



VVG FASTENERS
A COMPANY OF THE HONSEL-GROUP

Perfect fastener solutions for industry and trade.



Blind rivets



Blind rivet nuts



Blind rivet bolts



Special parts



Self-clinching fasteners



Coil threaded inserts



Battery riveters



Pneumatic riveters



Manual riveters



Automation/process monitoring

BLIND RIVET FASTENERS

For over **85 years**, we in the HONSEL Group have been successfully developing and producing **rivet and fastener technology** and are **worldwide contacts** for industry and trade.

We find reliable and optimised solutions for the needs of your application. A particular focus here is on the handling of individual, complex projects.

Our experienced **experts** in all areas have an open ear for your needs at all times and will be happy to advise you! **Online, by telephone** or **on site**.

The latest production facilities in Germany and Asia guarantee the **highest availability** of all standard article and **fast production** of special customised parts.

High-quality **fasteners**, advanced **processing tools** and fully automated and process-controlled **automation systems**
 – in our development departments, **innovative new products** and further developments are constantly being produced to complement and expand our product portfolio.

VVG. WE fasten it. For YOU.



In this edition ...

you can find a whole series of innovations in addition to the well-proven VVG range. Most notably with the

Rivdom ZERO

– the newest member of our battery riveter family.

A **weight of just 1.3 kg**, the wear-free **brushless motor** and practical **tool-free maintenance** are just a few of the features that you will like!

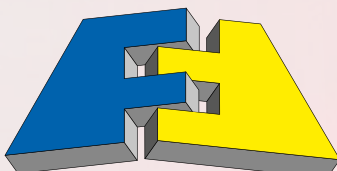


In the meantime, a constituent part of our range is made up of the **VVG StarCoil coil threaded inserts** that we also offer in the attractive **StarCoil boxes** in three sizes.

Just take a look at the options for **process monitoring with DMSD2G** of the current generation that can be used with both pneumatic riveters as well as with battery riveters.

On the following pages there is information on **sizes with national technical approvals** and our **free 3D data service** for designers and developers.

Please note this date in your calendars: The next **Fastener Fair** in Stuttgart from 19th -21st March 2019. You can find us there on Stand 1022 in Hall 1.



FASTENER FAIR

STUTTGART

The World's No.1

www.vvg.info



HONSEL Umformtechnik Fröndenberg



HONSEL 1965



New Works III in Fröndenberg (as of April 2018)

More than 85 years.

In 1930, Alfred Honsel founded the “Alfred Honsel Nieten- und Metallwarenfabrik GmbH & Co.” in Fröndenberg an der Ruhr that initially produced aluminium pots and pans whose handles were **attached with rivets**.

It quickly became clear: There’s great potential here. As early as **1945**, the production of household goods was discontinued completely and the company concentrated exclusively on the development and production of riveting technology.

By the **1960s**, HONSEL was already one of the leading manufacturers of brake and clutch pad rivets in Europe, and at the same time went into the production of blind rivets and rivet tools.

In the **1980s** the company began the development of blind rivet nuts, blind rivet bolts and pneumatic-hydraulic setting tools and their production.

In **1994**, the VVG-Befestigungstechnik was founded in Neumünster as a special trading company for riveting technology in order to be able to supply customers quickly and reliably

with the latest products from a well-stocked warehouse, and at the same time to make the know-how from many years of development and production available.

A concept for success. After several moves to different locations, the buildings at the current site in Neumünster were purchased in **2007**, creating the best boundary conditions for the further growth.

HONSEL has been producing more than a billion parts a year at a new works in Fröndenberg since **2003**.

The next expansion of the production facilities by 3500 m² to more than 10,000 m² and a new office building followed in **2014**.

The building of the third new works in Fröndenberg has now started that will go into operation in the second half of 2018 and will offer further space for production and fully automated logistics.

At the same time, a completely new workshop and service centre for processing components is being built at VVG in Neumünster.



VVG Befestigungstechnik Neumünster



HONSEL Fasteners Wuxi / China



VVG France in Frasné / France

Today

... the companies in the HONSEL Group offer an **all-embracing spectrum of rivet and fastener technology from a single source**. From the standard blind rivet through modern battery riveters or individually modified customised products right up to full automated and process-monitored processing units.

The companies are also successfully active in new product areas, such as **VVG StarCoil® threaded inserts** or the **HONSEL Powertrain Fasteners captive sleeve/stud system**.

HONSEL Umformtechnik in Fröndenberg is the production facility and development/sales location for special parts and automation solutions.

The whole range of standard and catalogue parts is marketed by **VVG Befestigungstechnik** in Neumünster where the new and further development of processing tools and the implementation of individual industry solutions is also centred.

VVG France in Frasné/France is responsible for the large French market.

The Group's activities are complemented by **HONSEL Fasteners** in Wuxi/China where, in addition to other production facilities, standard fasteners to HONSEL/VVG standard are manufactured and tested in a dedicated quality assurance centre. The site is also the logistics centre for Asia and delivers directly to the local Chinese market.

In addition, the Group works together with **sales and cooperation partners** in the USA, Asia, India, Australia, Brazil and many European countries, including the BeNeLux, Scandinavia, Poland, Italy, Switzerland or Turkey, in some cases for decades already, and can thus reach customers worldwide.



Design and development

The **continuous new and further development** of the HONSEL/VVG products plays a central role.

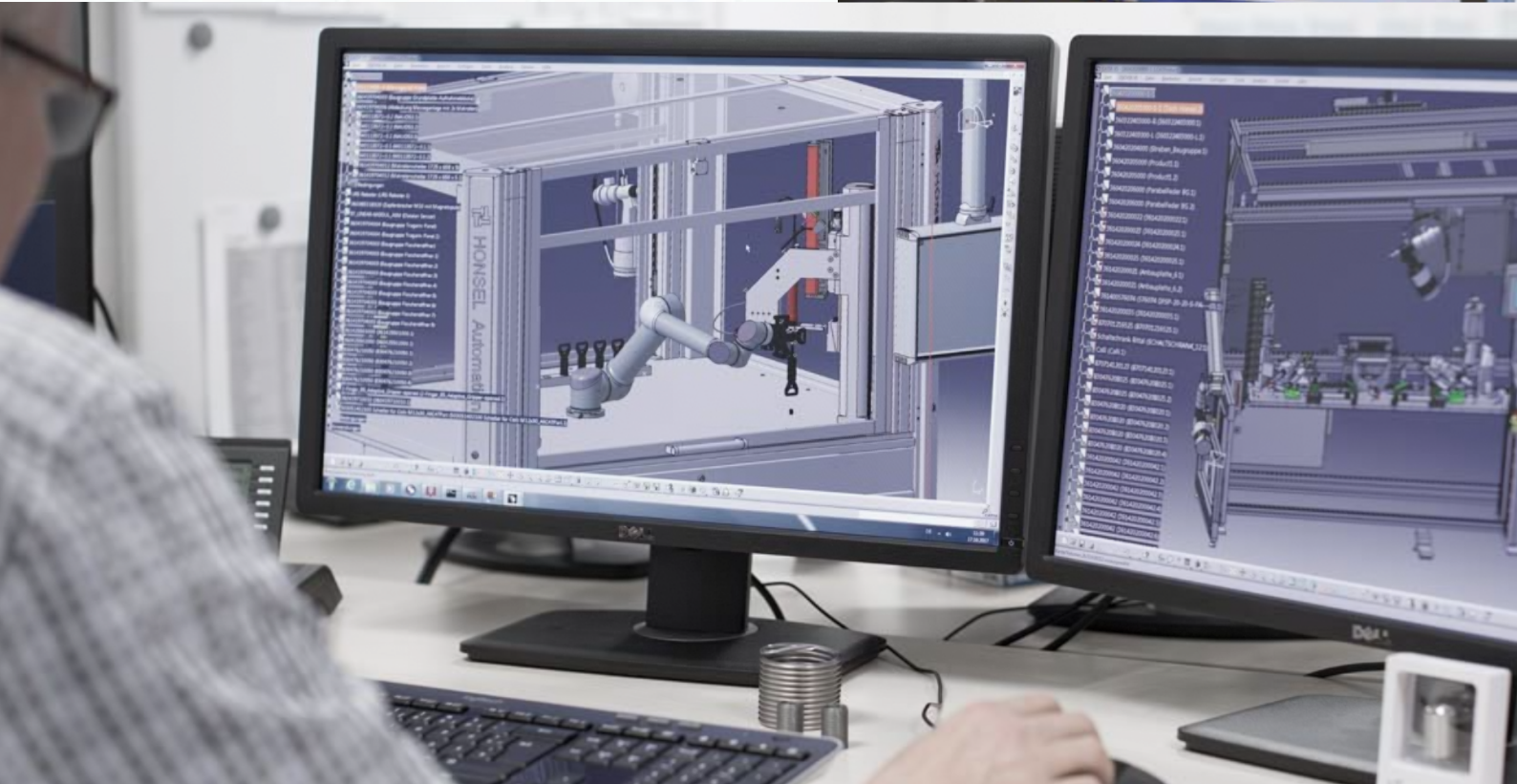
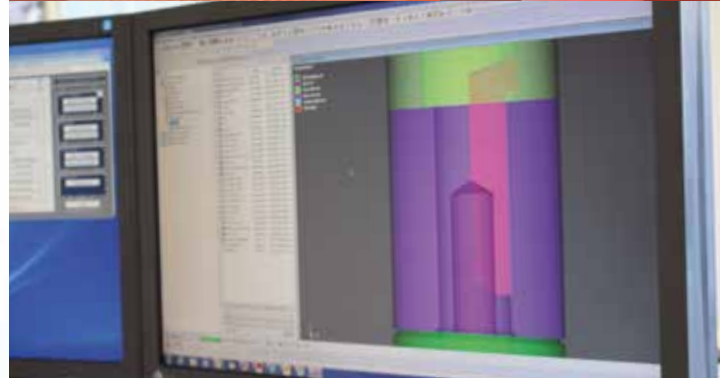
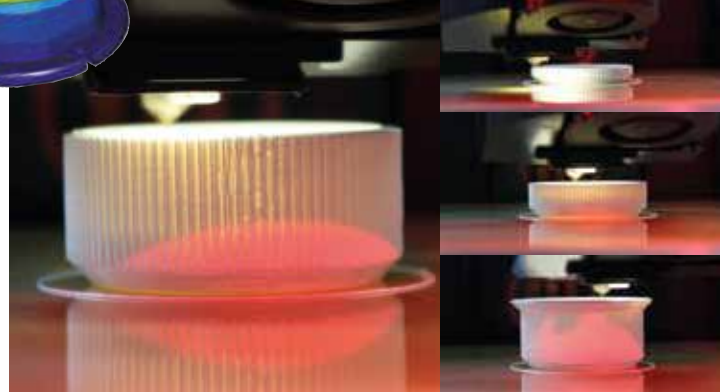
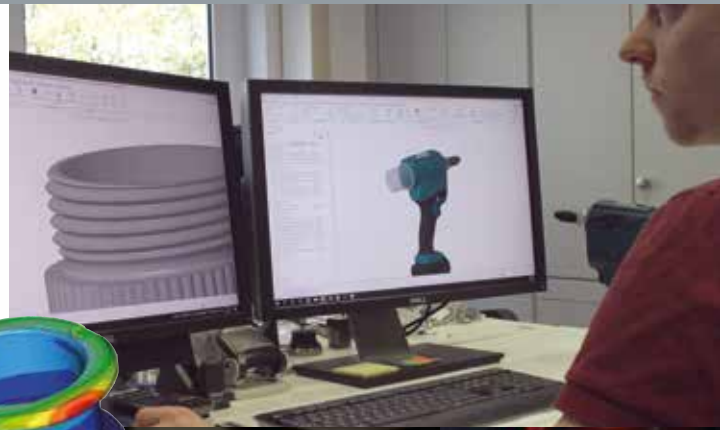
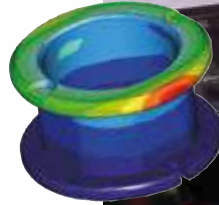
On the one hand, our application technicians and designers are permanently engaged in the **optimisation of the existing product range**.

Here they test, analyse, evaluate customer experience, correct, inspect and plan the feedback into the manufacturing at the various production sites.

This all happens against the background of an almost infinite basis of well-founded practical know-how from numerous decades during which HONSEL has been one of the pioneers in the development of innumerable products, particularly for blind rivet technology.

On the other hand, sophisticated ideas for **new products** evolve time and again in the minds of our engineers. We see ourselves as development partners for our customers who not seldom give us the stimulus for innovative and cost-efficient results.

Whether the variety of different fasteners, hand-held tools such as the successful **Rivdom** and **RivSmart** battery riveters or complex, fully automated industrial systems – we elaborate together with you and experienced technical consultants on site the individual, efficient, cost-effective – in short ... **the perfect solution for your application**.





CAD data service

The right models for every CAD system.

We offer designers and product developers the opportunity of downloading each of our more than 1,300 standard sizes from the latest catalogue range for direct integration into their applications – in **over 100 different formats** as native 3D CAD models for all common CAD systems.

Simple, quick and free of charge.

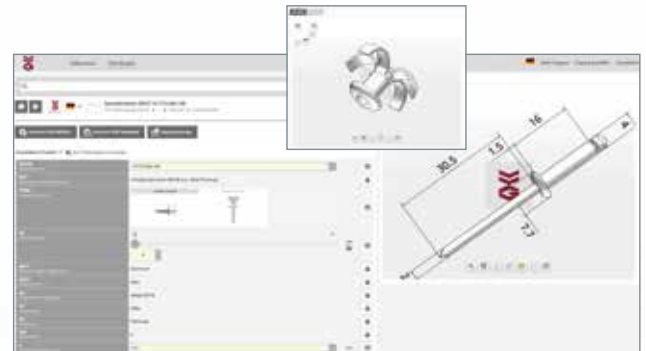
They thus eliminate the need for time-consuming product searches or for requesting the necessary data material and can concentrate fully on their own development work.

Just find the required fastener as normal in the product section of our Internet website under www.vvg.info/produkte and then click on the CAD symbol behind the required size.



You either log in directly to the **CADENAS PARTcommunity** or simply create an account once only.

In the portal you then have the possibility of adapting the product to your demands again before the download and of selecting, for example, between delivery condition and finished rivet product.





Production, further processing and toolmaking

Our manufacturing competence is the **complex cold forming of wire** in all common materials, such as steel, aluminium, stainless steel, copper and brass – **and many more**.

Pressing of the wire on a number of the latest **5-6 multistage headers** brings the **wire up to a diameter of 20 mm** into shape.

All presses are process-controlled and designed with redundancy. This guarantees sufficient flexibility to be able to meet even production demands at short notice.

The most important component, however, on which the **HONSEL** experience is based are **highly motivated staff** who are regularly trained and can successfully solve any task.

Pressing is often followed by a large number of further work steps:

Individual components are **laser welded** or **mechanically crimped**. A wide range of **threads** (male or female) are formed or **sealants are applied** (mechanically or injection moulded).

Certain contours can be modified by machining and even the application of special **partial scratch protection** coatings is possible.





Particular attention has been paid for many years to investments in future-oriented technologies and the machine park, and specially in our **in-house toolmaking shop**. The in-house production of the necessary manufacturing tools guarantees **reduced delivery times up to series maturity** and vast possibilities for **meeting even unusual wishes of our customers**. The complex tool kits often comprising several hundred parts are stored in a perfectly organised and fully automated system, and are therefore quickly available for use on the machines at any time.

In order to be able to carry out central production processes in-house, HONSEL has amassed vast know-how in a very wide range of **heat treatment technologies** and is therefore able to modify lightweight materials in such a way that their strength is significantly higher than normal in some areas.

Finishing operations such as barrel finishing, drilling, turning and milling, rolling and pointing or the assembly of component elements are also performed in-house.



Quality

Quality in every form has the greatest importance in our day-to-day business activities.

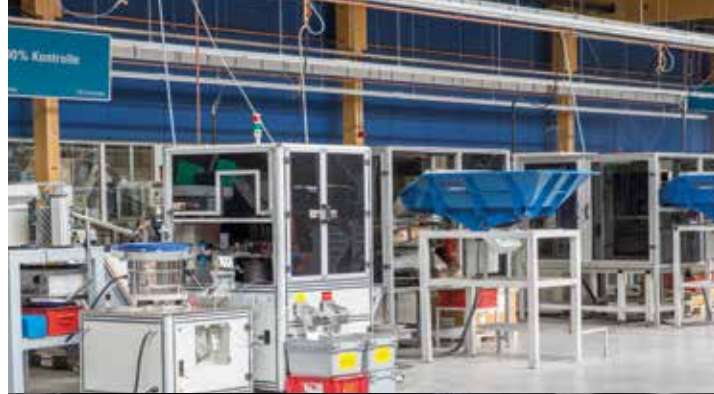
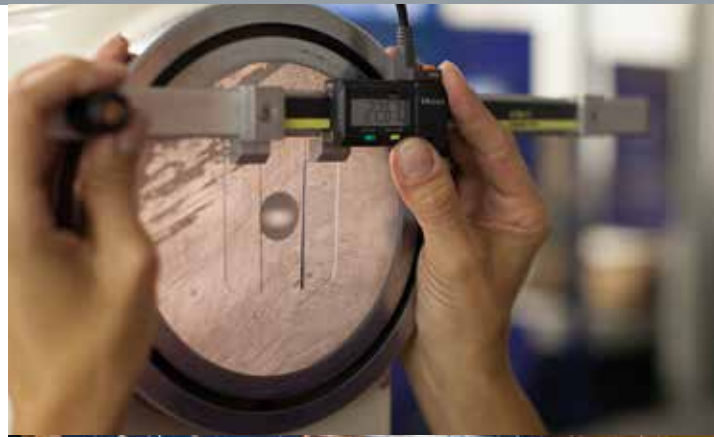
100 % inspection and 0 ppm strategies are criteria that companies have to meet today when it comes to defining targets in quality assurance.

The HONSEL Group has made very significant investments in this area in recent years and **developed exemplary quality assurance processes**. This is underlined by our certification to ISO 9001:2008, ISO 14001 and ISO/TS 16949.

In addition to standard test methods for checking shear and tensile forces, the riveting mandrel breaking forces and push-out forces and the locking of the mandrel inside the head, the latest measuring instruments and testing facilities ensure the highest level of production even with very large quantities. Here we use **process monitoring systems** and **optoelectronic testing machines** developed in-house for the individual 100 % inspection.

By **already testing every individual batch at all phases of the running production process** and its documentation by means of a CAQ software integrated into our modern IT system, continuous tracking of all shipped products is assured back to the starting material used.

Measuring equipment is also available for length and roughness tests, metallurgical tests, microscopy, profile projection, eddy current and hardness tests.





National technical approvals

General national technical approvals are required for many types of construction and construction products where no defined rules and standards exist, or where extreme deviations from these exist.

These serve as proof of their safe use in the intended applications and describe the necessary technical requirements for a construction.

In the field of blind rivet technology, for example, these are:

- General fasteners for steel and aluminium substructures
- Aluminium substructures for solar energy installations
- Longitudinal butt joints of corrugated sheets
- Longitudinal butt joints of metal and corrugated plastic sheets
- Production of sliding points on aluminium substructures



The blind rivets currently approved or undergoing the approval process from the product groups **ALFO®**, **OPTO®**, **CERTO®** and for **folding blind rivets with neoprene seal** are marked with the symbol opposite.

For necessary documents and further information, please contact the specialists from our technical sales team directly.

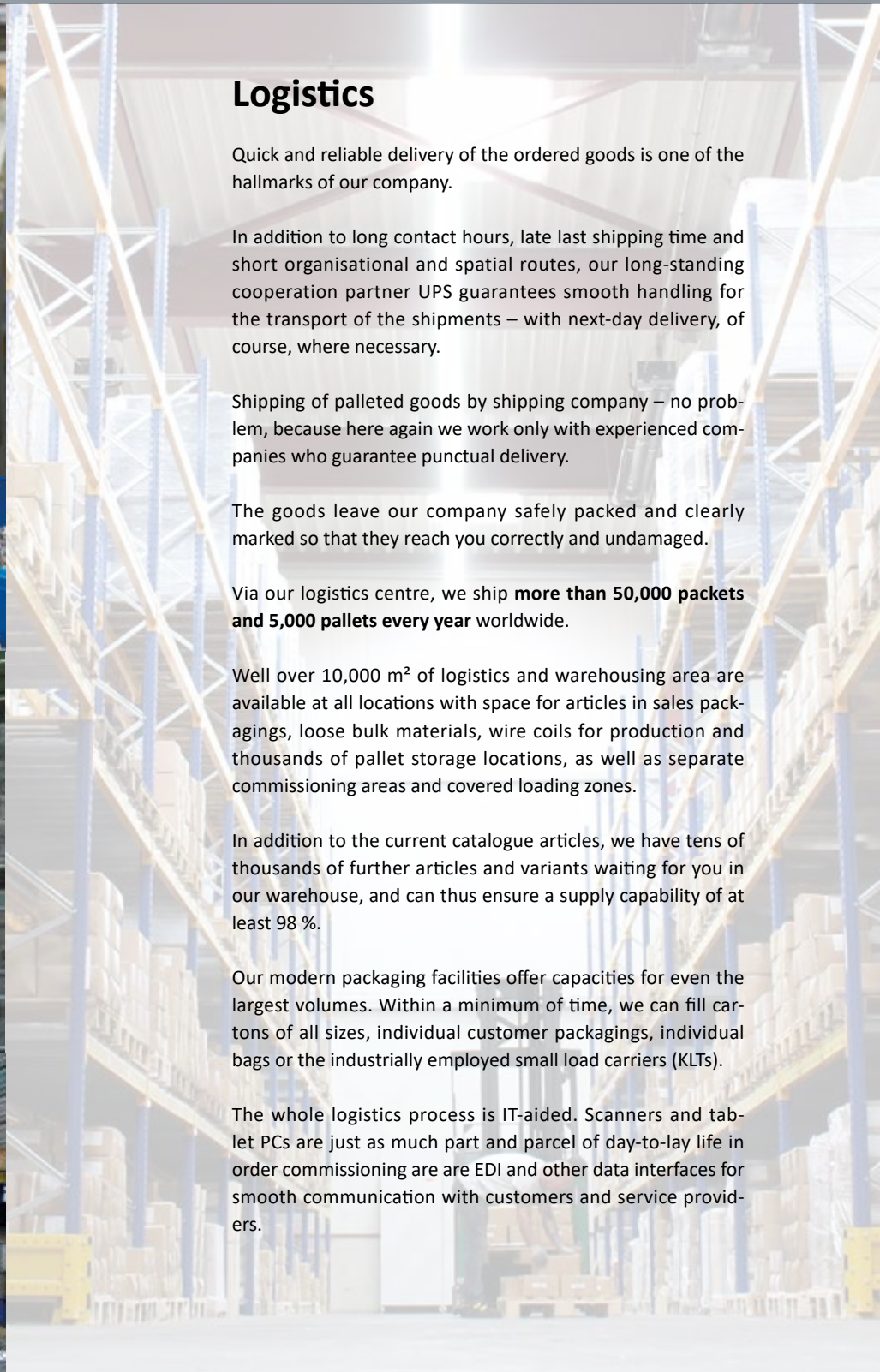


Certificates



You can rely on us. Guaranteed.

Please ask for possible updated versions of the certificates issued during the life of the catalogue.



Logistics

Quick and reliable delivery of the ordered goods is one of the hallmarks of our company.

In addition to long contact hours, late last shipping time and short organisational and spatial routes, our long-standing cooperation partner UPS guarantees smooth handling for the transport of the shipments – with next-day delivery, of course, where necessary.

Shipping of palletized goods by shipping company – no problem, because here again we work only with experienced companies who guarantee punctual delivery.

The goods leave our company safely packed and clearly marked so that they reach you correctly and undamaged.

Via our logistics centre, we ship **more than 50,000 packets and 5,000 pallets every year** worldwide.

Well over 10,000 m² of logistics and warehousing area are available at all locations with space for articles in sales packagings, loose bulk materials, wire coils for production and thousands of pallet storage locations, as well as separate commissioning areas and covered loading zones.

In addition to the current catalogue articles, we have tens of thousands of further articles and variants waiting for you in our warehouse, and can thus ensure a supply capability of at least 98 %.

Our modern packaging facilities offer capacities for even the largest volumes. Within a minimum of time, we can fill cartons of all sizes, individual customer packagings, individual bags or the industrially employed small load carriers (KLTs).

The whole logistics process is IT-aided. Scanners and tablet PCs are just as much part and parcel of day-to-day life in order commissioning as EDI and other data interfaces for smooth communication with customers and service providers.



Advice

Product know-how and application experience are part of our DNA.

Our employees in all departments can call on the vast know-how developed over the **more than 85 years** of the company history.

This, and the ongoing in-house and external further training, ensures that outstandingly qualified and motivated staff are ready to competently answer all your questions surrounding the topic of “riveting technology”.

We accompany special projects from the first idea through to the final delivery with experts from all the necessary department who work closely together to **guarantee optimum handling**.

We'll come to you.

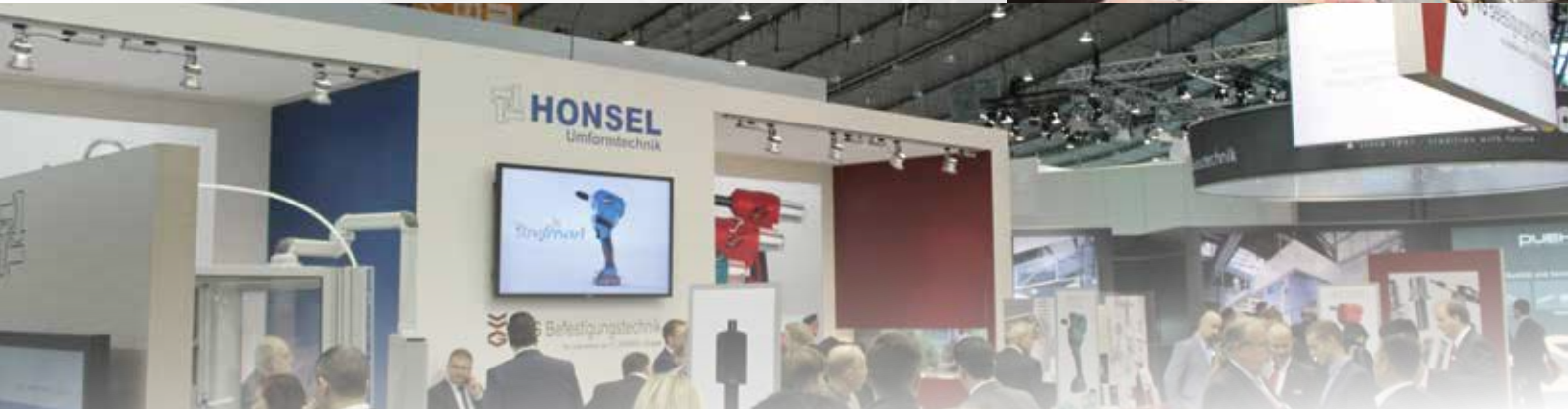
On site, our technical application consultants are available with advice and support throughout Germany.

Detailed demonstrations and intensive advise together with **comprehensive training** are indispensable aspects of the successful cooperation with our customers.

At **in-house fairs** or during special information days as part of the “Riveting Technology on Tour” campaigns that we have successfully organised for many years on our retail partners' premises throughout Germany, our experts present all the products from our portfolio.

Furthermore, you can meet us regularly at a wide range of **trade fairs** in Germany and abroad.

There we provide information on both innovations and our classic products. It is not unusual for the discussions held here to lead to interesting suggestions and ideas from practical use that we integrate into our product portfolio.





Service

In addition to our high-quality products, as system supplier for rivet and fastener technology we also offer a comprehensive “**all-round service**”.

In order to guarantee **maximum contact hours** for our customers, our customer support staff in Sales can be reached **from Monday to Thursday from 7.00 a.m. until 5.00 p.m. and on Friday until 4.00 p.m.**



Orders reaching us on workdays by 3.00 p.m. are shipped **on the same day** on request. The required goods can be at their destination the following day with standard shipment – guaranteeing you high flexibility in your order planning.

Within the framework of skeleton contract, we produce and stock the goods for you and ship them automatically and reliably to the point of use **just in time** according to an agreed delivery plan.

We offer our retail partners a variety of different **sales support materials**, for example in the form of catalogues and flyers, that can also be individually designed on request. In addition, we advise you during the presentation of our products in your shop.

Our **Rivet Processing Competence Centre** is available for the maintenance and repair of all VVG/HONSEL tools. Here our staff ensure that tools sent in are ready for use again within a minimum of time. And in order that there is no loss of production, we can provide you with a **hire tool** on request.





Online

Visit us regularly on the Internet!

On our website www.vvg.info/en you will find not only information about the company group, but also a number of useful tips to simplify your day-to-day work in rivet and fastener technology.

The heart of the website is the extensive, convenient **product search**. Here you will quickly and easily find the desired product from our current catalogue assortment with photo, drawings, in many cases film or animation, technical data, PDF data sheets, tool recommendations and CAD data for the design engineering (► [PAGE 7](#)).

In addition, we offer a wide range of material such as product flyers or illustrative materials for your sales activities in the **Download Centre**, a convenient **product viewer** for finding tool spare parts and a **live chat** as a quick and direct link to our team.

Further information on the Group can be found at:
www.rivsmart.com (battery riveters with smart technology)
www.honsel.de/en (HONSEL Umformtechnik. wire products)
www.honsel-automation.de/en (New in 2018 – Industrial Automation)

The pages can also be used easily and intuitively on all mobile devices.

On the two **YouTube** channels we have a large number of films and animations explaining our products that can also be called up via the **QR codes** in this catalogue.

Up-to-date information can also be found constantly, for example, on **facebook** or **twitter** and further social media platforms.



www.vvg.info/en



www.honsel.de/en



www.rivsmart.com



www.honsel-automation.com



www.youtube.com/nietweltdigital



www.youtube.com/honselumformtechnik



VVG Befestigungstechnik

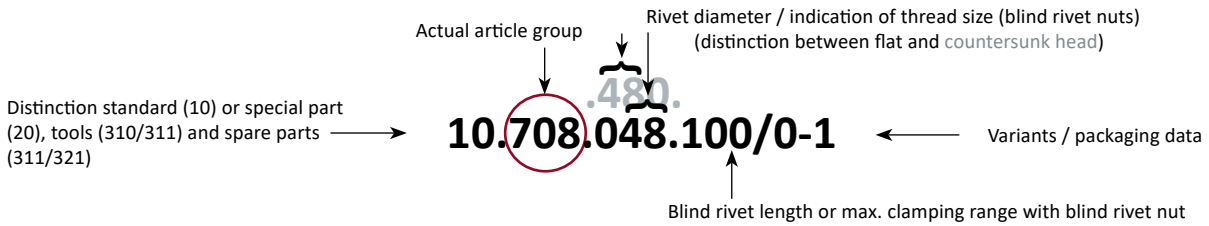


Blindbolts
Perfektion.

► RivSmart - Klein, Leicht, Smart

Information and explanation of symbols

Article numbers / allocation to tools:



Info block
with additional information / icons

Article group designation
with materials and version

Figures
with product photo, drawings and material details

Tabs
for better orientation when the catalogue is closed

Table – basic data
diameter / length / clamping range / article no. / packaging size / price

Table – additional information
head + shank diameter, head height, bore diameter, various force data

ALFO® Standard Blind Rivet
Stainless Steel A2 → Stainless Steel A2
Dome Head | open

QR code | FILM | DIN EN ISO 15983 | CAD DATA ONLINE | Series 708

d	l	⌀	Nr.	⊞
2,4	6,0	0,5 - 3,5	10.708.024.060	500
	8,0	3,0 - 5,5	10.708.024.080	500
⌀ _h 5,0 - ⌀ _h 2,5 ⌀ _h 1,5 k 0,8 - ⌀ _h 1 ⌀ _h 2,5 mm ⌀ _h 1000 N ⌀ _h 1500 N				
3,0	6,0	0,5 - 3,0	10.708.030.060	500
	8,0	3,0 - 5,0	10.708.030.080	500
	10,0	5,0 - 7,0	10.708.030.100	500
	12,0	6,5 - 8,5	10.708.030.120	500
16,0	8,5 - 12,0	10.708.030.160	500	
⌀ _h 6,3 - ⌀ _h 1,9 k 0,8 - ⌀ _h 2,7 ⌀ _h 3,1 mm ⌀ _h 2050 N ⌀ _h 2600 N				
6,0	0,5 - 3,0	10.708.032.060	500	
8,0	3,0 - 5,0	10.708.032.080	500	
10,0	5,0 - 7,0	10.708.032.100	500	

d	l	⌀	Nr.	⊞
4,8	8,0	1,5 - 4,0	10.708.048.080	500
	10,0	4,0 - 6,0	10.708.048.100	500
	12,0	6,0 - 8,0	10.708.048.120	500
	14,0	7,0 - 9,5	10.708.048.140	500
16,0	8,0 - 11,0	10.708.048.160	500	
18,0	11,0 - 13,0	10.708.048.180	500	
20,0	13,0 - 16,0	10.708.048.200	500	
⌀ _h 9,5 - ⌀ _h 2,9 k 1,1 - ⌀ _h 3,3 ⌀ _h 4,4 mm ⌀ _h 4250 N ⌀ _h 5400 N				
8,0	2,0 - 4,0	10.708.050.080	500	
10,0	4,0 - 6,0	10.708.050.100	500	
12,0	6,0 - 8,0	10.708.050.120	500	
14,0	7,0 - 9,5	10.708.050.140	500	

Colour coding system

An unambiguous colour is assigned to each material that can be found also in both the navigation bar and the production designations and drawings as an aid to orientation. Furthermore, the colours are also integrated into the representation of the processing possibilities of all the tools. In addition, you will find the colour coding on a large proportion of our labels.

- Steel
- Stainless steel
- Aluminium
- Copper
- Bronze

	M3	M4	M5	M6	M8	M10	M12
Aluminium							
Steel							
Stainless steel							



ICONS

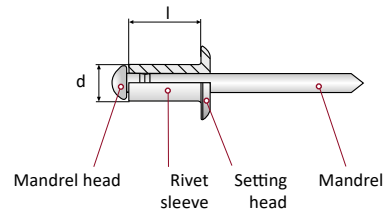
- General product information
Useful information on further dimensions, variants or special features and cross-references
- Page references
- VVG Serial No.
- CAD data available online
- DIN EN ISO
- QR code with content information

- Clamping range
- Shear breaking force
- Tensile breaking force
- Tightening torque
- Axial tensile force
- Bore diameter

Required information for your order / enquiry

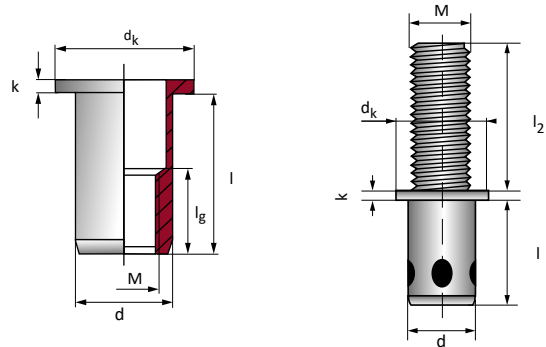
Blind rivets

- Material combination (sleeve / mandrel)
- Shaft / bore diameter (d)
- Shaft length / clamping range (l)
- Head form (flat, countersunk, large dome head)



Blind rivet nuts / bolts

- Material
- Thread size (M)
- Shaft / bore diameter (d)
- Shaft length / clamping range (l)
- Shaft form (open / closed)
- Head form (flat, countersunk, small countersunk head)
- Twist lock (knurling / (partial) hexagonal shank)
- Bolt length in set condition (l₂)



Tools

- **How often is the tool used?**
No. of rivets
- **Where is the tool used?**
Production / workshop / construction site, etc.
- **What max. dimensions / materials are processed?**
- **Are special rivet types to be processed?**
e.g. high-strength blind rivets



Please note

that a very large number of individual factors have an influence on a riveted joint. For this reason, riveting tests should always be performed (we can provide samples for these on request).

The standard range presented in this catalogue shows only a small proportion of all the products available. Should you not find an article or size – we'll find an alternative!



Special nosepiece required



Pivoting tool head



Sound emissions in dB(A)



Hexagonal product



Weight in kg



Air consumption in litres



Closed shaft



Tensile force at 7 bar



Connection possibilities



knurled



Pressure in bar



Scope of delivery

Imperial dimensions



Stroke in mm



Type of packaging



Stainless steel A4 grade



Maximum stud diameter



Packaging with hole for hanging

Blind Rivets



ALFO® Dome Head



ALFO® Countersunk Head



ALFO® Large Dome Head



ALFO® grooved



painted / head painted / anodized



OPTO® Multigrip
Different Head Shapes



CERTO® Seales Blind Rivet
Dome or Countersunk head



HIGH-STRENGTH
FERO®-BOLT
Dome or Countersunk head



Folding Blind Rivet



Folding Blind Rivet Special



HIGH-STRENGTH
OPTO®-BULB Dome Head



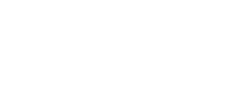
CERTO® PERFECT Dome Head



Hammer Stroke



Grounding



ARCO® Spreizblindniet

Blind Rivet Nuts



Round Shank Flat Head



Round Shank Countersunk Head



Round Shank Small Countersunk Head



Round Shank knurled



Round Shank closed



OPTO® Multigrip



HEXAFORM® Hexagonal



HEXATOP® Patial Hexagonal



Folding Blind Rivet Nut

Hollow Blind Rivet Nut

Blind Rivet Bolts



RIFBOLT® Flat Head



RIFBOLT® Countersunk Head



RIFBOLT® Small Countersunk Head



RIFBOLT® Hexagonal

Self Clinching Fasteners



Self Clinching Nuts



Self Clinching Rivet Nuts



Self Clinching Studs



Self-Clinching Stand-Offs

Coil Threaded Inserts



VVG StarCoil



VVG StarCoilBoxes



Blind Rivets

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Detailed Directory

Page 21

Hand Tools

BZ Series for Blind Rivets



BZ 2

BZ 44

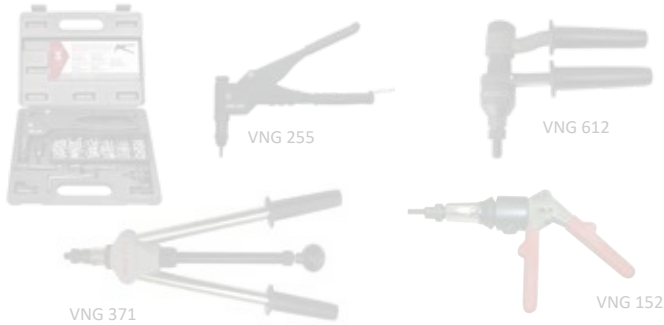
BZ 6



BZ 70 / BZ 72

BZ 58

VNG Series for Blind Rivets Nuts and Bolts



VNG 255

VNG 612

VNG 371

VNG 152

MULTI series for Blind Rivets, Blind Rivet Nuts and Bolts



MULTI 1

MULTI 5

Battery Tools



Rivdom ZERO^{12V}

Rivdom ONE^{18V}

Rivdom TWO^{20V}

RivSmart

Pneumatic-hydraulic

BZ series for Blind Rivets



BZ 103 A

BZ 123 A

BZ 133 A

BZ 143 A

VNG for Blind Rivets Nuts and Bolts



VNG 703

(force-controlled)

VNG 903

(stroke-controlled)

VNG 753

(for Folding Blind Rivet Nuts)

Blind Rivet Nuts

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Detailed Directory

Page 81

Blind Rivet Bolts

118

Self Clinching Fasteners

Coil Threaded Inserts

For more information about these product groups see our separate catalogs or visit our website www.vvg.info/en

Processing / Tools

- Hand Tools
- Battery Tools
- Pneumatic-hydraulic Tools

HONSEL Umformtechnik

Automation

BLIND RIVETS



The blind rivet consists of a **shank** assembled to the **rivet mandrel**.

