

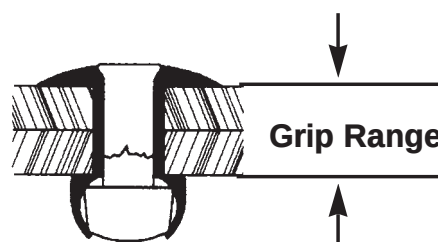
DIAMETER DRILL SIZE

Thickness to be Riveted	Up to	Inch mm	1/16	1/8	3/16	1/4	5/16	3/8
			1.6	3.2	4.8	6.4	8	9.5
PLUG (Break)	Diameter of Rivet							
AS ALUMINIUM 5056	No. 3	3/32		3-2	3-3			
2S ALUMINIUM 5052								
AA ALL ALUMINIUM								
SS STEEL	No. 4	1/8	4-1	4-2	4-3	4-4	4-5	4-6
MS MONEL® ALLOY	No. 5	5/32	5-1	5-2	5-3	5-4	5-5	5-6
4S STAINLESS STEEL	No. 6	3/16	6-1	6-2	6-3	6-4	6-5	6-6
44 ALL STAINLESS	No. 8	1/4		8-2		8-4		8-6
SEALED (Weatherproof)	Diameter of Rivet							
ST ALUMINIUM	No. 4	1/8		4-2	4-3	4-4	4-5	4-6
	No. 5	5/32		5-2	5-3	5-4	5-5	5-6
	No. 6	3/16		6-2	6-3	6-4	6-5	6-6

RIVET MATERIALS

- AS** Aluminium Rivet Grade 5056
Steel Stem Zinc Plated
- AS** Aluminium Rivet
Grade 5052
- AA** Aluminium Rivet Grade 5052
Aluminium Stem
- SS** Steel Rivet Zinc Plated 1010
Steel Stem Zinc Plated
- MS** Monel® Rivet
Steel Stem Zinc Plated
- 4S** Stainless Steel Rivet Grade 304 HQ
Steel Stem Zinc Plated
- 44** Stainless Steel Rivet Grade 304 HQ
Stainless Steel Stem
- ST** Aluminium Sealed Rivet Grade 5056
Steel Stem Oil Finish

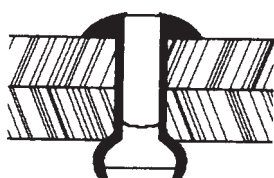
Monel® is a registered trade mark of Inco



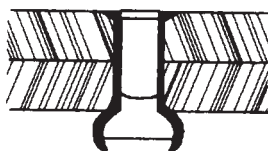
DIAMETER DRILL SIZE (CONTINUED)

1/2	5/8	3/4	7/8	1	1.1/4	Rivet Diam.	Drill Size		
12.7	16	19	22.2	25.4	31.8		mm	No.	In.
						3/32	2.5	41	3/32
4-8	4-10	4-12				1/8	3.3	30	1/8
5-8	5-10					5/32	4.1	20	5/32
6-8	6-10	6-12	6-14	6-16	6-20	3/16	4.9	11	3/16
8-8	8-10	8-12	8-14			1/4	6.5	E	1/4
						1/8	3.3	30	1/8
						5/32	4.1	20	5/32
6-8	6-10					3/16	4.9	11	3/16

HEAD AND RIVET TYPES



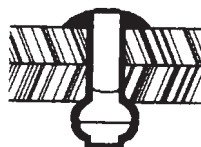
**TRUSS HEAD
PLUG**



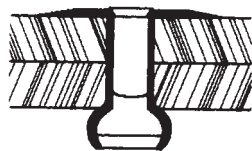
**COUNTERSUNK
HEAD PLUG**



**GROOVED
RIVET**
Grooves improve
holding strength



SEALED
End of rivet is sealed
for weatherproofing

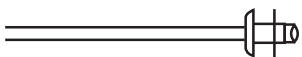
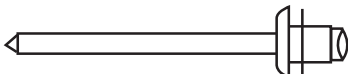
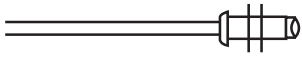
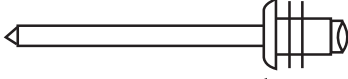
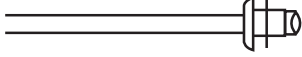
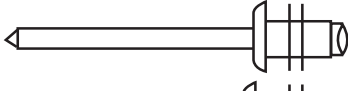
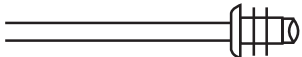
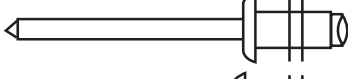
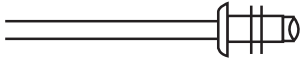
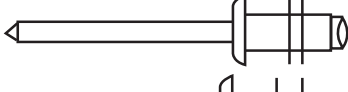
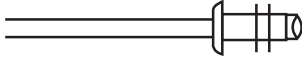
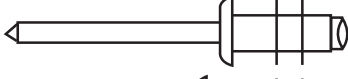
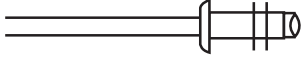
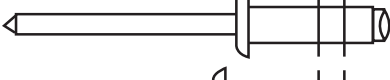
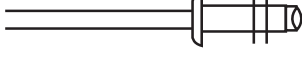
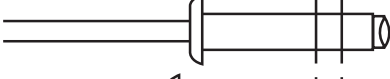
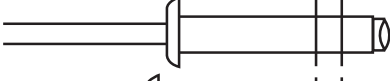
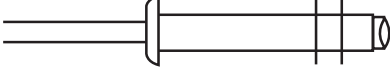
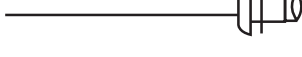
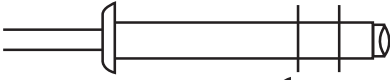
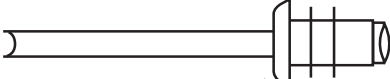
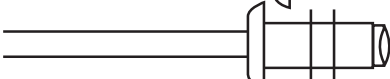
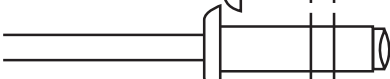
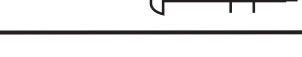
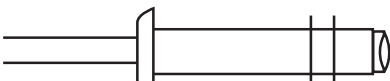


