

# Blind rivet

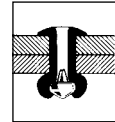
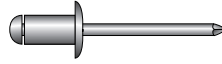
Blind rivet, also called "pop-rivet", is to a great extent used for joints in the manufacturing- as well as in the construction industry.

Riveting with blind rivets is a very simple and reliable fastening system that creates a vibration resistant joint. Blind rivets fit most materials, for example sheet metal, plastic, wood and laminate.

## Rivet heads

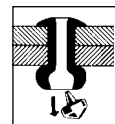
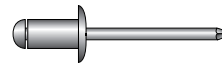
### Protruding head • BS-mandrel

The splint head is fastened after it has been riveted. Seals against particles and dirt. Air-tight rivet suitable for higher sealing requirements.



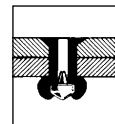
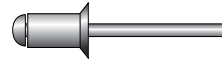
### Protruding head • BH-mandrel

The splint head is loosened when riveting. Reduces the corrosion risk. The hole is practical for design solutions.



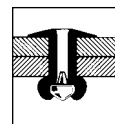
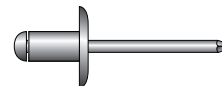
### Countersunk head • BS-mandrel

The splint head is fastened after it has been riveted. Seals against particles and dirt. Air-tight rivet suitable for higher sealing requirements.



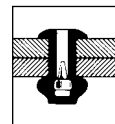
### Large protruding head • BS-mandrel

Idealistic for soft and elastic materials, for example rubber moldings. A large contact surface gives reliable fastening.



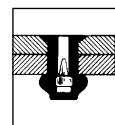
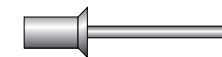
### Protruding head

An air-tight rivet is a rivet with fully confined rivet body. This guarantees a completely water and air-tight riveting. Suitable for use in overlap joints with roof and facade plates.



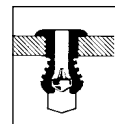
### Countersunk head

An air-tight rivet is a rivet with fully confined rivet body. This guarantees a completely water and air-tight riveting. Suitable for use in overlap joints with roof and facade plates.



### Protruding head • BS-mandrel

For porous and brittle materials, for example wood and brick. The grooves give safe fastening in the material and good withdrawing resistance.



## Material:

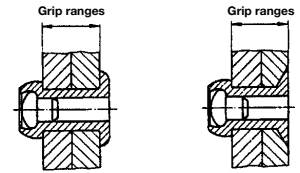
The blind rivet is delivered in the following materials:

Steel  
Aluminium  
Stainless/Acidproof  
Copper  
Bronze

Monel (this is a rivet of copper and nickel alloy. It gives a high strength and a very high corrosion resistance.)  
It is also available in lacquered performance.

# Blind rivet

Recommended grip ranges acc. to DIN 7337.



**Table 172**

**Rivet body aluminium/mandrel steel or stainless steel A2**

d <sub>1</sub>	2,4 <sup>*)</sup>	3	3,2	4	4,8	5	6 <sup>*)</sup>	6,4 <sup>*)</sup>
l	Grip ranges							
4	0,5 - 2	0,5 - 1,5	—	—	—	—	—	—
6	2 - 4	1,5 - 3,5	1,5 - 3	2 - 3	—	—	—	—
8	4 - 6	3,5 - 5,5	3 - 5	3 - 4,5	2 - 4	—	—	—
10	—	5,5 - 7	5 - 6,5	4,5 - 6	4 - 6	—	—	—
12	—	7 - 9	6,5 - 8,5	6 - 8	6 - 8	2 - 6	—	—
16	—	9 - 13	8,5 - 12,5	8 - 12	8 - 11	6 - 10	—	—
20	—	13 - 17	12,5 - 16,5	12 - 16	11 - 15	10 - 14	—	—
25	—	17 - 22	16,5 - 21,5	16 - 21	15 - 20	14 - 18	—	—
30	—	—	—	21 - 25	20 - 24	18 - 23	—	—
35	—	—	—	25 - 30	24 - 29	—	—	—
40	—	—	—	30 - 35	29 - 34	—	—	—
45	—	—	—	35 - 40	34 - 39	—	—	—
50	—	—	—	40 - 45	39 - 44	—	—	—

<sup>\*)</sup> Not valid for countersunk head.

**Table 173**

**Rivet body steel/mandrel steel**

d <sub>1</sub>	2,4	3	3,2	4	4,8	5	6 <sup>*)</sup>	6,4 <sup>*)</sup>
l	Grip ranges							
6	—	0,5 - 3	0,5 - 2,5	—	—	—	—	—
8	—	3 - 5	2,5 - 4,5	2 - 4	—	—	—	—
10	—	5 - 7	4,5 - 6,5	4 - 6	2,5 - 4,5	—	—	—
12	—	7 - 9	6,5 - 8,5	6 - 8	4,5 - 6,5	3 - 6	—	—
16	—	9 - 12,5	8,5 - 12	8 - 11	6,5 - 10,5	6 - 9	—	—
20	—	12,5 - 16,5	12 - 16	11 - 15	10,5 - 14,5	9 - 13	—	—
25	—	—	16 - 21	15 - 20	14,5 - 19,5	13 - 17	—	—
30	—	—	—	20 - 25	—	—	—	—
35	—	—	—	25 - 30	—	—	—	—

<sup>\*)</sup> Not valid for countersunk head.

**Table 174**

**Rivet body stainless steel A2 or nickel copper alloy/mandrel steel or stainless steel A2**

d <sub>1</sub>	2,4	3 <sup>*)</sup>	3,2 <sup>*)</sup>	4 <sup>*)</sup>	4,8 <sup>*)</sup>	5 <sup>*)</sup>	6	6,4
l	Grip ranges							
6	—	1 - 3	1 - 2,5	1 - 2	—	—	—	—
8	—	3 - 5	2,5 - 4,5	2 - 4	—	—	—	—
10	—	5 - 7	4,5 - 6,5	4 - 6	—	—	—	—
12	—	7 - 9	6,5 - 8,5	6 - 8	—	—	—	—
16	—	—	8,5 - 12	8 - 11	—	—	—	—
20	—	—	12 - 16	11 - 15	—	—	—	—
25	—	—	16 - 21	15 - 20	—	—	—	—

<sup>\*)</sup> Not valid for countersunk head.

**Table 175**

**Rivet body copper/mandrel steel, stainless steel A2 or brass**

d <sub>1</sub>	2,4	3 <sup>*)</sup>	3,2 <sup>*)</sup>	4 <sup>*)</sup>	4,8	5	6	6,4
l	Grip ranges							
4	—	0,5 - 1,5	—	—	—	—	—	—
6	—	1,5 - 3	2,5 - 3,5	—	—	—	—	—
8	—	3 - 5	3,5 - 4,5	—	—	—	—	—
10	—	5 - 7	4,5 - 6,5	—	—	—	—	—
12	—	7 - 9	6,5 - 8,5	—	—	—	—	—

<sup>\*)</sup> Not valid for countersunk head.

Source: DIN 7337.