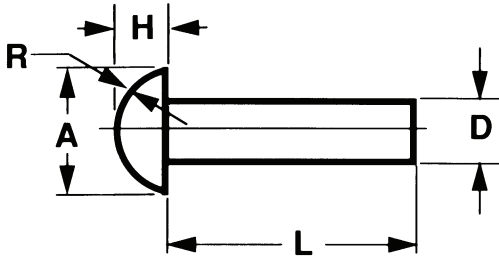




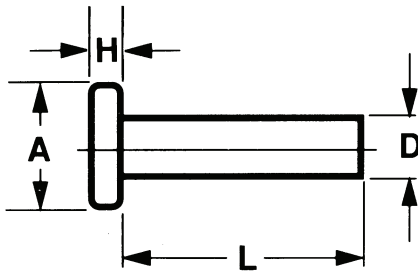
# HEAD STYLES OF ALUMINUM RIVETS



## ROUND HEAD RIVETS

Nominal diameter (D)		A	H	R
Fraction	Decimal	Head Diameter	Head Height	Head Radius
3/32	0.094	0.187	0.070	0.098
1/8	0.125	0.250	0.094	0.130
5/32	0.156	0.312	0.117	0.163
3/16	0.187	0.375	0.141	0.195
1/4	0.250	0.500	0.188	0.260
5/16	0.312	0.625	0.234	0.326
3/8	0.375	0.750	0.281	0.391

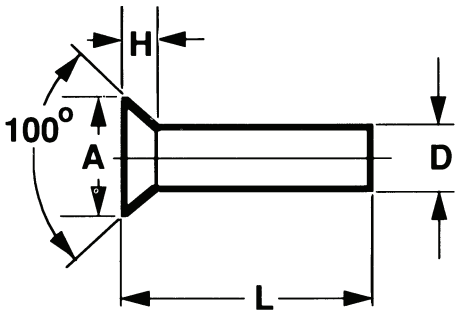
Notes: 1. Approximate proportions:  $A = 2.00 \times D$   
 $H = 0.75 \times D$   
 $R = 1.042 \times D$



## FLAT HEAD RIVETS

Nominal diameter (D)		A	H
Fraction	Decimal	Head Diameter	Head Height
3/32	0.094	0.187	0.038
1/8	0.125	0.250	0.050
5/32	0.156	0.312	0.062
3/16	0.187	0.375	0.075
1/4	0.250	0.500	0.100
5/16	0.312	0.625	0.125
3/8	0.375	0.750	0.150

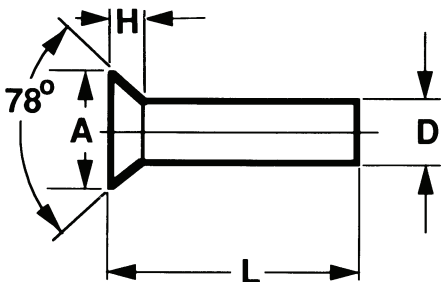
Notes: 1. Approximate proportions:  $A = 2.00 \times D$   
 $H = 0.40 \times D$



## 100° COUNTERSUNK HEAD RIVETS

Nominal diameter (D)		A	H
Fraction	Decimal	Head Diameter	Head Height
3/32	0.094	0.170	0.036
1/8	0.125	0.216	0.042
5/32	0.156	0.278	0.055
3/16	0.187	0.344	0.070
1/4	0.250	0.467	0.095
5/16	0.312	0.555	0.106
3/8	0.375	0.685	0.134

Notes: 1. Approximate proportions:  $A = 1.54 \times D$   
 $H = 0.26 \times D$



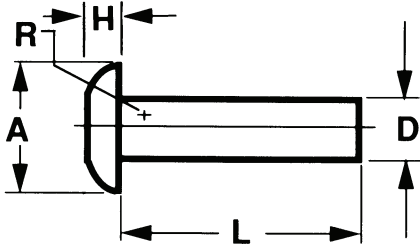
## 78° COUNTERSUNK HEAD RIVETS

Nominal diameter (D)		A	H
Fraction	Decimal	Head Diameter	Head Height
3/32	0.094	0.170	0.047
1/8	0.125	0.225	0.062
5/32	0.156	0.282	0.078
3/16	0.187	0.339	0.094
1/4	0.250	0.452	0.125
5/16	0.312	0.565	0.156
3/8	0.375	0.678	0.187

Notes: 1. Approximate proportions:  $A = 1.81 \times D$   
 $H = 0.50 \times D$



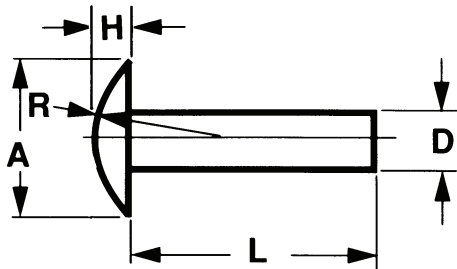
# HEAD STYLES OF ALUMINUM RIVETS



## UNIVERSAL HEAD RIVETS

Nominal diameter (D)		A	H	R
Fraction	Decimal	Head Diameter	Head Height	Head Radius
3/32	0.094	0.187	0.045	0.082
1/8	0.125	0.250	0.059	0.108
5/32	0.156	0.312	0.072	0.135
3/16	0.187	0.375	0.085	0.164
1/4	0.250	0.500	0.112	0.217
5/16	0.312	0.625	0.138	0.272
3/8	0.375	0.750	0.166	0.328