The handling of blind rivets occurs from one side of the construction elements.

After inserting the rivet into the components bore holes, the rivet mandrel is pulled back by the tool and forms the closing head. The mandrel or parts of it can remain in the shaft after reaching the predetermined break point.

Open, closed or high strength versions, multigrip or expanding blind rivets, with dome head, countersunk head or large head - the variety of available dimensions and types is almost **unlimited**.

Our production facilities certified in accordance with the automotive industry standards guarantee a consistently high

quality with respect to geometric dimensions, mechanical values and function.

Many features have significantly closer tolerances than specified in the DIN standards, others not specified there are optimised in detail.

Special tools are needed for processing blind rivets.

These tools have to be chosen on the basis of the rivet type, the field of application and the processing volume.

The scope ranges from **manual pliers** and **lever tools**, to modern cordless **battery riveters** to **pneumatic-hydraulic tools** and **fully automated applications** for industrial volume productions.

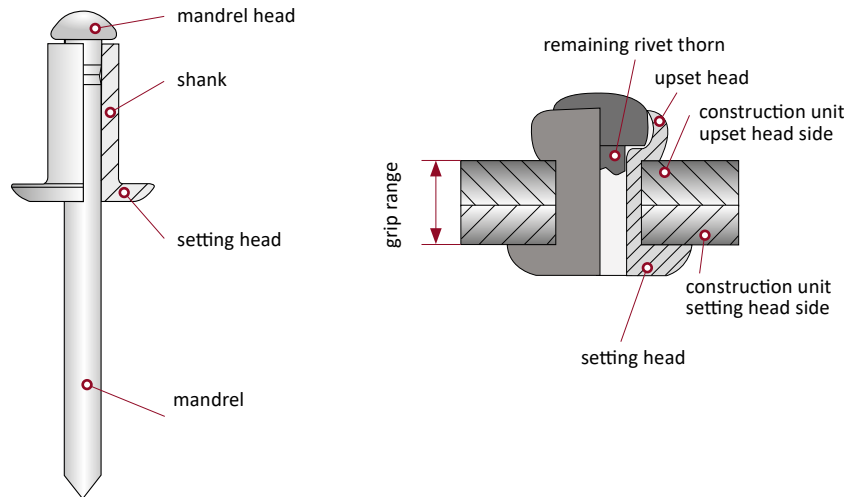
rivet	material														mandrel head	page	
	shank							mandrel									
	aluminium	steel	stainless steel A2	stainless steel A4	nickel/copper	copper	messing	aluminium	steel	stainless steel A2	stainless steel A4	nickel/copper	copper	bronze			
Standard blind rivets ALFO	x								x						Dome head	30/31	
	x								x						Countersunk head	32	
	x								x						Large dome head	33	
	x								x						Dome head, rilliert	34	
	x									x					Dome head	36	
	x										x				Countersunk head	37	
	x										x				Large dome head	38	
	x								x						Dome head	39	
		x								x					Dome head	40	
		x								x					Countersunk head	41	
		x								x					Large dome head	41	
			x								x				Dome head	42	
			x								x				Countersunk head	43	
			x								x				Large dome head	43	
				x								x			Dome head	44	
				x								x			Countersunk head	44	
					x							x			Dome head	45	
						x				x					Dome head	46	
							x							x	Dome head	46	
		x								x					Dome head, painted	48	
	Multigrip blind rivets OPTO	x								x						Dome head, painted	49
		x								x						Dome head	51
		x								x						Countersunk head	52
		x								x						Large dome head	52
		x										x				Dome head	53
		x										x				Countersunk head	53
x											x				Large dome head	53	
x											x				Dome head, extended mandrel	54	
x									x						Dome head	55	
x									x						Large dome head	55	
		x								x					Dome head	56	
		x								x					Countersunk head	56	
		x								x					Large dome head	56	
			x								x				Dome head	57	
Multigrip blind rivets OPTO-BULB			x								x					Dome head	58
				x								x				Dome head	58
Sealed blind rivets CERTO	x								x						Dome head	59	
	x								x						Countersunk head	60	
	x								x						Large dome head	60	
	x										x				Dome head	61	
	x										x				Countersunk head	61	
	x								x						Dome head	62	
		x								x					Dome head	62	
			x								x				Dome head	63	
										x					Dome head	64	
											x				Dome head	64	
				x								x			Dome head	65	
	Sealed blind rivets CERTO-PERFECT															Dome head	67
x									x						Dome head	67	
Structural blind rivets FERO-BULB		x								x					Dome head	68	
		x								x					Dome head	68	
											x				Countersunk head	69	
				x								x			Dome head	70	
Structural blind rivets FERO-BOLT	x								x						Dome head	72	
	x								x						Countersunk head	72	
		x								x					Dome head	72	
		x								x					Countersunk head	73	
				x							x				Dome head	73	
				x								x			Countersunk head	73	
Folding blind rivets	x								x						Dome head, standard	74	
	x								x						Dome head, special-2	75	
Body-bound blind rivets ARCO	x									x					Dome head	76	
	x									x					Large dome head	76	
Hammer stroke blind rivet	x										x				Dome head	77	
Grounding blind rivets ARCO															Dome head	78	
										x					1 earthing conductor	79	
										x					2 earthing conductor	79	
	x									x					Dome head knurled	79	

TECHNICAL EXPLANATIONS

❗ The rivet shaft is the element which makes the connection.

The rivet shaft is formed by the rivet mandrel and remains in the component on a permanent basis. The shaft type selection is made on the basis of the grounds of

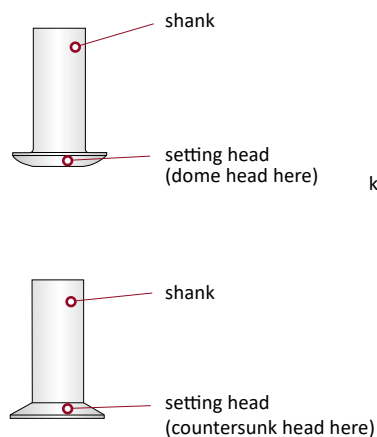
- the expected **mechanical stress**,
- the required anti-corrosion performance,
- the component layout,
- the temperature stress and partly also on
- the visual impact.



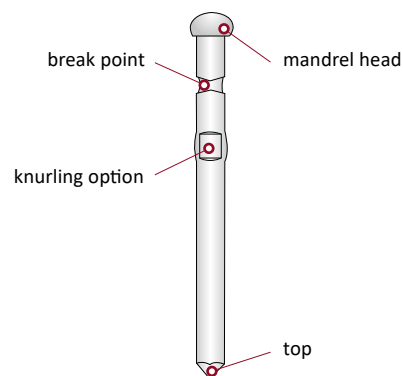
The rivet mandrel is needed for shaping the rivet shaft.

The mandrel selection is based on the shaft type and on the requirements with regard to processing and operating properties. In order to enhance the rivet's shearing force, some rivet types use a captive mandrel which remains in place after the connection has been made.

rivet shaft



mandrel

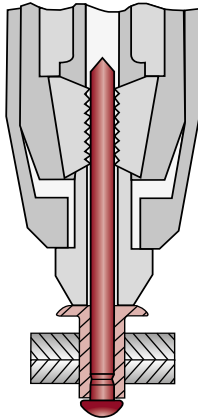


The principle of the setting process

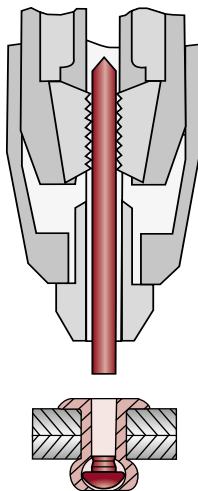
In order to process the blind rivet a setting tool is required. This can either be operated by muscle power (hand tools) or through external power (e.g. pneumatic-hydraulic or battery tools). The devices are chosen on the basis of the blind rivet type and on the basis of throughput volume. Basically, the setting process can be broken down into the following stages:



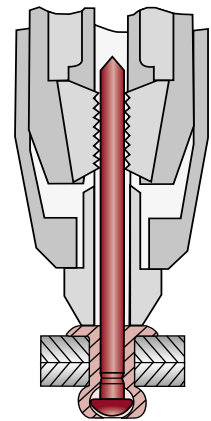
animation blind rivet



Together with the mandrel, the blind rivet is inserted into the setting device and introduced into the rivet hole.



The rivet mandrel is pulled by triggering the stroke with the help of the clamping jaws. The mandrel head reshapes the end of the rivet shaft. When the rivet head is flush with the component surface, the process is completed.



In this position the forces increase and the mandrel fractures on the predetermined break point. The spent part of the mandrel is removed and the captive mandrel remains in the shaft.

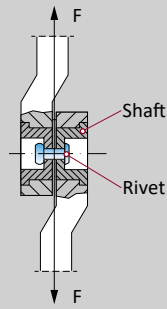


Extensive information from all areas of riveting and fastener technology can be found in our steadily growing glossary on our Internet website at www.vvg.info/know-how/glossar or using the QR code throughout the catalogue.

TECHNICAL EXPLANATIONS

Shear strength

EXPERIMENTAL SETUP



The shear strength is the maximum radial force which a rivet can absorb before fracture occurs.

Depending on the rivet principle, the forces are determined either with or without the captive mandrel covering the shearing zone. Statical measurements use the testing device covered by **DIN EN ISO 14589** (Exception: FEROTM-BOLT). The **minimum shear strength parameter** is listed on the pages with the following symbol:

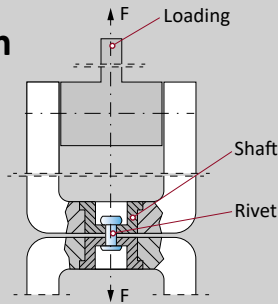


Shear strength - measured data [N]

	type	dimension	page	2,4	3,0	3,2	3,8	4,0	4,8	5,0/ 5,2 ¹	6,0	6,3 ¹ / 6,4	7,8	8,0
ALFO®	Alu / Steel Dome head		38/39	380	740	750	–	1250	1640	1820	2660	2880	6600	–
	Alu / Steel Countersunk head		40	–	740	750	–	1250	1640	1820	–	–	–	–
	Alu / Steel Large dome head		41	–	–	580	–	1250	1640	1820	2660	–	–	–
	Alu / Steel Dome head grooved		42	–	–	600	–	1000	1350	–	–	–	–	–
	Alu / Stainless steel Dome head		44	420	740	750	–	1250	1640	1820	2660	2880	–	–
	Alu / Stainless steel Countersunk head		45	420	740	–	–	1250	–	1820	–	–	–	–
	Alu / Stainless steel Large dome head		46	–	–	–	–	–	–	1820	–	–	–	–
	Alu / Alu Dome head		47	–	–	380	–	740	1140	–	–	–	–	–
	Steel / Steel Dome head		48	–	1000	1180	–	2100	3180	3320	4340	4920	–	9400
	Steel / Steel Countersunk head		49	–	1000	1180	–	2100	3180	3320	–	4920	–	–
	Steel / Steel Large dome head		49	–	–	–	–	–	2900	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		50	1000	2050	2050	–	2750	4250	5000	6300	7250	–	–
	Stainless steel / Stainless steel Countersunk head		51	–	1800	1900	–	2750	4250	5000	–	–	–	–
	Stainless steel / Stainless steel Large dome head		51	–	–	1900	–	2700	4220	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		52	–	1760	1900	–	3500	4230	4800	–	–	–	–
	Stainless steel / Stainless steel Countersunk head		52	–	–	–	–	3500	–	–	–	–	–	–
	Nickel-Copper / Stainless steel Dome head		53	–	–	1600	–	2300	3400	–	–	5400	–	–
	Copper / Steel Dome head		54	–	760	–	–	1500	–	–	–	–	–	–
	Copper / Bronze Dome head		54	–	760	800	–	1500	–	–	–	–	–	–
OPTO®	Alu / Steel Dome head		56	–	–	720	–	1120	1530	–	–	2000	–	–
	Alu / Steel Countersunk head		58	–	–	670	–	980	1500	–	–	–	–	–
	Alu / Steel Large dome head		58	–	–	720	–	1120	1530	–	–	–	–	–
	Alu / Stainless steel Dome head		59	–	–	670	–	980	1530	–	–	–	–	–
	Alu / Stainless steel Countersunk head		59	–	–	–	–	950	1200	–	–	–	–	–
	Alu / Stainless steel Large dome head		59	–	–	–	–	980	1530	–	–	–	–	–
	Alu / Stainless steel Dome head (ex. mandrel)		60	–	–	670	–	980	1530	–	–	–	–	–
	Alu / Alu Dome head		61	–	–	280	–	640	800	–	–	–	–	–
	Alu / Alu Large dome head		61	–	–	–	–	–	800	–	–	–	–	–
	Steel / Steel Dome head		62	–	–	1500	–	1950	2700	–	–	6500	–	–
	Steel / Steel Countersunk head		62	–	–	–	–	–	2000	–	–	–	–	–
	Steel / Steel Large dome head		62	–	–	–	–	–	2050	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		63	–	–	1600	–	2700	3900	–	–	–	–	–
OPTO®-BULB	Steel / Steel Dome head		64	–	–	–	–	–	–	–	–	11000	–	–
	Stainless steel / Stainless steel Dome head		64	–	–	–	–	–	–	–	–	14000	–	–
CERTO®	Alu / Steel Dome head		65	–	–	1100	–	1700	2480	–	–	3760	–	–
	Alu / Steel Countersunk head		66	–	–	1100	–	1700	2480	–	–	–	–	–
	Alu / Steel Large dome head		66	–	–	–	–	–	2480	–	–	–	–	–
	Alu / Stainless steel Dome head		67	–	–	1100	–	1700	2480	–	–	–	–	–
	Alu / Stainless steel Countersunk head		67	–	–	–	–	1700	–	–	–	–	–	–
	Alu / Alu Dome head		68	–	–	520	–	720	1020	–	–	–	–	–
	Steel / Steel Dome head		68	–	–	1150	–	1730	2400	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		69	–	–	2000	–	3000	4500	–	–	6500	–	–
CERTO®-PERFECT	Copper / Steel Dome head		70	–	–	970	–	1450	2190	–	–	–	–	–
	Copper / Stainless steel Dome head		70	–	–	1050	–	1450	2190	–	–	–	–	–
FERO®-BULB	Stainless steel / Stainless steel Dome head		71	–	–	–	–	–	4500	–	–	–	–	–
	Alu / Alu Dome head ¹		73	–	–	–	–	–	–	–	–	4200-5600	–	–
	Steel / Steel Dome head ¹		74	–	–	–	–	–	3600-5600	–	–	10000-16500	–	–
	Steel / Steel Countersunk head		75	–	–	–	–	–	–	–	–	5300-10300	–	–
FERO®-BOLT	Stainless steel / Stainless steel Dome head ¹		76	–	–	–	–	5200	5500	–	–	11500-15000	–	–
	Alu / Alu Dome head		78	–	–	–	–	–	2200	–	–	4200	–	–
	Alu / Alu Countersunk head		78	–	–	–	–	–	2400	–	–	4700	–	–
	Steel / Steel Dome head		78	–	–	–	–	–	5800	–	–	10500	–	–
	Steel / Steel Countersunk head		79	–	–	–	–	–	5800	–	–	11000	–	–
	Stainless steel / Stainless steel Dome head		79	–	–	–	–	–	6000	–	–	10500	–	–
	Stainless steel / Stainless steel Countersunk head		79	–	–	–	–	–	6000	–	–	11200	–	–
Folding Rivet	Alu / Alu Dome head Standard		80	–	–	–	–	500	900	–	–	–	–	–
	Alu / Alu Dome head Spezial-2		81	–	–	–	–	–	–	3000	–	4900	–	–
ARCO®	Alu / Steel Dome head		82	–	–	850	–	1330	2100	–	–	–	–	–
	Alu / Steel Large dome head		82	–	–	–	–	–	1700	–	–	–	–	–
Grounding Rivet	Copper / Steel Dome head		84	–	–	–	1400	–	–	–	–	–	–	–
Grounding OPTO®	Alu / Steel Dome head		85	–	–	–	–	1140	–	–	–	–	–	–

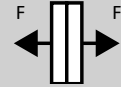
Tensile strength

EXPERIMENTAL SETUP



The tensile strength is the maximum axial force which a rivet can absorb before fracture occurs.

For the statical measurement, the testing device presented under **DIN EN ISO 14589** is used. The value for the tensile force is listed on the pages below the following symbol:



Tensile Strength - measured data [N]

	type	dimension	page	2,4	3,0	3,2	3,8	4,0	4,8	5,0/ 5,2 ¹	6,0	6,3 ¹ / 6,4	7,8	8,0
ALFO®	Alu / Steel Dome head		38/39	600	1000	1220	–	1800	2200	2400	3500	4600	9550	–
	Alu / Steel Countersunk head		40	–	1000	1220	–	1580	2200	2400	–	–	–	–
	Alu / Steel Large dome head		41	–	–	1000	–	2000	2600	2800	3500	–	–	–
	Alu / Steel Dome head grooved		42	–	–	1000	–	1350	1820	–	–	–	–	–
	Alu / Stainless steel Dome head		44	660	1000	1220	–	1800	2200	2400	3500	4600	–	–
	Alu / Stainless steel Countersunk head		45	660	1000	–	–	1580	–	2100	–	–	–	–
	Alu / Stainless steel Large dome head		46	–	–	–	–	–	–	2500	–	–	–	–
	Alu / Alu Dome head		47	–	–	670	–	1240	1600	–	–	–	–	–
	Steel / Steel Dome head		48	–	1340	1560	–	2800	4220	4740	6000	7000	–	13000
	Steel / Steel Countersunk head		49	–	1340	1560	–	2800	4220	4740	–	5700	–	–
	Steel / Steel Large dome head		49	–	–	–	–	–	3850	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		50	1500	2600	2600	–	3550	5400	6400	8250	9335	–	–
	Stainless steel / Stainless steel Countersunk head		51	–	2200	2500	–	3550	5400	6400	–	–	–	–
	Stainless steel / Stainless steel Large dome head		51	–	–	2500	–	3500	5330	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		52	–	2270	2500	–	4650	5250	6600	–	–	–	–
	Stainless steel / Stainless steel Countersunk head		52	–	–	–	–	4650	–	–	–	–	–	–
	Nickel-Copper / Stainless steel Dome head		53	–	–	2400	–	3450	5000	–	–	8200	–	–
	Copper / Steel Dome head		54	–	950	–	–	1800	–	–	–	–	–	–
Copper / Bronze Dome head		54	–	950	1000	–	1800	–	–	–	–	–	–	
OPTO®	Alu / Steel Dome head		56	–	–	1000	–	1650	2300	–	–	2500	–	–
	Alu / Steel Countersunk head		58	–	–	900	–	1320	2300	–	–	–	–	–
	Alu / Steel Large dome head		58	–	–	1000	–	1650	2300	–	–	–	–	–
	Alu / Stainless steel Dome head		59	–	–	900	–	1320	2300	–	–	–	–	–
	Alu / Stainless steel Countersunk head		59	–	–	–	–	1500	1700	–	–	–	–	–
	Alu / Stainless steel Large dome head		59	–	–	–	–	1320	2300	–	–	–	–	–
	Alu / Stainless steel Dome head (ex. mandrel)		60	–	–	900	–	1320	2300	–	–	–	–	–
	Alu / Alu Dome head		61	–	–	370	–	910	1100	–	–	–	–	–
	Alu / Alu Large dome head		61	–	–	–	–	–	1100	–	–	–	–	–
	Steel / Steel Dome head		62	–	–	1700	–	2350	3300	–	–	4200	–	–
	Steel / Steel Countersunk head		62	–	–	–	–	–	2900	–	–	–	–	–
	Steel / Steel Large dome head		62	–	–	–	–	–	2940	–	–	–	–	–
Stainless steel / Stainless steel Dome head		63	–	–	2000	–	3500	5000	–	–	–	–	–	
OPTO®-BULB	Steel / Steel Dome head		64	–	–	–	–	–	–	–	–	7800	–	–
	Stainless steel / Stainless steel Dome head		64	–	–	–	–	–	–	–	–	8000	–	–
CERTO®	Alu / Steel Dome head		65	–	–	1450	–	2700	3540	–	–	5460	–	–
	Alu / Steel Countersunk head		66	–	–	1450	–	2700	3540	–	–	–	–	–
	Alu / Steel Large dome head		66	–	–	–	–	–	3540	–	–	–	–	–
	Alu / Stainless steel Dome head		67	–	–	1450	–	2700	3540	–	–	–	–	–
	Alu / Stainless steel Countersunk head		67	–	–	–	–	2700	–	–	–	–	–	–
	Alu / Alu Dome head		68	–	–	540	–	760	1420	–	–	–	–	–
	Steel / Steel Dome head		68	–	–	1300	–	1860	2800	–	–	–	–	–
	Stainless steel / Stainless steel Dome head		69	–	–	2500	–	4000	5500	–	–	8000	–	–
	Copper / Steel Dome head		70	–	–	1270	–	2300	3280	–	–	–	–	–
Copper / Stainless steel Dome head		70	–	–	1350	–	2300	3280	–	–	–	–	–	
CERTO®-PERFECT	Stainless steel / Stainless steel Dome head		71	–	–	–	–	–	5500	–	–	–	–	–
FERO®-BULB	Alu / Alu Dome head ¹		73	–	–	–	–	–	–	–	–	3100	–	–
	Steel / Steel Dome head ¹		74	–	–	–	–	–	3800	–	–	7800	–	–
	Steel / Steel Countersunk head		75	–	–	–	–	–	–	–	–	5400	–	–
	Stainless steel / Stainless steel Dome head ¹		76	–	–	–	–	4000	5000	–	–	8800	–	–
FERO®-BOLT	Alu / Alu Dome head		78	–	–	–	–	–	1800	–	–	3000	–	–
	Alu / Alu Countersunk head		78	–	–	–	–	–	2000	–	–	4500	–	–
	Steel / Steel Dome head		78	–	–	–	–	–	4100	–	–	8000	–	–
	Steel / Steel Countersunk head		79	–	–	–	–	–	4100	–	–	9500	–	–
	Stainless steel / Stainless steel Dome head		79	–	–	–	–	–	4500	–	–	8200	–	–
	Stainless steel / Stainless steel Countersunk head		79	–	–	–	–	–	4500	–	–	8900	–	–
Folding Rivet	Alu / Alu Dome head Standard		80	–	–	–	–	800	1100	–	–	–	–	–
	Alu / Alu Dome head Spezial-2		81	–	–	–	–	–	–	2000	–	3000	–	–
ARCO®	Alu / Steel Dome head		82	–	–	720	–	1300	1950	–	–	–	–	–
	Alu / Steel Large dome head		82	–	–	–	–	–	1700	–	–	–	–	–
Grounding Rivet	Copper / Steel Dome head		84	–	–	–	2000	–	–	–	–	–	–	–
Grounding OPTO®	Alu / Steel Dome head		85	–	–	–	–	1670	–	–	–	–	–	–

¹ depending on the length

TECHNICAL EXPLANATIONS

Corrosion resistance and protection

Surface corrosion

Surface corrosion is the abrasion of surfaces and the conversion of the material into oxidation products (e.g. rust).

Suitable protective measures include:

- Application of a surface coating (passive corrosion proofing)
- Use of corrosion-proof materials (stainless steel, copper, aluminium and aluminium alloy) (active corrosion proofing)

Surface treatments

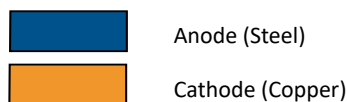
Electro galvanizing

Through galvanic processes, the zinc coat is applied to rivets made from steel, CuNi and NiCu alloys. The thickness of the layer should be at least 3 µm, but it should not exceed 20 µm. Whilst the main reason for galvanizing steel rivets consists in protection of the rivet body against rust formation, it is also applied for the purposes of reducing contact erosion e.g. when there is assembly in aluminium components. Copper-nickel rivets and rivets made from nickel-copper alloys are primarily coated in order to improve their contact corrosion performance.

Lacquer coating

In order to provide colour, rivets may also be coated with organic lacquers. This process is primarily carried out on aluminium materials; whilst already the choice from RAL and NCS colours is virtually unlimited, and it is even possible to select from a wider array of colour shades.

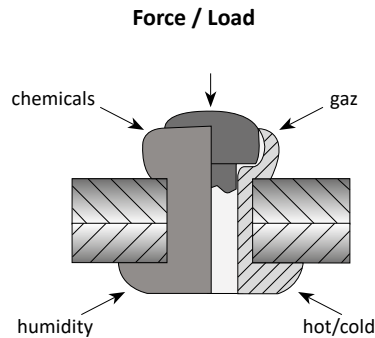
Active corrosion protection



Anoden current = Cathode current

Contact corrosion

Due to the potential difference between electrodes, contact corrosion leads to surface damage in the area where the



Zinc-nickel coating

Zinc-nickel coats that are applied by means of galvanization are primarily used when there are extremely high demands with regard to the corrosion resistance of a steel rivet. Whilst the layer thickness itself remains the same, the corrosion resistance reaches 500% of the value that would be achieved for conventional galvanization.

Chromating of electroplated layers

Chromating of electroplated parts further enhances corrosion resistance. Depending on the chromating process, resistance performance can be almost doubled.

Anodic oxidation

Anodic oxidation or eloxy coating is one further method for aluminium rivet coating. This coat which is applied through an electrochemical process is used for colour and in order to enhance corrosion resistance of the surface and for colour

In the long-run it is basically impossible to prevent corrosion, the corrosion process can be delayed by suitable measures. In terms of dimensions and complexity, when designing the rivet connections, the following types of corrosion have to be borne in mind:

different metal materials mate in the presence of an electrolyte. The abrasion always takes place on the base metal (anode).

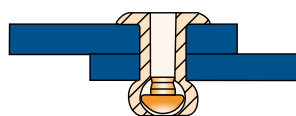
Suitable protective measures include:

- When deploying different material types, use of identical or near identical material combinations;
- Choice of a material combination with a potential difference that is as low as possible
- rivet material should be higher grade than the component material
- Choosing suitable surface coatings as electrical insulation layer.

purposes. Whilst the surface bond is high, the colour range provides but a limited choice.

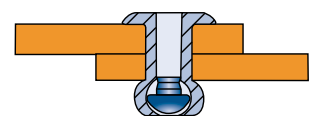
Microlayer corrosion protection systems (MKS)

Microlayer corrosion protection systems stand for state of the art procedures in material surface coating. They allow combining excellent corrosion protection with additional properties like, for instance, colour schemes and the implementation of predefined coefficients of frictions. MKS systems are selected on the basis of the specific requirements and they are customised with a view to the components that need to be coated. They contain neither heavy metals nor environmentally harmful chemicals. MKS systems are widely used in the automotive industry - the MKS systems we use are free from hexavalent chromium.



Large anode sector

- small current density
- low corrosion



Small anode sector

- large current density
- fast corrosion

Contact corrosion performance in the case of different material combinations

Components Shaft material \	Aluminium	Steel	Stainless Steel	Copper	Copper-Nickel Nickel-Copper
Aluminium	++	+	+	-	-
Steel - galvanized	+	++	+	-	+
Stainless Steel	+	++	++	-	+
Copper	+	+	+	++	++
Copper-Nickel / Nickel-Copper -galvanized	+	+	+	++	++

++ Combination well suited
 + Combination suitable
 - Combination unsuitable

This table merely serves for orientation purposes.

Corrosion behavior of nickel-copper blind rivets (Ni Cu 30 FE)

Tap water

NiCu30Fe has excellent corrosion resistance in distilled, hard or soft water.

Salt water

NiCu30Fe is a great seawater resistant material. In stationary seawater it may come to slight surface corrosion due to collection of oxygen-forming marine organisms.

Neutral an alkaline salts

High corrosion resistance when in use of neutral and alkaline saline solutions.

Acids salts

NiCu30Fe has good corrosion resistance to salt solutions such as zinc chloride, ammonium sulfate, aluminum sulfate, zinc chloride, ammonium sulfate, aluminum sulfate, aluminum chloride etc..

Oxidising acid salts

NiCu30Fe is not very resistant to most oxidizing action acid salts such as ferric chloride, with oxidizing constituents, silver nitrate, mercuric chloride and acids.

Oxidising alkaline salts

Hypochlorites are the only common alkaline salts with a corrosive effect on NiCu30Fe.

Mineral acids

NiCu30Fe has good corrosion resistance to all acids with the exception of strong oxidizing acids. In air-free acid a temperature increase is of no importance. In aerated acid is the corrosion strongest effect at about 85 ° C. Good resistance is therefore against sulfuric acid, hydrochloric acid, hydrofluoric acid, etc. to be expected. Also acid and hydrogen sulfide have no corrosion effect under the above conditions.

Oxidising acids

NiCu30Fe is only in limited dimensions useable with strong oxidizing acids. For example in 1% nitric acid considerable corrosion can occur caused through motion.

Organic acids and compounds

NiCu30Fe has a good corrosion resistance to all common organic acids. There is also virtually no corrosion by neutral and alkaline organic compounds. These acids are e.g. acetic acid, fruit or food acids, fatty acids etc..

Alkalis

NiCu30Fe is resistant to most of the alkaline solutions. The result e.g. by caustic soda concentrations up to 50% virtually is almost no corrosion. In a caustic soda evaporator the NiCu30Fe components stood. Ten years without significant corrosion, whereas the same components made from steel had to be exchanged after one year.

Moist and dry gases

NiCu30Fe is corrosion-resistant to all the usual dry gases. Dry chlorine gas has e.g. no effect on NiCu30Fe. These metal alloy is resistant against the corrosion and erosive action of steam at temperatures up to 400 ° C. In contrast to many other alloys NiCu30Fe showed neither fatigue yet it was brittle when it overheated long time.

SPECIAL BLIND RIVETS

Do **YOU** need a special type of blind rivet for your application?

Our experienced technicians will develop an **individual solution** for your special need:

- >> Consulting,
- >> Construction and design,
- >> Tool making,
- >> Prototyping,
- >> Manufacturing and
- >> Delivery schedules

are available from one source.

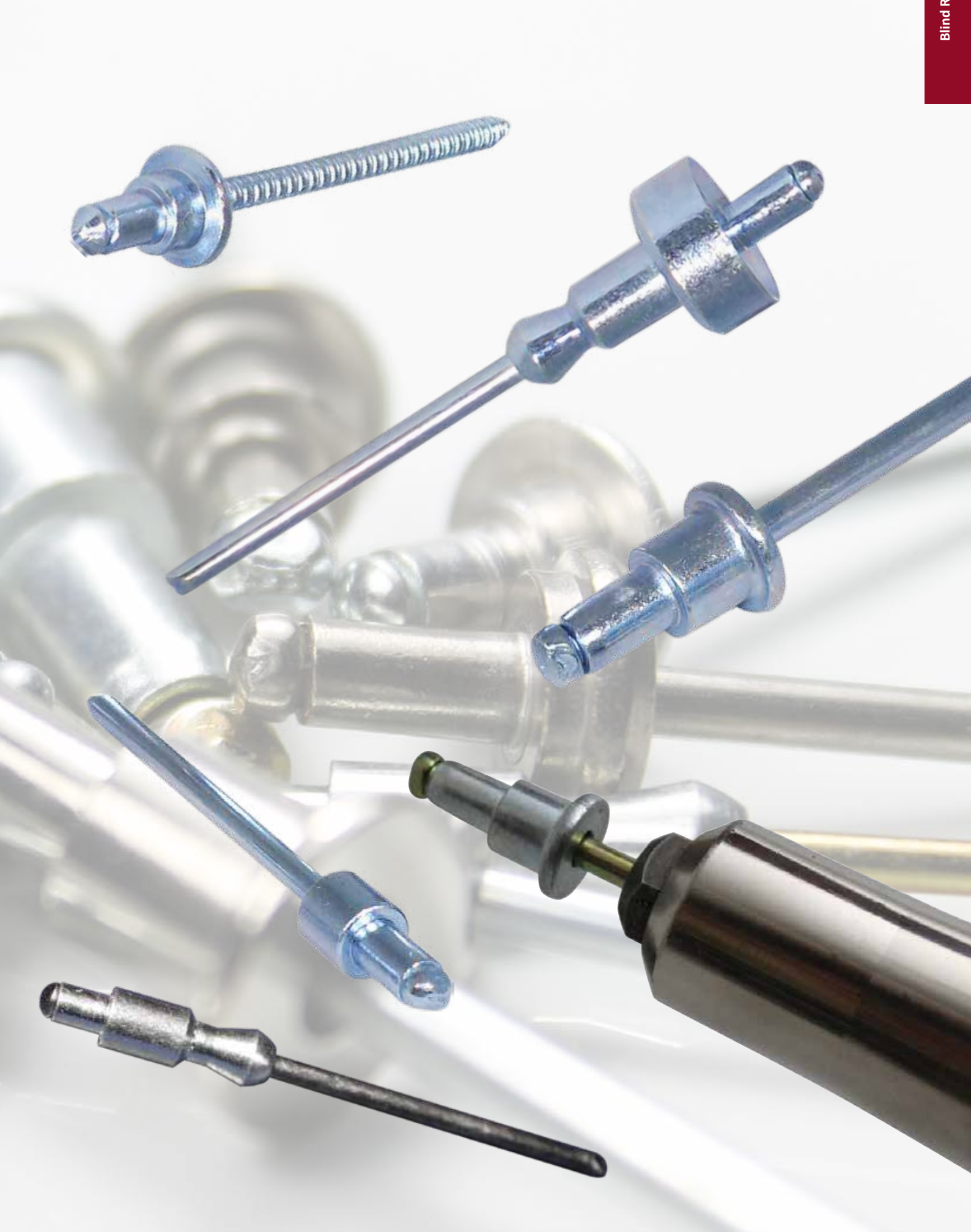
We realize projects in all dimensions for different industrial sectors, for example:

- >> Automotive industries and vehicle constructors and their suppliers,
- >> Sheet metal forming,
- >> Ventilation systems and air-conditioning plants,
- >> Furniture industry,
- >> Container and tank construction,
- >> Electric cabinets,
- >> Lightning industry and
- >> Solar- and photovoltaics suppliers

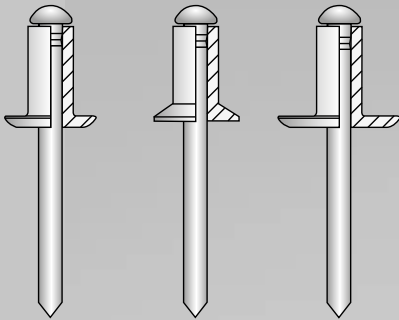
The VVG team is looking forward to your ideas! - **Send your request!**

We will find the solution.





STANDARD BLIND RIVET ALFO®



A true classic.

The description ALFO® specifies several lines of open type standard blind rivets, available with dome head, countersunk head or large dome head.

It covers the designs and special types described in DIN EN ISO 15977 – 15984, as well as 16582 und 16584. By special types we define rivets whose functional principle is identical with described versions, but with feature differences as far as certain dimensions or functional properties or materials are concerned.

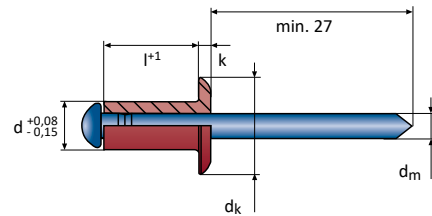
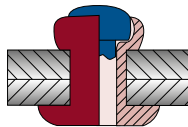
ALFO® offers more. We have specified some parameters **more detailed** such as grip range, tensile strength as well as the shear strength more detailed.

These modifications based on our **long term experience** and assist you in implementing a rivet design according to **practical purposes**.

