

| D                     | L              |                 |               | dk          | k              | dm             |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|-----------------------|----------------|-----------------|---------------|-------------|----------------|----------------|---------------------|----------------------------------------------------------------------------------|----------------------------------------------------------------------------------|----------|-----|-----|---------|----------------------------------------------------------------------------------|----------------------------------------------------------------------------------|
| RIVET<br>SIZE         | PART<br>NUMBER | RIVET<br>LENGTH | GRIP<br>RANGE | HEAD<br>DIA | HEAD<br>HEIGHT | MANDREL<br>DIA | HOLE<br>SIZE(DRILL) | Shear<br>(N)                                                                     | Tensile<br>(N)                                                                   |          |     |     |         |                                                                                  |                                                                                  |
|                       |                | [+1/-0]         | MIN-MIX       |             | MAX.           | MAX.           | Φ                   | MIN.                                                                             | MIN.                                                                             |          |     |     |         |                                                                                  |                                                                                  |
| 2.4<br>+0.08<br>-0.15 | AS2404         | 4.0             | 0.5-2.0       | 4.2-5.0     | 1.0            | 1.6            | 2.5-2.6             | 5050Alu.<br>180N<br>5052Alu.<br>250N<br>5154Alu.<br>350N<br>5056Alu.<br>450N     | 5050Alu.<br>280N<br>5052Alu.<br>350N<br>5154Alu.<br>500N<br>5056Alu.<br>600N     |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2406         | 6.0             | 2.0-4.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2408         | 8.0             | 4.0-6.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2410         | 10.0            | 6.0-8.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2412         | 12.0            | 7.0-9.5       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2414         | 14.0            | 8.0-11.5      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS2416         | 16.0            | 10.0-13.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| 3.0<br>+0.08<br>-0.15 | AS3006         | 6.0             | 1.0-3.5       | 5.4-6.3     | 1.3            | 2.00           | 3.1-3.2             | 5050Alu.<br>300N<br>5052Alu.<br>400N<br>5154Alu.<br>550N<br>5056Alu.<br>750N     | 5050Alu.<br>400N<br>5052Alu.<br>550N<br>5154Alu.<br>700N<br>5056Alu.<br>900N     |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3008         | 8.0             | 3.5-5.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3010         | 10.0            | 5.0-7.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3012         | 12.0            | 7.0-9.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3014         | 14.0            | 9.0-11.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3016         | 16.0            | 9.0-12.5      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3018         | 18.0            | 12.0-14.5     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| 3.2<br>+0.08<br>-0.15 | AS3020         | 20.0            | 13.0-16.5     | 5.8-6.7     | 1.3            | 2.00           | 3.3-3.4             | 5050Alu.<br>400N<br>5052Alu.<br>500N<br>5154Alu.<br>750N<br>5056Alu.<br>850N     | 5050Alu.<br>500N<br>5052Alu.<br>700N<br>5154Alu.<br>1000N<br>5056Alu.<br>1100N   |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3206         | 6.0             | 1.0-3.5       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3208         | 8.0             | 3.5-5.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3210         | 10.0            | 5.0-7.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3212         | 12.0            | 7.0-9.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3214         | 14.0            | 9.0-11.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3216         | 16.0            | 9.0-12.5      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| 4.0<br>+0.08<br>-0.15 | AS3218         | 18.0            | 12.0-14.5     | 6.9-8.4     | 1.7            | 2.50           | 4.1-4.2             | 5050Alu.<br>800N<br>5052Alu.<br>850N<br>5154Alu.<br>1100N<br>5056Alu.<br>1400N   | 5050Alu.<br>1000N<br>5052Alu.<br>1200N<br>5154Alu.<br>1700N<br>5056Alu.<br>2000N |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3220         | 20.0            | 13.0-16.5     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS3225         | 25.0            | 15.0-21.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4006         | 6.0             | 1.0-3.0       |             |                |                |                     |                                                                                  |                                                                                  | 8.3-10.1 | 2.0 | 3.0 | 4.9-5.0 | 5050Alu.<br>1300N<br>5052Alu.<br>1500N<br>5154Alu.<br>1700N<br>5056Alu.<br>2000N | 5050Alu.<br>1500N<br>5052Alu.<br>1800N<br>5154Alu.<br>2500N<br>5056Alu.<br>3000N |
|                       | AS4008         | 8.0             | 3.0-5.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4010         | 10.0            | 4.0-6.5       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4012         | 12.0            | 6.0-8.5       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| AS4014                | 14.0           | 7.0-10.5        |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| AS4016                | 16.0           | 8.0-12.5        |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| AS4018                | 18.0           | 10.0-14.5       |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| 4.8<br>+0.08<br>-0.15 | AS4020         | 20.0            | 12.0-16.0     | 11.6-13.4   | 2.7            | 3.90           | 6.5-6.6             | 5050Alu.<br>2200N<br>5052Alu.<br>2700N<br>5154Alu.<br>3400N<br>5056Alu.<br>3800N | 5050Alu.<br>3000N<br>5052Alu.<br>3400N<br>5154Alu.<br>4850N<br>5056Alu.<br>5200N |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4025         | 25.0            | 16.0-21.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4030         | 30.0            | 21.0-26.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4035         | 35.0            | 26.0-30.5     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4040         | 40.0            | 30.5-35.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4806         | 6.0             | 1.0-2.5       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4808         | 8.0             | 2.5-4.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| AS4810                | 10.0           | 4.0-6.0         |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| 6.4<br>+0.08<br>-0.15 | AS4812         | 12.0            | 6.0-8.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4814         | 14.0            | 8.0-10.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4816         | 16.0            | 8.0-12.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4818         | 18.0            | 10.0-14.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4820         | 20.0            | 12.0-16.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4825         | 25.0            | 16.0-21.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4830         | 30.0            | 21.0-25.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
| AS4835                | 35.0           | 25.0-30.0       |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4840         | 40.0            | 30.0-35.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4845         | 45.0            | 35.0-40.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS4850         | 50.0            | 40.0-45.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6408         | 8.0             | 1.5-3.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6410         | 10.0            | 2.0-4.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6412         | 12.0            | 3.0-6.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6414         | 14.0            | 6.0-8.0       |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6416         | 16.0            | 6.0-10.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6418         | 18.0            | 8.0-12.0      |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6420         | 20.0            | 10.0-14.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6425         | 25.0            | 14.0-18.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6430         | 30.0            | 18.0-23.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6435         | 35.0            | 23.0-28.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       | AS6440         | 40.0            | 28.0-33.0     |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
|                       |                |                 |               |             |                |                |                     |                                                                                  |                                                                                  |          |     |     |         |                                                                                  |                                                                                  |
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