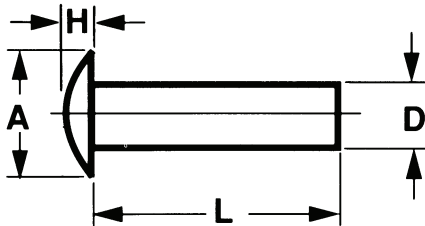
Notes: 1. Approximate proportions:  $A = 2.00 \times D$   
 $H = 0.465 \times D$   
 $R = 0.872 \times D$



## BRAZIER HEAD RIVETS

Nominal diameter (D)		A	H	R
Fraction	Decimal	Head Diameter	Head Height	Head Radius
3/32	0.094	0.234	0.047	0.170
1/8	0.125	0.312	0.062	0.227
5/32	0.156	0.391	0.078	0.283
3/16	0.187	0.469	0.094	0.340
1/4	0.250	0.625	0.125	0.453
5/16	0.312	0.781	0.156	0.566
3/8	0.375	0.937	0.187	0.680

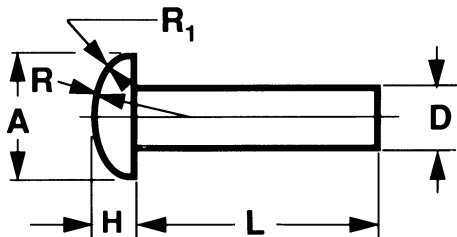
Notes: 1. Approximate proportions:  $A = 2.00 \times D$   
 $H = 0.50 \times D$   
 $R = 1.8125 \times D$



## MODIFIED BRAZIER HEAD RIVETS

Nominal diameter (D)		A	H
Fraction	Decimal	Head Diameter	Head Height
3/32	0.094	0.156	0.031
1/8	0.125	0.235	0.047
5/32	0.156	0.312	0.063
3/16	0.187	0.390	0.078
1/4	0.250	0.468	0.094
5/16	0.312	0.625	0.125
3/8	0.375	0.781	0.156

Notes: 1. Approximate proportions:  $A = 1.94 \times D$   
 $H = 0.33 \times D$



## MUSHROOM HEAD RIVETS

Nominal diameter (D)		A	H	R	R <sub>1</sub>
Fraction	Decimal	Head	Diameter	Head	Height
3/32	0.094	0.187	0.059	0.153	0.047
1/8	0.125	0.250	0.078	0.204	0.062
5/32	0.156	0.312	0.098	0.255	0.078
3/16	0.187	0.375	0.117	0.306	0.094
1/4	0.250	0.500	0.156	0.408	0.125
5/16	0.312	0.625	0.195	0.511	0.156
3/8	0.375	0.750	0.234	0.613	0.187

Notes: 1. Approximate proportions:  $A = 2.00 \times D$   
 $H = 0.625 \times D$   
 $R = 1.634 \times D$   
 $R_1 = 0.50 \times D$



# ALUMINUM RIVET DATA

## APPROXIMATE PRESSURES REQUIRED TO DRIVE ROUND HEADS WITH SQUEEZE RIVETER

Pressures given are for complete round heads as dimensioned.

Rivet size, in.	Pressures in tons		
	Cold-driven		
	1100-F	2117-T4	6053-T61
3/16	3	6	4
1/4	6	10	8
3/8	14	23	16
1/2	25	39	30

1. Driven immediately after quenching.

## RIVET TOLERANCES

### Diameter of Shank

#### Dimensions in Inches

Nominal Diameter	Minus	Plus
0.052-0.094	0.001	0.003
0.095-0.156	0.001	0.004
0.157-0.219	0.002	0.005
0.220-0.375	0.003	0.006
0.376-0.625	0.004	0.008
0.626-0.875	0.006	0.012
0.876-1.000	0.007	0.015

### Height of Head

Plus 8 percent minus 4 percent of the nominal or basic head height, but in no case less than  $\pm 0.005$  in.

### Out-of-Roundness of Head and Eccentricity of Head in Relation to Shank

#### Dimensions in Inches

Nominal head diameter	Total dial indicator reading resulting from eccentricity and out-of-roundness not to exceed
up to 1/4	0.015
over 1/4 to 3/8	0.020

### Length of Shank

Diameters to 3/4 in. x up to 4 in. long inclusive  $\pm 1/64$  in. Diameters to 3/4 in. in lengths over 4 in.  $\pm 1/32$  in. Diameters over 3/4 in. to 4 in. long  $\pm 1/32$  in. Diameters over 3/4 in. in lengths over 4 in.  $\pm 1/16$  in.

### Diameter of Head

Because the heads of these rivets are not machined or trimmed, the circumference may be irregular and the edges rounded or flat.

The diameter of the rivet head shall be within -8 percent and + 4 percent of the nominal head diameter