














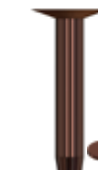



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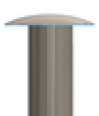


## SEMI TUBULAR RIVETS

OVAL HEAD/ TRUSS HEAD	DEEP HOLE	BRAKE LINING RIVET 144°	SEMI TUBULAR SHOULDER RIVETS	SEMI TUBULAR COLLAR RIVETS	OVAL HEAD SELF PIERCING SEMI TUBULAR	ELECTRICAL CONTACT	SPLIT RIVET
							
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## SOLID RIVETS: STEEL, BRASS, STAINLESS, COPPER AND MONEL

ROUND HEAD	FLAT HEAD	COUNTERSUNK 90°	TRUSS HEAD	SOLID SHOULDER	SOLID COLLAR CLUTCH FACING	TRUNK RIVET & BURRS	COPPER BELT RIVETS & BURRS	TINNERS' RIVET
								
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## ALUMINUM RIVETS

ROUND / BUTTON HEAD	FLAT HEAD	UNIVERSAL HEAD	BRAZIER HEAD	MODIFIED BRAZIER HEAD	COUNTERSUNK 78°	COUNTERSUNK 100°
						
PAGES 23,25	PAGES 23,25	PAGES 23,25	PAGES 23,25	PAGES 24,26	PAGES 24,26	PAGES 24,26

## VARIOUS SPECIALS

COLLAR RIVETS	CLEVIS PIN
	
PAGES 01,02	PAGES 01,02

## RETAINER LOCK PINS

SQUARED RETAINER LOCK PIN	ROUNDED RETAINER LOCK PIN
	
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## SETTING EQUIPMENT

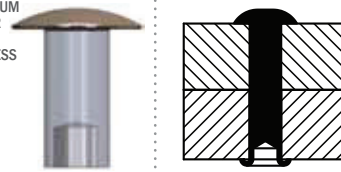
HANDSETS	AIR HAMMERS	BENCH MOUNTED MACHINES	PEDESTAL MACHINES
			
PAGE 27	PAGE 27	PAGE 27	PAGE 27



# RIVETKING® RIVET TYPES

## SEMI TUBULAR OVAL/ TRUSS HEAD

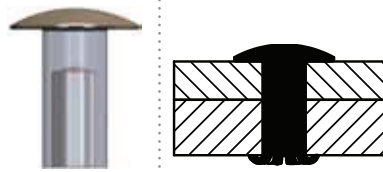
- STEEL
- ALUMINUM
- COPPER
- BRASS
- STAINLESS STEEL



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

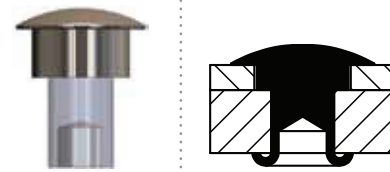
## SEMI TUBULAR DEEP-HOLE



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.

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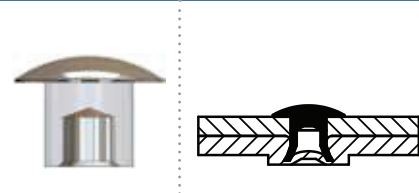
## SEMI TUBULAR SHOULDER RIVET



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

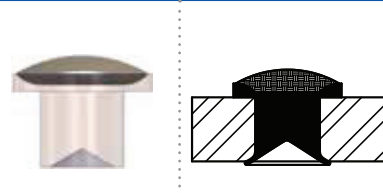
## METAL PIERCING



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.

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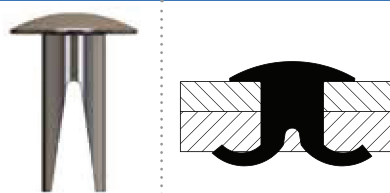
## SEMI TUBULAR ELECTRICAL CONTACT



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.