ALFO® Standard Blind Rivet

Aluminium Steel galvanized

Dome Head | open



2,0 - 3,2 mm EN AW-5019 [AlMg5]

4,0 - 7,8 mm EN AW-5754 [AlMg3]

d	l+1	k	Nr.	Box
2,4	3,0	0,5 - 1,0	10.700.024.030	500
	4,0	0,5 - 2,0	10.700.024.040	500
	6,0	1,5 - 4,0	10.700.024.060	500
	8,0	3,5 - 6,0	10.700.024.080	500
	10,0	6,0 - 8,0	10.700.024.100	500
	12,0	8,0 - 10,0	10.700.024.120	500

dk 5,0 -0,7 dm 1,5 k 0,55 ±0,15 2,5 mm 380 N 600 N

3,0	4,0	0,5 - 2,0	10.700.030.040	500
	5,0	1,0 - 3,0	10.700.030.050	500
	6,0	1,5 - 4,0	10.700.030.060	500
	7,0	3,0 - 5,0	10.700.030.070	500
	8,0	3,0 - 6,0	10.700.030.080	500
	10,0	5,0 - 7,5	10.700.030.100	500
	12,0	7,0 - 9,0	10.700.030.120	500
	16,0	9,0 - 12,5	10.700.030.160	500
	18,0	12,0 - 14,5	10.700.030.180	500
	20,0	13,0 - 16,5	10.700.030.200	500
25,0	16,0 - 21,5	10.700.030.250	500	

dk 6,3 -0,7 dm 1,7 k 0,8 ±0,2 3,1 mm 740 N 1000 N

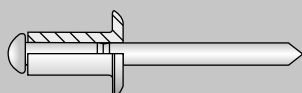
d	l+1	k	Nr.	Box
3,2	4,0	0,5 - 1,5	10.700.032.040	500
	5,0	1,0 - 2,5	10.700.032.050	500
	6,0	1,5 - 3,5	10.700.032.060	500
	8,0	3,0 - 5,5	10.700.032.080	500
	10,0	5,0 - 7,5	10.700.032.100	500
	12,0	7,0 - 9,0	10.700.032.120	500
	14,0	8,5 - 10,5	10.700.032.140	500
	16,0	9,0 - 13,0	10.700.032.160	500
	18,0	10,0 - 14,5	10.700.032.180	500
	20,0	13,0 - 17,0	10.700.032.200	500
25,0	16,0 - 21,5	10.700.032.250	500	

dk 6,5 -0,7 dm 1,9 k 0,8 ±0,2 3,3 mm 750 N 1220 N

4,0	4,0	0,5 - 1,5	10.700.040.040	500
	5,0	1,0 - 2,5	10.700.040.050	500
	6,0	1,0 - 3,5	10.700.040.060	500
	7,0	3,0 - 4,5	10.700.040.070	500
	8,0	3,0 - 5,5	10.700.040.080	500
	10,0	5,0 - 7,0	10.700.040.100	500
	12,0	6,5 - 9,0	10.700.040.120	500
	14,0	8,5 - 11,0	10.700.040.140	500
	16,0	8,5 - 12,5	10.700.040.160	500
	18,0	12,0 - 14,5	10.700.040.180	500
20,0	12,5 - 16,5	10.700.040.200	500	
25,0	15,5 - 21,0	10.700.040.250	500	
30,0	20,5 - 26,0	10.700.040.300	500	
35,0	25,5 - 31,0	10.700.040.350	500	
40,0	30,5 - 35,0	10.700.040.400	500	

dk 8,0 -1,0 dm 2,0 k 1,0 ±0,3 4,1 mm 1250 N 1800 N

Many ALFO® dimensions are available as FERRO® version. In this speciality the major part of the mandrel remains in the shank to increase the shear strength.



d	l ⁺¹		Nr.	
4,8	6,0	1,0 - 3,0	10.700.048.060	500
	8,0	2,5 - 5,0	10.700.048.080	500
	9,0	2,5 - 6,0	10.700.048.090	500
	10,0	4,0 - 6,5	10.700.048.100	500
	12,0	6,0 - 8,0	10.700.048.120	500
	14,0	7,5 - 10,0	10.700.048.140	500
	16,0	8,0 - 12,0	10.700.048.160	500
	18,0	11,5 - 13,5	10.700.048.180	500
	20,0	12,0 - 15,5	10.700.048.200	500
	25,0	15,0 - 20,5	10.700.048.250	500
	30,0	20,0 - 25,0	10.700.048.300	500
	35,0	24,5 - 29,5	10.700.048.350	250
	40,0	29,0 - 34,5	10.700.048.400	250
	45,0	34,0 - 39,5	10.700.048.450	250
50,0	39,0 - 44,5	10.700.048.500	100	
55,0	44,0 - 49,5	10.700.048.550	100	

d_k 9,5 -1,0 **d_m 2,7** **k 1,1 ±0,3** 4,9 mm 1640 N 2200 N

5,0	6,0	1,0 - 3,0	10.700.050.060	500
	8,0	2,5 - 5,0	10.700.050.080	500
	10,0	4,0 - 6,5	10.700.050.100	500
	12,0	6,0 - 8,0	10.700.050.120	500
	14,0	7,5 - 10,0	10.700.050.140	500
	16,0	8,0 - 12,0	10.700.050.160	500
	18,0	11,5 - 13,5	10.700.050.180	500
	20,0	12,0 - 15,5	10.700.050.200	500
	25,0	15,0 - 20,5	10.700.050.250	500
	30,0	20,0 - 25,0	10.700.050.300	500
	35,0	24,5 - 30,0	10.700.050.350	250
	40,0	29,0 - 35,0	10.700.050.400	250
	45,0	34,5 - 40,0	10.700.050.450	250
	50,0	39,5 - 45,0	10.700.050.500	250

d_k 9,5 -0,8 **d_m 2,7** **k 1,1 ±0,3** 5,1 mm 1820 N 2400 N

d	l ⁺¹		Nr.	
6,0	8,0	1,0 - 3,5	10.700.060.080	500
	10,0	3,0 - 5,5	10.700.060.100	500
	12,0	5,0 - 7,5	10.700.060.120	500
	16,0	7,0 - 11,0	10.700.060.160	500
	18,0	10,5 - 13,0	10.700.060.180	500
	20,0	11,0 - 15,0	10.700.060.200	500
	22,0	14,5 - 17,0	10.700.060.220	500
	25,0	15,0 - 20,0	10.700.060.250	250
	28,0	19,5 - 22,5	10.700.060.280	250
	30,0	20,0 - 25,0	10.700.060.300	250
	50,0	38,0 - 43,0	10.700.060.500	250

d_k 12,0 -1,2 **d_m 3,2** **k 1,5 ±0,4** 6,1 mm 2660 N 3500 N

6,4	12,0	2,5 - 7,0	10.700.064.120	250
	16,0	6,0 - 11,0	10.700.064.160	250
	18,0	10,0 - 13,0	10.700.064.180	250
	20,0	10,0 - 14,5	10.700.064.200	250
	25,0	14,0 - 19,0	10.700.064.250	250
	30,0	18,0 - 24,0	10.700.064.300	250

d_k 13,0 -1,4 **d_m 3,6** **k 1,8 ±0,4** 6,5 mm 2880 N 4600 N

7,8	15,0	4,0 - 9,5	10.700.078.150	250
	18,0	9,5 - 12,5	10.700.078.180	250
	22,0	12,5 - 16,5	10.700.078.220	250
	26,0	16,5 - 20,5	10.700.078.260	250

d_k 14,0 **d_m 3,7** **k 2,0** 8,0 mm 6600 N 9550 N

Small Packages



ALFO® Standard Blind Rivet

Aluminium Steel galvanised
Dome Head | open

d	l ⁺¹		Nr.	
3,0	6,0	1,5 - 4,0	10.700.030.060/31	100
	8,0	3,0 - 6,0	10.700.030.080/31	100
	10,0	5,0 - 7,5	10.700.030.100/31	100
	12,0	7,0 - 9,0	10.700.030.120/31	100

4,0	6,0	1,0 - 3,5	10.700.040.060/31	100
	8,0	3,0 - 5,5	10.700.040.080/31	100
	10,0	5,0 - 7,0	10.700.040.100/31	100
	12,0	6,5 - 9,0	10.700.040.120/31	100

d	l ⁺¹		Nr.	
5,0	8,0	2,5 - 5,0	10.700.050.080/31	100
	10,0	4,0 - 6,5	10.700.050.100/31	100
	12,0	6,0 - 8,0	10.700.050.120/31	100

Additional dimensions are available from stock.

Minimum purchase quantity for all small packs are 10 packing units of each dimension.



ALFO® Standard Blind Rivet

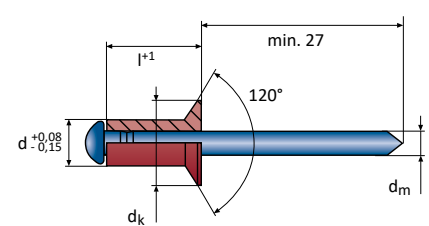
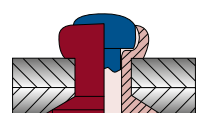
Aluminium  Steel  galvanized
Countersunk Head | open



DIN EN ISO
15978

CAD
DATA
ONLINE

Series
700



3,0 - 3,2 mm EN AW-5019 [AlMg5]

4,0 - 5,0 mm EN AW-5754 [AlMg3]

d	l ⁺¹		Nr.	
3,0	5,0	1,5 - 3,0	10.700.300.050	500
	6,0	2,0 - 4,0	10.700.300.060	500
	8,0	3,5 - 6,0	10.700.300.080	500
	10,0	5,0 - 7,5	10.700.300.100	500

dk 6,0 -0,4 **dm** 1,7 3,1 mm 740 N 1000 N

3,2	6,0	1,5 - 3,5	10.700.320.060	500
	8,0	3,0 - 5,5	10.700.320.080	500
	10,0	5,0 - 7,5	10.700.320.100	500

dk 6,2 -0,4 **dm** 1,9 3,3 mm 750 N 1220 N

4,0	6,0	1,5 - 3,5	10.700.400.060	500
	8,0	2,0 - 5,5	10.700.400.080	500
	10,0	5,0 - 7,0	10.700.400.100	500
	12,0	6,5 - 9,0	10.700.400.120	500
	16,0	8,5 - 12,5	10.700.400.160	500
	18,0	12,0 - 14,5	10.700.400.180	500
	20,0	12,5 - 16,5	10.700.400.200	500

dk 7,5 -0,5 **dm** 2,0 4,1 mm 1250 N 1580 N

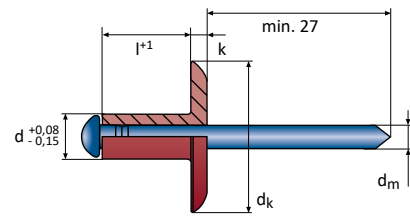
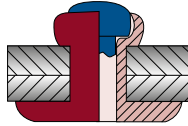
4,8	10,0	4,0 - 6,5	10.700.480.100	500
	12,0	6,0 - 8,0	10.700.480.120	500
	16,0	8,0 - 12,0	10.700.480.160	500
	20,0	12,0 - 15,5	10.700.480.200	500
	25,0	15,0 - 20,5	10.700.480.250	500

dk 9,0 -0,5 **dm** 2,7 4,9 mm 1640 N 2200 N

d	l ⁺¹		Nr.	
5,0	8,0	2,0 - 5,0	10.700.500.080	500
	10,0	4,0 - 6,5	10.700.500.100	500
	12,0	6,0 - 8,0	10.700.500.120	500
	14,0	7,5 - 10,0	10.700.500.140	500
	16,0	8,0 - 12,0	10.700.500.160	500
	20,0	12,0 - 15,5	10.700.500.200	500
	25,0	15,0 - 20,5	10.700.500.250	500
	30,0	20,0 - 25,5	10.700.500.300	500
	35,0	25,0 - 30,0	10.700.500.350	250

dk 9,3 -0,5 **dm** 2,7 5,1 mm 1820 N 2400 N





EN AW-5754 [AlMg3]

d	l ⁺¹	$\frac{k}{d}$	Nr.	
3,2	6,0	1,5 - 3,5	10.730.032.060	500
	8,0	3,0 - 5,5	10.730.032.080	500
	10,0	5,0 - 7,5	10.730.032.100	500
	12,0	7,0 - 9,0	10.730.032.120	500
	16,0	9,0 - 13,0	10.730.032.160	500

dk 9,5^{-0,3} **dm 1,9** **k 1,2**^{+0,5} 3,3 mm $\leftarrow \rightarrow$ 580 N $\left\| \right\|$ 1000 N

4,0	6,0	1,0 - 3,5	10.750.040.060	500
	8,0	3,0 - 5,5	10.750.040.080	500
	10,0	5,0 - 7,0	10.750.040.100	500
	12,0	6,5 - 9,0	10.750.040.120	500
	16,0	8,5 - 12,5	10.750.040.160	500
	18,0	12,0 - 14,5	10.750.040.180	500
	20,0	14,0 - 16,0	10.750.040.200	500

dk 12,0^{-0,3} **dm 2,2** **k 1,5**^{+0,5} 4,1 mm $\leftarrow \rightarrow$ 1250 N $\left\| \right\|$ 2000 N

4,8	8,0	2,0 - 5,0	10.770.048.080	500
	10,0	4,0 - 6,5	10.770.048.100	500
	12,0	6,0 - 8,0	10.770.048.120	500
	16,0	7,5 - 12,0	10.770.048.160	500
	18,0	11,5 - 13,5	10.770.048.180	500
	20,0	12,0 - 15,5	10.770.048.200	250
	25,0	15,0 - 20,5	10.770.048.250	250
	30,0	20,0 - 25,0	10.770.048.300	250

dk 16,0^{-0,3} **dm 2,7** **k 1,8**^{+0,5} 4,9 mm $\leftarrow \rightarrow$ 1640 N $\left\| \right\|$ 2600 N

d	l ⁺¹	$\frac{k}{d}$	Nr.	
5,0	8,0	2,0 - 5,0	10.740.050.080	500
	10,0	4,0 - 6,5	10.740.050.100	500
	12,0	6,0 - 8,0	10.740.050.120	500
	14,0	7,5 - 10,0	10.740.050.140	500
	16,0	8,0 - 12,0	10.740.050.160	500
	18,0	11,5 - 13,5	10.740.050.180	500
	20,0	12,0 - 15,5	10.740.050.200	500
	25,0	15,0 - 20,5	10.740.050.250	500
	30,0	20,0 - 25,0	10.740.050.300	500

dk 11,0^{-0,3} **dm 2,7** **k 1,5**^{+0,5} 5,1 mm $\leftarrow \rightarrow$ 1820 N $\left\| \right\|$ 2800 N

5,0	8,0	2,5 - 5,0	10.760.050.080	500
	10,0	4,0 - 6,5	10.760.050.100	500
	12,0	6,0 - 8,0	10.760.050.120	500
	14,0	7,5 - 10,0	10.760.050.140	500
	16,0	8,0 - 12,0	10.760.050.160	500
	18,0	11,5 - 13,5	10.760.050.180	500
	20,0	12,0 - 15,5	10.760.050.200	500
	25,0	15,0 - 20,5	10.760.050.250	250
	30,0	20,0 - 25,0	10.760.050.300	250

dk 14,0^{-0,3} **dm 2,7** **k 1,5**^{+0,5} 5,1 mm $\leftarrow \rightarrow$ 1820 N $\left\| \right\|$ 2800 N

5,0	10,0	4,0 - 6,5	10.770.050.100	500
	16,0	8,0 - 12,0	10.770.050.160	500
	20,0	12,0 - 15,5	10.770.050.200	250
	25,0	15,0 - 20,5	10.770.050.250	250
	33,0	20,0 - 28,0	10.770.050.330	250

dk 16,0^{-0,3} **dm 2,7** **k 1,8**^{+0,5} 5,1 mm $\leftarrow \rightarrow$ 1820 N $\left\| \right\|$ 2800 N

6,0	16,0	7,0 - 11,0	10.770.060.160	250
	20,0	11,0 - 15,0	10.770.060.200	250

dk 16,0^{-0,3} **dm 3,2** **k 1,8**^{+0,5} 6,1 mm $\leftarrow \rightarrow$ 2660 N $\left\| \right\|$ 3500 N

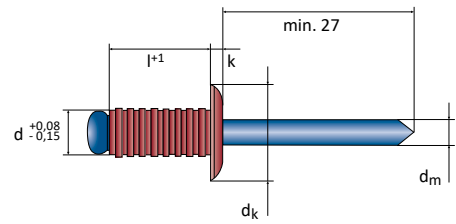
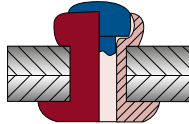


Information on the colour coding of blind rivets can be found from [page 47](#).


ALFO® Standard Blind Rivet -grooved-




 Aluminium
  Steel galvanized

Dome Head | open




CAD
DATA
ONLINESeries
712


EN AW-5754 [AlMg3]




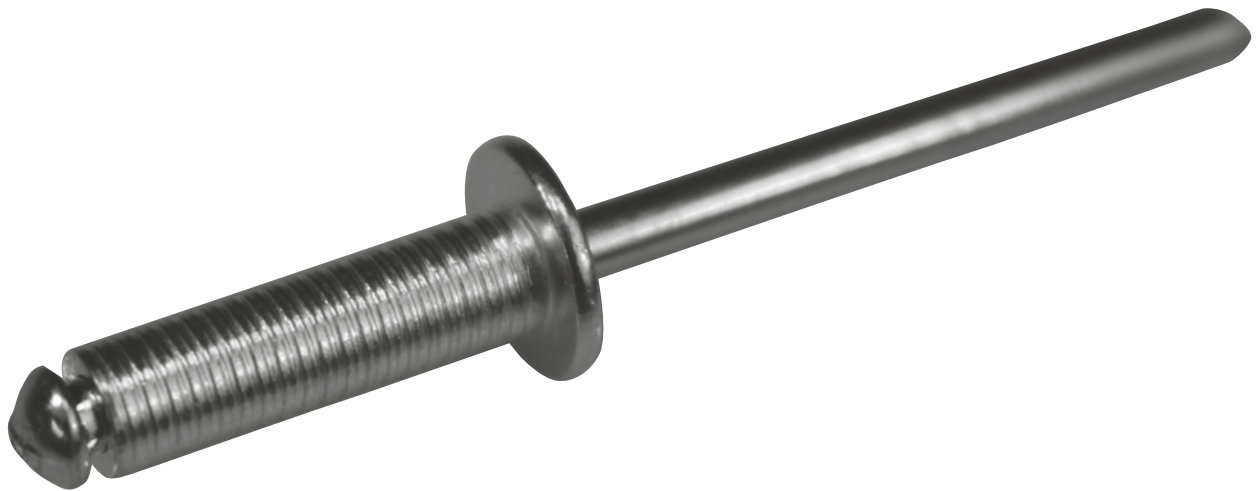
d	l +1	Mindest-bohrlochtiefe	Nr.	
3,2	10,0	13,0	10.712.032.100	500


 $d_k 6,5_{-0,7}$ $d_m 1,7$ $k 0,8_{\pm 0,15}$  3,3 mm  600 N  1000 N

4,0	8,0	11,0	10.712.040.080	500
	12,0	15,0	10.712.040.120	500

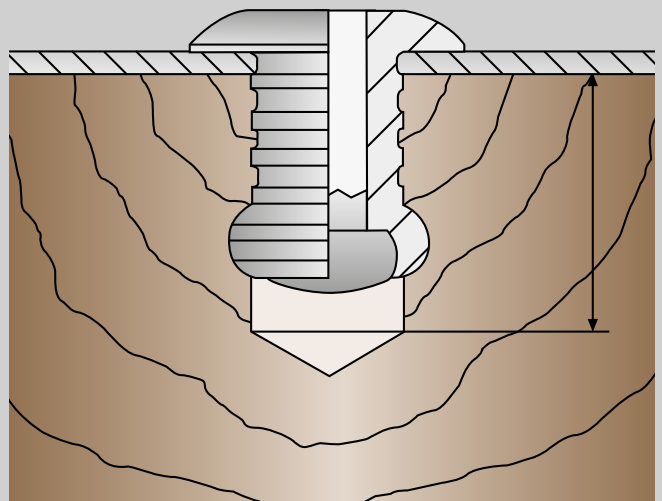
 $d_k 8,0_{-0,7}$ $d_m 2,0$ $k 1,0_{\pm 0,15}$  4,1 mm  1000 N  1350 N

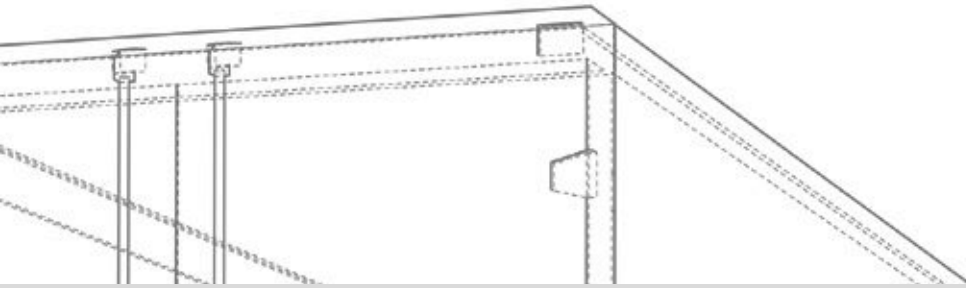
d	l +1	Mindest-bohrlochtiefe	Nr.	
4,8	10,0	14,0	10.712.048.100	500
	16,0	20,0	10.712.048.160	500

 $d_k 9,5_{-0,7}$ $d_m 2,7$ $k 1,1_{\pm 0,15}$  4,9 mm  1350 N  1820 N


 The ALFO® version with grooved rivet shank is perfectly suitable for blind holes. In this case the grooves claw into the environmental material of the bore hole. Please take care of the following instructions:

- Determination of the drilling diameter by trial
- Min. hole depth t = rivet length including mandrel head minus assembly part
- Indicated forces refer to the rivet forces have to be determined by trial.





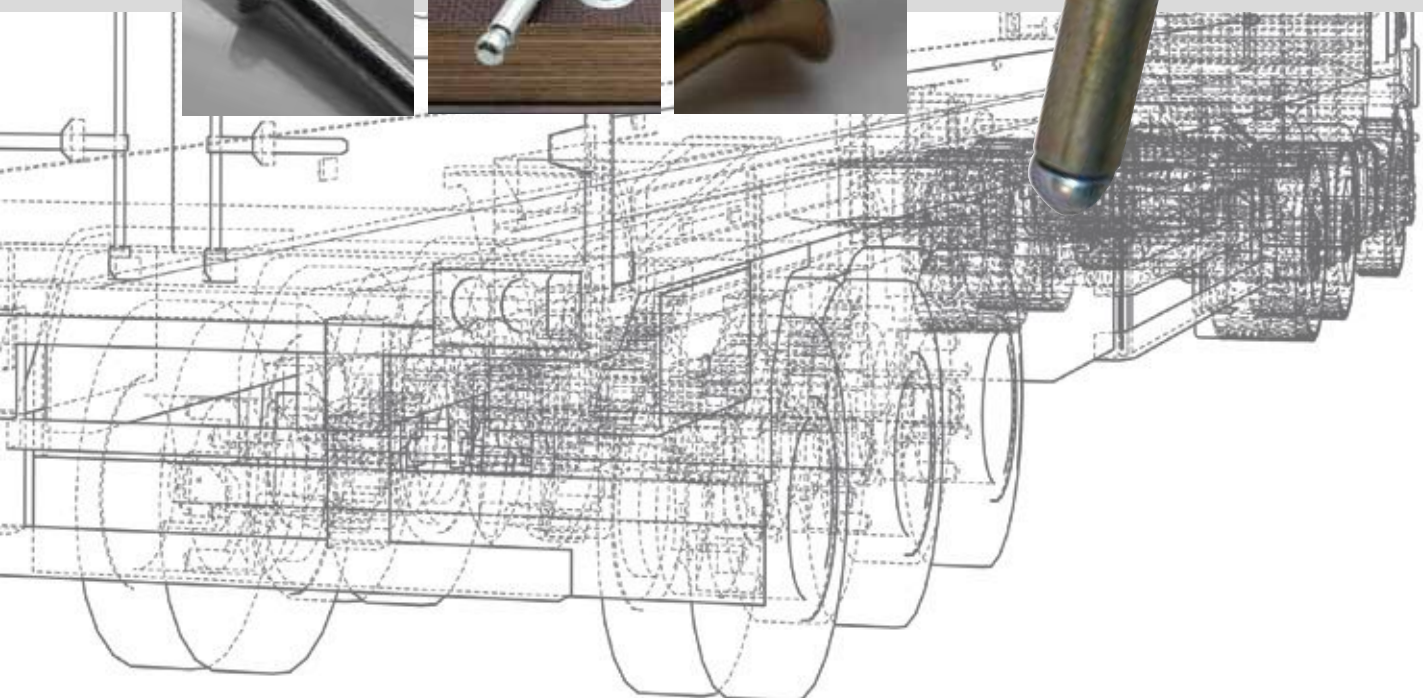
i Production optimisation through application-oriented solutions.

The joining of wooden or plastic floorboards to a metal substructure takes place in all areas of commercial vehicle production, from trailer building through to the production of omnibuses.

An important aspect in addition to the **high strength** of the joint is the **absolutely flush surface without projections**.

A special head form ensures that it is **drawn independently into the part** during setting of the rivet – countersinking of the bore and hence a further work step is eliminated and **simplifies the production process considerably**.

High shear and tensile strengths and the **breakstem that remains in the joint** guarantee a **permanently strong and vibration-resistant joint** that, depending on the form, is **splash water-tight** and thus prevents corrosion.



ALFO® Standard Blind Rivet

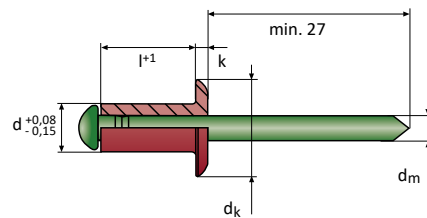
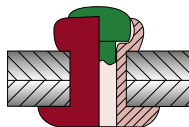
Aluminium  Stainless Steel A2
Dome Head | open



in accordance with
DIN EN ISO
15977

CAD
DATA
ONLINE

Series
702



2,4 - 3,2 mm EN AW-5019 [AlMg5]

4,0 - 6,0 mm EN AW-5754 [AlMg3]

d	l ⁺¹		Nr.	
2,4	4,0	0,5 - 2,0	10.702.024.040	500
	6,0	1,5 - 4,0	10.702.024.060	500
	8,0	3,5 - 6,0	10.702.024.080	500

dk 5,0 -0,7 **dm** 1,5 **k** 0,55 ±0,15 2,5 mm 420 N 660 N

3,0	4,0	0,5 - 2,0	10.702.030.040	500
	5,0	1,0 - 3,0	10.702.030.050	500
	6,0	1,5 - 4,0	10.702.030.060	500
	8,0	3,0 - 6,0	10.702.030.080	500
	10,0	5,0 - 7,5	10.702.030.100	500
12,0	7,0 - 9,0	10.702.030.120	500	

dk 6,3 -0,7 **dm** 1,7 **k** 0,8 ±0,2 3,1 mm 740 N 1000 N

3,2	6,0	1,0 - 3,5	10.702.032.060	500
	8,0	3,0 - 5,5	10.702.032.080	500
	10,0	5,0 - 7,5	10.702.032.100	500
	12,0	7,0 - 9,0	10.702.032.120	500
	16,0	9,0 - 13,0	10.702.032.160	500
20,0	13,0 - 17,0	10.702.032.200	500	

dk 6,5 -0,7 **dm** 1,9 **k** 0,8 ±0,2 3,3 mm 750 N 1220 N

4,0	5,0	0,5 - 2,5	10.702.040.050	500
	6,0	1,0 - 3,5	10.702.040.060	500
	7,0	3,0 - 4,5	10.702.040.070	500
	8,0	3,0 - 5,5	10.702.040.080	500
	10,0	5,0 - 7,0	10.702.040.100	500
	12,0	6,5 - 9,0	10.702.040.120	500
	16,0	8,5 - 12,5	10.702.040.160	500
	18,0	12,0 - 14,5	10.702.040.180	500
	20,0	12,5 - 16,5	10.702.040.200	500
25,0	15,5 - 21,0	10.702.040.250	500	

dk 8,0 -1,0 **dm** 2,0 **k** 1,0 ±0,3 4,1 mm 1250 N 1800 N

4,8	6,0	1,0 - 3,0	10.702.048.060	500
	8,0	2,0 - 5,0	10.702.048.080	500
	10,0	4,0 - 6,5	10.702.048.100	500
	12,0	5,5 - 8,0	10.702.048.120	500
	14,0	7,0 - 10,0	10.702.048.140	500
	16,0	8,0 - 12,0	10.702.048.160	500
20,0	11,5 - 15,5	10.702.048.200	500	

dk 9,5 -1,0 **dm** 2,7 **k** 1,1 ±0,3 4,9 mm 1640 N 2200 N

5,0	6,0	1,0 - 3,0	10.702.050.060	500
	8,0	2,5 - 5,0	10.702.050.080	500
	10,0	4,0 - 6,5	10.702.050.100	500
	12,0	6,0 - 8,0	10.702.050.120	500
	14,0	7,5 - 10,0	10.702.050.140	500
	16,0	8,0 - 12,0	10.702.050.160	500
	18,0	11,5 - 13,5	10.702.050.180	500
	20,0	12,0 - 15,5	10.702.050.200	500
	25,0	15,0 - 20,5	10.702.050.250	500
	30,0	20,0 - 25,0	10.702.050.300	500
35,0	24,5 - 30,0	10.702.050.350	250	
40,0	29,5 - 35,0	10.702.050.400	250	

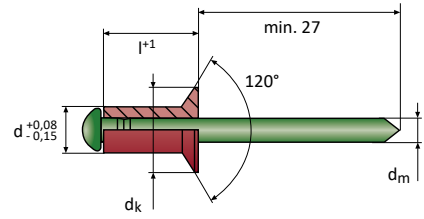
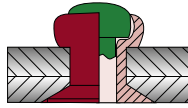
dk 9,5 -0,8 **dm** 2,7 **k** 1,1 ±0,3 5,1 mm 1820 N 2400 N

6,0	10,0	3,0 - 5,5	10.702.060.100	500
	12,0	5,0 - 7,5	10.702.060.120	500
	16,0	7,0 - 11,0	10.702.060.160	500
	18,0	10,5 - 13,0	10.702.060.180	500

dk 12,0 -1,2 **dm** 3,2 **k** 1,5 ±0,4 6,1 mm 2660 N 3500 N

6,4	12,0	2,5 - 7,0	10.702.064.120	250
	16,0	6,0 - 11,0	10.702.064.160	250

dk 12,7 -0,3 **dm** 3,6 **k** 2,3 ±0,2 6,5 mm 2880 N 4600 N



2,4 - 3,0 mm EN AW-5019 [AlMg5]

4,0 - 5,0 mm EN AW-5754 [AlMg3]

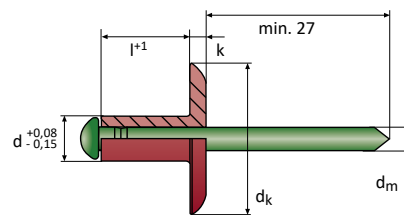
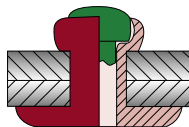
d	l ⁺¹		Nr.	
2,4	6,0	1,5 - 4,0	10.702.240.060	500
3,0	6,0	1,5 - 4,0	10.702.300.060	500
3,0	8,0	3,5 - 6,0	10.702.300.080	500
3,0	10,0	5,0 - 7,5	10.702.300.100	500
dk 4,5 ^{0,2}	dm 1,45	2,5 mm	420 N	660 N
dk 6,0 ^{-0,4}	dm 1,7	3,1 mm	740 N	1000 N

d	l ⁺¹		Nr.		
4,0	6,0	1,5 - 3,5	10.702.400.060	500	
	7,0	2,0 - 4,5	10.702.400.070	500	
	8,0	2,0 - 5,5	10.702.400.080	500	
	10,0	5,0 - 7,0	10.702.400.100	500	
	12,0	6,5 - 9,0	10.702.400.120	500	
5,0	16,0	8,5 - 12,5	10.702.400.160	500	
	dk 7,5 ^{-0,5}	dm 2,0	4,1 mm	1250 N	1580 N
	10,0	2,0 - 6,5	10.702.500.100	500	
	12,0	6,0 - 8,0	10.702.500.120	500	
5,0	16,0	8,0 - 12,0	10.702.500.160	500	
	20,0	12,0 - 15,5	10.702.500.200	500	
dk 9,3 ^{-0,5}	dm 2,7	5,1 mm	1820 N	2100 N	



ALFO® Standard Blind Rivet

Aluminium Stainless Steel A2
Large Dome Head | open



EN AW-5754 [AlMg3]

d	l ⁺¹	$\frac{d}{h}$	Nr.	
5,0	8,0	2,0 - 5,0	10.742.050.080	500
	10,0	4,0 - 6,5	10.742.050.100	500
	12,0	6,0 - 8,0	10.742.050.120	500
	14,0	7,5 - 10,0	10.742.050.140	500
	16,0	8,0 - 12,0	10.742.050.160	500
	20,0	12,0 - 15,5	10.742.050.200	500
	25,0	15,0 - 20,5	10.742.050.250	500
	30,0	20,0 - 25,0	10.742.050.300	500

dk 11,0_{-0,5} **dm 2,7** **k 1,5**_{+0,4} 5,1 mm 1820 N 2500 N

d	l ⁺¹	$\frac{d}{h}$	Nr.	
5,0	8,0	2,0 - 5,0	10.762.050.080	500
	10,0	4,0 - 6,5	10.762.050.100	500
	12,0	6,0 - 8,0	10.762.050.120	500
	14,0	7,5 - 10,0	10.762.050.140	500
	16,0	9,5 - 12,0	10.762.050.160	500
	18,0	11,5 - 13,5	10.762.050.180	500
	20,0	12,0 - 15,5	10.762.050.200	500
	25,0	15,0 - 20,5	10.762.050.250	500
	30,0	20,0 - 25,0	10.762.050.300	250

dk 14,0_{-0,3} **dm 2,7** **k 1,5**_{+0,4} 5,1 mm 1820 N 2500 N

5,0	12,0	6,0 - 8,5	10.772.050.120	500
	16,0	8,0 - 12,0	10.772.050.160	500
	20,0	12,0 - 15,5	10.772.050.200	250
	25,0	15,0 - 20,0	10.772.050.250	250
	33,0	20,0 - 28,0	10.772.050.330	250

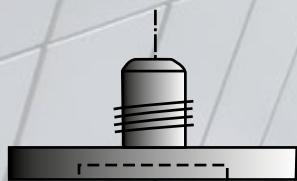
dk 16,0_{-0,3} **dm 2,7** **k 1,5**_{+0,4} 5,1 mm 1820 N 2500 N

To avoid traces of corrosion blind rivets made from aluminium with stainless steel mandrels are used in the outside area. Take care, that the tolerance of the hole is as large as the thermal expansion of the storefront plates.

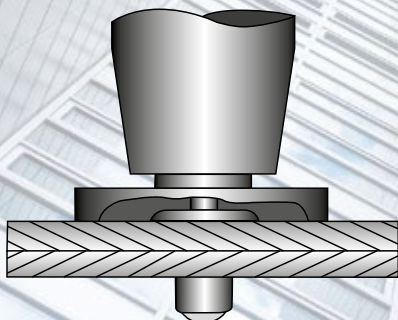
- With special facade nosepieces it is guaranteed that the rivet is placed with a tolerance of 0,3 mm. Rivet and nosepiece should be from one manufacturer.

- The grip range results from the thickness of material plus 2,0 mm to secure a well done closing head.

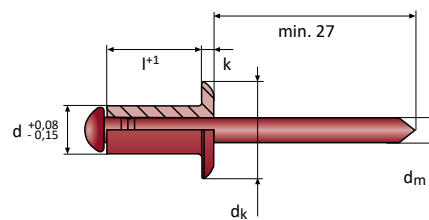
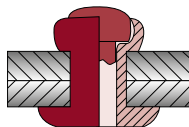
We recommend to **try out the riveting process** in advance!



Pivoting nosepiece



The appropriate facade nosepieces can be found with the respective setting tools.



EN AW-5251 [AlMg2]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,2	6,0	0,5 - 4,0	10.701.032.060	500
	8,0	3,5 - 6,0	10.701.032.080	500
	10,0	5,0 - 8,0	10.701.032.100	500
	12,0	7,0 - 9,0	10.701.032.120	500

dk 6,5 -0,7 dm 2,0 k 0,8 ±0,2 3,3 mm 380 N 670 N

4,0	6,0	1,0 - 3,5	10.701.040.060	500
	8,0	3,0 - 5,5	10.701.040.080	500
	10,0	5,0 - 7,0	10.701.040.100	500
	12,0	6,5 - 9,0	10.701.040.120	500
	16,0	8,5 - 12,5	10.701.040.160	500

dk 8,0 -1,0 dm 2,5 k 1,0 ±0,3 4,1 mm 740 N 1240 N

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,8	8,0	1,0 - 5,0	10.701.048.080	500
	10,0	4,0 - 7,0	10.701.048.100	500
	12,0	6,0 - 8,5	10.701.048.120	500
	14,0	8,0 - 10,5	10.701.048.140	500
	16,0	8,0 - 12,0	10.701.048.160	500
	18,0	12,5 - 14,5	10.701.048.180	500
	20,0	14,5 - 16,5	10.701.048.200	500

dk 9,5 -1,0 dm 2,9 k 1,1 ±0,3 4,9 mm 1140 N 1600 N



Rivdom ONE 16V

THE CORDLESS BATTERY RIVETER

Our up-to-date cordless battery rivet tool with plenty of interesting options and accessories. Detailed information on [▶ page 188](#).

ALFO® Standard Blind Rivet

Steel galvanized Steel galvanized

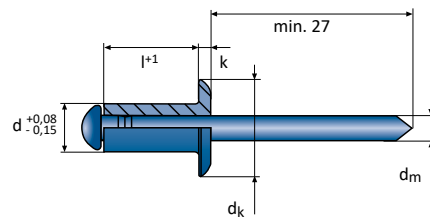
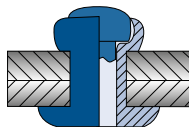
Dome Head | open

DIN EN ISO
15979

CAD
DATA
ONLINE

Series
707

ALFO®



C4C [1.0303]

d	l+1	$\frac{k}{d}$	Nr.	
3,0	5,0	0,5 - 2,5	10.707.030.050	500
	6,0	0,5 - 3,5	10.707.030.060	500
	7,0	2,0 - 4,5	10.707.030.070	500
	8,0	3,0 - 5,5	10.707.030.080	500
	10,0	5,0 - 7,0	10.707.030.100	500
	12,0	6,5 - 9,0	10.707.030.120	500
dk 6,3 -0,7	dm 1,9	k 0,8 ±0,2	3,1 mm 1000 N 1340 N	
3,2	5,0	0,5 - 2,5	10.707.032.050	500
	6,0	0,5 - 3,5	10.707.032.060	500
	8,0	3,0 - 5,5	10.707.032.080	500
	10,0	5,0 - 7,0	10.707.032.100	500
	12,0	6,5 - 9,0	10.707.032.120	500
	14,0	8,5 - 11,0	10.707.032.140	500
dk 6,5 -0,7	dm 2,0	k 0,8 ±0,2	3,3 mm 1180 N 1560 N	
4,0	6,0	0,5 - 3,5	10.707.040.060	500
	7,0	2,0 - 4,5	10.707.040.070	500
	8,0	3,0 - 5,5	10.707.040.080	500
	9,0	4,0 - 6,5	10.707.040.090	500
	10,0	5,0 - 7,0	10.707.040.100	500
	12,0	6,0 - 9,0	10.707.040.120	500
	14,0	8,0 - 11,0	10.707.040.140	500
	16,0	9,0 - 12,5	10.707.040.160	500
18,0	12,0 - 14,5	10.707.040.180	500	
20,0	12,0 - 16,5	10.707.040.200	500	
dk 8,0 -1,0	dm 2,3	k 1,0 ±0,3	4,1 mm 2100 N 2800 N	
4,8	6,0	1,0 - 2,5	10.707.048.060	500
	7,0	1,0 - 3,5	10.707.048.070	500
	8,0	2,5 - 4,5	10.707.048.080	500
	9,0	3,0 - 5,5	10.707.048.090	500
	10,0	4,0 - 6,5	10.707.048.100	500
	12,0	6,0 - 8,5	10.707.048.120	500
	14,0	7,0 - 10,0	10.707.048.140	500
	16,0	8,0 - 12,0	10.707.048.160	500
	18,0	9,0 - 13,5	10.707.048.180	500
	20,0	11,0 - 15,5	10.707.048.200	500
	22,0	13,0 - 17,0	10.707.048.220	500
	25,0	15,0 - 20,0	10.707.048.250	500
30,0	19,5 - 24,5	10.707.048.300	500	
dk 9,5 -1,0	dm 2,7	k 1,1 ±0,3	4,9 mm 3180 N 4220 N	

d	l+1	$\frac{k}{d}$	Nr.	
5,0	8,0	2,5 - 4,5	10.707.050.080	500
	10,0	4,0 - 6,5	10.707.050.100	500
	12,0	6,0 - 8,5	10.707.050.120	500
	14,0	7,0 - 10,5	10.707.050.140	500
	16,0	8,0 - 12,0	10.707.050.160	500
	18,0	10,0 - 13,5	10.707.050.180	500
	20,0	11,0 - 15,0	10.707.050.200	500
	25,0	14,5 - 20,0	10.707.050.250	250
	30,0	19,5 - 25,0	10.707.050.300	250
	35,0	24,5 - 29,5	10.707.050.350	250
40,0	29,0 - 34,0	10.707.050.400	250	
dk 9,5 -0,8	dm 2,9	k 1,1 ±0,3	5,1 mm 3320 N 4740 N	
6,0	10,0	2,0 - 5,5	10.707.060.100	250
	12,0	4,0 - 7,5	10.707.060.120	250
	16,0	7,0 - 11,5	10.707.060.160	250
	20,0	11,0 - 15,0	10.707.060.200	250
	25,0	14,5 - 20,0	10.707.060.250	250
dk 12,0 -1,2	dm 3,6	k 1,5 ±0,4	6,1 mm 4340 N 6000 N	
6,4	8,0	1,0 - 4,0	10.707.064.080	250
	10,0	3,0 - 6,0	10.707.064.100	250
	12,0	3,5 - 7,5	10.707.064.120	250
	16,0	6,0 - 11,5	10.707.064.160	250
	18,0	8,0 - 13,0	10.707.064.180	250
	20,0	9,0 - 14,5	10.707.064.200	250
	25,0	13,0 - 19,5	10.707.064.250	250
	30,0	19,0 - 24,5	10.707.064.300	250
dk 13,0 -1,4	dm 3,8	k 1,8 ±0,4	6,5 mm 4920 N 7000 N	
8,0	14,0	3,0 - 8,5	10.707.080.140	250
	16,0	5,0 - 10,5	10.707.080.160	250
	18,0	8,0 - 12,0	10.707.080.180	100
	20,0	11,5 - 14,0	10.707.080.200	100
dk 20,0 -0,7	dm 4,0	k 2,5 ±0,5	8,1 mm 9400 N 13000 N	

Diameter 8,0 mm not standardized.