**LARGE FLANGED
RIVET PLUG**



**MULTI-GRIP
PLUG**
One rivet does a
number of grip ranges

SIZE IDENTIFICATION CHART AND CODE COMPARISON

	SIZE CODE		Typical Body Length mm			SIZE CODE		Typical Body Length mm
	Pop	Bremick/ Cherry				Pop	Bremick/ Cherry	
	33	3-2	5.5			62 624	6-1	6.3
	36	3-3	7.0			64 624	6-2	7.9
	42 419	4-1	4.7			66 630	6-3	9.5
	44 424	4-2	6.3			68 639	6-4	11.0
	46 429	4-3	7.9			610	6-5	12.6
	48 435	4-4	9.5			612 650	6-6	14.2
	410 440	4-5	11.1			665	6-8	17.9
	412	4-6	12.7			617 675	6-10	21.1
	416	4-8	16.4			625	6-12	24.2
	421	4-10	20.1			-	6-14	27.4
	425	4-12	23.3			633	6-16	30.6
	52 519	5-1	5.5			6150	6-20	36.0
	54 524	5-2	7.1			88	8-4	12.6
	56 530	5-3	8.7			812	8-6	15.8
	58 537	5-4	10.3			816	8-8	19.0
	510 545	5-5	11.9			-	8-10	22.1
	512	5-6	13.5			824	8-12	25.3
	516	5-8	17.1			-	8-14	28.4
						-	8-16	31.0

MECHANICAL PROPERTIES - RIVET MATERIAL COMPATIBILITY

RIVET MATERIAL	MATERIAL TO JOIN					
	Aluminium	Copper	Steel	Copper - Nickel	Stainless Steel	Brass
Aluminium	++	-	+	+-	++	-
Copper	-	++	-	++	+	++
Steel	+	-	++	+	++	-
Copper - Nickel	+-	++	+	++	++	++
Stainless Steel	++	+	++	++	++	++
Nickel - Copper	+-	+	++	++	+	++

- not compatible
- + good compatibility
- ++ very good compatibility
- +- Compatible in rural and mild environments

Some corrosion may occur in marine / industrial environments.
Painting both metals would reduce reaction.

THIS TABLE IS INTENDED FOR GUIDANCE ONLY

The data may vary depending on both atmosphere and temperature.

MECHANICAL PROPERTIES (CHARACTERISTIC CAPACITY)

Nominal Rivet Size	Aluminium 5056, Plug Style				Aluminium 5056, Sealed Style			
	Minimum Shear Strength		Minimum Tensile Strength		Minimum Shear Strength		Minimum Tensile Strength	
	N	lbs	N	lbs	N	lbs	N	lbs
No 3 3/32" 2.4mm	400	90	530	120	-	-	-	-
No 4 1/8" 3.2mm	760	170	980	220	1070	240	1240	280
No 5 5/32" 4.0mm	1160	260	1560	350	1560	350	2130	480
No 6 3/16" 4.8mm	1690	380	2220	500	2220	500	3070	690
No 8 1/4" 6.4mm	3110	700	4090	920	-	-	-	-

Nominal Rivet Size	Zinc Plated Steel 1010, Plug Style				Stainless Steel, Plug Style			
	Minimum Shear Strength		Minimum Tensile Strength		Minimum Shear Strength		Minimum Tensile Strength	
	N	lbs	N	lbs	N	lbs	N	lbs
No 4 1/8" 3.2mm	1100	260	1200	310	1900	420	2500	530
No 5 5/32" 4.0mm	1700	370	2200	470	2700	650	3500	820
No 6 3/16" 4.8mm	2900	540	3100	680	4000	950	5000	1200
No 8 1/4" 6.4mm	4900	1000	5700	1240	-	-	-	-

Nominal Rivet Size	Monel® Plug Style				Aluminium & All Aluminium 5052, Plug Style			
	Minimum Shear Strength		Minimum Tensile Strength		Minimum Shear Strength		Minimum Tensile Strength	
	N	lbs	N	lbs	N	lbs	N	lbs
No 4 1/8" 3.2mm	1560	350	2000	450	530	120	670	150
No 5 5/32" 4.0mm	2450	550	3110	700	850	190	1020	230
No 6 3/16" 4.8mm	3560	800	4450	1000	1160	260	1420	320

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