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## SPLIT RIVETS (BIFURCATED)

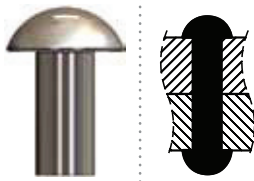


Split rivets are typically used in the luggage, case and leather goods industries to fasten soft materials such as plastics, animal hide and wood. With automatic setting equipment it can pierce through soft materials without a pre-punched hole. Typically offered in Steel or Brass material with a host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

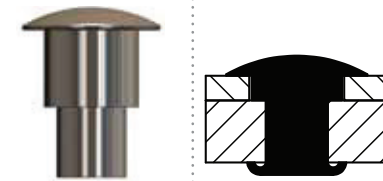


- SOLID LARGE DIAMETER:
- STEEL ONLY

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

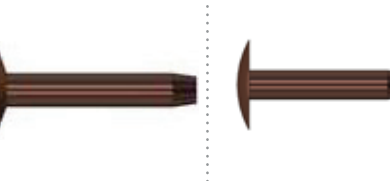
## SOLID SHOULDER RIVET



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

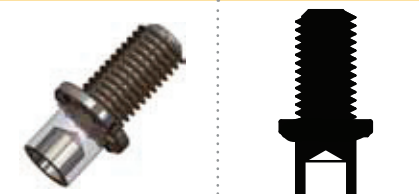
## COPPER BELT/ TRUNK RIVETS



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.

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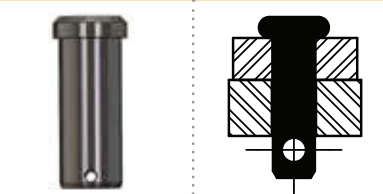
## COLLAR RIVETS



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

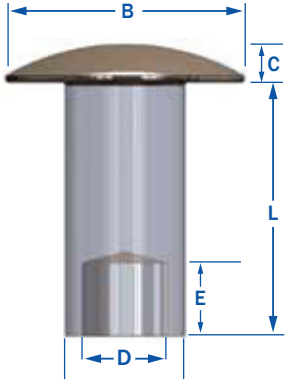

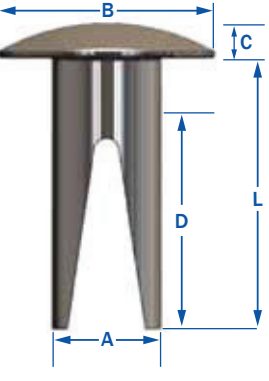
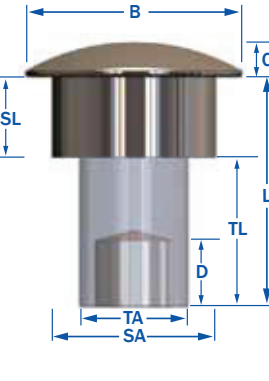


Used to secure the latch on a hitch assembly for tractors, trucks or trailers. Offered with or without a vinyl coated steel lanyard. Available in Steel with Zinc or high salt spray Zinc Nickel Plating.

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# RIVETKING<sup>®</sup> 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

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

<p>Use a roll or scored clinch. A roll clinch is stronger. For a uniform appearance, a cap may be used on the clinched end.</p>	<p>Can be impact set on a press or auto feed riveting machine. Can also be set on radial forming machines.</p>	<p>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.</p>	<p>Clinching is similar to Semi Tubular rivet. Roll clinch or scored clinch. The roll clinch is stronger.</p>
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## ADVANTAGES

<p>High shear strength of solid rivet combined with ease of clinching on automatic, pneumatic and manually operated rivet setting machines.</p>	<p>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.</p>	<p>Eliminate the cost of pre-punching or pre-drilling of holes in material without weakening the assembly by removing of material.</p>	<p>Shoulder rivets combine low cost with ease of assembly for permanent fastening with automatic rivet setting machines.</p>
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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.



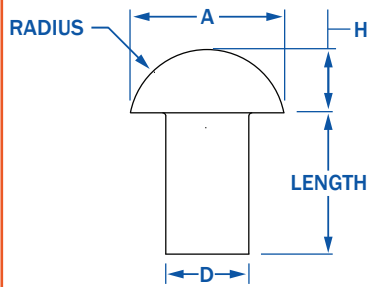
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# RIVETKING® STEEL LARGE DIAMETER RIVETS

SOLID RIVET LARGE DIAMETER

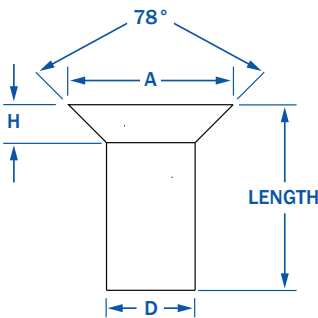
## ROUND HEAD RIVETS



	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

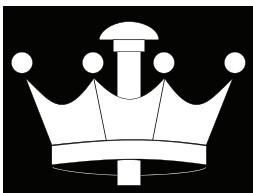
## 78° COUNTERSUNK HEAD RIVETS



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

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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