Types with large dome head available as multigrip blind rivet OPTO® on page 56.

Further blind rivets made of steel are available as high strength type OPTO®-BULB (page 58), FERRO®-BULB (page 68) or FERRO®-BOLT (page 72).

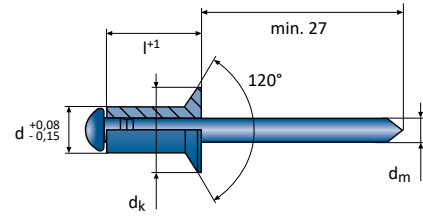
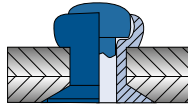
Series
707

CAD
DATA
ONLINE

DIN EN ISO
15980

ALFO® Standard Blind Rivet
Steel galvanized Steel galvanized
Countersunk Head | open

ALFO®



C4C [1.0303]

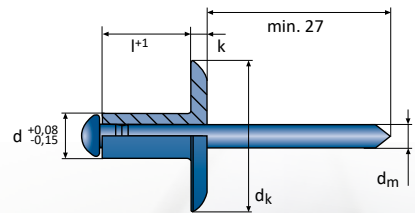
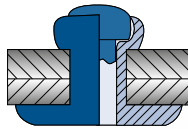
d	l ⁺¹		Nr.	
3,0	6,0	1,5 - 3,5	10.707.300.060	500
	8,0	3,0 - 5,5	10.707.300.080	500
	10,0	5,0 - 7,0	10.707.300.100	500
d_k 6,0 -0,4	d_m 1,9	3,1 mm	1000 N	1340 N
3,2	6,0	1,5 - 3,5	10.707.320.060	500
	8,0	3,0 - 5,5	10.707.320.080	500
d_k 6,2 -0,4	d_m 2,0	3,3 mm	1180 N	1560 N
4,0	6,0	1,5 - 3,5	10.707.400.060	500
	7,0	2,0 - 4,5	10.707.400.070	500
	8,0	3,0 - 5,5	10.707.400.080	500
	10,0	5,0 - 7,0	10.707.400.100	500
	12,0	6,5 - 9,0	10.707.400.120	500
	16,0	8,0 - 12,5	10.707.400.160	500
d_k 7,5 -0,5	d_m 2,3	4,1 mm	2100 N	2800 N

d	l ⁺¹		Nr.	
4,8	8,0	2,0 - 4,5	10.707.480.080	500
	10,0	3,0 - 6,5	10.707.480.100	500
	12,0	5,0 - 8,5	10.707.480.120	500
	14,0	6,5 - 10,0	10.707.480.140	500
	16,0	8,0 - 12,0	10.707.480.160	500
	18,0	9,5 - 13,5	10.707.480.180	500
d_k 9,0 -0,5	d_m 2,7	4,9 mm	3180 N	4220 N
5,0	8,0	2,0 - 4,5	10.707.500.080	500
	10,0	4,0 - 6,5	10.707.500.100	500
	12,0	6,0 - 8,5	10.707.500.120	500
	16,0	8,0 - 12,0	10.707.500.160	500
	20,0	11,0 - 15,5	10.707.500.200	500
	25,0	15,0 - 20,0	10.707.500.250	250
	30,0	19,5 - 25,0	10.707.500.300	250
d_k 9,3 -0,5	d_m 2,9	5,1 mm	3320 N	4740 N
6,4	10,0	3,0 - 5,0	10.707.640.100	250
d_k 13,4 -1,8	d_m 3,8	6,5 mm	4920 N	5700 N

Series
767

CAD
DATA
ONLINE

ALFO® Standard Blind Rivet
Steel galvanized Steel galvanized
Large Dome Head | open



C4C [1.0303]

d	l ⁺¹		Nr.	
4,8	10,0	4,0 - 6,0	10.767.048.100	500
	12,7	6,0 - 8,5	10.767.048.127	500
	16,0	10,0 - 12,0	10.767.048.160	500
	20,0	14,0 - 16,0	10.767.048.200	500
	25,0	16,0 - 21,0	10.767.048.250	500
d_k 14,0 -0,4	d_m 2,9	k 1,5 4,9 mm	2900 N	3850 N

ALFO® Standard Blind Rivet

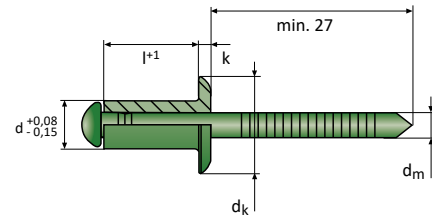
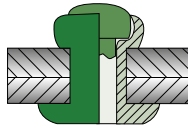
Stainless Steel A2 Stainless Steel A2

Dome Head | open

DIN EN ISO
15983

CAD
DATA
ONLINE

Series
708



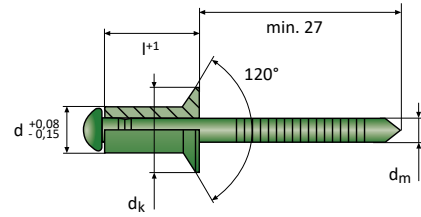
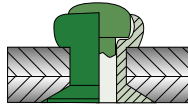
[1.4301]

d	l ⁺¹		Nr.	
2,4	6,0	0,5 - 3,5	10.708.024.060	500
	8,0	3,0 - 5,5	10.708.024.080	500
dk 5,0 -0,2 dm 1,5 k 0,8 ±0,1 2,5 mm 1000 N 1500 N				
3,0	6,0	0,5 - 3,0	10.708.030.060	500
	8,0	3,0 - 5,0	10.708.030.080	500
	10,0	5,0 - 7,0	10.708.030.100	500
	12,0	6,5 - 8,5	10.708.030.120	500
	16,0	8,5 - 12,0	10.708.030.160	500
dk 6,3 -0,7 dm 1,9 k 0,8 ±0,2 3,1 mm 2050 N 2600 N				
3,2	6,0	0,5 - 3,0	10.708.032.060	500
	8,0	3,0 - 5,0	10.708.032.080	500
	10,0	5,0 - 7,0	10.708.032.100	500
	12,0	6,5 - 8,5	10.708.032.120	500
	16,0	8,5 - 12,0	10.708.032.160	500
	18,0	12,0 - 14,0	10.708.032.180	500
dk 6,5 -0,7 dm 1,9 k 0,8 ±0,2 3,3 mm 2050 N 2600 N				
4,0	6,0	1,0 - 2,5	10.708.040.060	500
	8,0	2,5 - 4,5	10.708.040.080	500
	10,0	4,5 - 6,5	10.708.040.100	500
	12,0	6,5 - 8,5	10.708.040.120	500
	14,0	8,5 - 10,5	10.708.040.140	500
	16,0	10,0 - 12,0	10.708.040.160	500
	18,0	12,0 - 14,0	10.708.040.180	500
	20,0	14,0 - 16,0	10.708.040.200	500
25,0	16,0 - 21,0	10.708.040.250	500	
dk 8,0 -1,0 dm 2,5 k 1,0 ±0,3 4,1 mm 2750 N 3550 N				

4,8	8,0	1,5 - 4,0	10.708.048.080	500
	10,0	4,0 - 6,0	10.708.048.100	500
	12,0	6,0 - 8,0	10.708.048.120	500
	14,0	7,0 - 9,5	10.708.048.140	500
	16,0	8,0 - 11,0	10.708.048.160	500
	18,0	11,0 - 13,0	10.708.048.180	500
20,0	13,0 - 16,0	10.708.048.200	500	
dk 9,5 -1,0 dm 2,9 k 1,1 ±0,3 4,9 mm 4250 N 5400 N				
5,0	8,0	2,0 - 4,0	10.708.050.080	500
	10,0	4,0 - 6,0	10.708.050.100	500
	12,0	6,0 - 8,0	10.708.050.120	500
	14,0	7,0 - 9,5	10.708.050.140	500
	16,0	8,0 - 11,0	10.708.050.160	500
	18,0	11,0 - 13,0	10.708.050.180	500
	20,0	13,0 - 15,0	10.708.050.200	500
	25,0	15,0 - 20,0	10.708.050.250	250
	30,0	20,0 - 25,0	10.708.050.300	250
	35,0	25,0 - 30,0	10.708.050.350	250
40,0	30,0 - 35,0	10.708.050.400	250	
dk 9,5 -0,8 dm 2,9 k 1,1 ±0,3 5,1 mm 5000 N 6400 N				
6,0	10,0	2,0 - 5,5	10.708.060.100	250
	12,0	5,5 - 7,5	10.708.060.120	250
	16,0	7,5 - 11,0	10.708.060.160	250
dk 12,0 -1,2 dm 3,8 k 1,5 ±0,4 6,1 mm 6300 N 8250 N				
6,4	10,0	2,5 - 6,0	10.708.064.100	250
	12,0	4,0 - 7,5	10.708.064.120	250
	14,0	6,0 - 9,5	10.708.064.140	250
	16,0	7,5 - 11,5	10.708.064.160	250
	18,0	9,0 - 13,0	10.708.064.180	250
	20,0	12,0 - 14,0	10.708.064.200	250
	25,0	14,0 - 19,0	10.708.064.250	250
	30,0	22,0 - 24,0	10.708.064.300	250
dk 13,0 -1,5 dm 3,8 k 1,8 ±0,4 6,5 mm 7250 N 9335 N				

- The hammer shaped specification of the mandrels head guarantees a **perfect forming of the closing head**.
- Diameters 6,0 and 6,4 are not standardized.

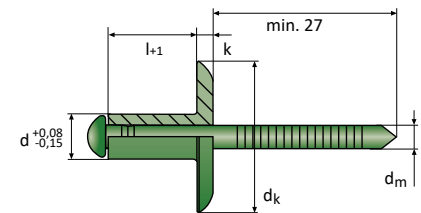
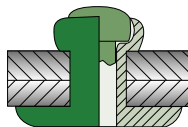




[1.4301]

d	l ⁺¹		Nr.	
3,0	6,0	1,5 - 3,0	10.708.300.060	500
	8,0	3,0 - 5,0	10.708.300.080	500
dk 6,0 -0,4		dm 1,9	3,1 mm	1800 N 2200 N
3,2	6,0	1,5 - 3,0	10.708.320.060	500
	8,0	3,0 - 5,0	10.708.320.080	500
	10,0	5,0 - 7,0	10.708.320.100	500
dk 6,0 -0,4		dm 1,9	3,3 mm	1900 N 2500 N
4,0	6,0	1,0 - 2,5	10.708.400.060	500
	8,0	2,5 - 4,5	10.708.400.080	500
	10,0	4,5 - 6,5	10.708.400.100	500
	12,0	6,5 - 8,5	10.708.400.120	500
	14,0	8,5 - 10,5	10.708.400.140	500
	16,0	10,0 - 12,0	10.708.400.160	500
	18,0	11,5 - 14,0	10.708.400.180	500
20,0	13,5 - 16,0	10.708.400.200	500	
dk 7,5 -0,5		dm 2,5	4,1 mm	2750 N 3550 N

d	l ⁺¹		Nr.	
4,8	8,0	2,0 - 4,0	10.708.480.080	500
	10,0	4,0 - 6,0	10.708.480.100	500
	12,0	6,0 - 8,5	10.708.480.120	500
	16,0	8,0 - 11,0	10.708.480.160	500
dk 9,0 -0,5		dm 2,9	4,9 mm	4250 N 5400 N
5,0	8,0	2,0 - 4,0	10.708.500.080	500
	10,0	4,0 - 6,0	10.708.500.100	500
	12,0	6,0 - 8,5	10.708.500.120	500
	16,0	8,0 - 11,0	10.708.500.160	500
dk 9,3 -0,5		dm 2,9	5,1 mm	5000 N 6400 N



[1.4301]

d	l ⁺¹		Nr.	
3,2	6,0	0,5 - 3,0	10.738.032.060	500
	8,0	3,0 - 5,0	10.738.032.080	500
	10,0	5,0 - 7,0	10.738.032.100	500
	12,0	6,5 - 8,5	10.738.032.120	500
	14,0	8,5 - 10,5	10.738.032.140	500
	16,0	10,0 - 12,0	10.738.032.160	500
dk 9,5 -0,3		dm 1,9	k 1,1 ±0,3 3,3 mm	1900 N 2500 N
4,0	8,0	2,5 - 4,5	10.758.040.080	500
	10,0	4,5 - 6,5	10.758.040.100	500
	12,0	6,5 - 8,5	10.758.040.120	500
	14,0	8,5 - 10,5	10.758.040.140	500
	16,0	10,0 - 12,0	10.758.040.160	500
dk 11,5 -0,3		dm 2,5	k 1,9 ±0,3 4,1 mm	2700 N 3500 N

d	l ⁺¹		Nr.	
4,8	10,0	3,5 - 5,5	10.778.048.100	500
	12,0	5,5 - 7,5	10.778.048.120	500
	14,0	6,5 - 9,0	10.778.048.140	500
	16,0	7,5 - 10,5	10.778.048.160	500
	18,0	10,5 - 12,5	10.778.048.180	500
	20,0	12,5 - 15,5	10.778.048.200	250
	25,0	16,5 - 19,5	10.778.048.250	250
	dk 15,3 -0,2		dm 2,9	k 2,3 ±0,4 4,9 mm

ALFO® Standard Blind Rivet

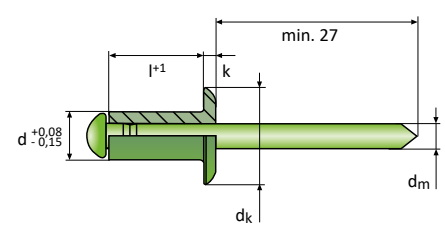
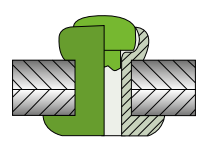
☐ Stainless Steel A2 ⇨ Stainless Steel A4

Dome Head | open

in accordance with DIN EN ISO
15983

CAD
DATA
ONLINE

Series
713



[1.4404]

d	l ⁺¹	☐	Nr.	☐
3,0	6,0	0,5 - 3,0	10.713.030.060	500
	8,0	3,0 - 5,0	10.713.030.080	500
	10,0	5,0 - 7,0	10.713.030.100	500
	12,0	6,5 - 8,5	10.713.030.120	500

d_k 6,3 -0,7 d_m 1,9 k 0,8 ±0,2 ☐ 3,1 mm ⇨ 1760 N ⇨ 2270 N

3,2	6,0	0,5 - 3,0	10.713.032.060	500
	8,0	3,0 - 5,0	10.713.032.080	500
	10,0	5,0 - 7,0	10.713.032.100	500

d_k 6,3 -0,7 d_m 2,0 k 0,8 ±0,2 ☐ 3,3 mm ⇨ 1900 N ⇨ 2500 N

4,0	6,0	1,0 - 2,5	10.713.040.060	500
	8,0	2,5 - 4,5	10.713.040.080	500
	10,0	4,5 - 6,5	10.713.040.100	500
	12,0	6,5 - 8,5	10.713.040.120	500
	16,0	8,5 - 12,0	10.713.040.160	500

d_k 8,0 -1,0 d_m 2,5 k 1,0 ±0,3 ☐ 4,1 mm ⇨ 3500 N ⇨ 4650 N

d	l ⁺¹	☐	Nr.	☐
4,8	6,0	0,5 - 2,0	10.713.048.060	500
	8,0	1,5 - 4,0	10.713.048.080	500
	10,0	4,0 - 6,0	10.713.048.100	500
	12,0	6,0 - 8,0	10.713.048.120	500
	16,0	8,0 - 11,0	10.713.048.160	500

d_k 9,0 -0,8 d_m 3,0 k 1,1 ±0,3 ☐ 4,9 mm ⇨ 4230 N ⇨ 5250 N

5,0	8,0	2,0 - 4,0	10.713.050.080	500
	10,0	4,0 - 6,0	10.713.050.100	500
	12,0	6,0 - 8,0	10.713.050.120	500
	16,0	9,5 - 11,0	10.713.050.160	500
	18,0	11,0 - 13,0	10.713.050.180	500
	20,0	13,0 - 15,0	10.713.050.200	500
	25,0	15,0 - 20,0	10.713.050.250	250
	30,0	20,0 - 25,0	10.713.050.300	250

d_k 9,5 -0,8 d_m 3,2 k 1,1 ±0,3 ☐ 5,1 mm ⇨ 4800 N ⇨ 6600 N

ALFO® Standard Blind Rivet

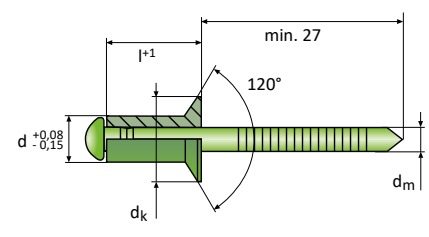
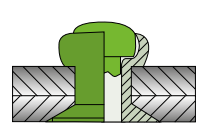
☐ Stainless Steel A2 ⇨ Stainless Steel A4

Countersunk Head | open

in accordance with DIN EN ISO
15984

CAD
DATA
ONLINE

Series
713



[1.4404]

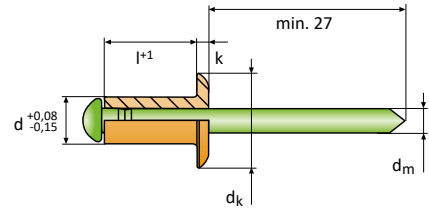
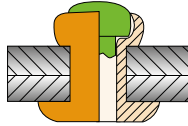
d	l ⁺¹	☐	Nr.	☐
4,0	8,0	2,5 - 4,5	10.713.400.080	500
	10,0	4,5 - 6,5	10.713.400.100	500
	12,0	6,5 - 8,5	10.713.400.120	500

d_k 7,5 -0,5 d_m 2,5 ☐ 4,1 mm ⇨ 3500 N ⇨ 4650 N

According to the higher percentage of molybdenum A4 blind rivets are **more corrosion resistant** than A2 types. Typical fields of application are container construction, food component sub-suppliers, ship- and boat-building or ocean side and off-shore industries.

Many additional details about corrosion can be found on [pages 26/27](#). Please note our new blind rivet nuts in A4 on [page 116](#).





[2.4360]

d	l ⁺¹		Nr.		
3,2	6,0	1,0 - 3,0	10.720.032.060	500	
	8,0	3,0 - 5,0	10.720.032.080	500	
	10,0	5,0 - 7,0	10.720.032.100	500	
dk 6,5 -0,7	dm 1,9	k 0,8 ±0,2	3,3 mm	1600 N	2400 N
4,0	6,0	1,0 - 3,0	10.720.040.060	500	
	8,0	3,0 - 5,0	10.720.040.080	500	
	10,0	5,0 - 7,0	10.720.040.100	500	
	12,0	7,0 - 9,0	10.720.040.120	500	
dk 8,0 -1,0	dm 2,3	k 1,0 ±0,3	4,1 mm	2300 N	3450 N

d	l ⁺¹		Nr.		
4,8	8,0	2,0 - 4,0	10.720.048.080	500	
	10,0	4,0 - 6,0	10.720.048.100	500	
	12,0	6,0 - 8,0	10.720.048.120	500	
	16,0	10,0 - 12,0	10.720.048.160	500	
	20,0	14,0 - 16,0	10.720.048.200	250	
dk 9,5 -1,0	dm 2,9	k 1,1 ±0,3	4,9 mm	3400 N	5000 N
6,4	12,0	4,0 - 6,0	10.720.064.120	250	
	16,0	7,0 - 10,0	10.720.064.160	250	
	18,0	9,0 - 12,0	10.720.064.180	250	
dk 13,0 -1,5	dm 3,8	k 1,8 ±0,4	6,5 mm	5400 N	8200 N

Please note: The rivet sleeve is **additionally galvanised** for optimum corrosion resistance!

Nickel-Copper/Stainless Steel (Ni Cu 30 Fe)

Nickel-copper (named as “Monel”(1) or “Nicros”(2) too) features the **best performance to strength and corrosion resistance** for fastening technology. Because of this outstanding property against salts and acids and similar strength as stainless steel it is often used in off-shore, chemical and food industry. Blind rivets from this material are generally deep drawn from strip. HONSEL/VVG produces these rivets **from wire** thus achieving **higher strength** and realizing an **undetachably rivet mandrel**.

This allows us to meet the strong increase in quality requirements that has taken place in this sector of riveting. **A perfect rivet in all aspects.**

[1] Trademark of INCO Alloys International
[2] Trademark of KRUPP

Good corrosion properties:

- Tap water _____ ✓✓✓
- Neutral and alkaline salts _____ ✓✓✓
- Oxidizing salts _____ ✓✓✓
- Humid and dry gases _____ ✓✓✓
- Saltwater (sea water) _____ ✓✓
- Acidic salts _____ ✓✓
- Mineral acid _____ ✓✓
- Organic acid _____ ✓✓
- Alkalis _____ ✓

very well suited ✓✓✓

well suited ✓✓

suited ✓



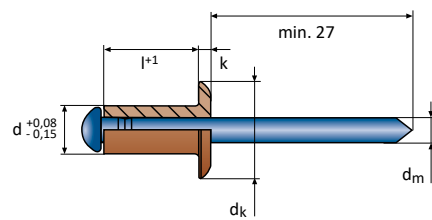
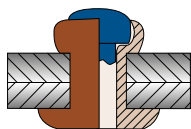
ALFO® Standard Blind Rivet

Copper Steel galvanized
Dome Head | open

DIN EN ISO
16582

CAD
DATA
ONLINE

Series
705



[2.0040]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,0	5,0	0,5 - 2,5	10.705.030.050	500
	6,0	2,0 - 3,0	10.705.030.060	500
	8,0	3,0 - 5,0	10.705.030.080	500
	10,0	5,0 - 7,0	10.705.030.100	500
	12,0	7,0 - 9,0	10.705.030.120	500

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	6,0	2,5 - 3,5	10.705.040.060	500
	8,0	3,5 - 5,0	10.705.040.080	500
	10,0	5,0 - 7,0	10.705.040.100	500

dk 6,3 -0,7 dm 1,7 k 0,8 ±0,2 $\frac{d}{k}$ 3,1 mm $\frac{d}{k}$ 760 N $\frac{d}{k}$ 950 N

dk 8,0 -1,0 dm 2,0 k 1,0 ±0,3 $\frac{d}{k}$ 4,1 mm $\frac{d}{k}$ 1500 N $\frac{d}{k}$ 1800 N

ALFO® Standard Blind Rivet

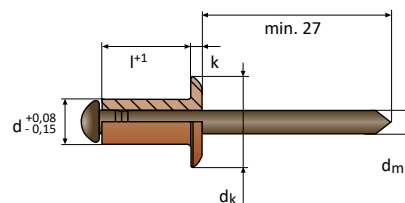
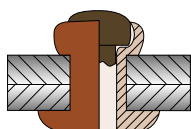
Copper Bronze
Dome Head | open



in accordance with
DIN EN ISO
16582

CAD
DATA
ONLINE

Series
709



[2.0040]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,0	5,0	0,5 - 2,5	10.709.030.050	500
	6,0	2,0 - 3,0	10.709.030.060	500
	8,0	3,0 - 5,0	10.709.030.080	500
	10,0	5,0 - 7,0	10.709.030.100	500

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	6,0	2,0 - 3,5	10.709.040.060	500
	8,0	3,0 - 5,0	10.709.040.080	500
	10,0	5,0 - 7,0	10.709.040.100	500
	12,0	6,5 - 8,5	10.709.040.120	500
	16,0	8,0 - 11,5	10.709.040.160	500

dk 6,3 -0,7 dm 1,7 k 0,8 ±0,2 $\frac{d}{k}$ 3,1 mm $\frac{d}{k}$ 760 N $\frac{d}{k}$ 950 N

dk 8,0 -1,0 dm 2,0 k 1,0 ±0,3 $\frac{d}{k}$ 4,1 mm $\frac{d}{k}$ 1500 N $\frac{d}{k}$ 1800 N

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,2	5,0	0,5 - 2,5	10.709.032.050	500
	6,0	1,5 - 3,5	10.709.032.060	500
	8,0	3,0 - 5,5	10.709.032.080	500
	10,0	5,0 - 7,0	10.709.032.100	500

dk 6,4 -0,5 dm 1,9 k 0,8 ±0,2 $\frac{d}{k}$ 3,3 mm $\frac{d}{k}$ 800 N $\frac{d}{k}$ 1000 N



We bring colour to your world.

The design in terms of colour in visual ranges is more and more important nowadays.

Typical samples are applications curtain fronts, rolling shutters or awning systems.

We offer different types of solutions and produce **exactly the required shade of colour** according to all established scales.

Furthermore we store several hundreds of different types, colours and dimensions of painted or anodized rivets **immediately available** for delivery.

Please ask our sales team that will find the perfect alternative.

Painted ALFO® blind rivets

In this version especially suitable for larger amounts the rivet sleeve is painted with a high-performance surface before assembling with the mandrel.

Detail on ► [page 48](#).



ALFO® blind rivets with painted large head

The perfect solution even for smaller lot sizes with short production periods.

A special painting procedure guarantees a surface of highest quality.



Anodized ALFO® blind rivets

Corresponding to individual requirements we produce anodized rivet sleeves in black or dark bronze colour.



Painted OPTO® multi grip blind rivets

Our standard. We provide two series of OPTO® multigrip blind rivets with large grip ranges in **WHITE (RAL 9010)** or **BLACK (RAL 9005)** - available directly from stock.

Details on ► [page 49](#).



Painted folding blind rivets

Individual colours matched exactly to the specific application.



ALFO® Standard Blind Rivet -painted-

Aluminium Steel galvanized

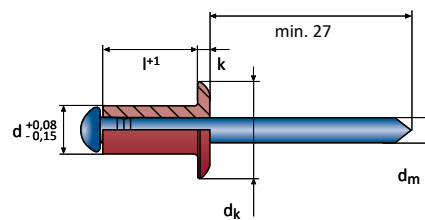
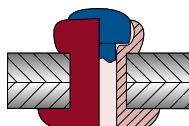
Dome Head | open



in accordance with DIN EN ISO 15977

RAL 9010

Series 700



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	6,0	1,0 - 3,5	10.700.040.060	500
	8,0	3,0 - 5,5	10.700.040.080	500
	10,0	5,0 - 7,0	10.700.040.100	500
	12,0	6,5 - 9,0	10.700.040.120	500

dk 5,0 -0,7 dm 1,5 k 0,6 ±0,15 2,5 mm 380 N 600 N

ALFO® Standard Blind Rivet -painted-

Aluminium Steel galvanized

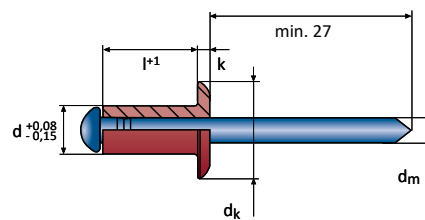
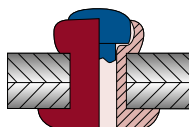
Dome Head | open



in accordance with DIN EN ISO 15977

RAL 9005

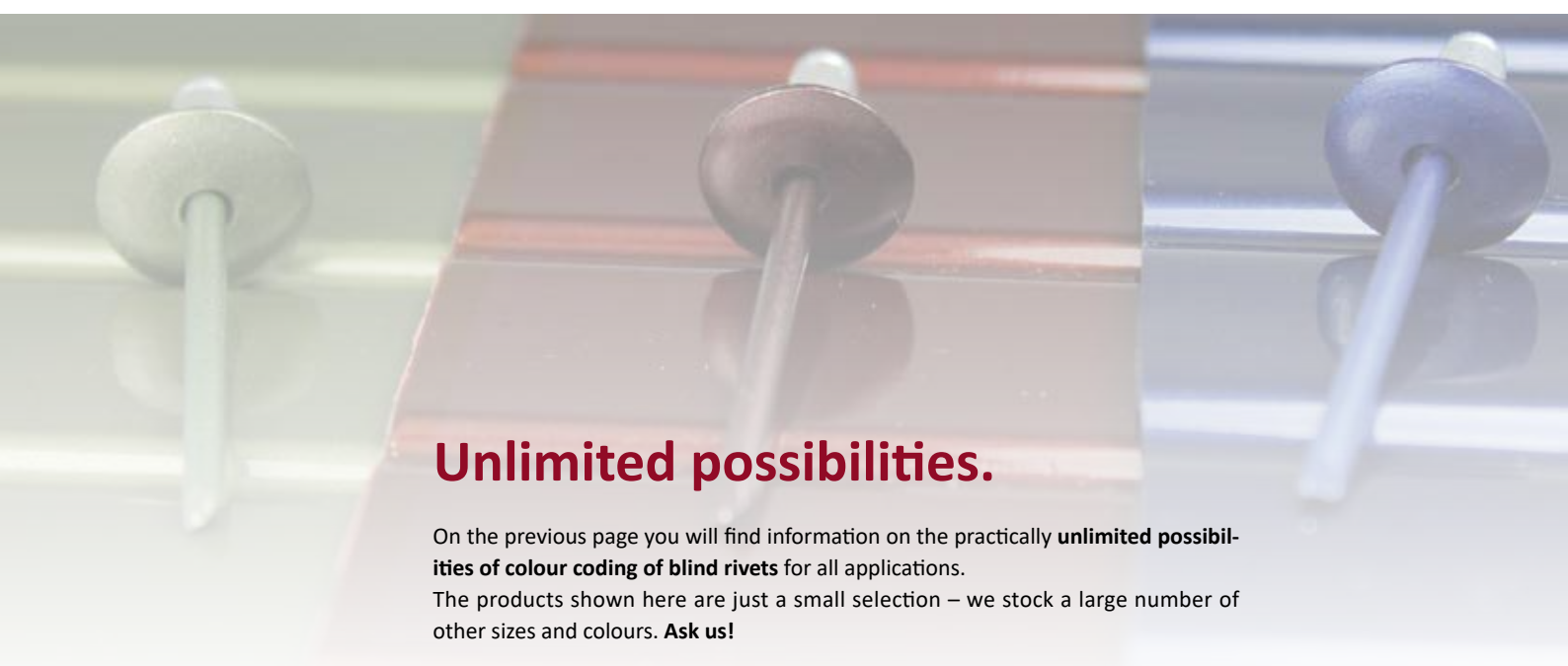
Series 700



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	6,0	1,0 - 3,5	10.700.040.060	500
	8,0	3,0 - 5,5	10.700.040.080	500
	10,0	5,0 - 7,0	10.700.040.100	500
	12,0	6,5 - 9,0	10.700.040.120	500

dk 5,0 -0,7 dm 1,5 k 0,6 ±0,15 2,5 mm 380 N 600 N



Unlimited possibilities.

On the previous page you will find information on the practically **unlimited possibilities of colour coding of blind rivets** for all applications. The products shown here are just a small selection – we stock a large number of other sizes and colours. **Ask us!**

Series
600

CAD
DATA
ONLINE

RAL
9010

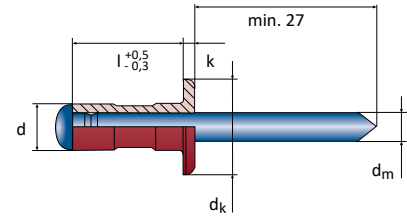
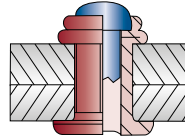
OPTO® Multigrip Blind Rivet -painted-

Aluminium

Steel galvanized

Dome Head | open

OPTO®



EN AW-5052 [AlMg2,5]

d	l ⁺¹	$\frac{+}{-}$	Nr.	
3,2	6,8	0,8 - 3,4	10.600.032.068/9010	500
	8,0	0,8 - 4,8	10.600.032.080/9010	500
	9,5	1,2 - 6,4	10.600.032.095/9010	500
	11,0	4,0 - 7,9	10.600.032.110/9010	500

dk 6,4 dm 1,8 k 1,0 3,3 mm 720 N 1000 N

4,0	6,0	0,5 - 3,0	10.600.040.060/9010	500
	9,5	1,2 - 6,4	10.600.040.095/9010	500
	12,7	4,0 - 9,5	10.600.040.127/9010	500
	16,9	6,4 - 12,7	10.600.040.169/9010	500

dk 7,9 dm 2,3 k 1,2 4,1 mm 1120 N 1650 N

4,8	10,3	1,6 - 6,4	10.600.048.103/9010	500
	15,1	4,8 - 11,1	10.600.048.151/9010	500
	16,9	6,4 - 12,7	10.600.048.169/9010	500
	24,8	12,7 - 19,8	10.600.048.248/9010	500

dk 9,8 dm 2,8 k 1,5 4,9 mm 1530 N 2300 N

Series
600

CAD
DATA
ONLINE

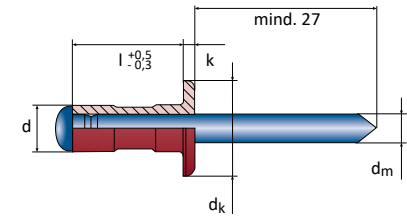
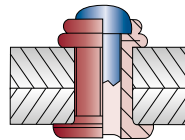
RAL
9005

OPTO® Multigrip Blind Rivet -painted-

Aluminium

Steel galvanized

Dome Head | open



EN AW-5052 [AlMg2,5]

d	l ⁺¹	$\frac{+}{-}$	Nr.	
3,2	6,8	0,8 - 3,4	10.600.032.068/9005	500
	8,0	0,8 - 4,8	10.600.032.080/9005	500
	9,5	1,2 - 6,4	10.600.032.095/9005	500
	11,0	4,0 - 7,9	10.600.032.110/9005	500

dk 6,4 dm 1,8 k 1,0 3,3 mm 720 N 1000 N

4,0	6,0	0,5 - 3,0	10.600.040.060/9005	500
	9,5	1,2 - 6,4	10.600.040.095/9005	500
	12,7	4,0 - 9,5	10.600.040.127/9005	500
	16,9	6,4 - 12,7	10.600.040.169/9005	500

dk 7,9 dm 2,3 k 1,2 4,1 mm 1120 N 1650 N

4,8	10,3	1,6 - 6,4	10.600.048.103/9005	500
	15,1	4,8 - 11,1	10.600.048.151/9005	500
	16,9	6,4 - 12,7	10.600.048.169/9005	500
	24,8	12,7 - 19,8	10.600.048.248/9005	500

dk 9,8 dm 2,8 k 1,5 4,9 mm 1530 N 2300 N

OPTO® MULTIGRIP BLIND RIVET



Adaptable. Flexible.

The all-rounder.

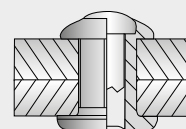
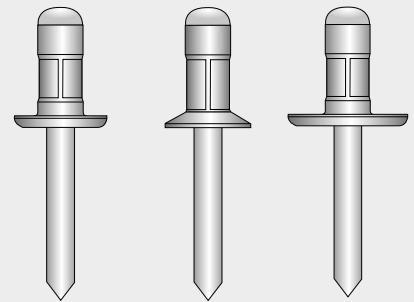
The **OPTO®** multigrip blind rivet can be easily distinguished from a standard blind rivet by its specially formed rivet shaft.

All head forms, painted versions or universal rivets with extended mandrel are available.

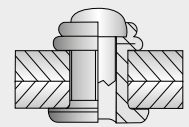
The main characteristic is the **large clamping range** that eliminates the need for several standard blind rivet sizes, thus simplifying work planning and reducing stocks.

Thanks to its special design, it guarantees a range of further outstanding functional properties:

- Excellent bore filling properties
- Positive locking of the mandrel inside the head
- Free from rattling noises
- Dust and splash water-tight

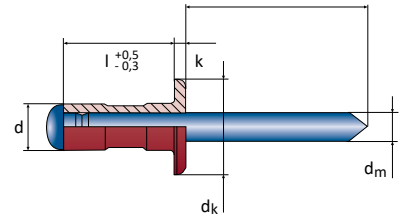
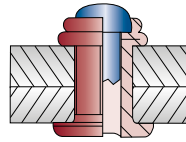


large grip range



low grip range





EN AW-5052 [AlMg2,5]

d	l ⁺¹	$\frac{dk}{d}$	Nr.	
3,2	6,8	0,8 - 3,4	10.600.032.068	500
	8,0	0,8 - 4,8	10.600.032.080	500
	9,5	1,2 - 6,4	10.600.032.095	500
	11,0	4,0 - 7,9	10.600.032.110	500

dk 6,4 dm 1,8 k 1,0 3,3 mm 720 N 1000 N

4,0	6,0	0,5 - 3,0	10.600.040.060	500
	9,5	1,2 - 6,4	10.600.040.095	500
	12,7	4,0 - 9,5	10.600.040.127	500
	16,9	6,4 - 12,7	10.600.040.169	500

dk 7,9 dm 2,3 k 1,2 4,1 mm 1120 N 1650 N

d	l ⁺¹	$\frac{dk}{d}$	Nr.	
4,8	10,3	1,5 - 6,0	10.600.048.103	500
	15,1	4,8 - 11,1	10.600.048.151	500
	16,9	6,4 - 12,7	10.600.048.169	500
	20,0	10,0 - 16,0	10.600.048.200	500
	24,8	12,7 - 19,8	10.600.048.248	500
	30,0	19,0 - 24,0	10.600.048.300	500

dk 9,8 dm 2,8 k 1,5 4,9 mm 1530 N 2300 N

6,4	15,0	2,0 - 8,0	10.600.064.150	250
	20,0	7,0 - 13,0	10.600.064.200	250

dk 12,7 dm 3,7 k 1,9 6,5 mm 2000 N 2500 N

Size 4.0 x 9.5 with **knurled sleeve** as grounding blind rivet on [▶ page 79](#).



