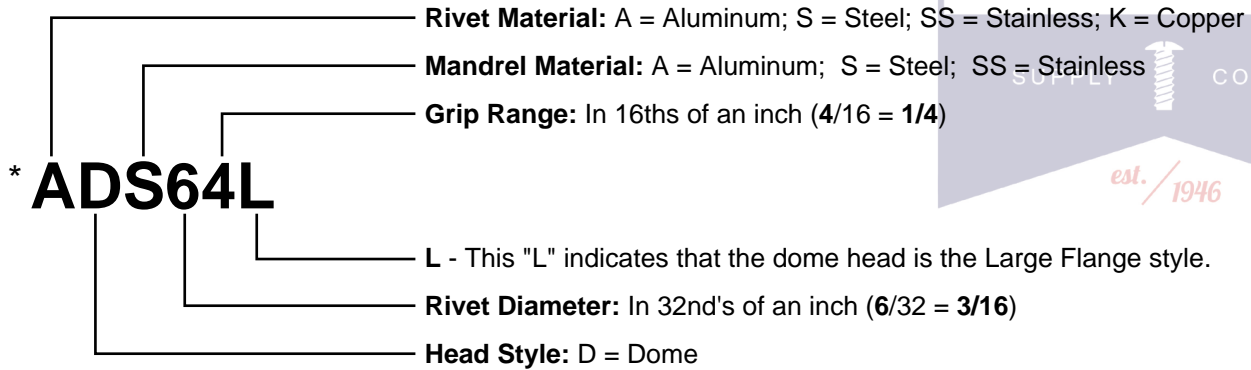
®Gesipa is a registered trademark of Gesipa Fasteners USA Inc..

®Pop is a registered trademark of Pop Fastening Systems, Emhart Fastening Technologies, a Black & Decker Company. Kanebridge's rivets are not manufactured by or connected with the producers of Gesipa® or Pop® rivets.

Application Data

Part Number Key

Rivets



*Kanebridge Part Number

Notes on Rivet Selection

Strength- The tensile and shear strengths required for an application must be determined and a rivet selected that meets those requirements.

Materials- Choose a rivet that is made of a metal with similar mechanical and physical properties as the materials being joined. This is especially critical in assemblies where higher temperatures and/or corrosive elements are present. Metal compatibility helps reduce the risks of galvanic corrosion and material fatigue.

Grip Range- Measure the total thickness of the materials being fastened. This is known as the "rivet grip". The grip ranges of the most commonly available rivets are listed in the table below. Sufficient rivet length is necessary for proper formation of the secondary head on the blind side of the assembly. Multi-grip rivets have wider grip ranges than standard break-stem blind rivets.

APPLICATION DATA FOR STANDARD BREAK-STEM BLIND RIVETS

SAE J-1200

| Rivet Number | Grip Range | Barrel Length | Recommended Hole Size | | Drill Size | Rivet Number | Grip Range | Barrel Length | Recommended Hole Size | | Drill Size | | | |
|--------------|------------|---------------|-----------------------|-------|------------|--------------|------------|---------------|-----------------------|-----------|------------|-------|-------|---|
| | | | Max | Min | | | | | Max | Min | | | | |
| 31 | .020-.062 | .187 | 0.100 | 0.097 | #41 | 62 | .020-.125 | .325 | 0.196 | 0.192 | #11 | | | |
| 32 | .020-.125 | .250 | | | | | | | | | | | | |
| 33 | .087-.187 | .312 | | | | | | | | | | | | |
| 34 | .126-.250 | .375 | | | | | | | | | | | | |
| 41 | .020-.062 | .212 | 0.133 | 0.129 | #30 | 66 | .251-.375 | .575 | | | | | | |
| 42 | .063-.125 | .275 | | | | | | | | | | | | |
| 43 | .126-.187 | .337 | | | | | | | | | | | | |
| 44 | .188-.250 | .400 | | | | | | | | | | | | |
| 45 | .251-.312 | .462 | | | | | | | | | | | | |
| 46 | .313-.375 | .525 | | | | | | | | | | | | |
| 48 | .376-.500 | .650 | | | | | | | | | | | | |
| 52 | .020-.125 | .300 | | | | 0.164 | 0.160 | #20 | 68 | .376-.500 | .700 | | | |
| 53 | .125-.187 | .362 | | | | | | | | | | | | |
| 54 | .188-.250 | .425 | | | | | | | | | | | | |
| 56 | .251-.375 | .550 | | | | | | | | | | | | |
| 58 | .376-.500 | .675 | | | | | | | | | | | | |
| 510 | .501-.625 | .800 | | | | | | | | | | | | |
| 512 | .626-.750 | .925 | | | | | | | | | | | | |
| 516 | .876-1.000 | 1.175 | | | | | | | | | | | | |
| | | | | | | | | | 84 | .126-.250 | .500 | 0.261 | 0.257 | F |
| | | | | | | | | | 86 | .251-.375 | .625 | | | |
| | | | | | | 88 | .376-.500 | .750 | | | | | | |
| | | | | | | 810 | .501-.625 | .875 | | | | | | |
| | | | | | | 812 | .626-.750 | .990 | | | | | | |
| | | | | | | 816 | .751-1.000 | 1.240 | | | | | | |