Applications for **OPTO®** multigrip blind rivets are to be found in almost every branch of industry, for example in vehicle construction, in AC technology or in container and housing construction.

Furthermore, the OPTO® is outstandingly suitable as a **repair rivet**.

VVG has also successfully developed **special variants for industrial series production** of this blind rivet type, for example with diameters up to 8.0 mm!



We can do MORE multigrips.

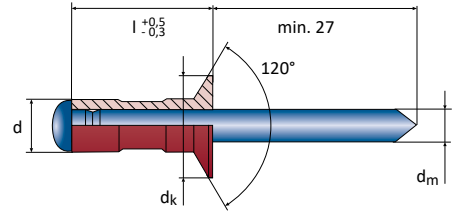
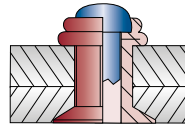


The experience from the development and optimisation of the OPTO® multigrip blind rivet was exploited from a very early stage in the development of the patented OPTO® multigrip blind rivet nuts. These can be found on [▶ pages 90-91](#).



OPTO® Multigrip Blind Rivet

Aluminium Steel galvanized
Countersunk Head | open



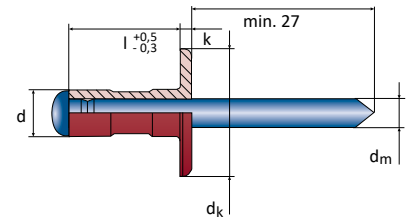
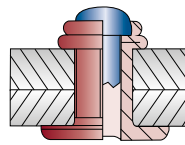
EN AW-5052 [AlMg2,5]

d	l ⁺¹		Nr.	
3,2	9,7	2,4 - 6,4	10.600.320.097	500
d _k 5,4	d _m 1,8	3,3 mm	670 N	900 N
4,0	11,3	2,9 - 7,9	10.600.400.113	500
d _k 7,0	d _m 2,3	4,1 mm	980 N	1320 N

d	l ⁺¹		Nr.	
4,8	16,9	6,4 - 12,7	10.600.480.169	500
d _k 9,0	d _m 2,7	4,9 mm	1500 N	2300 N

OPTO® Multigrip Blind Rivet

Aluminium Steel galvanized
Large Dome Head | open



EN AW-5052 [AlMg2,5]

d	l ⁺¹		Nr.	
3,2	8,0	0,8 - 4,8	10.630.032.080	500
	11,0	4,0 - 7,9	10.630.032.110	500
d _k 9,5	d _m 1,8	k 1,5 3,3 mm	720 N	1000 N
4,0	6,0	1,0 - 3,0	10.650.040.060	500
	9,5	1,2 - 6,4	10.650.040.095	500
	12,7	4,0 - 9,5	10.650.040.127	500
	16,9	6,4 - 12,7	10.650.040.169	500
d _k 12,0	d _m 2,3	k 1,8 4,1 mm	1120 N	1650 N

d	l ⁺¹		Nr.	
4,8	10,3	1,6 - 6,4	10.670.048.103	500
	16,9	6,4 - 12,7	10.670.048.169	500
	24,8	12,7 - 19,8	10.670.048.248	250
	30,0	19,0 - 24,0	10.670.048.300	250
d _k 16,0	d _m 2,8	k 2,1 4,9 mm	1530 N	2300 N



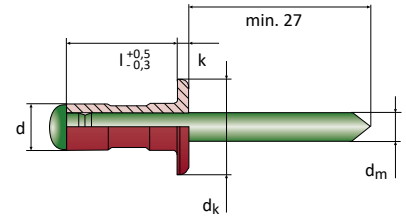
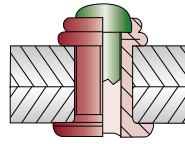
Series
612

CAD
DATA
ONLINE

CERT

OPTO® Multigrip Blind Rivet
Aluminium Stainless Steel A2
Dome Head | open

OPTO®



EN AW-5052 [AlMg2,5]

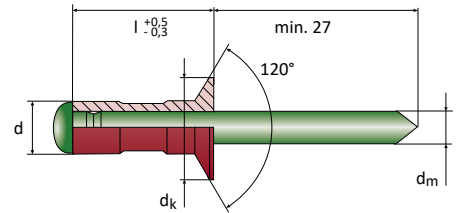
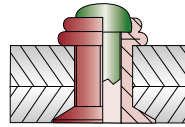
d	l ⁺¹		Nr.	
3,2	8,0	0,8 - 4,8	10.612.032.080	500
	11,0	4,0 - 7,9	10.612.032.110	500
dk 6,4	dm 1,8	k 1,0	3,3 mm	670 N 900 N
4,0	9,5	1,2 - 6,4	10.612.040.095	500
	12,7	4,0 - 9,5	10.612.040.127	500
	16,9	6,4 - 12,7	10.612.040.169	500
dk 7,9	dm 2,3	k 1,2	4,1 mm	980 N 1320 N

d	l ⁺¹		Nr.	
4,8	10,3	1,6 - 6,4	10.612.048.103	500
	15,1	4,8 - 11,1	10.612.048.151	500
	16,9	6,4 - 12,7	10.612.048.169	500
	24,8	12,7 - 19,8	10.612.048.248	500
dk 9,8	dm 2,8	k 1,5	4,9 mm	1530 N 2300 N

Series
612

CAD
DATA
ONLINE

OPTO® Multigrip Blind Rivet
Aluminium Stainless Steel A2
Countersunk Head | open



EN AW-5052 [AlMg2,5]

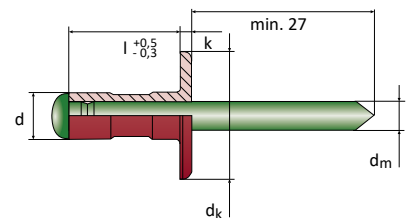
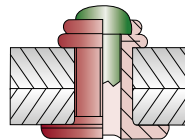
d	l ⁺¹		Nr.	
4,0	9,7	1,2 - 6,4	10.612.400.097	500
	12,7	4,3 - 9,5	10.612.400.127	500
dk 7,5	dm 2,1	k 1,0	4,1 mm	950 N 1500 N

d	l ⁺¹		Nr.	
4,8	12,1	4,0 - 8,0	10.612.480.121	500
dk 9,0	dm 2,7	k 1,5	4,9 mm	1200 N 1700 N

Series
**652
672**

CAD
DATA
ONLINE

OPTO® Multigrip Blind Rivet
Aluminium Stainless Steel A2
Large Dome Head | open



EN AW-5052 [AlMg2,5]

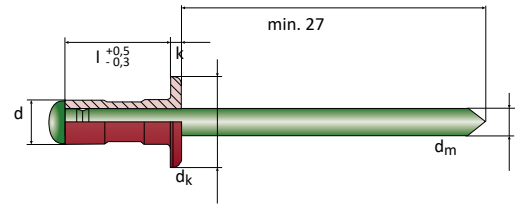
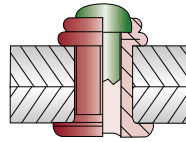
d	l ⁺¹		Nr.	
4,0	9,5	1,2 - 6,4	10.652.040.095	500
dk 12,0	dm 2,3	k 1,5	4,1 mm	980 N 1320 N

d	l ⁺¹		Nr.	
4,8	10,3	1,6 - 6,4	10.672.048.103	500
	16,9	6,4 - 12,7	10.672.048.169	500
	24,8	12,7 - 19,8	10.672.048.248	250
dk 16,0	dm 2,8	k 1,8	4,9 mm	1530 N 2300 N









OPTO® Multigrip Blind Rivet -verlängerter Dorn-






Aluminium  Stainless Steel A2 

Dome Head | open

CAD
DATA
ONLINESeries
622

EN AW-5052 [AlMg2,5]

d	l ⁺¹		Nr.		
3,2	8,0	0,8 - 4,8	10.622.032.080	500	
	11,1	4,0 - 7,9	10.622.032.111	500	
d _k 6,4	d _m 1,8	k 1,0	 3,3 mm	 670 N	 900 N
4,0	9,5	1,2 - 6,4	10.622.040.095	500	
	16,9	4,0 - 9,5	10.622.040.169	500	
d _k 7,9	d _m 2,3	k 1,2	 4,1 mm	 980 N	 1320 N

d	l ⁺¹		Nr.		
4,8	10,3	1,5 - 6,0	10.622.048.103	500	
	16,9	4,8 - 11,1	10.622.048.169	500	
d _k 9,8	d _m 2,8	k 1,5	 4,9 mm	 1530 N	 2300 N

Extended nose pieces 20 mm (diameter 7mm)

BZ 103 A (and precursors) / Battery riveter RivdomONE

Blindniete 3,0/3,2 mm	321.103.932.200
Blindniete 4,0 mm	321.103.940.200
Blindniete 4,8/5,0 mm	321.103.950.200

BZ 123 A (and precursors)

Blindniete 4,0 mm	321.123.940.200
Blindniete 4,8/5,0 mm	321.123.950.200
Blindniete 6,0 mm	321.123.960.200
Blindniete 6,4 mm	321.123.964.200



The universal rivet for use with extended nose pieces for recessed riveting points.

Other blind rivet types and sizes with extended mandrel available on demand!



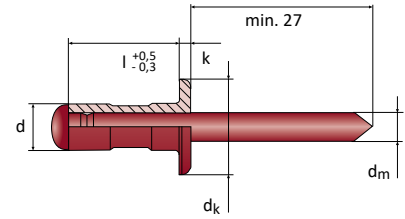
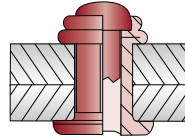
Series
601

CAD
DATA
ONLINE

OPTO® Multigrip Blind Rivet

Aluminium Aluminium

Dome Head | open



EN AW-5052 [AlMg2,5]

d	l ⁺¹	$\frac{k}{d}$	Nr.		
3,2	8,0	1,0 - 4,7	10.601.032.080	500	
	11,0	4,0 - 7,5	10.601.032.110	500	
dk 6,3	dm 1,9	k 1,0	3,3 mm	280 N	370 N
4,0	9,5	1,5 - 6,4	10.601.040.095	500	
	dk 8,0	dm 2,4	k 1,3	4,1 mm	640 N

d	l ⁺¹	$\frac{k}{d}$	Nr.		
4,8	10,3	1,6 - 6,3	10.601.048.103	500	
	16,9	5,0 - 11,0	10.601.048.169	500	
dk 9,5	dm 2,9	k 1,5	4,9 mm	800 N	1420 N

OPTO®

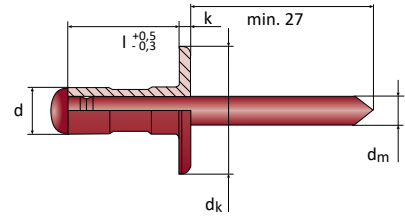
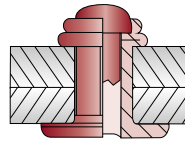
Series
671

CAD
DATA
ONLINE

OPTO® Multigrip Blind Rivet

Aluminium Aluminium

Large Dome Head | open



EN AW-5052 [AlMg2,5]

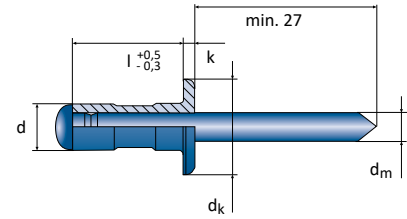
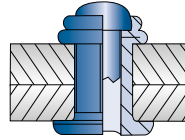
d	l ⁺¹	$\frac{k}{d}$	Nr.		
4,8	10,3	1,6 - 6,3	10.671.048.103	500	
	16,9	5,0 - 11,0	10.671.048.169	500	
	24,8	11,0 - 17,8	10.671.048.248	250	
dk 16,0	dm 2,9	k 2,4	4,9 mm	800 N	1420 N



OPTO® Multigrip Blind Rivet

Steel galvanized Steel galvanized

Dome Head | open

CAD
DATA
ONLINESeries
607

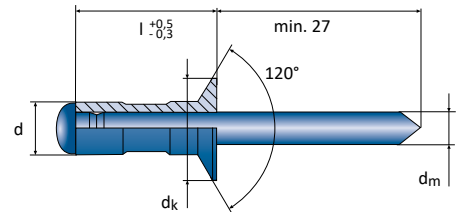
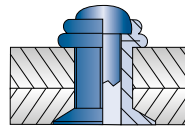
d	l ⁺¹	$\frac{\pm}{\pm}$	Nr.	
3,2	9,0	1,1 - 4,0	10.607.032.090	500
	13,0	1,0 - 9,0	10.607.032.130	500
dk 6,2	dm 2,1	k 0,9	3,3 mm 1500 N 1700 N	
4,0	11,0	2,0 - 6,5	10.607.040.110	500
	14,5	4,5 - 9,0	10.607.040.145	500
dk 8,1	dm 2,7	k 1,2	4,1 mm 1950 N 2350 N	

d	l ⁺¹	$\frac{\pm}{\pm}$	Nr.	
4,8	10,3	1,2 - 4,8	10.607.048.103	500
	14,5	4,0 - 9,0	10.607.048.145	500
	17,5	7,5 - 12,5	10.607.048.175	500
	24,8	12,7 - 19,8	10.607.048.248	500
dk 9,8	dm 2,9	k 1,8	4,9 mm 2700 N 3300 N	
6,4	14,5	1,5 - 7,0	10.607.064.145	250
	20,0	7,0 - 12,5	10.607.064.200	250
dk 12,7	dm 3,8	k 2,2	6,5 mm 6500 N 4200 N	

OPTO® Multigrip Blind Rivet

Steel galvanized Steel galvanized

Countersunk Head | open

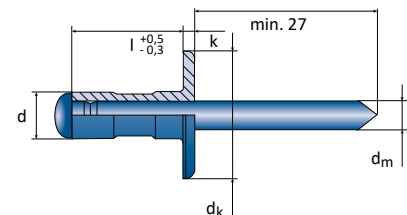
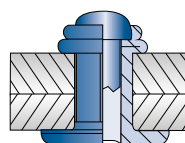
CAD
DATA
ONLINESeries
607

d	l ⁺¹	$\frac{\pm}{\pm}$	Nr.	
4,8	11,0	3,0 - 6,0	10.607.480.110	500
	14,0	4,5 - 7,5	10.607.480.140	500
	17,0	6,5 - 11,5	10.607.480.170	500
dk 9,0	dm 2,9	4,9 mm 2000 N 2900 N		

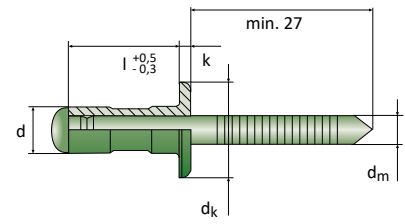
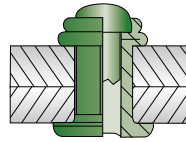
OPTO® Multigrip Blind Rivet









Steel galvanized Steel galvanized






Large Dome Head | open

CAD
DATA
ONLINESeries
677

d	l ⁺¹	$\frac{\pm}{\pm}$	Nr.	
4,8	11,0	1,0 - 6,0	10.677.048.110	500
	16,9	3,0 - 12,0	10.677.048.169	500
dk 16,0	dm 3,4	k 1,6	4,9 mm 2050 N 2940 N	

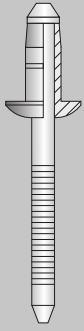


d	l ⁺¹		Nr.	
3,2	8,0	1,0 - 4,0	10.618.032.080	500
	12,0	1,0 - 7,0	10.618.032.120	500
d_k 7,3	d_m 2,1	k 0,9	 3,3 mm  1600 N  2000 N	
4,0	10,0	1,0 - 4,5	10.618.040.100	500
	12,0	2,5 - 6,5	10.618.040.120	500
	15,0	4,5 - 9,5	10.618.040.150	500
d_k 7,9	d_m 2,8	k 1,3	 4,1 mm  2700 N  3500 N	

d	l ⁺¹		Nr.	
4,8	10,3	1,5 - 6,0	10.618.048.103	500
	12,7	2,5 - 7,5	10.618.048.127	500
	15,0	6,5 - 10,5	10.618.048.150	500
	17,5	7,5 - 12,5	10.618.048.175	500
d_k 9,8	d_m 3,4	k 1,8	 4,9 mm  3900 N  5000 N	



MULTIGRIP BLIND RIVET OPTO®-BULB



The high-strength OPTO®-version

Large grip ranges and higher shear and tensile forces

- OPTO®-Bulb is the universal rivet for difficult jobs.

The OPTO®-Bulb is combining the flexibility of multigrip rivets with the excellent strength of the FERRO®-Bulb series. It offers a secure locking of the remaining mandrel as well as a smooth formed closing head.

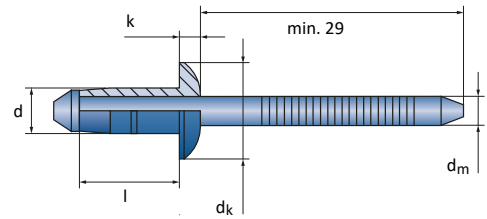
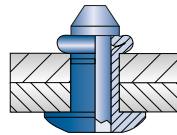
OPTO®-BULB Multigrip Blind Rivet high strength-

Steel galvanized Steel galvanized

Dome Head | open

CAD
DATA
ONLINE

Series
692



d	l ⁺¹		Nr.	
6,4	13,0	1,5 - 5,5	10.692.064.130	250
	17,0	5,0 - 9,0	10.692.064.170	250

dk 13,4 dm 4,1 k 3,1 6,7 - 6,9 mm 11000 N 7800 N

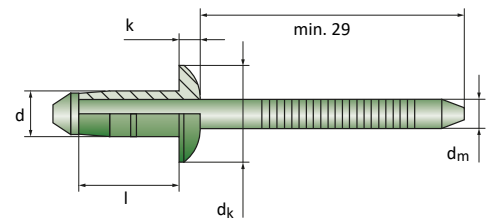
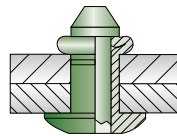
OPTO®-BULB Multigrip Blind Rivet high strength-

Stainless Steel A2 Stainless Steel A2

Dome Head | open

CAD
DATA
ONLINE

Series
691

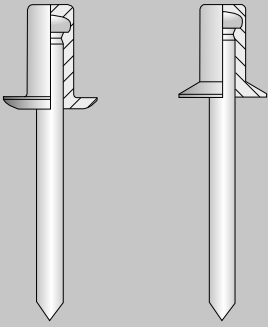


d	l ⁺¹		Nr.	
6,4	13,0	1,5 - 5,5	10.691.064.130	250
	17,0	5,0 - 9,0	10.691.064.170	250

dk 13,4 dm 4,1 k 3,1 6,7 - 6,9 mm 14000 N 8000 N



SEALED BLIND RIVET CERTO®



Due to its closed rivet body the **CERTO®** sealed blind rivets are experts for **liquid tight processing**. The rivets characteristic guarantees a **captive remaining mandrel** and a **smooth, burr-free closing head**, which is perfect for **automated handling**.

The properties mentioned above are the reasons why **CERTO®** sealed blind rivets are the fastening element of choice for the automotive industry, like, e.g. for the purposes of AIRBAG production. Further fields of application can be found in tank and container manufacturing as well as in the construction sector.

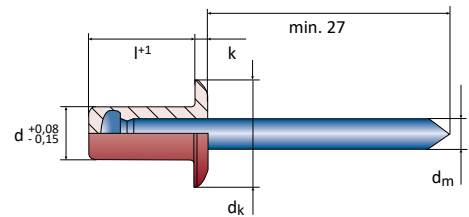
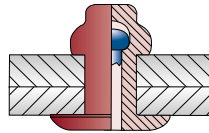
Series
900

CAD
DATA
ONLINE

DIN EN ISO
15973



CERTO® Sealed Blind Rivet
 Aluminium  Steel galvanized
Dome Head | closed



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{k}{d}$	Nr.	
3,2	6,5	0,5 - 2,0	10.900.032.065	500
	8,0	1,5 - 3,5	10.900.032.080	500
	9,5	3,0 - 5,0	10.900.032.095	500
	11,0	4,5 - 6,5	10.900.032.110	500
	12,5	6,0 - 8,0	10.900.032.125	500

dk 6,0 -0,3 dm 1,7 k 1,1 ±0,15 3,3 mm 1100 N 1450 N

4,0	8,0	0,5 - 3,5	10.900.040.080	500
	9,5	3,0 - 5,0	10.900.040.095	500
	11,0	4,5 - 6,5	10.900.040.110	500
	12,5	6,0 - 8,0	10.900.040.125	500
	14,5	7,5 - 10,0	10.900.040.145	500

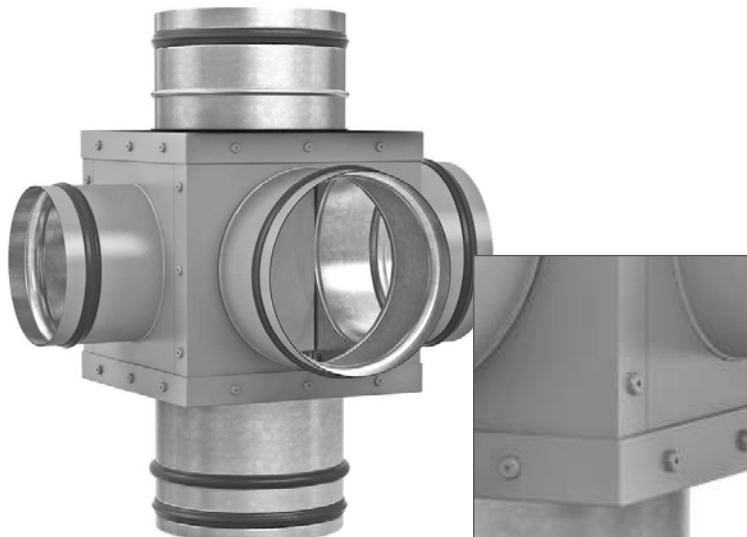
dk 8,0 -0,4 dm 2,2 k 1,3 ±0,2 4,1 mm 1700 N 2700 N

d	l ⁺¹	$\frac{k}{d}$	Nr.	
4,8	8,5	0,5 - 3,5	10.900.048.085	500
	9,5	3,0 - 5,0	10.900.048.095	500
	11,0	4,5 - 6,5	10.900.048.110	500
	13,0	6,0 - 8,0	10.900.048.130	500
	14,5	7,5 - 9,5	10.900.048.145	500
	16,0	9,0 - 11,0	10.900.048.160	500
	18,0	10,5 - 13,0	10.900.048.180	500
	21,0	12,5 - 16,0	10.900.048.210	500
25,0	15,5 - 20,0	10.900.048.250	500	

dk 9,5 -0,4 dm 2,7 k 1,5 ±0,2 4,9 mm 2480 N 3540 N

6,4	12,5	1,5 - 6,5	10.900.064.125	500
	15,5	3,5 - 9,5	10.900.064.155	500

dk 13,0 -0,4 dm 3,7 k 2,0 ±0,3 6,5 mm 3760 N 5460 N



CERTO® Sealed Blind Rivet

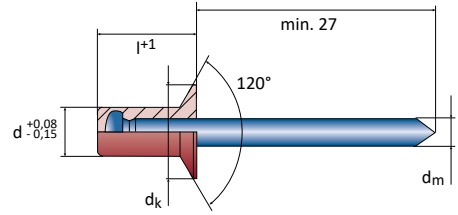
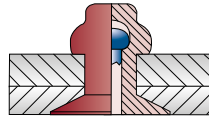
Aluminium Steel galvanized
Countersunk Head | closed



DIN EN ISO
15974

CAD
DATA
ONLINE

Series
900



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{dk}{d}$	Nr.	
3,2	8,0	1,0 - 3,5	10.900.320.080	500
	9,5	2,5 - 5,0	10.900.320.095	500
	11,0	4,0 - 6,5	10.900.320.110	500
	12,5	5,5 - 8,0	10.900.320.125	500

dk 6,0 -0,3 dm 1,7 $\frac{dk}{d}$ 3,3 mm $\leftarrow \rightarrow$ 1100 N $\left\| \right\|$ 1450 N

4,0	9,5	1,5 - 5,0	10.900.400.095	500
	11,0	4,0 - 6,5	10.900.400.110	500
	12,5	6,0 - 8,0	10.900.400.125	500
	14,5	7,5 - 10,0	10.900.400.145	500

dk 8,0 -0,4 dm 2,2 $\frac{dk}{d}$ 4,1 mm $\leftarrow \rightarrow$ 1700 N $\left\| \right\|$ 2700 N

4,8	9,5	1,5 - 5,0	10.900.480.095	500
	11,0	4,0 - 6,5	10.900.480.110	500
	13,0	6,0 - 8,0	10.900.480.130	500
	14,5	7,5 - 9,5	10.900.480.145	500
	16,0	9,0 - 11,0	10.900.480.160	500
	18,0	10,0 - 13,0	10.900.480.180	500
	19,5	11,5 - 14,5	10.900.480.195	500
	21,0	12,5 - 16,0	10.900.480.210	500

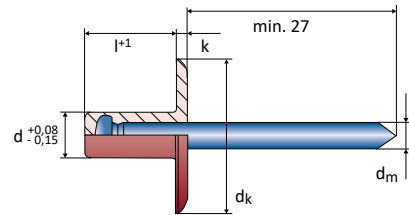
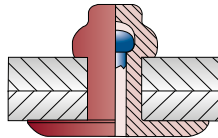
dk 9,5 -0,4 dm 2,7 $\frac{dk}{d}$ 4,9 mm $\leftarrow \rightarrow$ 2480 N $\left\| \right\|$ 3540 N

CERTO® Sealed Blind Rivet

Aluminium Steel galvanized
Large Dome Head | closed

CAD
DATA
ONLINE

Series
960



EN AW-5056 [AlMg5]

d	l ⁺¹	$\frac{dk}{d}$	Nr.	
4,8	13,0	6,0 - 8,0	10.960.048.130	500
	16,0	8,0 - 10,5	10.960.048.160	500
	18,0	10,5 - 13,0	10.960.048.180	500

dk 14,0 dm 2,7 k 2,5 $\frac{dk}{d}$ 4,9 mm $\leftarrow \rightarrow$ 2480 N $\left\| \right\|$ 3540 N



Series
902

CAD
DATA
ONLINE

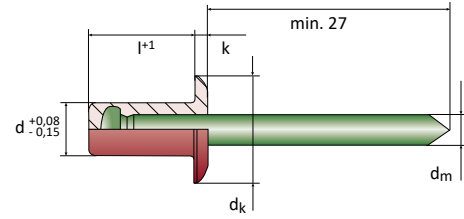
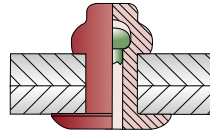
entsprechend
DIN EN ISO
15973

CERT

CERTO® Sealed Blind Rivet

Aluminium Stainless Steel A2
Dome Head | closed

CERTO®



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{h}$	Nr.		
3,2	6,5	0,5 - 2,0	10.902.032.065	500	
	8,0	1,5 - 3,5	10.902.032.080	500	
	9,5	3,0 - 5,0	10.902.032.095	500	
	11,0	4,5 - 6,5	10.902.032.110	500	
	12,5	6,0 - 8,0	10.902.032.125	500	
dk 6,0 -0,3	dm 1,7	k 1,1 ±0,15	3,3 mm	$\leftarrow \rightarrow$ 1100 N	$\left\ \right\ $ 1450 N
4,0	8,0	0,5 - 3,5	10.902.040.080	500	
	9,5	3,0 - 5,0	10.902.040.095	500	
	11,0	4,5 - 6,5	10.902.040.110	500	
	12,5	6,0 - 8,0	10.902.040.125	500	

CERT

d	l ⁺¹	$\frac{d}{h}$	Nr.	
4,8	8,0	0,5 - 3,5	10.902.048.080	500
	9,5	3,0 - 5,0	10.902.048.095	500
	11,0	4,5 - 6,5	10.902.048.110	500
	12,5	6,0 - 8,0	10.902.048.125	500
	14,0	7,5 - 9,5	10.902.048.140	500
	16,0	9,0 - 11,0	10.902.048.160	500
	18,0	10,5 - 13,0	10.902.048.180	500
	21,0	12,5 - 16,0	10.902.048.210	500
	25,0	16,0 - 20,0	10.902.048.250	500

dk 9,5 -0,4 **dm 2,7** **k 1,5 ±0,2** 4,9 mm $\leftarrow \rightarrow$ 2480 N $\left\| \right\|$ 3540 N

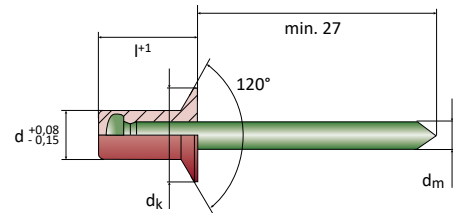
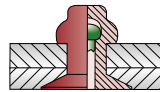
Series
902

CAD
DATA
ONLINE

entsprechend
DIN EN ISO
15974

CERTO® Sealed Blind Rivet

Aluminium Stainless Steel A2
Countersunk Head | closed



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{h}$	Nr.	
4,0	9,5	1,5 - 5,0	10.902.400.095	500
	11,0	4,0 - 6,5	10.902.400.110	500
	12,5	6,0 - 8,0	10.902.400.125	500

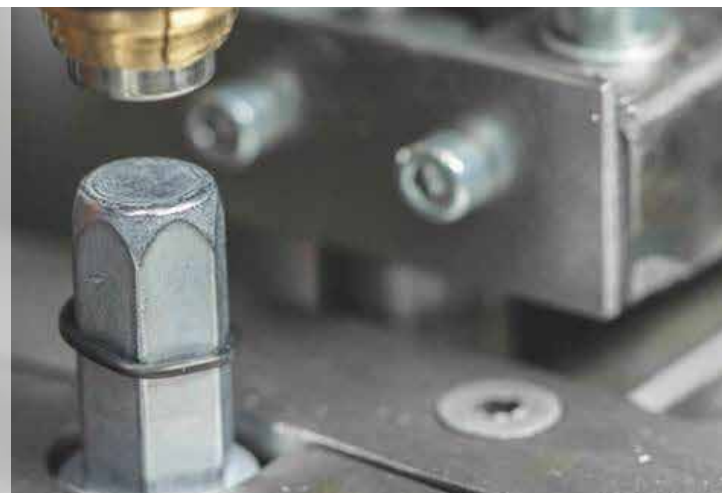
d	l ⁺¹	$\frac{d}{h}$	Nr.		
dk 8,0 -0,3	dm 2,2		4,1 mm	$\leftarrow \rightarrow$ 1700 N	$\left\ \right\ $ 2700 N

Options of additional sealings for closed blind rivet products

Various trials have shown that, during practical deployment, **CERTO®** connections feature excellent **splash water-tightness**. If you need a hydraulic seal or if there is a build up of certain media (e.g. in drainage pipes), an additional seal between the rivet body and component borehole is necessary.

Upon request, **CERTO®** sealed blind rivets can be provided with an additional seal (Neopren® washer).

As a result of the increasing demand for **improved possibilities of sealing** closed end blind rivets and blind rivet nuts, we offer a variety of sealing rings – automatically assembled, not fixed enclosed or with directly applied and certified compounds.



CERTO® Sealed Blind Rivet

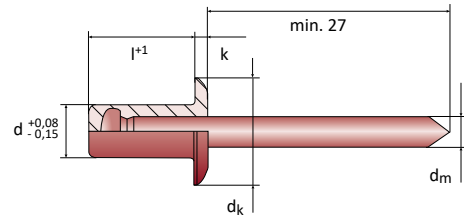
Aluminium Aluminium

Dome Head | closed

DIN EN ISO
15975

CAD
DATA
ONLINE

Series
901



EN AW-1050A [Al99,5]

d	l ⁺¹	$\frac{d}{k}$	Nr.		
3,2	8,0	0,5 - 3,5	10.901.032.080	500	
	9,5	3,5 - 5,0	10.901.032.095	500	
d_k 6,0 -0,3	d_m 1,9	k 1,1 ±0,15	3,3 mm	520 N	540 N
4,0	9,5	0,5 - 5,0	10.901.040.095	500	
	12,5	4,5 - 8,0	10.901.040.125	500	
d_k 8,0 -0,4	d_m 2,2	k 1,3 ±0,2	4,1 mm	720 N	760 N

d	l ⁺¹	$\frac{d}{k}$	Nr.		
4,8	9,5	1,0 - 4,5	10.901.048.095	500	
	11,5	4,0 - 6,5	10.901.048.115	500	
	14,5	6,5 - 9,5	10.901.048.145	500	
	18,0	9,0 - 13,0	10.901.048.180	500	
d_k 9,5 -0,4	d_m 2,7	k 1,5 ±0,2	4,9 mm	1020 N	1420 N

CERTO® Sealed Blind Rivet

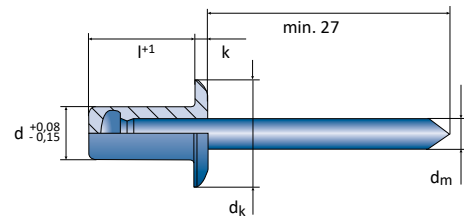
Steel galvanized Steel galvanized

Dome Head | closed

DIN EN ISO
15976

CAD
DATA
ONLINE

Series
907

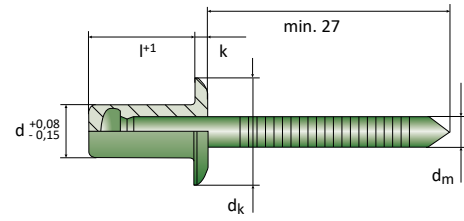
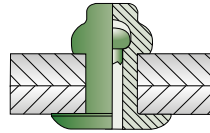


d	l ⁺¹	$\frac{d}{k}$	Nr.		
3,2	6,0	0,5 - 1,5	10.907.032.060	500	
	8,0	1,0 - 3,0	10.907.032.080	500	
	9,5	2,5 - 5,0	10.907.032.095	500	
d_k 6,0 -0,3	d_m 1,9	k 1,0 ±0,3	3,3 mm	1150 N	1300 N
4,0	6,0	0,5 - 1,5	10.907.040.060	500	
	8,0	1,0 - 3,0	10.907.040.080	500	
	9,5	2,5 - 5,0	10.907.040.095	500	
	12,0	4,5 - 6,5	10.907.040.120	500	
	16,0	6,0 - 10,5	10.907.040.160	500	
d_k 8,0 -0,3	d_m 2,3	k 1,4 ±0,3	4,1 mm	1730 N	1860 N

d	l ⁺¹	$\frac{d}{k}$	Nr.		
4,8	8,0	0,5 - 3,0	10.907.048.080	500	
	9,5	2,5 - 5,0	10.907.048.095	500	
	12,0	4,5 - 6,5	10.907.048.120	500	
	16,0	6,0 - 10,5	10.907.048.160	500	
d_k 9,5 -0,3	d_m 2,9	k 1,7 ±0,3	4,9 mm	2400 N	2800 N

Premium class. Certo® sealed blind rivets made of steel covered with a thick-film passivation.

By the use of an adapted thick-film passivation accepted in automotive industries, CERTO® sealed blind rivets made of steel feature an **out-standing corrosion conformity**.



[1.4301]

d	l+1	$\frac{d}{k}$	Nr.	
3,2	6,0	0,5 - 1,5	10.908.032.060	500
	8,0	1,0 - 3,5	10.908.032.080	500
	9,5	2,5 - 5,0	10.908.032.095	500
	12,0	4,5 - 7,0	10.908.032.120	500

dk 6,0 -0,3 dm 1,9 k 1,0 ±0,3 3,3 mm 2000 N 2500 N

4,0	6,0	0,5 - 1,5	10.908.040.060	500
	8,0	1,0 - 3,0	10.908.040.080	500
	9,5	2,5 - 4,5	10.908.040.095	500
	12,0	4,5 - 7,0	10.908.040.120	500
16,0	8,0 - 11,0	10.908.040.160	500	

dk 8,0 -0,3 dm 2,3 k 1,4 ±0,3 4,1 mm 3000 N 4000 N

d	l+1	$\frac{d}{k}$	Nr.	
4,8	8,0	0,5 - 4,0	10.908.048.080	500
	9,5	2,5 - 5,0	10.908.048.095	500
	12,0	4,5 - 7,5	10.908.048.120	500
	16,0	6,0 - 11,0	10.908.048.160	500
	20,0	9,0 - 14,5	10.908.048.200	500

dk 9,5 -0,3 dm 2,9 k 1,7 ±0,3 4,9 mm 4500 N 5500 N

6,4	10,0	2,5 - 5,0	10.908.064.100	250
	12,0	4,5 - 6,5	10.908.064.120	250
	16,0	6,0 - 10,5	10.908.064.160	250
	18,0	7,5 - 11,5	10.908.064.180	250

dk 12,5 -0,3 dm 3,8 k 2,0 ±0,3 6,5 mm 6500 N 8000 N

CERTO® sealed blind rivets made of stainless steel A4

Following the trend to more and more high-grade materials and surfaces, CERTO® sealed blind rivets can be produced in stainless steel quality A4 on request.

Especially in plant and container constructions and all seawater related applications, but even safety-related functions for example in power stations the CERTO® A4 is an excellent fastener solution.

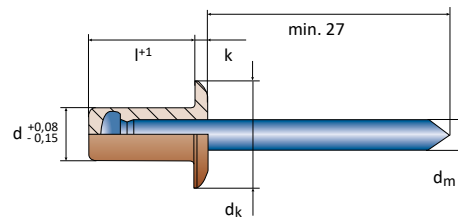
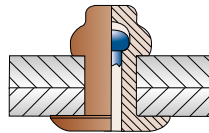


CERTO® Sealed Blind Rivet

Copper Steel galvanized
Dome Head | closed

CAD
DATA
ONLINE

Series
905



[2.0040]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,2	6,5	0,5 - 2,0	10.905.032.065	500
	8,0	1,5 - 3,5	10.905.032.080	500
	9,5	3,0 - 5,0	10.905.032.095	500
	12,5	4,5 - 8,0	10.905.032.125	500

dk 6,0 -0,3 dm 1,7 k 1,1 ±0,15 3,3 mm 970 N 1270 N

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	8,0	0,5 - 3,5	10.905.040.080	500
	10,0	3,0 - 5,0	10.905.040.100	500
4,8	11,5	4,5 - 6,5	10.905.048.115	500

dk 8,0 -0,4 dm 2,2 k 1,3 ±0,2 4,1 mm 1450 N 2300 N

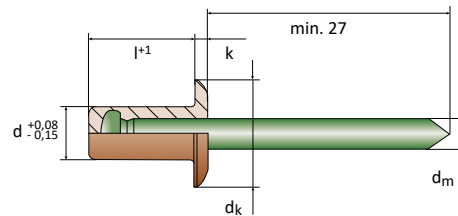
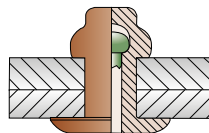
dk 9,5 -0,4 dm 2,7 k 1,5 ±0,2 4,9 mm 2190 N 3280 N

CERTO® Sealed Blind Rivet

Copper Stainless Steel A2
Dome Head | closed

CAD
DATA
ONLINE

Series
906



[2.0040]

d	l ⁺¹	$\frac{d}{k}$	Nr.	
3,2	6,5	0,5 - 2,0	10.906.032.065	500
	8,0	1,5 - 3,5	10.906.032.080	500
	9,5	3,0 - 5,0	10.906.032.095	500
	12,5	4,5 - 8,0	10.906.032.125	500

dk 6,0 -0,3 dm 1,7 k 1,1 ±0,15 3,3 mm 1050 N 1350 N

d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,0	8,0	0,5 - 3,5	10.906.040.080	500
	10,0	3,0 - 5,0	10.906.040.100	500
4,8	9,5	1,0 - 5,0	10.906.048.095	500

dk 8,0 -0,4 dm 2,2 k 1,3 ±0,2 4,1 mm 1450 N 2300 N

dk 9,5 -0,4 dm 2,7 k 1,5 ±0,2 4,9 mm 2190 N 3280 N

CE nosepieces

CERTO® sealed blind rivets can be processed with most standard nosepieces. In order to prevent the formation of burrs even on versions without head recess, however, we also offer the corresponding CE nosepieces. These can be found alongside the corresponding setting tools.



CERTO®-PERFECT. The sealed blind rivet for special demands.

The powerful CERTO®-PERFECT sealed blind rivet forms a **large, uniform blind head** thanks to the special clamping of the mandrel head. This greatly reduces the risk of the rivet being pulled through if the holes in the part are drilled too large, and **increases the process reliability**.

In addition, the **leak-tightness even with standing water** is considerably improved.



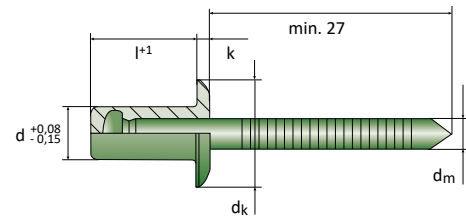
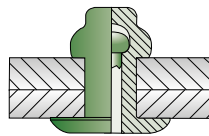
Series
908

CAD
DATA
ONLINE

CERTO® PERFECT Special Sealed Blind Rivet

→ Stainless Steel A2 ← Stainless Steel A2

Dome Head | closed



d	l ⁺¹	$\frac{d}{\pm}$	Nr.	
4,8	12,0	0,5 - 4,5	10.908.048.120/10301	500
	13,7	3,5 - 6,0	10.908.048.137/10301	500

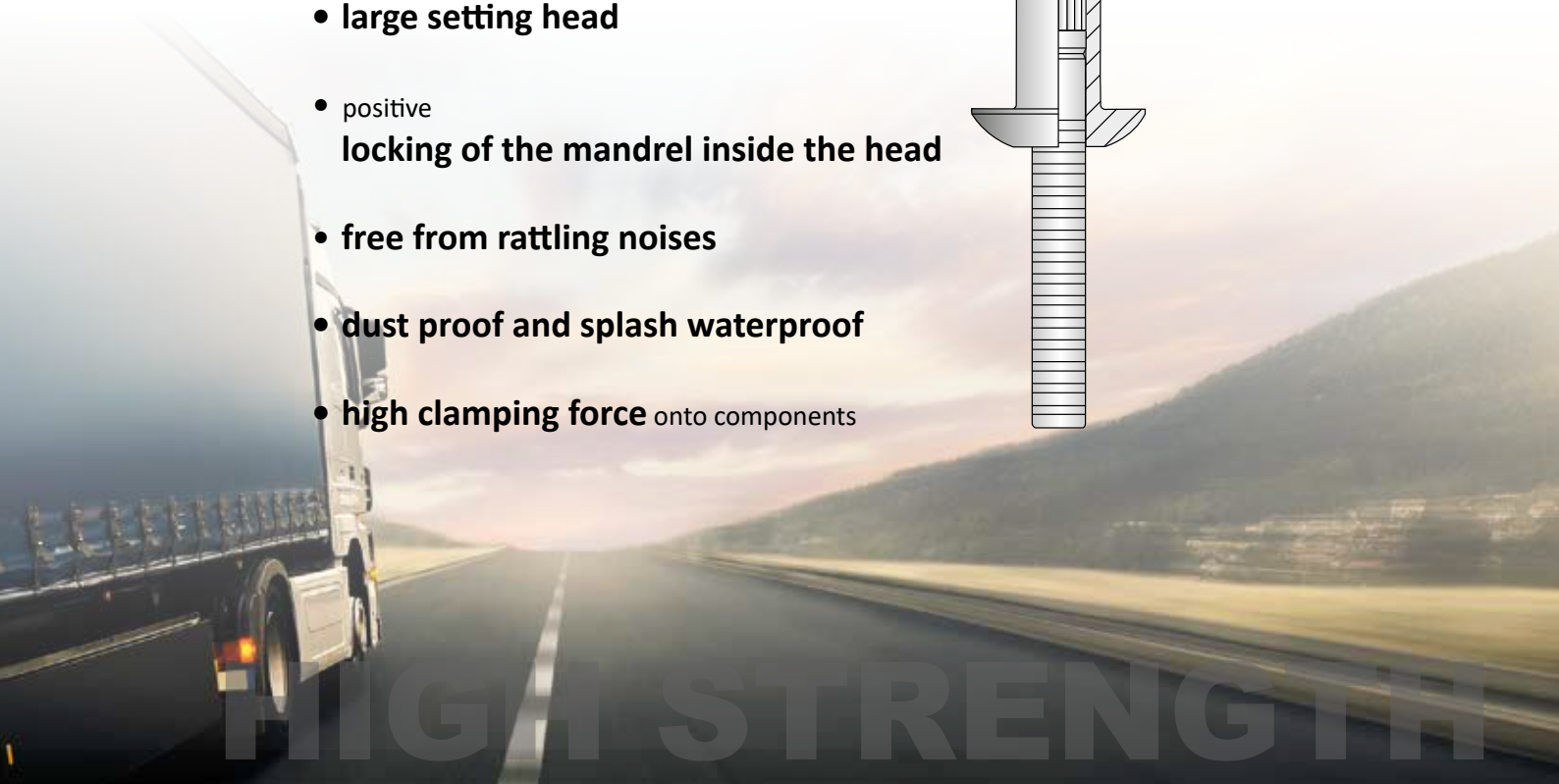
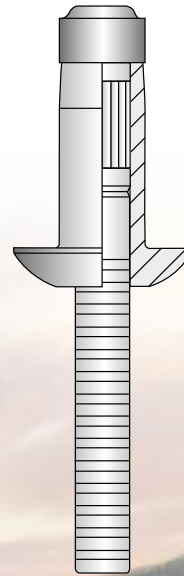
dk 9,5 -0,7 dm 2,9 k 1,3 ±0,15 4,9 mm ←→ 4500 N 5500 N

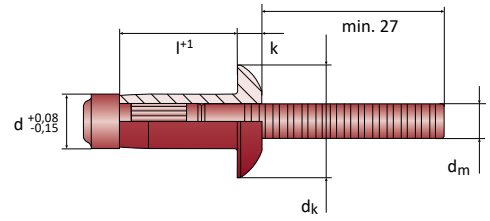
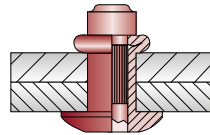


STRUCTURAL BLIND RIVET FERO®-BULB

High-strength blind rivets of type FERO®-BULB are employed in large quantities, particularly in vehicle and container construction, and impress with their combination of the following properties:

- **very high shear strength**
through a captive mandrel
- **large setting head**
- positive **locking of the mandrel inside the head**
- **free from rattling noises**
- **dust proof and splash waterproof**
- **high clamping force** onto components





d	l ⁺¹		Nr.		
6,4	10,5	2,8 - 4,8	10.790.064.105	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	4200 N	3100 N
6,4	12,5	4,8 - 6,8	10.790.064.125	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	4500 N	3100 N
6,4	14,5	6,8 - 8,8	10.790.064.145	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	4600 N	3100 N

d	l ⁺¹		Nr.		
6,4	16,5	8,8 - 10,8	10.790.064.165	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	5000 N	3100 N
6,4	18,5	10,8 - 12,8	10.790.064.185	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	5400 N	3100 N
6,4	20,5	12,8 - 14,8	10.790.064.205	250	
d _k 13,0	d _m 4,2	k 3,0	6,7 - 6,9 mm	5600 N	3100 N



High-strength blind rivets require correspondingly optimised setting tools adapted to the demands of the fastener and the application.

The balance between stroke and setting force plays just as important a role here as the design of the nosepieces or clamping jaws matched to individual grooves.

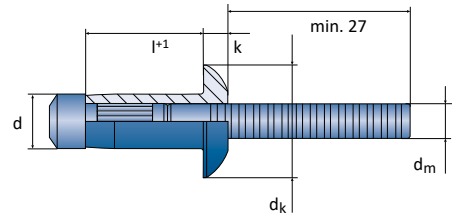
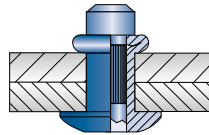
VVG offers solutions in the field of hydraulic and pneumatic riveters, as well as modern cordless tools for mobile use.



FERO®-BULB Structural Blind Rivet

Steel galvanized Steel galvanized

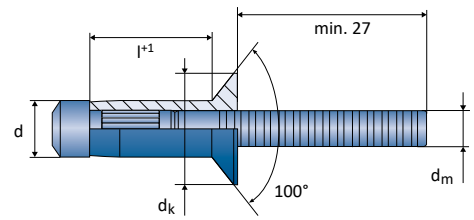
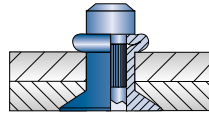
Dome Head | open



d	l ⁺¹		Nr.	
4,8	9,0	1,5 - 3,5	10.792.048.090	500
dk 9,6	dm 3,1	k 1,5 4,9 - 5,1 mm	3600 N	3800 N
4,8	11,5	3,5 - 6,0	10.792.048.115	500
dk 9,6	dm 3,1	k 1,5 4,9 - 5,1 mm	4200 N	3800 N
4,8	14,5	6,0 - 8,5	10.792.048.145	250
dk 9,6	dm 3,1	k 1,5 4,9 - 5,1 mm	5600 N	3800 N
6,4	9,0	1,5 - 3,5	10.792.064.090	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	10000 N	7800 N
6,4	10,5	2,8 - 4,8	10.792.064.105	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	11000 N	7800 N
6,4	12,5	4,8 - 6,8	10.792.064.125	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	12500 N	7800 N
6,4	14,5	6,8 - 8,8	10.792.064.145	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	13000 N	7800 N

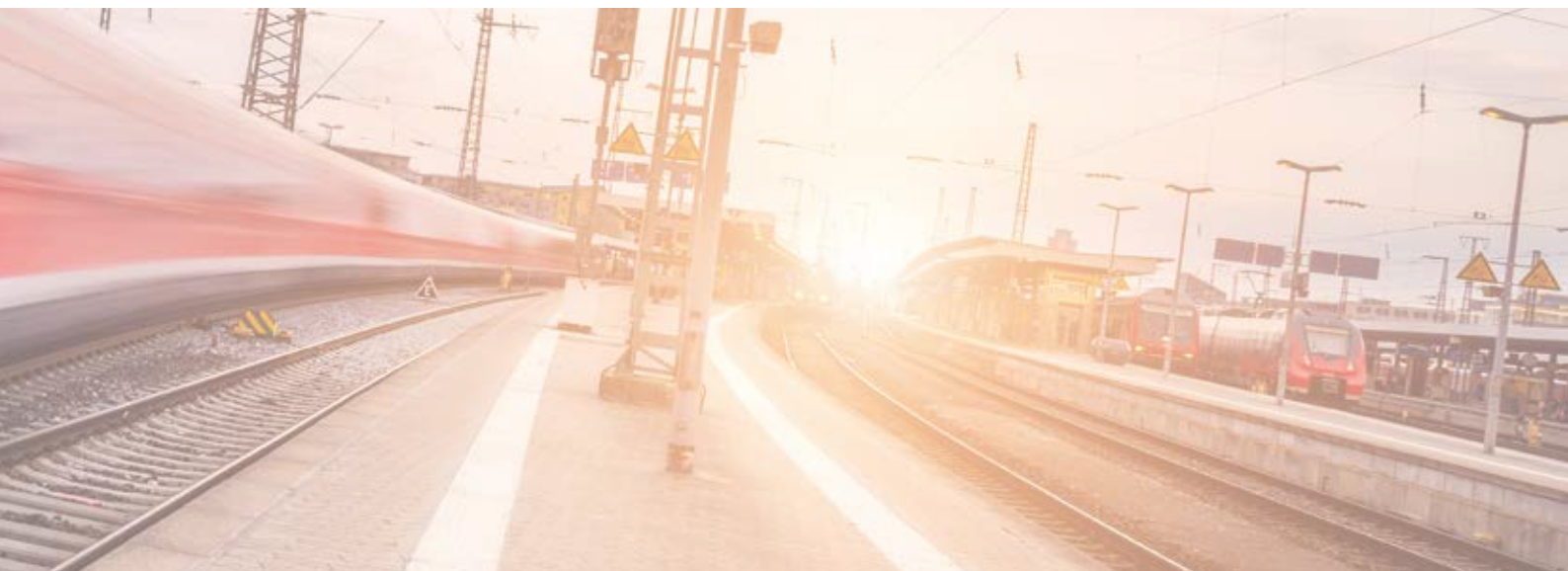
d	l ⁺¹		Nr.	
6,4	16,5	8,8 - 10,8	10.792.064.165	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	14500 N	7800 N
6,4	18,5	10,8 - 12,8	10.792.064.185	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	15000 N	7800 N
6,4	20,5	12,8 - 14,8	10.792.064.205	250
dk 13,4	dm 4,2	k 2,7 6,7 - 6,9 mm	16500 N	7800 N





d	l ⁺¹		Nr.		€ / 1.000
6,4	11,5	3,8 - 5,8	10.792.640.115	250	314,00
d _k 10,0	d _m 4,2	6,7 - 6,9 mm	5300 N	5400 N	
6,4	13,5	5,8 - 7,8	10.792.640.135	250	
d _k 10,0	d _m 4,2	6,7 - 6,9 mm	7300 N	5400 N	
6,4	15,5	7,8 - 9,8	10.792.640.155	250	
d _k 10,0	d _m 4,2	6,7 - 6,9 mm	9300 N	5400 N	

d	l ⁺¹		Nr.	
6,4	17,5	9,8 - 11,8	10.792.640.175	250
	19,5	11,8 - 13,8	10.792.640.195	250
	21,5	13,8 - 15,8	10.792.640.215	250
	23,5	15,8 - 17,8	10.792.640.235	250
d _k 10,0	d _m 4,2	6,7 - 6,9 mm	10300 N	5400 N

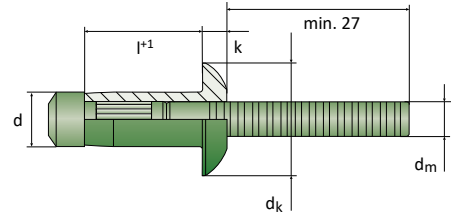
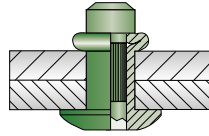


FERO®-BULB Structural Blind Rivet

□ Stainless Steel A2 ↔ Stainless Steel A2
Dome Head | open

CAD
DATA
ONLINE

Series
791



d	l ⁺¹		Nr.	
4,0	7,5	1,0 - 3,0	10.791.040.075	500
	10,0	3,0 - 5,0	10.791.040.100	500
	12,5	5,0 - 7,0	10.791.040.125	500
dk 8,0	dm 2,6	k 1,5 4,1 - 4,3 mm	5200 N 4000 N	
4,8	10,0	1,5 - 3,5	10.791.048.100	500
	12,5	3,5 - 6,0	10.791.048.125	500
	15,5	6,0 - 8,5	10.791.048.155	250
dk 9,6	dm 3,2	k 1,5 4,9 - 5,1 mm	5500 N 5000 N	

d	l ⁺¹		Nr.	
6,4	10,5	2,8 - 4,8	10.791.064.105	250
dk 13,4	dm 3,9	k 2,7 6,7 - 6,9 mm	11500 N 8800 N	
6,4	12,5	4,8 - 6,8	10.791.064.125	250
dk 13,4	dm 3,9	k 2,7 6,7 - 6,9 mm	12500 N 8800 N	
6,4	14,5	6,8 - 8,8	10.791.064.145	250
dk 13,4	dm 3,9	k 2,7 6,7 - 6,9 mm	13000 N 8800 N	
6,4	16,5	8,8 - 10,8	10.791.064.165	250
dk 13,4	dm 3,9	k 2,7 6,7 - 6,9 mm	14000 N 8800 N	
6,4	18,5	10,8 - 12,8	10.791.064.185	250
dk 13,4	dm 3,9	k 2,7 6,7 - 6,9 mm	15000 N 8800 N	



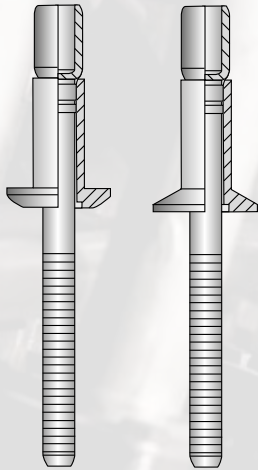
STRUCTURAL BLIND RIVET FERRO®-BOLT

FERRO®-BOLT blind rivets are **the** high-quality connecting element for industrial applications where particular attention is paid to the factor **safety**.

Thanks to its design, the rivet is able to take on a **load-bearing** function.

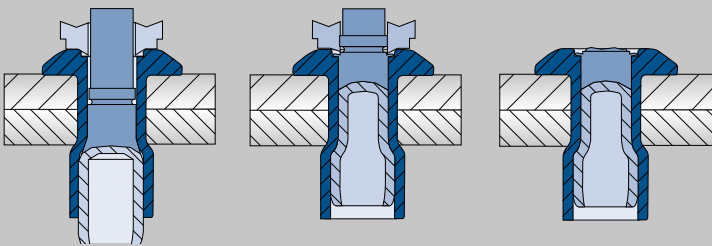
By contrast with other versions on the market, the **locking of the mandrel can be monitored visually**.

Characteristic for the structural blind rivet is the **guaranteed flush shearing** in the area of the setting head.



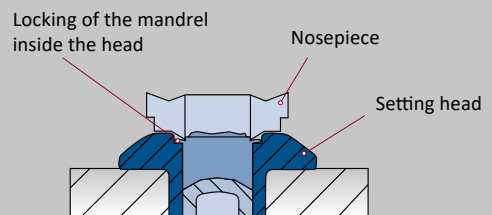
- **Very high shear breaking force** thanks to load-bearing breakstem
- **Very large clamping range**
- Good visual control of the positive **locking of the mandrel inside the head**
- **Vibration-resistant** and **splash water-proof**
- **Very good bore filling properties** and outstanding **compensation of bore tolerances**

Setting sequence:



When the mandrel is pulled back, the head is deformed so that the rivet is adapted perfectly to the parts to be riveted by the wall pressure. The special nosepiece required ensures the functionally safe locking of the mandrel inside the head.

Setting principle:



Available up to 9.8 mm diameter!!



Please note that the tool used must be equipped with the **special nosepiece** shown!

361.121.008.401 4.8 mm nosepiece

361.121.008.601 6.4 mm nosepiece



Our setting tool **BZ 123 A** with a large stroke of 25 mm is available for the processing of the **FERRO®-BOLT** blind rivets.

Further information can be found on ► [page 212](#).



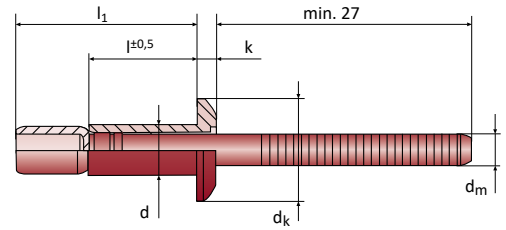
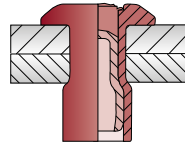
FERO®-BOLT Structural Blind Rivet

Aluminium Aluminium

Dome Head | open



Series
793



d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
4,8	14,0	24,4	1,6 - 11,1	10.793.048.140 500	MENGE

d_k 10,1 d_m 2,9 k 2,1 \approx 4,9 - 5,1 mm \leftarrow 2200 N \rightleftarrows 1800 N

d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
6,4	14,0	23,7	2,0 - 9,5	10.793.064.140 250	MENGE
	19,0	32,9	2,0 - 15,8	10.793.064.190 250	MENGE

d_k 13,3 d_m 3,9 k 2,9 \approx 6,6 - 7,0 mm \leftarrow 4200 N \rightleftarrows 3000 N

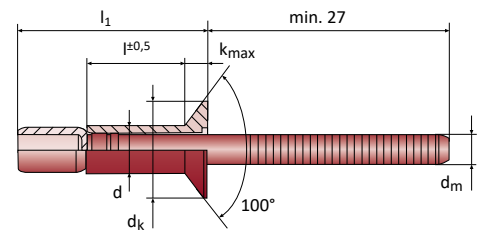
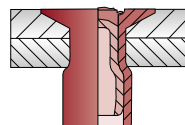
FERO®-BOLT Structural Blind Rivet

Aluminium Aluminium

Countersunk Head | open



Series
793



d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
4,8	12,5	20,0	3,2 - 8,4	10.793.480.125 500	MENGE

d_k 8,5 d_m 2,9 k 2,2 \approx 4,9 - 5,1 mm \leftarrow 2400 N \rightleftarrows 2000 N

d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
6,4	16,5	27,0	3,2 - 12,1	10.793.640.165 500	MENGE

d_k 10,0 d_m 3,9 k 2,4 \approx 6,6 - 7,0 mm \leftarrow 4700 N \rightleftarrows 4500 N

FERO®-BOLT Structural Blind Rivet

Steel galvanized Steel galvanized

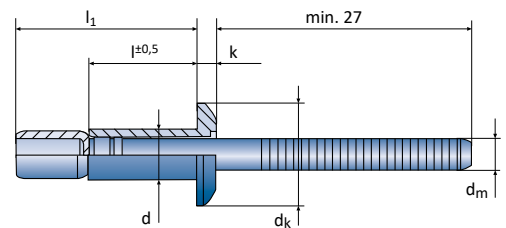
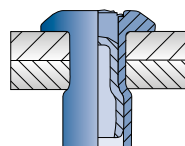
Dome Head | open



MOVIE



Series
797



d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
4,8	10,0	18,2	1,6 - 6,9	10.797.048.100 500	MENGE
	14,0	24,4	1,6 - 11,1	10.797.048.140 500	MENGE

d_k 10,1 d_m 2,9 k 2,1 \approx 4,9 - 5,1 mm \leftarrow 5800 N \rightleftarrows 4100 N

d	l	l ₁	$\frac{\pm}{\pm}$	Nr.	
6,4	14,0	23,7	2,0 - 9,5	10.797.064.140 250	MENGE
	19,0	32,9	2,0 - 15,9	10.797.064.190 250	MENGE

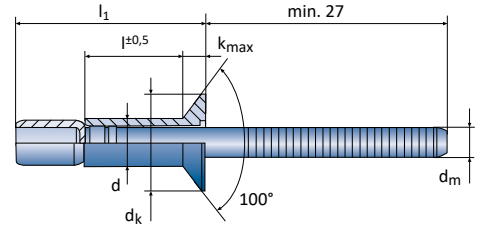
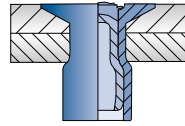
d_k 13,3 d_m 3,9 k 2,9 \approx 6,6 - 7,0 mm \leftarrow 10500 N \rightleftarrows 8000 N

Series
797

CAD
DATA
ONLINE

FERO®-BOLT Structural Blind Rivet

Steel galvanized Steel galvanized
Countersunk Head | open



d	l	l ₁	$\frac{d}{k}$	Nr.	
4,8	12,5	20,0	3,2 - 8,4	10.797.480.125	500
	16,5	26,2	3,2 - 12,2	10.797.480.165	250

d_k 8,5 d_m 2,9 k 2,2 $\frac{d}{k}$ 4,9 - 5,1 mm $\frac{d}{k}$ 5800 N $\frac{d}{k}$ 4100 N

d	l	l ₁	$\frac{d}{k}$	Nr.	
6,4	16,5	27,0	3,2 - 12,1	10.797.640.165	250

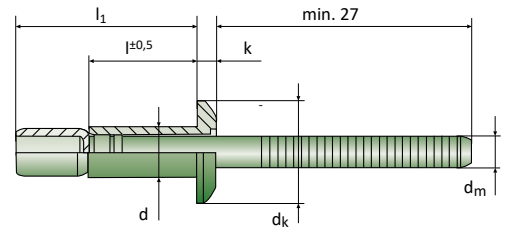
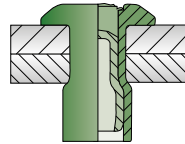
d_k 10,0 d_m 3,9 k 2,4 $\frac{d}{k}$ 6,6 - 7,0 mm $\frac{d}{k}$ 11000 N $\frac{d}{k}$ 9500 N

Series
798

CAD
DATA
ONLINE

FERO®-BOLT Structural Blind Rivet

Stainless Steel A2 Stainless Steel A2
Dome Head | open



d	l	l ₁	$\frac{d}{k}$	Nr.	
4,8	10,0	18,2	1,6 - 6,9	10.798.048.100	500
	14,0	24,4	1,6 - 11,1	10.798.048.140	500

d_k 10,1 d_m 2,9 k 2,1 $\frac{d}{k}$ 4,9 - 5,1 mm $\frac{d}{k}$ 6000 N $\frac{d}{k}$ 4500 N

d	l	l ₁	$\frac{d}{k}$	Nr.	
6,4	14,0	23,7	2,0 - 9,5	10.798.064.140	250
	19,0	32,9	2,0 - 15,9	10.798.064.190	250

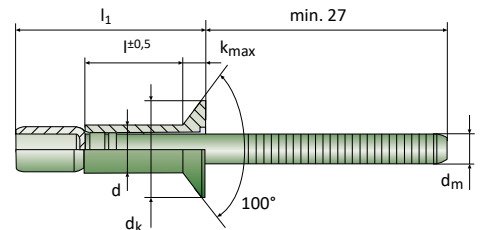
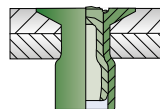
d_k 13,3 d_m 3,9 k 2,9 $\frac{d}{k}$ 6,6 - 7,0 mm $\frac{d}{k}$ 10500 N $\frac{d}{k}$ 8200 N

Series
798

CAD
DATA
ONLINE

FERO®-BOLT Structural Blind Rivet

Stainless Steel A2 Stainless Steel A6
Countersunk Head | open



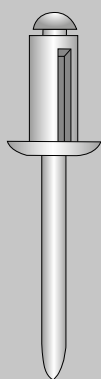
d	l	l ₁	$\frac{d}{k}$	Nr.	
4,8	12,5	20,0	3,2 - 8,4	10.798.480.125	500

d_k 8,5 d_m 2,9 k 2,2 $\frac{d}{k}$ 4,9 - 5,1 mm $\frac{d}{k}$ 6000 N $\frac{d}{k}$ 4500 N

d	l	l ₁	$\frac{d}{k}$	Nr.	
6,4	16,7	27,0	4,1 - 12,1	10.798.640.167	250

d_k 10,0 d_m 3,9 k 2,4 $\frac{d}{k}$ 6,6 - 7,0 mm $\frac{d}{k}$ 11200 N $\frac{d}{k}$ 8900 N

FOLDING BLIND RIVET



According to the ARCO® body-bound rivet on ► page 76 this folding rivet forms a large upset head too. This guarantees an **equal distribution of forces**, so that especially plastics and other soft or vulnerable materials resist against cracking or pullthrough.

Typically this rivet is used in all areas of **industrial light weight constructions**. As a result of the locked mandrel in the connection, the spread rivet is splash water resistant.

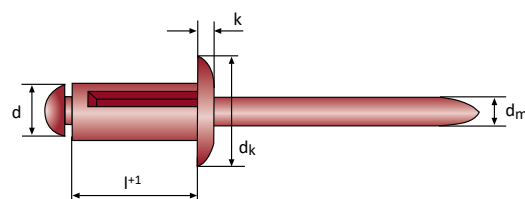
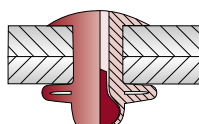
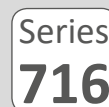
VVG offers two different types – the standard split rivet and a **high strength version with neoprene washer**.

Individually painted sizes also available on demand.



Folding Blind Rivet STANDARD

Aluminium Aluminium
Dome Head | open



d	l+1	dk	Nr.	Q
4,0	13,6	1,0 - 3,0	10.716.040.136	500
	18,8	3,0 - 7,0	10.716.040.188	500
	24,5	5,0 - 12,0	10.716.040.245	500

dk 8,0 dm 2,5 k 1,4 4,2 mm 500 N 800 N

d	l+1	dk	Nr.	Q
4,8	15,3	1,0 - 4,0	10.716.048.153	500
	20,5	1,0 - 9,0	10.716.048.205	500
	24,5	4,0 - 12,0	10.716.048.245	500
	28,0	6,0 - 16,0	10.716.048.280	500

dk 9,6 dm 2,9 k 1,6 5,0 mm 900 N 1100 N



⚠ Large head diameter 16 mm available!

Also available from stock

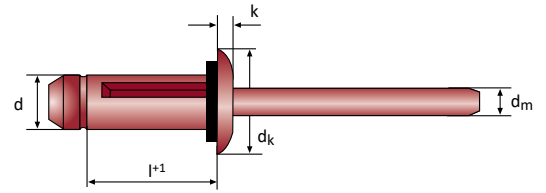
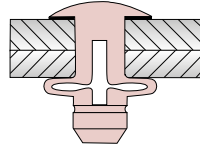
Plastic blind rivets

Plastic folding blind rivets are used, for example, in many areas of the electrical, automotive and computer hardware industry.

Due to the material, the plastic version offers the advantage that it is corrosion-resistant and not electrically conductive. Furthermore, the weight is very low and the surfaces of the parts to be joined are less subject to damage during riveting. Plastic blind rivets can be set with all matching standard blind rivet setting tools.

We stock a large number of sizes and models of standard and folding plastic blind rivets.





d	l	l ₁		Nr.	
5,2	17,5	xxx	0,5 - 4,8	10.716.052.175	500
	19,1	xxx	1,5 - 6,4	10.716.052.191	500
	22,2	xxx	4,7 - 9,6	10.716.052.222	500
	25,4	xxx	7,9 - 12,7	10.716.052.254	500
	28,6	xxx	11,1 - 15,9	10.716.052.286	500

dk 11,5 dm 2,9 k 2,5 5,3 - 5,6 mm 3000 N 2000 N

d	l	l ₁		Nr.	
6,3	20,0	xxx	1,5 - 6,4	10.716.063.200	500
	27,0	xxx	6,4 - 12,7	10.716.063.270	250

dk 14,4 dm 3,9 k 3,0 6,4 - 6,7 mm 4900 N 3000 N

- Good load-bearing strength thanks to high tensile and shear values
- Splash water-proof
- Large clamping range
- Universal applications



Please note that the tool used must be equipped with a **special nose piece!**

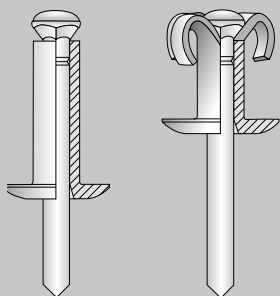
Nosepieces for folding blind rivets

Presslaschen-Blindniete 5,2 BZ 103 A* / RivdomONE	321.103.716.052
Presslaschen-Blindniete 5,2 BZ 123 A* / RivdomTWO	321.123.716.052
Presslaschen-Blindniete 6,3 BZ 123 A* / RivdomTWO	321.123.716.063

* (and precursors)



BODY BOUND BLIND RIVET ARCO®



During the setting process, edges on the mandrel head cut the rivet shaft into four segments. These four segments then unfold on the component surface thus forming the **large locking head**. Once the mandrel reaches its predetermined breakload, the mandrel head falls out of the rivet body. The large locking head allows **connecting soft or brittle components** and helps transfer high tensile forces.

ARCO® body-bound blind rivets are preferably used for plastic or wood element assembly, caravan manufacturing and fastening of claddings.

ARCO® Body Bound Blind Rivet

Aluminium Steel galvanized

Dome Head | open



MOVIE

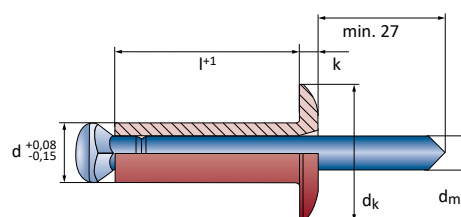
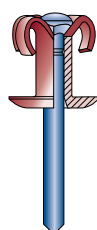
CAD
DATA
ONLINE

Series
710



EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{k}$	Nr.		
3,2	10,0	1,5 - 5,0	10.710.032.100	500	
	16,0	4,0 - 11,0	10.710.032.160	500	
	18,0	5,0 - 13,0	10.710.032.180	500	
d _k 6,5	d _m 1,7	k 0,8	3,6 mm	850 N	720 N
4,0	10,0	1,5 - 5,0	10.710.040.100	500	
	16,0	4,0 - 11,0	10.710.040.160	500	
	18,0	5,0 - 13,0	10.710.040.180	500	
d _k 7,7	d _m 2,4	k 1,5	4,4 mm	1330 N	1300 N



d	l ⁺¹	$\frac{d}{k}$	Nr.		
4,8	10,0	1,5 - 4,0	10.710.048.100	500	
	15,0	3,0 - 9,0	10.710.048.150	500	
	21,0	8,0 - 15,0	10.710.048.210	500	
	26,0	14,0 - 20,0	10.710.048.260	250	
	35,0	20,0 - 28,0	10.710.048.350	250	
d _k 11,0	d _m 2,8	k 1,5	5,2 mm	2100 N	1950 N

ARCO® Body Bound Blind Rivet

Aluminium Steel galvanized

Large Dome Head | open

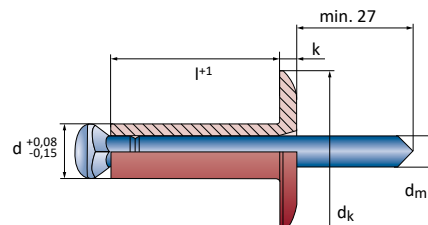
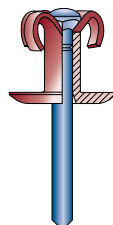
CAD
DATA
ONLINE

Series
718

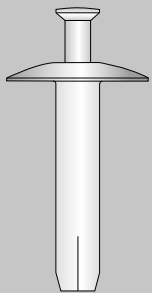


EN AW-5019 [AlMg5]

d	l ⁺¹	$\frac{d}{k}$	Nr.		
4,8	15,0	5,0 - 8,0	10.718.048.150	500	
	21,0	11,0 - 15,0	10.718.048.210	250	
d _k 16,0	d _m 2,8	k 2,0	5,2 mm	1700 N	1700 N



HAMMERDRIVE BLIND RIVET

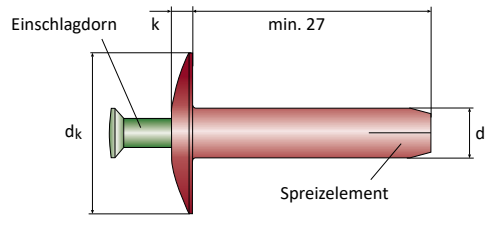


Hammer stroke or drive rivets are set by driving the mandrel into the rivet body (e.g. by means of a hammer). This causes the lower end of the rivet body to expand and allows riveting components with open-end boreholes and also riveting of blind-end boreholes. This riveting technology is suitable for the most diverse material combinations. For blind-end boreholes, a trial is necessary in order to establish the optimum rivet length based on the component characteristics and the firmness requirements.

Series **602** CAD DATA ONLINE

HAMMERDRIVE Blind Rivet

Aluminium Stainless Steel A2
Dome Head | open

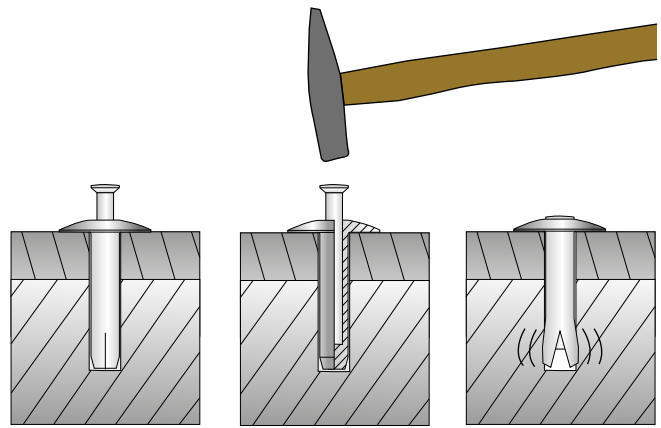


d	l ⁺¹	$\frac{d}{k}$	Nr.	
4,8	16,0	9,5 - 12,0	10.602.048.160	500
	18,0	12,0 - 14,5	10.602.048.180	500
	20,0	14,5 - 16,5	10.602.048.200	500

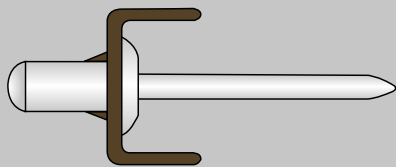
dk 14,0 -0,7 k 2,0 $\approx 4,9$ mm

4,8	26,0	20,0 - 22,0	10.602.048.260	500
	30,0	25,0 - 26,5	10.602.048.300	500
	36,0	29,0 - 31,0	10.602.048.360	500
	40,0	33,0 - 35,5	10.602.048.400	500
	50,0	43,5 - 46,0	10.602.048.500	250

dk 15,5 -0,7 k 2,0 $\approx 4,9$ mm



GROUNDING BLIND RIVET



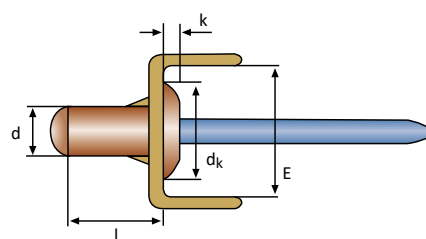
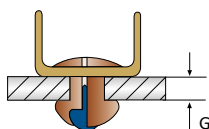
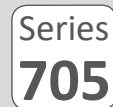
Grounding rivets offer a simple and reliable opportunity to create a ground connection with your products.

The grounding is achieved by pressing the tothing on the conductor into the material. The grounding conductor can be used with standard cable sockets.

The processing of grounding blind rivets can be done with all kinds of standard type blind rivet tools.

Grounding Blind Rivet

Copper Steel copper plated
Dome Head | open | 2x Erdungsleiter Messing



d	l ⁺¹		Nr.	
3,8	8,0	0,5 - 1,5	10.705.038.080	500

d_k 8,0^{-0,7} d_m 2,0 k 1,0^{±0,15} 3,9 mm 1400 N 2000 N

The width of the cable shoes is 6 mm.



Series
705

CAD
DATA
ONLINE

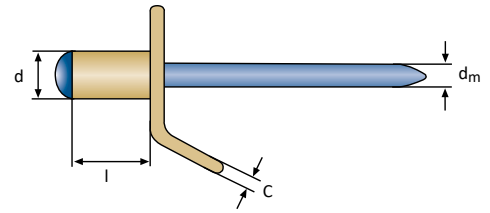
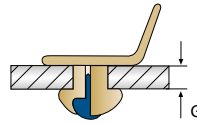


Grounding Blind Rivet

Messing

Stahl copper plated

Dome Head | open



d	l ⁺¹		Nr.	
4,0	7,0	0,0 - 4,0	10.705.040.070/00715	500

d_m 2,4

C ???

4,1 mm

Grounding Blind Rivet

Series
705

CAD
DATA
ONLINE

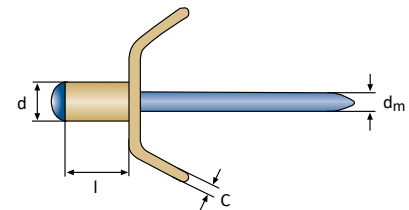
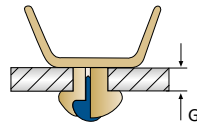


Grounding Blind Rivet

Messing

Steel copper plated

Dome Head | open



d	l ⁺¹		Nr.	
4,0	7,0	0,0 - 4,0	10.705.040.070/00716	500

d_m 2,4

C ???

4,1 mm

Series
600

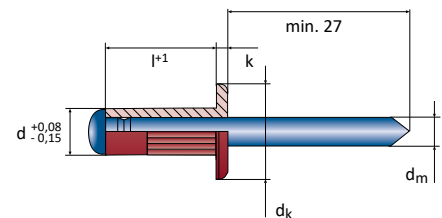
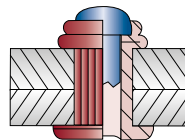
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ONLINE

OPTO® Multigrip Blind Rivet -grooved-

Aluminium

Steel galvanized

Dome Head | open



EN AW-5052 [AIMg2,5]

d	l ⁺¹		Nr.	
4,0	9,5	1,2 - 6,4	10.600.040.095/00002	500

d_k 7,9

d_m 2,3

k 1,2

4,1 mm

1140 N

1670 N



Qualified for grounding by grooved shaft.

BLIND RIVET NUTS



Blind rivet nuts have become an **indispensable part modern installation engineering**.

They allow to

- install bolt threads of different types into ...
 - ... thin or low rigidity components
 - ... hollow sections or other components not accessible from both sides
 - ... components which already have a coated surface,
- connect different components to each other at the same time and
- attach additional parts.

The continuous development of new types, forms and dimensions documents the **nearly unlimited fields of applications**.

The **Honsel-Group** has been one of the leading companies in this progress for decades. On the following pages we present several interesting examples like the **patented OPTO® multigrip blind rivet nut** (▶ [page 90/91](#)), **high-strength HONSELmuttern** made from aluminium or steel (▶ [page 87](#)) or blind rivet nuts made from **stainless steel A4** (▶ [page 116](#)).

Open and closed versions, possibilities to avoid rotating (knurling, (partial) hexagon shafts or downhead tothing) and flat, countersunk or small countersunk heads - the VVG range is one of the most compact and complete programmes available immediately from stock.



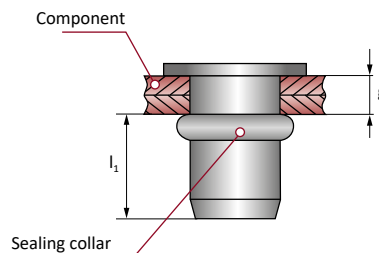
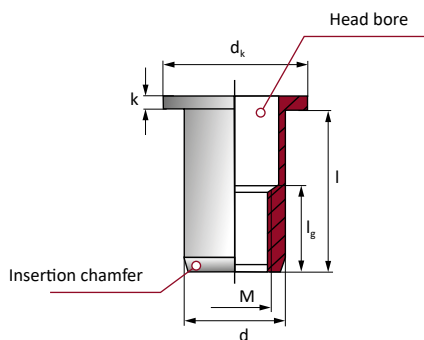
BLIND RIVET NUTS

Blind Rivet Nut	Material				Setting Head	Shank Type	Shank Design	Page
	Aluminium	Steel galvani-	Stainless steel A2	Stainless steel A4				
AFM	x				Dome head	Round shank	open	88
	x				Dome head	Round shank	closed	88
ASM	x				Countersunk head	Round shank	open	89
	x				Countersunk head	Round shank	closed	89
	x				small Countersunk head	Round shank	open	89
OPTO (Multigrip Blind Rivet Nuts)	x				Dome head	Round shank	open	90
	x				Countersunk head	Round shank	open	90
		x			Dome head	Round shank	open	91
		x			Countersunk head	Round shank	open	91
SFM		x			Dome head	Round shank	open	92
		x			Dome head	Round shank	closed	92
		x			Dome head	Round shank	open / knurled	93
SFM-PL (Folding Blind Rivet Nut)		x			Dome head	Round shank	open / slotted	94
SFM-H (Hollow Blind Rivet Nut)		x			Dome head	Round shank	open / slotted	95
SSM		x			Countersunk head	Round shank	open	96
		x			Countersunk head	Round shank	closed	96
		x			Countersunk head	Round shank	open / knurled	97
		x			small Countersunk head	Round shank	open	98
		x			small Countersunk head	Round shank	closed / knurled	98
		x			small Countersunk head	Round shank	open / knurled	99
UNIVERSAL		x			small Countersunk head	Round shank	open	100
		x			small Countersunk head	Round shank	open / knurled	100
		x			small Countersunk head	Round shank	closed / knurled	100
FLATSERT		x			small Countersunk head	Round shank	open	101
		x			small Countersunk head	Round shank	open / knurled	101
HEXAFORM®		x			Dome head	Hexagonal shank	open	102
		x			small Countersunk head	Hexagonal shank	open	102
		x			small Countersunk head	Hexagonal shank	closed	103
HEXATOP®		x			Dome head	Partial Hexagonal shank	open	104
		x			small Countersunk head	Partial Hexagonal shank	open	104
EFM			x		Dome head	Round shank	open	106
			x		Dome head	Round shank	closed	106
			x		Dome head	Round shank	open / knurled	107
ESM			x		Countersunk head	Round shank	open	108
			x		Countersunk head	Round shank	closed	108
			x		Countersunk head	Round shank	open / knurled	109
			x		small Countersunk head	Round shank	open	110
			x		small Countersunk head	Round shank	closed	110
			x		small Countersunk head	Round shank	open / knurled	111
UNIVERSAL			x		small Countersunk head	Round shank	open	112
			x		small Countersunk head	Round shank	open / knurled	113
HEXATOP®			x		Dome head	Partial Hexagonal shank	open	114
			x		Dome head	Partial Hexagonal shank	closed	114
			x		small Countersunk head	Partial Hexagonal shank	open	115
			x		small Countersunk head	Partial Hexagonal shank	closed	115
EFM				x	Dome head	Round shank	open	116
ESM				x	Small Countersunk head	Round shank	open	116
HEXATOP®				x	Small Countersunk head	Partial Hexagonal shank	open	116



Blind rivet nuts out of brass producible on request.

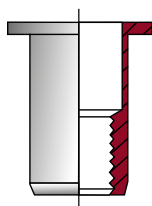
- d - shaft diameter
- dk - setting head diameter
- k - setting head height
- lg - thread length min. 1 x M
- l - shaft length
- l1 - projection length
- M - thread diameter
- g - grip length



Head design

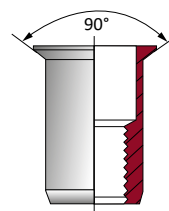
Flat head

- universally useable type of nut with a high level of availability and a wide material spectrum
- used with dry and grease-free components



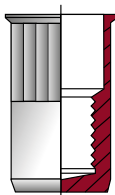
Countersunk head

- For the machining of blind rivet nuts with countersunk head, the component is only to be countersunk to a depth at which the countersunk head protrudes by min. 0,1 mm after setting.



Small countersunk head

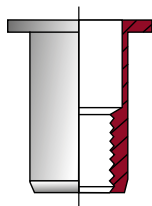
- The countersinking of the borehole is not normally necessary when machining blind rivet nuts. If technically necessary, the countersinking is to be carried out so that the countersunk head protrudes by min. 0,1 mm after setting.



Shank designs

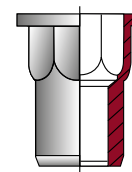
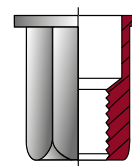
Round shaft blind rivet nuts

- universal nut type with high availability and broad material spectrum
- use with dry and grease-free components



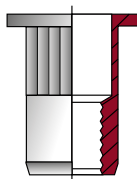
Blind rivet nuts with hexagonal shaft (Hexatop / Hexaform)

- shaft design with positive locking antirotation device
- preferred use with coated components
- high rotation resistance even with insufficient setting device height
- suitable for multiple screwing



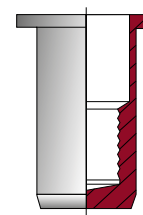
Blind rivet nuts with knurled shaft

- shaft design with positive locking antirotation device
- preferred use in components with low rigidity (component material less "hard" than the material of the blind rivet nut)

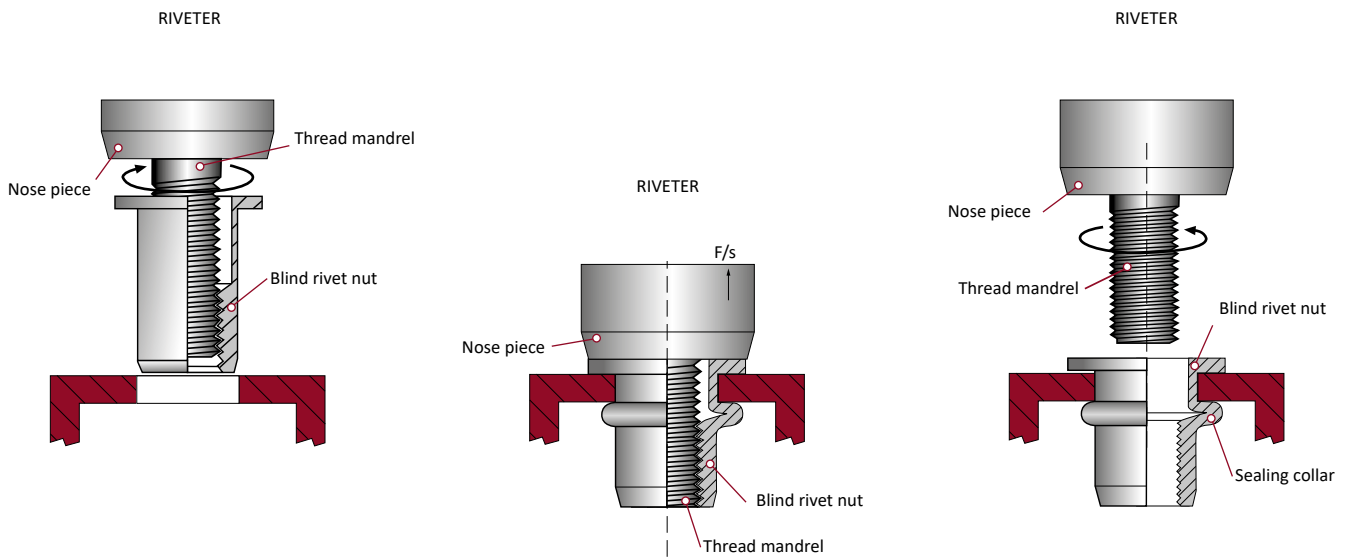


Blind rivet nuts with closed shaft

- closed nut shaft hinders the entrance of liquid and gas through the nut
- additional sealing possible between the nut shaft and the component borehole
- mechanical properties identical to comparable design with open shaft



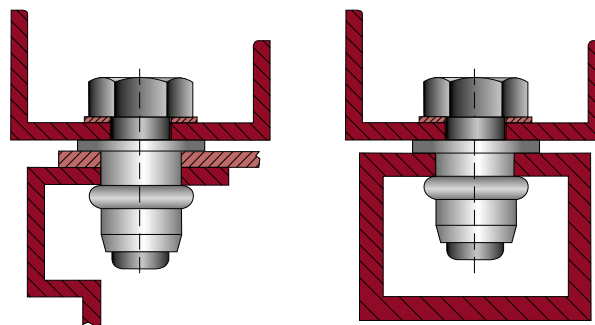
Installation



Blind rivet nuts are distinguished by simple and rapid installation. To set the nut, it is screwed onto the threaded mandrel of the setting tool, inserted into the component borehole, and set through the tool stroke. This causes the closing bead of the nut to form. After the threaded mandrel is removed, the components can be screwed tight.

For installing the nut, various tools are available with which the procedure can be carried out carefully. Setting tools operated by muscle power or by pneumatic hydraulics which can be selected.

Animation
blind rivet nut



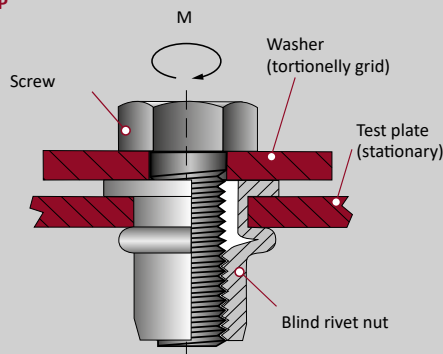
General assembly instructions

In order to guarantee correct functioning of the blind rivet nut, the points listed in the following should be noted:

- set blind rivet nut until complete formation of the closing head
- threaded mandrel must be easy to unscrew after setting
- installation at correct angle to the component surface
- blind rivet nuts with standard countersunk head should be sunk with a slight protrusion
- when using blind rivet nuts with small countersunk head (e.g. FLATSERT) it is not necessary to sink the borehole
- for blind rivet nuts without an additional positive locking anti-rotational device, the component surfaces must be dry, clean and grease-free
- specified component bore holes must be maintained: overlarge boreholes lead to problems with torque and load capacity

Tightening torque

TEST-SETUP



To measure the screwing torque, the nut is to be tested while setting into a test plate, a torsionally secured steel underlay plate superimposed, and the screw tightened. The following conditions apply for the test:

- Test / inspection plate of construction steel:
Uncoated, dry, grease-free, thickness c. max. grip length of the nut
- Component bore hole:
Nominal dimension of the nut shaft + 0.2 mm
- Machine screw:
Oiled, rigidity class min. 8.8

Under the defined conditions, the result will be the **minimum value** measured before failure of the nut. Rotation of the nut counts as failure, as does recognisable plastic deformation of the blind rivet nut. In practical use, partially different usage conditions may apply which can lead to an alteration on the tightening torques. **In general we recommend an examination of each specific individual case.**

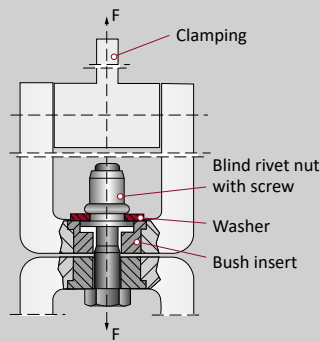
Maximum tightening torque - measured values [Nm]

Type	Thread dimensions	page	M 3	M 4	M 5	M 6	M 8	M 10	M 12
AFM		88	1	3	4	6	18	28	45
AFM-G		88	–	3	4	6	18	28	–
ASM		89	1	3	4	6	18	28	45
ASM-G		89	–	–	4	6	18	–	–
ASM-KLSK		89	–	2	4	6	18	–	–
OPTO® AFM		90	–	3	4	6	18	–	–
OPTO® ASM		90	–	3	4	6	18	–	–
OPTO® SFM		91	–	4	6	11	24	–	–
OPTO® SSM		91	–	4	6	11	24	–	–
SFM		92	1,2	4	6	11	24	50	82
SFM-G		92	–	–	6	11	24	50	–
SFM-R		93				*			
SFM-PL		94	–	–	–	12	21	–	–
SFM-H		95	–	1,1	2,2	2,2	–	–	–
SSM		96	–	4	6	11	24	50	–
SSM-G		96	–	–	6	11	24	50	–
SSM-R		97				*			
SSM-KLSK		98	–	3	5	10	20	–	–
SSM-R-KLSK-G		98				*			
SSM-R-KLSK		99				*			
UNIVERSAL		100	–	3	5	10	20	40	–
UNIVERSAL-R		100				*			
UNIVERSAL-R-G		100				*			
FLATSERT		101	2	3	5	10	20	–	–
FLATSERT-R		101				*			
HEXAFORM®-FK		102	–	5	7	13	25	55	85
HEXAFORM®-KLSK		102	1,2	5	7	13	25	55	85
HEXAFORM®-KLSK-G		103	–	5	7	13	25	55	–
HEXATOP®-FK		104	–	4	6	11	24	50	–
HEXATOP®-KLSK		104	–	4	6	11	24	50	–
EFM		106	–	4	6	11	24	50	85
EFM-G		106	–	4	6	11	24	50	–
EFM-R		107				*			
ESM		108	–	4	6	11	24	50	85
ESM-G		108	–	3	6	11	24	–	–
ESM-R		109				*			
ESM-KLSK		110	–	4	6	11	24	50	–
ESM-KLSK-G		110	–	4	6	11	24	50	–
ESM-KLSK-R		111				*			
UNIVERSAL		112	–	3	5	10	20	–	–
UNIVERSAL-R		113				*			
HEXATOP®-E-FK		114	2	5	7	13	25	55	–
HEXATOP®-E-FK-G		114	–	5	7	13	25	–	–
HEXATOP®-E-KLSK		115	2	5	7	13	25	55	85
HEXATOP®-E-KLSK-G		115	–	5	7	13	25	–	–
EFM A4		116	–	5	8	15	26	–	–
ESM KLSK A4		116	–	3	6	11	20	–	–
HEXATOP®-E-KLSK A4		116	–	5	8	15	26	–	–

* Knurled blind rivet nuts are designed for use with less solid materials or in components with a dense surface coating. For this reason, there are no general torque information. In individual cases, the test is carried out on the original component.

Axial tensile force

TEST-SETUP



The axial tensile force is determined with the testing device stipulated in DIN EN ISO 14589.

Unlike the blind rivet test, the nut is riveted into a steel washer. This is placed on the bush insert and the two parts of the device are screwed together.

The following conditions have validity during the test:

- Testing device in accordance with DIN EN ISO 14589
- Forming speed approx. 10 mm/min.
- Min. property class of the screw 8.8
- Direction of traction against the closing head of the nut

The **minimum values** measured under the stipulated conditions until the nut fails. Failure are deemed to be the tearing out of the thread or the tearing off of the closing head of the nut.

The stated values are to be seen as being standard values for the design of the splice. In practical use, it is normally the case that there are deviating conditions of use which can result in changes being made to the type of failure and the forces. **We therefore generally recommend that a bearing test be carried out in certain individual cases.**

Axial tensile force - measured values [Nm]

Type	Thread dimensions	page	M 3	M 4	M 5	M 6	M 8	M 10	M 12
AFM		88	1500	2600	4300	6700	11000	17500	28000
AFM-G		88	–	2600	4300	6700	11000	17500	–
ASM		89	1500	2600	4300	6700	11000	17500	28000
ASM-G		89	–	–	4300	6700	11000	–	–
ASM-KLSK		89	–	2400	4000	6000	10500	–	–
OPTO® AFM		90	–	3000	4200	6500	10500	–	–
OPTO® ASM		90	–	3000	4200	6500	10500	–	–
OPTO® SFM		91	–	5200	9500	15500	21500	–	–
OPTO® SSM		91	–	5200	9500	15500	21500	–	–
SFM		92	4000	5200	9500	16500	23500	37000	54000
SFM-G		92	–	–	9500	16500	23500	37000	–
SFM-R		93	–	5000	9000	13500	20000	28000	45000
SFM-PL		94	–	–	–	15000	27000	–	–
SFM-H		95	–	245	290	390	–	–	–
SSM		96	–	5200	9500	16500	23500	37000	–
SSM-G		96	–	–	9500	16500	23500	37000	–
SSM-R		97	–	5000	9000	15000	20000	28000	45000
SSM-KLSK		98	–	5000	9000	15000	20000	–	–
SSM-R-KLSK-G		98	–	6800	10000	15000	27000	37000	–
SSM-R-KLSK		99	4000	4800	8000	12000	18000	25000	40000
UNIVERSAL		100	–	6500	8000	11500	14500	22000	–
UNIVERSAL-R		100	–	6000	7500	10000	14000	17500	–
UNIVERSAL-R-G		100	–	6000	7500	–	–	–	–
FLATSERT		101	3000	6000	9500	13000	16000	–	–
FLATSERT-R		101	–	5500	9000	12000	15000	–	–
HEXAFORM®-FK		102	–	5200	9500	16500	23500	37000	56000
HEXAFORM®-KLSK		102	3500	5000	9000	16000	23000	36500	55000
HEXAFORM®-KLSK-G		103	–	5200	9500	16500	23500	37000	–
HEXATOP®-FK		104	–	3800	6000	9500	12500	37000	–
HEXATOP®-KLSK		104	–	3800	6000	9500	12500	37000	–
EFM		106	–	7000	11000	18000	27000	40000	57000
EFM-G		106	–	7000	11000	18000	27000	40000	–
EFM-R		107	4000	6500	10000	17000	25000	38000	–
ESM		108	–	7000	11000	16000	27000	40000	57000
ESM-G		108	–	6800	10000	15000	27000	–	–
ESM-R		109	3700	6500	10000	15000	25000	38000	–
ESM-KLSK		110	–	6500	10000	15000	25000	38000	–
ESM-KLSK-G		110	–	7000	11000	18000	27000	40000	–
ESM-KLSK-R		111	3500	6500	10000	15000	25000	38000	50000
UNIVERSAL		112	–	7000	11000	18000	27000	–	–
UNIVERSAL-R		113	–	6800	10000	14000	25000	37000	–
HEXATOP®-E-FK		114	4000	6500	10000	17000	27000	39000	–
HEXATOP®-E-FK-G		114	–	6500	10000	17000	27000	–	–
HEXATOP®-E-KLSK		115	3800	6000	9500	16000	26000	39000	55000
HEXATOP®-E-KLSK-G		115	–	6000	9500	16000	26000	–	–
EFM A4		116	–	7000	11000	18000	27000	–	–
ESM KLSK A4		116	–	6500	10000	15000	25000	–	–
HEXATOP®-E-KLSK A4		116	–	6500	10000	15000	25000	–	–

How to find the correct length of the shaft?

Length of shaft =
size of component +
shaft diameter



MORE than standard

Our long-term experience and modern manufacturing plants enables us to create **individual custom made products** to complete the standard range of this catalogue.

Many expertises out of these projects have direct influence on the standard product range and support the continuous improvement.

Blind Rivet Nuts

Special head and shaft forms

Round or (partial) hexagon shaft as well as special head forms for use e.g. as spacers or for centering of parts can be produced as well as customised geometries.



Under and over-head serration

Apart from the different shaft forms mentioned above, increased twist resistance can also be achieved, particularly in soft parts, by the use of serrations under the head of the blind rivet nut. Serrations on the top of the head can reliably lock components lying on the head.



Long chamfers

In order to optimise the fully automatic feeding process for blind rivet nuts, we manufacture for example particularly long chamfers individually to meet customers' requirements.



We develop
and produce
your special
blind rivet nut.



Competently.
Reliable.



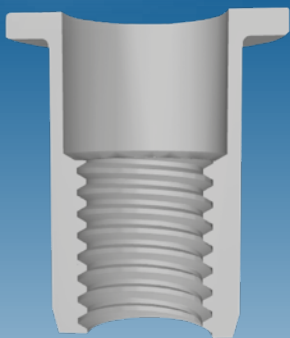
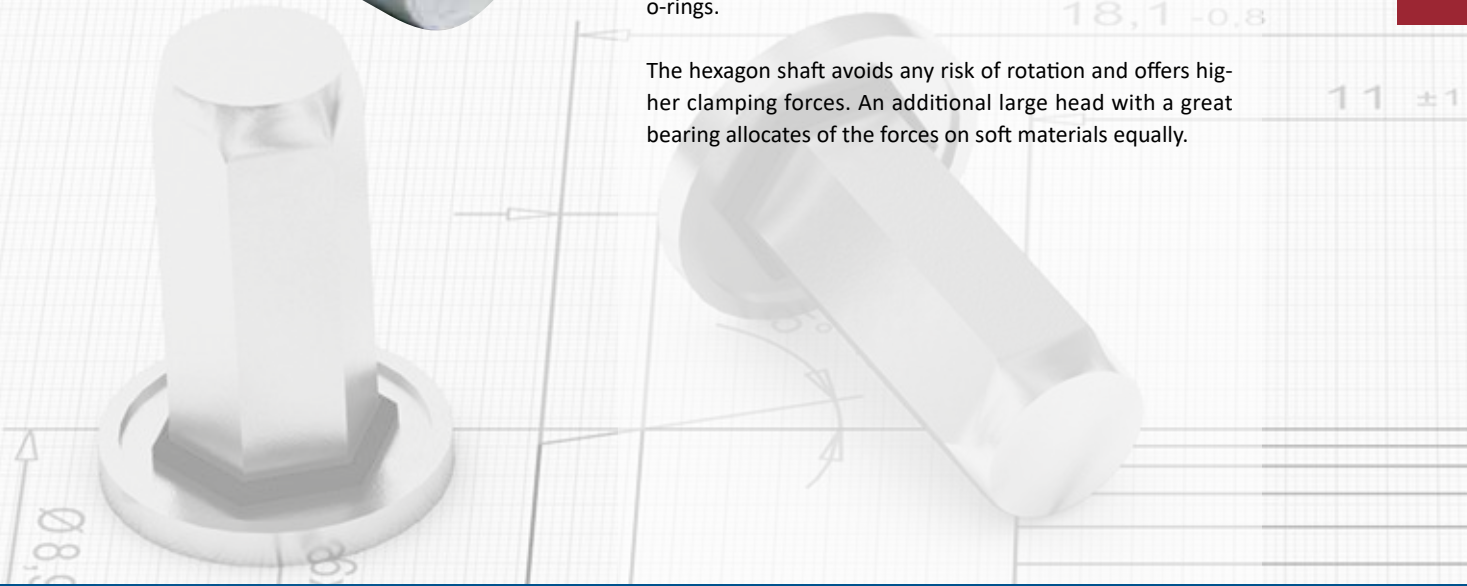
Pressure tight - blind rivet nut with sprayed seal



Based on the increasing demand of gas- and waterproofed fasteners with threads, HONSEL developed a closed end blind rivet nut with an additional seal made of automotive certified material that combined these requirements with the advantages of an economic and process secure machining.

The sprayed and embedded seal on the bottom of the head guarantees a much better form closure than conventional o-rings.

The hexagon shaft avoids any risk of rotation and offers higher clamping forces. An additional large head with a great bearing allocates of the forces on soft materials equally.



Malleable steel/
Aluminium
„HOCHFEST“

HONSEL's "HOCHFEST" technology enables the carrying capacity of the thread to be increased greatly. This facility ensures that when mechanical overload occurs, a 12.9 strength class screw ("HOCHFEST" steel) or an 8.8 strength class screw ("HOCHFEST" aluminium) fails much sooner than the HONSEL nut. This provides greater security in all applications where heightened mechanical specifications are required.

We supply the following embodiments

Shaft shapes:

- Fully and Partially hexagonal
- Round Shank
- Closed embodiments

Heads:

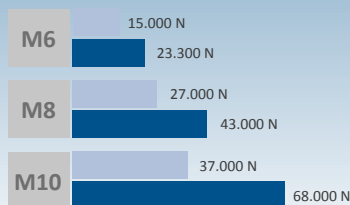
- Flat head
- Small countersunk head
- Countersunk head
- Large head

Advantages

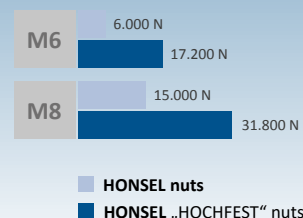
- An alternative to welded and punched nuts
- Withstands high moments of torque
- Allows for smaller dimensions to be used
- Rational machining
- Saves on weight
- Correctly sorted recycling (especially in the case of aluminium)
- Resistant to corrosion

Test load (N)

„HOCHFEST“ steel



„HOCHFEST“ alu



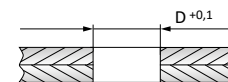
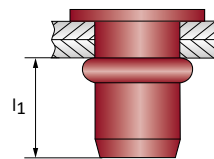
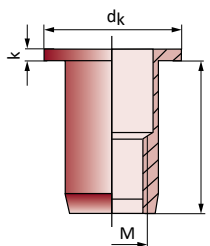
Blind Rivet Nut AFM

Aluminium

Flat head | Round shank | open



Series 850



EN AW-5754 [AlMg3]

M	$\frac{D}{2}$	l	No.	
M3	0,3 - 2,0	8,5	10.850.030.200	500
	2,0 - 3,5	11,2	10.850.030.350	500
D 5,0	k 0,8	dk 7,0	l₁ max. 6,0	\curvearrowright 1,0 Nm \updownarrow 1500 N
M4	0,5 - 3,0	11,0	10.850.040.300	500
	2,5 - 4,0	12,0	10.850.040.400	500
	3,0 - 5,0	13,2	10.850.040.500	500
D 6,0	k 0,8	dk 10,0	l₁ max. 8,0	\curvearrowright 3,0 Nm \updownarrow 2600 N
M5	0,5 - 3,0	12,0	10.850.050.300	500
	2,5 - 4,5	13,5	10.850.050.450	500
	4,0 - 6,0	15,0	10.850.050.600	500
D 7,0	k 1,0	dk 11,0	l₁ max. 9,0	\curvearrowright 4,0 Nm \updownarrow 4300 N

M	$\frac{D}{2}$	l	No.	
M6	0,5 - 3,0	14,5	10.850.060.300	500
	3,0 - 4,5	16,0	10.850.060.450	500
D 9,0	k 1,5	dk 13,0	l₁ max. 11,0	\curvearrowright 6,0 Nm \updownarrow 6700 N
M8	0,5 - 3,0	17,0	10.850.080.300	500
	3,0 - 5,5	19,5	10.850.080.550	500
	5,5 - 7,5	21,5	10.850.080.750	500
D 11,0	k 1,5	dk 16,0	l₁ max. 13,5	\curvearrowright 18,0 Nm \updownarrow 11000 N
M10	1,0 - 4,0	22,0	10.850.100.400	250
	3,0 - 6,0	24,0	10.850.100.600	250
D 13,0	k 2,0	dk 19,0	l₁ max. 16,5	\curvearrowright 28,0 Nm \updownarrow 17500 N
M12	1,0 - 4,0	24,0	10.850.120.400	100
	3,5 - 7,0	27,0	10.850.120.700	100
D 16,0	k 2,0	dk 23,0	l₁ max. 18,5	\curvearrowright 45,0 Nm \updownarrow 28000 N

Note the OPTO®multigrip blind rivet nut on [page 90](#).

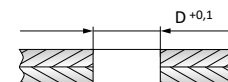
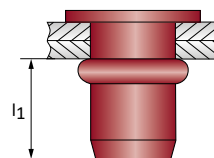
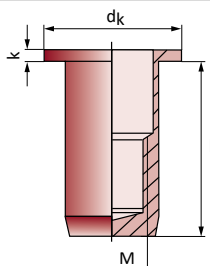
Blind Rivet Nut AFM-G

Aluminium

Flat head | Round shank | closed



Series 854



EN AW-5754 [AlMg3]

M	$\frac{D}{2}$	l	No.	
M4	0,3 - 2,0	16,0	10.854.040.200	500
	2,0 - 3,0	16,5	10.854.040.300	500
D 6,0	k 0,8	dk 10,0	l₁ max. 13,5	\curvearrowright 3,0 Nm \updownarrow 2600 N
M5	0,3 - 3,0	18,5	10.854.050.300	500
	3,0 - 4,0	19,5	10.854.050.400	500
D 7,0	k 1,0	dk 11,0	l₁ max. 15,5	\curvearrowright 4,0 Nm \updownarrow 4300 N
M6	0,5 - 3,0	22,0	10.854.060.300	500
	3,0 - 4,5	23,5	10.854.060.450	500
D 9,0	k 1,5	dk 13,0	l₁ max. 18,5	\curvearrowright 6,0 Nm \updownarrow 6700 N

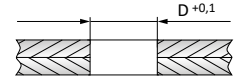
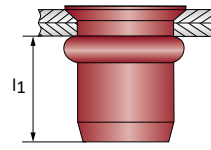
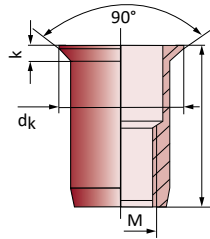
M	$\frac{D}{2}$	l	No.	
M8	0,5 - 3,0	26,5	10.854.080.300	250
	3,0 - 5,5	29,0	10.854.080.550	250
D 11,0	k 1,5	dk 16,0	l₁ max. 23,0	\curvearrowright 18,0 Nm \updownarrow 11000 N
M10	1,0 - 3,0	32,5	10.854.100.300	250
D 13,0	k 2,0	dk 19,0	l₁ max. 28,5	\curvearrowright 28,0 Nm \updownarrow 17500 N

Information about additional sealing possibilities for closed blind rivet nuts in chapter blind rivets on [page 60](#) and [103](#).



You can use the classic brief description of our blind rivet nuts for your inquiries or orders:

Serial name: **AFM**
 + Thread size: **M6**
 + Maximum grip range: **3,0 mm**
 = Brief description: **AFM 6-30**



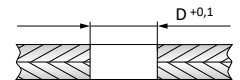
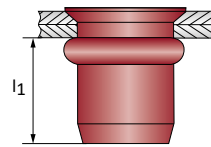
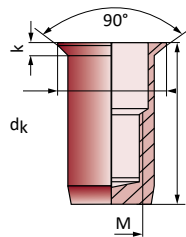
EN AW-5754 [AlMg3]

M	$\frac{D}{2}$	l	No.	
M3	1,5 - 2,5	10,0	10.851.030.250	500
	1,5 - 3,5	11,0	10.851.030.350	500
D 5,0	k 1,5	dk 7,3	l₁ max. 7,0	\curvearrowright 1,0 Nm \updownarrow 1500 N
M4	1,5 - 3,5	11,5	10.851.040.350	500
	3,5 - 5,0	13,0	10.851.040.500	500
D 6,0	k 1,5	dk 8,3	l₁ max. 8,0	\curvearrowright 3,0 Nm \updownarrow 2600 N
M5	1,5 - 4,0	13,0	10.851.050.400	500
	4,0 - 5,5	14,5	10.851.050.550	500
D 7,0	k 1,5	dk 9,3	l₁ max. 9,0	\curvearrowright 4,0 Nm \updownarrow 4300 N
M6	1,5 - 4,5	16,0	10.851.060.450	500
	4,0 - 6,0	17,5	10.851.060.600	500
D 9,0	k 1,5	dk 11,3	l₁ max. 11,0	\curvearrowright 6,0 Nm \updownarrow 6700 N

M	$\frac{D}{2}$	l	No.	
M8	1,5 - 4,5	18,5	10.851.080.450	500
	4,0 - 6,0	20,0	10.851.080.600	500
D 11,0	k 1,5	dk 13,3	l₁ max. 13,5	\curvearrowright 18,0 Nm \updownarrow 11000 N
M10	1,5 - 3,0	20,5	10.851.100.300	250
	3,0 - 4,5	22,0	10.851.100.450	250
	3,5 - 6,5	24,0	10.851.100.650	250
D 13,0	k 1,5	dk 15,5	l₁ max. 16,5	\curvearrowright 28,0 Nm \updownarrow 17500 N
M12	1,7 - 4,5	26,0	10.851.120.450	100
	4,0 - 7,5	29,0	10.851.120.750	100
D 16,0	k 1,9	dk 19,0	l₁ max. 17,5	\curvearrowright 45,0 Nm \updownarrow 28000 N

Note the OPTO®multigrip blind rivet nut on [page 90](#).

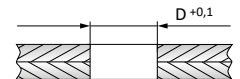
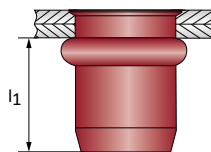
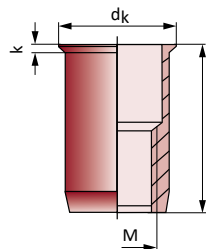
AFM



EN AW-5754 [AlMg3]

M	$\frac{D}{2}$	l	No.	
M5	1,5 - 4,0	19,5	10.855.050.400	500
D 7,0	k 1,5	dk 9,3	l₁ max. 15,5	\curvearrowright 4,0 Nm \updownarrow 4300 N
M6	1,5 - 4,5	23,0	10.855.060.450	500
D 9,0	k 1,5	dk 11,3	l₁ max. 18,5	\curvearrowright 6,0 Nm \updownarrow 6700 N

M	$\frac{D}{2}$	l	No.	
M8	1,5 - 4,5	28,0	10.855.080.450	500
	4,5 - 6,0	29,5	10.855.080.600	500
D 11,0	k 1,5	dk 13,3	l₁ max. 23,0	\curvearrowright 18,0 Nm \updownarrow 11000 N



EN AW-5754 [AlMg3]

M	$\frac{D}{2}$	l	No.	
M4	0,5 - 2,0	10,0	10.851.040.200/00010	500
D 6,0	k 0,5	dk 6,8	l₁ max. 6,5	\curvearrowright 2,0 Nm \updownarrow 2400 N
M5	0,5 - 3,0	12,0	10.851.050.300/00010	500
D 7,0	k 0,5	dk 8,0	l₁ max. 7,5	\curvearrowright 4,0 Nm \updownarrow 4000 N

M	$\frac{D}{2}$	l	No.	
M6	0,5 - 3,0	15,0	10.851.060.300/00010	500
D 9,0	k 0,6	dk 10,0	l₁ max. 10,0	\curvearrowright 6,0 Nm \updownarrow 6000 N
M8	0,5 - 3,0	16,0	10.851.080.300/00010	500
D 11,0	k 0,6	dk 12,0	l₁ max. 12,0	\curvearrowright 18,0 Nm \updownarrow 10500 N



ONE Blind Rivet Nut FOR ALL Grip Ranges

One blind rivet nut for all grip ranges.

The innovative and patented development of the Honsel-Group was in 2007 the first mass-production multigrip blind rivet nut.

The product has a lot of advantages over the common standard types:

- no mixing of different grip ranges
- reduction of storage and failure costs
- reduction of delivery times
- reduction of item diversity

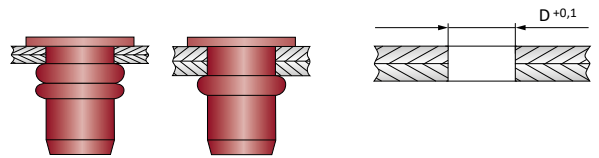
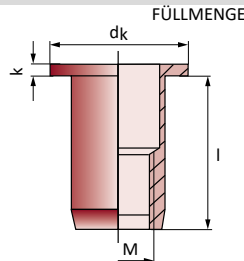


Closed end versions, size M10 or hexagonal shaft producible on request.

OPTO®

Multigrip Blind Rivet Nut OPTO®-AFM

Aluminium
Flat head | open



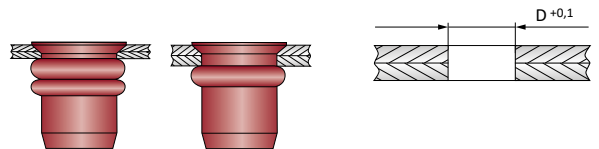
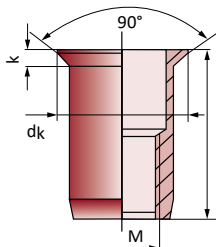
EN AW-5754 [AlMg3]

M	$\frac{D}{h}$	l	No.	
M4	0,5 - 6,0	14,0	10.894.040.600	500
D 6,0	k 0,8	d _k 10,0	↻ 3,0 Nm	↓ 3000 N
M5	0,5 - 6,0	15,0	10.894.050.600	500
D 7,0	k 1,0	d _k 11,0	↻ 4,0 Nm	↓ 4200 N

M	$\frac{D}{h}$	l	No.	
M6	0,5 - 6,0	17,5	10.894.060.600	500
D 9,0	k 1,5	d _k 13,0	↻ 6,0 Nm	↓ 6500 N
M8	0,5 - 7,5	21,5	10.894.080.750	500
D 11,0	k 1,5	d _k 16,0	↻ 18,0 Nm	↓ 10500 N

Multigrip Blind Rivet Nut OPTO®-ASM

Aluminium
Countersunk head | open



EN AW-5754 [AlMg3]

M	$\frac{D}{h}$	l	No.	
M4	1,5 - 6,0	14,0	10.894.400.600	500
D 6,0	k 1,5	d _k 10,0	↻ 3,0 Nm	↓ 3000 N
M5	1,5 - 6,0	15,0	10.894.500.600	500
D 7,0	k 1,5	d _k 11,0	↻ 4,0 Nm	↓ 4200 N

M	$\frac{D}{h}$	l	No.	
M6	1,5 - 6,0	17,5	10.894.600.600	500
D 9,0	k 1,5	d _k 13,0	↻ 6,0 Nm	↓ 6500 N
M8	1,5 - 7,5	21,5	10.894.800.750	500
D 11,0	k 1,5	d _k 16,0	↻ 18,0 Nm	↓ 10500 N

OPTO[®]-MULTIGRIP BLIND RIVET NUT



For the perfect handling of OPTO[®] multigrip blind rivet nuts: The **strength controlled** pneumatic-hydraulic tool **VNG 703**. Details on [page 218!](#)

OPTO[®]

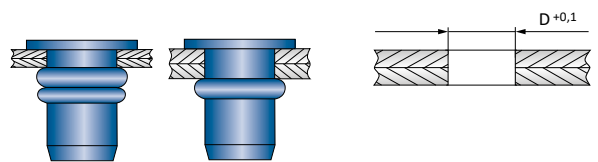
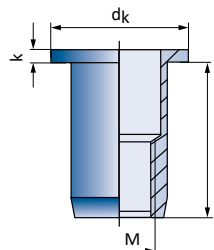
Series
895

CAD
DATA
ONLINE



Multigrip Blind Rivet Nut OPTO[®]-SFM

Steel galvanized
Flat head | open



C4C [1.0303]

M	$\frac{D}{h14}$	l	No.		€/ 1.000
M4	0,5 - 6,0	14,0	10.895.040.600	500	168,00
D 6,0	k 0,8	dk 10,0	\curvearrowright 4,0 Nm		\updownarrow 5200 N
M5	0,5 - 6,0	15,0	10.895.050.600	500	198,80
D 7,0	k 1,0	dk 11,0	\curvearrowright 6,0 Nm		\updownarrow 9500 N

M	$\frac{D}{h14}$	l	No.		€/ 1.000
M6	0,5 - 6,0	17,5	10.895.060.600	500	270,00
D 9,0	k 1,5	dk 13,0	\curvearrowright 11,0 Nm		\updownarrow 15500 N
M8	0,5 - 7,5	21,5	10.895.080.750	500	356,10
D 11,0	k 1,5	dk 16,0	\curvearrowright 24,0 Nm		\updownarrow 21500 N

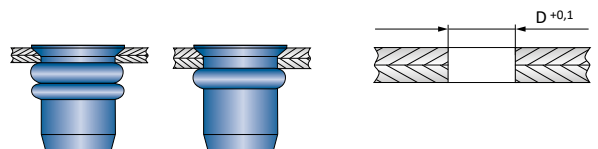
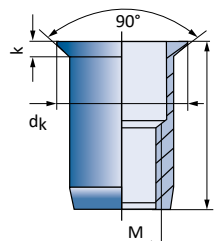
Series
895

CAD
DATA
ONLINE



Multigrip Blind Rivet Nut OPTO[®]-SSM

Steel galvanized
Countersunk head | open



C4C [1.0303]

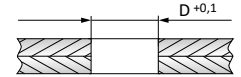
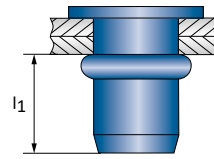
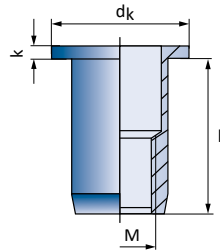
M	$\frac{D}{h14}$	l	No.		€/ 1.000
M4	1,5 - 6,0	14,0	10.895.400.600	500	170,20
D 6,0	k 1,5	dk 10,0	\curvearrowright 4,0 Nm		\updownarrow 5200 N
M5	1,5 - 6,0	15,0	10.895.500.600	500	201,60
D 7,0	k 1,5	dk 11,0	\curvearrowright 6,0 Nm		\updownarrow 9500 N

M	$\frac{D}{h14}$	l	No.		€/ 1.000
M6	1,5 - 6,0	17,5	10.895.600.600	500	273,30
D 9,0	k 1,5	dk 13,0	\curvearrowright 11,0 Nm		\updownarrow 15500 N
M8	1,5 - 7,5	21,5	10.895.800.750	500	358,80
D 11,0	k 1,5	dk 16,0	\curvearrowright 24,0 Nm		\updownarrow 21500 N

Blind Rivet Nut SFM

Steel galvanized

Flat head | Round shank | open



C4C [1.0303]

M	$\frac{D}{2}$	l	No.	
M3	0,5 - 2,0	9,0	10.852.030.200	500
	2,0 - 3,5	10,7	10.852.030.350	500
D 5,0	k 0,8	dk 7,0	l₁ max. 7,0	\curvearrowright 1,2 Nm \updownarrow 4000 N
M4	0,5 - 3,0	11,0	10.852.040.300	500
	2,5 - 5,0	13,2	10.852.040.500	500
D 6,0	k 0,8	dk 10,0	l₁ max. 8,0	\curvearrowright 4,0 Nm \updownarrow 5200 N
M5	0,5 - 3,0	12,0	10.852.050.300	500
D 7,0	k 1,0	dk 11,0	l₁ max. 9,0	\curvearrowright 6,0 Nm \updownarrow 9500 N
M6	0,5 - 3,0	14,5	10.852.060.300	500
	3,0 - 4,5	16,0	10.852.060.450	500
	4,5 - 6,0	17,5	10.852.060.600	500
D 9,0	k 1,5	dk 13,0	l₁ max. 11,0	\curvearrowright 11,0 Nm \updownarrow 16500 N

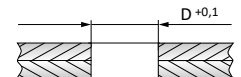
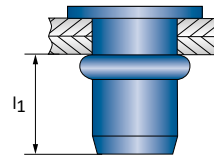
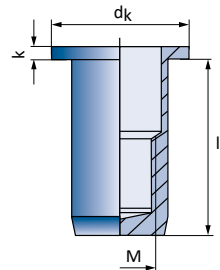
M	$\frac{D}{2}$	l	No.	
M8	0,5 - 3,0	17,0	10.852.080.300	250
	3,0 - 5,5	19,5	10.852.080.550	250
	5,5 - 7,5	21,5	10.852.080.750	250
	7,0 - 9,0	23,0	10.852.080.900	250
D 11,0	k 1,5	dk 16,0	l₁ max. 13,5	\curvearrowright 24,0 Nm \updownarrow 23500 N
M10	1,0 - 3,0	20,5	10.852.100.300	250
	3,5 - 6,0	23,5	10.852.100.600	250
D 13,0	k 2,0	dk 19,0	l₁ max. 16,5	\curvearrowright 50,0 Nm \updownarrow 37000 N
M12	1,0 - 4,0	25,0	10.852.120.400	100
	3,5 - 7,0	28,0	10.852.120.700	100
D 16,0	k 2,0	dk 23,0	l₁ max. 16,5	\curvearrowright 82,0 Nm \updownarrow 54000 N

Note the OPTO® multigrip blind rivet nuts on the [page 91](#).

Blind Rivet Nut SFM-G

Steel galvanized

Flat head | Round shank | closed

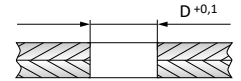
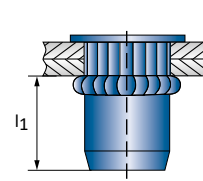
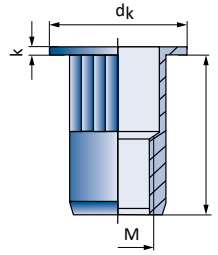


C4C [1.0303]

M	$\frac{D}{2}$	l	No.	
M5	0,5 - 3,0	17,0	10.856.050.300	500
	3,0 - 5,5	22,0	10.856.050.550	500
D 7,0	k 1,0	dk 11,0	l₁ max. 15,5	\curvearrowright 6,0 Nm \updownarrow 9500 N
M6	0,5 - 3,0	21,5	10.856.060.300	500
D 9,0	k 1,2	dk 12,0	l₁ max. 16,0	\curvearrowright 11,0 Nm \updownarrow 16500 N

M	$\frac{D}{2}$	l	No.	
M8	0,5 - 3,5	25,2	10.856.080.350	250
	3,5 - 6,0	29,5	10.856.080.600	250
D 11,0	k 1,3	dk 14,0	l₁ max. 17,5	\curvearrowright 24,0 Nm \updownarrow 23500 N
M10	1,0 - 3,0	33,0	10.856.100.300	250
D 13,0	k 2,0	dk 19,0	l₁ max. 28,5	\curvearrowright 50,0 Nm \updownarrow 37000 N





C4C [1.0303]

M	$\frac{k}{D}$	l	No.	
M4	0,5 - 2,5	9,5	10.842.040.250	500
	2,5 - 4,5	13,0	10.842.040.450	500
D 6,0	k 0,8	dk 9,0	l₁ max. 8,0	↓ 5000 N
M5	0,5 - 3,0	12,0	10.842.050.300	500
	2,5 - 5,0	14,0	10.842.050.500	500
D 7,0	k 1,0	dk 10,0	l₁ max. 9,0	↓ 9000 N
M6	0,5 - 3,0	14,5	10.842.060.300	500
	3,5 - 5,5	17,5	10.842.060.550	500
D 9,0	k 1,5	dk 13,0	l₁ max. 11,0	↓ 13500 N

M	$\frac{k}{D}$	l	No.	
M8	0,5 - 3,0	16,0	10.842.080.300	250
	3,0 - 5,5	18,5	10.842.080.550	250
	5,5 - 7,5	21,5	10.842.080.750	250
D 11,0	k 1,5	dk 16,0	l₁ max. 13,5	↓ 20000 N
M10	1,0 - 3,0	20,5	10.842.100.300	250
	3,0 - 4,5	22,0	10.842.100.450	250
D 13,0	k 2,0	dk 19,0	l₁ max. 16,5	↓ 28000 N
M12	1,0 - 4,0	25,0	10.842.120.400	100
	D 16,0	k 2,0	dk 23,0	l₁ max. 18,5

SFM

Knurled and more.



Special versions available directly from stock.

In addition to the standard products with torsional resistance available in all areas, a large number of article variants for example with **special surfaces, larger head diameters** or additional **serrations on or under the setting head** are also immediately available.

For example

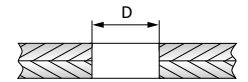
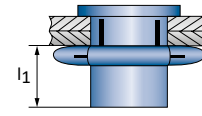
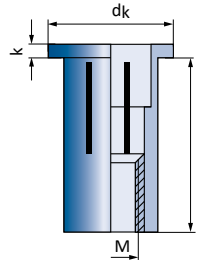
- Blind rivet nut SFM 6-45R K 18.5x1.5 10.842.060.450-2
M6 knurled, steel, large flat head (diameter 18.5 x height 1.5 mm), clamping range 3.0-4.5 mm
- Blind rivet nut SFM 8-30R K 21x2 20.842.080.300-5
M8 knurled, steel, large flat head (diameter 21.0 x height 2.0 mm), clamping range 1.0-3.0 mm
- Blind rivet nut SFM 8-50R K 22x1.6 20.842.080.500-2
M8 knurled, steel, large flat head (diameter 22.0 x height 1.6 mm), clamping range 2.5-5.5 mm



Folding Blind Rivet Nut SFM-PL

Steel galvanized

Flat head | open | geschlitzt



C4C [1.0303]

M	$\frac{H}{k}$	l	No.	
M6	0,5 - 7,1	25,8	10.816.060.710	250
D 8,8	k 1,6	d _k 16,4	l ₁ max. 11,7	⌚ 12,0 Nm ⬆ 15000 N

M	$\frac{H}{k}$	l	No.	
M8	0,5 - 7,1	29,6	10.816.080.710	250
D 11,1	k 1,6	d _k 19,6	l ₁ max. 13,6	⌚ 21,0 Nm ⬆ 27000 N

SFM

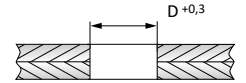
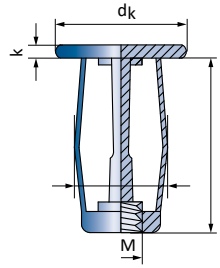


i Please note that special threaded mandrels are required for setting the folding blind rivet nuts. Where appropriate, these can be found alongside the corresponding tools.



i A **tool with a large stroke** is required for optimum setting of SFM-PL folding blind rivet nuts. Here HONSEL/VVG offers a special pneumatic-hydraulic setting tool with the **VNG 753**. Details can be found on [page 222](#). Ask your local dealer or our sales team for further information!

SFM-PL folding blind rivet nuts were developed for applications requiring **high tightening forces**. During setting, the slotted shaft fans out into four tabs which contact the part **uniformly and over a large area for uniform distribution of the forces**. Plastic and thin-walled sheet metal and other brittle or easily broken materials can thus be reliably joined. Furthermore, folding blind rivet nuts offer a **very large clamping range**.



C4C [1.0303]

M	$\frac{D}{k}$	l	No.	
M4	0,1 - 5,0	15,2	10.817.040.500	500

D 8,0 k 1,6 dk 12,2 ↻ 1,1 Nm ⬆ 245 N

M5	0,1 - 5,0	16,8	10.817.050.500	500
-----------	-----------	------	----------------	-----

D 10,0 k 1,6 dk 14,0 ↻ 2,2 Nm ⬆ 290 N

M	$\frac{D}{k}$	l	No.	
M6	0,1 - 5,0	17,0	10.817.060.500	500

D 12,0 k 1,6 dk 16,0 ↻ 2,2 Nm ⬆ 390 N



Slotted blind rivet nuts with threaded insert specially for use in brittle or soft materials such as plastic or perspex.

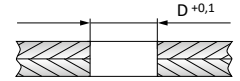
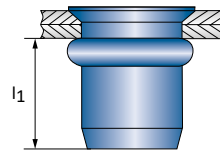
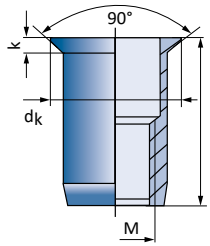
Particularly on uneven surfaces, these blind rivet nuts offer **outstanding torsional resistance**.

Thanks to the **large clamping range**, they can be used flexibly with differing material thicknesses.

Blind Rivet Nut SSM

Steel galvanized

Countersunk head | Round shank | open



C4C [1.0303]

M	$\frac{k}{dk}$	l	No.		
M4	1,5 - 3,5	11,5	10.853.040.350	500	
	3,0 - 5,0	13,0	10.853.040.500	500	
D 6,0	k 1,5	dk 8,3	l ₁ max. 8,0	↻ 4,0 Nm	↕ 5200 N
M5	1,5 - 4,0	13,0	10.853.050.400	500	
	4,0 - 5,5	14,5	10.853.050.550	500	
D 7,0	k 1,5	dk 9,3	l ₁ max. 9,0	↻ 6,0 Nm	↕ 9500 N
M6	1,5 - 4,5	16,0	10.853.060.450	500	
	4,5 - 6,0	17,5	10.853.060.600	500	
D 9,0	k 1,5	dk 11,3	l ₁ max. 11,0	↻ 11,0 Nm	↕ 16500 N

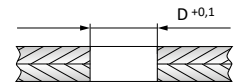
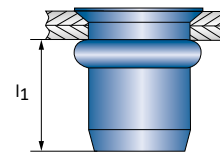
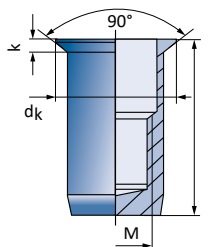
M	$\frac{k}{dk}$	l	No.		
M8	1,5 - 4,5	18,5	10.853.080.450	250	
	4,5 - 6,0	20,0	10.853.080.600	250	
D 11,0	k 1,5	dk 13,3	l ₁ max. 13,5	↻ 24,0 Nm	↕ 23500 N
M10	3,0 - 4,5	22,0	10.853.100.450	250	
	4,5 - 6,0	23,5	10.853.100.600	250	
	6,0 - 9,0	28,0	10.853.100.900	250	
D 13,0	k 1,5	dk 15,2	l ₁ max. 16,5	↻ 50,0 Nm	↕ 37000 N

Note the OPTO® multigrip blind rivet nuts on the [page 91](#).

Blind Rivet Nut SSM-G

Steel galvanized

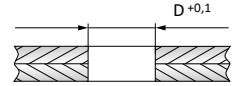
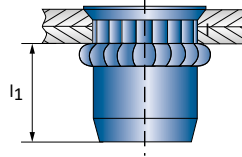
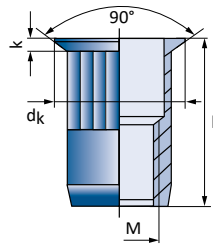
Countersunk head | Round shank | closed



C4C [1.0303]

M	$\frac{k}{dk}$	l	No.		
M5	1,5 - 4,0	19,5	10.857.050.400	500	
	D 7,0	k 1,5	dk 9,3	l ₁ max. 15,5	↻ 6,0 Nm
M6	1,5 - 4,5	23,5	10.857.060.450	500	
	4,5 - 6,0	25,0	10.857.060.600	500	
D 9,0	k 1,5	dk 11,3	l ₁ max. 18,5	↻ 11,0 Nm	↕ 16500 N

M	$\frac{k}{dk}$	l	No.		
M8	1,5 - 4,5	28,0	10.857.080.450	250	
	D 11,0	k 1,5	dk 13,3	l ₁ max. 23,0	↻ 24,0 Nm
M10	1,5 - 3,0	30,5	10.857.100.300	250	
	D 13,0	k 1,5	dk 14,9	l ₁ max. 28,5	↻ 50,0 Nm



C4C [1.0303]

M	$\frac{D}{2}$	l	No.	
M4	1,5 - 3,5	11,5	10.845.040.350	500
	3,0 - 5,0	13,0	10.845.040.500	500
D 6,0	k 1,5	dk 8,3	l₁ max. 8,0	↓ 5000 N
M5	1,5 - 4,0	13,5	10.845.050.400	500
	4,0 - 6,5	16,0	10.845.050.650	500
D 7,0	k 1,5	dk 9,3	l₁ max. 9,0	↓ 9000 N
M6	1,5 - 4,5	16,0	10.845.060.450	500
	4,5 - 6,5	18,0	10.845.060.650	500
D 9,0	k 1,5	dk 11,3	l₁ max. 11,0	↓ 15000 N

M	$\frac{D}{2}$	l	No.	
M8	1,5 - 4,5	19,0	10.845.080.450	500
	3,5 - 6,5	21,0	10.845.080.650	500
D 11,0	k 1,5	dk 13,3	l₁ max. 13,5	↓ 20000 N
M10	1,5 - 4,5	22,0	10.845.100.450	250
	3,5 - 6,5	25,0	10.845.100.650	250
D 13,0	k 1,6	dk 15,7	l₁ max. 14,5	↓ 28000 N
M12	1,7 - 4,5	26,0	10.845.120.450	100
	4,0 - 7,5	27,5	10.845.120.750	100
D 16,0	k 1,9	dk 19,0	l₁ max. 17,5	↓ 45000 N



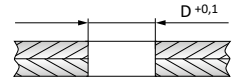
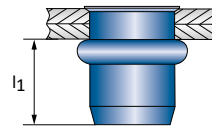
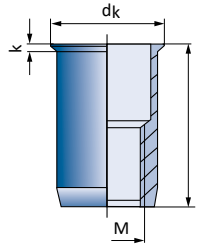
Blind Rivet Nut SSM-KLSK

Steel galvanized

Small countersunk head | Round shank | open



Series **841**



C4C [1.0303]

M	$\frac{D}{k}$	l	No.		
M4	0,5 - 2,0	10,0	10.841.040.200	500	
D 6,0	k 0,5	d _k 7,0	l ₁ max. 8,0	↻ 3,0 Nm	↕ 5000 N
M5	0,5 - 3,0	12,0	10.841.050.300	500	
D 7,0	k 0,5	d _k 8,0	l ₁ max. 9,0	↻ 5,0 Nm	↕ 9000 N

M	$\frac{D}{k}$	l	No.		
M6	0,5 - 3,0	15,0	10.841.060.300	500	
D 9,0	k 0,5	d _k 10,0	l ₁ max. 12,0	↻ 10,0 Nm	↕ 15000 N
M8	0,5 - 3,0	16,0	10.841.080.300	500	
D 11,0	k 0,5	d _k 12,0	l ₁ max. 13,5	↻ 20,0 Nm	↕ 20000 N

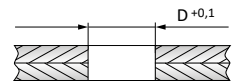
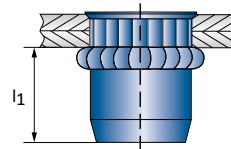
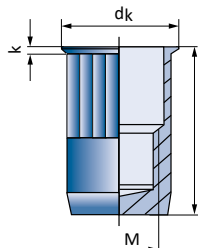
Blind Rivet Nut SSM-R-KLSK-G

Steel galvanized

Small countersunk head | Round shank knurled | closed



Series **847**



C4C [1.0303]

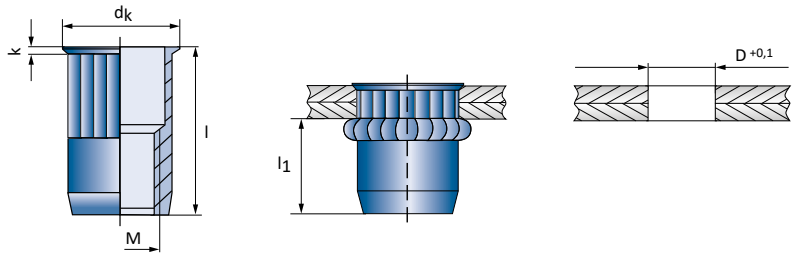
M	$\frac{D}{k}$	l	No.	
M4	0,5 - 2,0	14,5	10.847.040.200	500
D 6,0	k 0,4	d _k 7,0	l ₁ max. 12,5	↕ 6800 N
M5	0,5 - 3,0	18,5	10.847.050.300	500
D 7,0	k 0,5	d _k 8,0	l ₁ max. 14,5	↕ 10000 N
M6	0,5 - 3,0	21,0	10.847.060.300	500
D 9,0	k 0,5	d _k 10,0	l ₁ max. 17,0	↕ 15000 N

M	$\frac{D}{k}$	l	No.	
M8	0,7 - 4,0	24,0	10.847.080.400	500
D 11,0	k 0,5	d _k 12,0	l ₁ max. 19,0	↕ 27000 N
M10	1,0 - 4,5	29,0	10.847.100.450	250
D 13,0	k 0,6	d _k 14,0	l ₁ max. 23,0	↕ 37000 N



You can use the classic brief description of our blind rivet nuts for your inquiries or orders:

Serial name: **SSM-G**
 + Thread size: **M5**
 + Maximum grip range: **4,0 mm**
 = Brief description: **SSM 5-40 G**



C4C [1.0303]

M	$\frac{D}{2}$	l	No.	
M3	0,5 - 2,0	9,0	10.843.030.200	500
	2,0 - 3,5	10,5	10.843.030.350	500
D 5,0	k 0,4	dk 6,0	l₁ max. 5,5	↓ 4000 N
M4	1,0 - 2,0	10,0	10.843.040.200	500
	2,0 - 4,0	12,0	10.843.040.400	500
D 6,0	k 0,4	dk 7,0	l₁ max. 8,0	↓ 4800 N
M5	0,5 - 3,0	12,0	10.843.050.300	500
	2,0 - 4,5	14,0	10.843.050.450	500
D 7,0	k 0,5	dk 8,0	l₁ max. 9,0	↓ 8000 N
M6	0,5 - 3,0	13,5	10.843.060.300	500
	3,5 - 6,0	17,5	10.843.060.600	500
D 9,0	k 0,5	dk 10,0	l₁ max. 14,5	↓ 12000 N

M	$\frac{D}{2}$	l	No.	
M8	0,7 - 4,0	16,0	10.843.080.400	500
	3,5 - 6,0	18,0	10.843.080.600	500
D 11,0	k 0,5	dk 12,0	l₁ max. 16,0	↓ 18000 N
M10	1,0 - 4,5	20,5	10.843.100.450	250
	3,0 - 6,0	23,5	10.843.100.600	250
D 13,0	k 0,5	dk 14,0	l₁ max. 18,5	↓ 25000 N
M12	1,0 - 4,0	24,0	10.843.120.400	100
D 16,0	k 0,6	dk 17,0	l₁ max. 20,0	↓ 40000 N

Small Packages



SMALL PACKAGES

Blind Rivet Nut SFM-R

Steel galvanized

Flat head | Round shank knurled | open



M	$\frac{D}{2}$	l	No.	
M4	0,5 - 2,5	9,5	10.842.040.250/31	100
M5	0,5 - 3,0	12,0	10.842.050.300/31	100
M6	0,5 - 3,0	14,5	10.842.060.300/31	100
M8	0,5 - 3,0	16,0	10.842.080.300/42	50

Blind Rivet Nut UNIVERSAL

Steel galvanized

Small countersunk head | Round shank | open



M	$\frac{D}{2}$	l	No.	
M4	0,5 - 3,0	10,5	10.870.400.000/31	100
M5	0,5 - 3,0	11,5	10.870.500.000/31	100
M6	0,5 - 3,0	13,0	10.870.600.000/31	100
M8	0,5 - 3,0	15,5	10.870.800.000/31	100



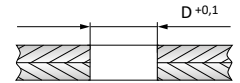
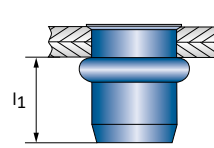
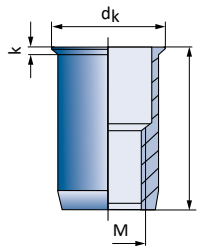
Blind Rivet Nut UNIVERSAL

Steel galvanized

Small countersunk head | Round shank | open



Series **870**



C4C [1.0303]

M	$\frac{k}{D}$	l	No.	
M4	0,5 - 3,0	10,5	10.870.400.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 7,0	↻ 3,0 Nm ⬆ 6500 N
M5	0,5 - 3,0	11,5	10.870.500.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 8,0	↻ 5,0 Nm ⬆ 8000 N
M6	0,5 - 3,0	13,0	10.870.600.000	500
D 8,0	k 0,4	dk 9,0	l ₁ max. 10,0	↻ 10,0 Nm ⬆ 11500 N

M	$\frac{k}{D}$	l	No.	
M8	0,5 - 3,0	15,5	10.870.800.000	500
D 10,0	k 0,4	dk 11,0	l ₁ max. 11,5	↻ 20,0 Nm ⬆ 14500 N
M10	0,5 - 3,0	17,5	10.870.100.000	250
D 12,0	k 0,4	dk 13,0	l ₁ max. 13,0	↻ 40,0 Nm ⬆ 22000 N

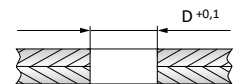
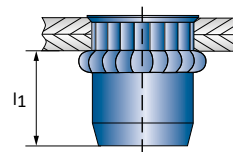
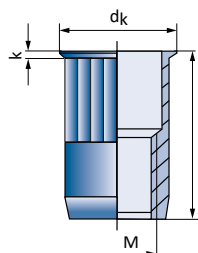
Blind Rivet Nut UNIVERSAL-R

Steel galvanized

Small countersunk head | Round shank knurled | open



Series **871**



C4C [1.0303]

M	$\frac{k}{D}$	l	No.	
M4	0,5 - 3,0	10,5	10.871.400.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 7,0	⬆ 6000 N
M5	0,5 - 3,0	11,5	10.871.500.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 8,0	⬆ 7500 N
M6	0,5 - 3,0	13,0	10.871.600.000	500
D 8,0	k 0,4	dk 9,0	l ₁ max. 10,0	⬆ 10000 N

M	$\frac{k}{D}$	l	No.	
M8	0,5 - 3,0	15,5	10.871.800.000	500
D 10,0	k 0,4	dk 11,5	l ₁ max. 11,5	⬆ 14000 N
M10	0,5 - 3,0	17,5	10.871.100.000	250
D 12,0	k 0,4	dk 13,0	l ₁ max. 13,0	⬆ 17500 N

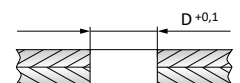
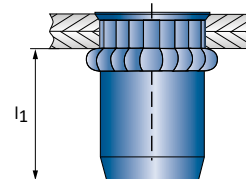
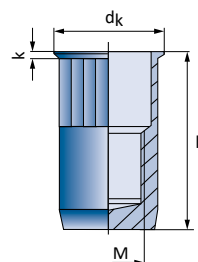
Blind Rivet Nut UNIVERSAL-R-G

Steel galvanized

Small countersunk head | Round shank knurled | closed



Series **872**



C4C [1.0303]

M	$\frac{k}{D}$	l	No.	
M4	0,5 - 2,5	16,5	10.872.400.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 13,0	⬆ 6000 N
M5	0,5 - 2,5	18,5	10.872.500.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 14,5	⬆ 7500 N

M	$\frac{k}{D}$	l	No.	
M6	0,5 - 3,0	20,5	10.872.600.000	500
D 8,0	k 0,4	dk 9,0	l ₁ max. 16,0	⬆ 10000 N

Series
874

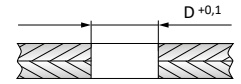
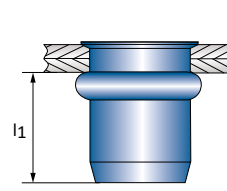
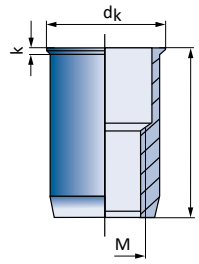
CAD
DATA
ONLINE

For imperial
holes
INCH

Blind Rivet Nut FLATSERT

Steel galvanized

Small countersunk head | Round shank | open



C4C [1.0303]

M	$\frac{D}{d}$	l	No.		
M3	0,5 - 2,0	9,0	10.874.300.000	500	
D 4,9	k 0,3	d _k 5,3	l ₁ max. 6,0	↻ 2,0 Nm	↑ 3000 N
M4	0,5 - 2,0	10,4	10.874.400.000	500	
D 6,4	k 0,4	d _k 7,2	l ₁ max. 8,0	↻ 3,0 Nm	↑ 6000 N
M5	0,5 - 3,2	12,0	10.874.500.000	500	
D 7,2	k 0,5	d _k 8,1	l ₁ max. 9,0	↻ 5,0 Nm	↑ 9500 N

M	$\frac{D}{d}$	l	No.		
M6	0,8 - 4,0	15,0	10.874.600.000	500	
D 9,6	k 0,5	d _k 10,5	l ₁ max. 11,0	↻ 10,0 Nm	↑ 13000 N
M8	1,0 - 4,0	16,0	10.874.800.000	500	
D 10,6	k 0,6	d _k 11,5	l ₁ max. 13,5	↻ 20,0 Nm	↑ 16000 N

FLATSERT

Series
844

CAD
DATA
ONLINE

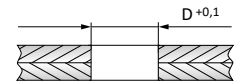
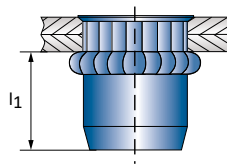
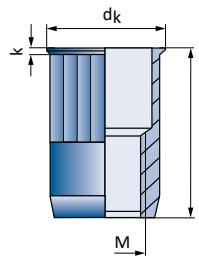


For imperial
holes
INCH

Blind Rivet Nut FLATSERT-R

Steel galvanized

Small countersunk head | Round shank knurled | open



C4C [1.0303]

M	$\frac{D}{d}$	l	No.		
M4	0,5 - 2,0	10,0	10.844.400.000	500	
D 6,4	k 0,4	d _k 7,2	l ₁ max. 8,0	↻ xxx	↑ 5500 N
M5	0,5 - 3,2	12,0	10.844.500.000	500	
D 7,2	k 0,5	d _k 8,1	l ₁ max. 9,0	↻ xxx	↑ 9000 N

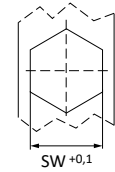
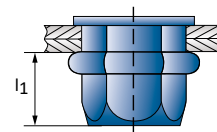
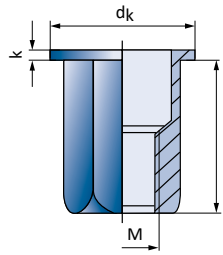
M	$\frac{D}{d}$	l	No.		
M6	0,7 - 3,2	15,0	10.844.600.000	500	
D 9,6	k 0,5	d _k 10,4	l ₁ max. 11,0	↻ xxx	↑ 12000 N
M8	0,7 - 4,0	16,0	10.844.800.000	500	
D 10,6	k 0,5	d _k 11,5	l ₁ max. 13,5	↻ xxx	↑ 15000 N



Blind Rivet Nut HEXAFORM-FK

Steel galvanized

Flat head | Hexagonal shank | open



C4C [1.0303]

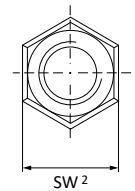
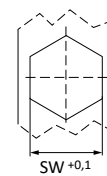
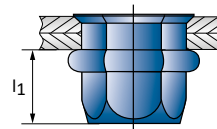
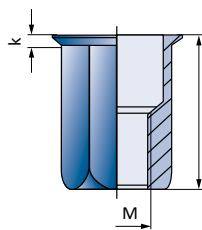
M	$\frac{k}{dk}$	l	No.		
M4	0,5 - 2,0	10,0	10.868.040.200	500	
SW 6,0	k 1,0	dk 9,0	l ₁ max. 7,5	↻ 5,0 Nm	↕ 5200 N
M5	0,5 - 3,0	12,5	10.868.050.300	500	
SW 7,0	k 1,0	dk 10,0	l ₁ max. 8,5	↻ 7,0 Nm	↕ 9500 N
M6	0,5 - 3,0	14,5	10.868.060.300	500	
	3,0 - 5,5	17,0	10.868.060.550	500	
SW 9,0	k 1,5	dk 13,0	l ₁ max. 10,5	↻ 13,0 Nm	↕ 16500 N

M	$\frac{k}{dk}$	l	No.		
M8	0,5 - 3,0	17,5	10.868.080.300	250	
	3,0 - 6,0	20,5	10.868.080.600	250	
SW 11,0	k 1,5	dk 16,0	l ₁ max. 13,0	↻ 25,0 Nm	↕ 23500 N
M10	1,0 - 4,5	21,0	10.868.100.450	250	
	3,5 - 6,0	24,0	10.868.100.600	250	
SW 13,0	k 2,0	dk 19,0	l ₁ max. 16,5	↻ 55,0 Nm	↕ 37000 N
M12	1,5 - 5,0	25,0	10.868.120.500	100	
SW 16,0	k 2,0	dk 23,0	l ₁ max. 19,0	↻ 85,0 Nm	↕ 56000 N

Blind Rivet Nut HEXAFORM-KLSK

Steel galvanized

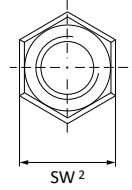
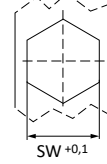
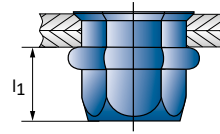
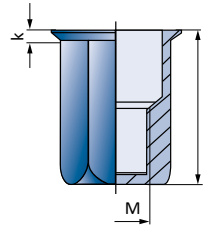
Small countersunk head | Hexagonal shank | open



C4C [1.0303]

M	$\frac{k}{dk}$	l	No.		
M3	1,5 - 3,0	9,7	10.892.030.250	500	
SW 5,0	SW ² 6,0	k 0,5	l ₁ max. 4,5	↻ 1,2 Nm	↕ 3500 N
M4	0,6 - 2,0	11,0	10.892.040.200	500	
	2,0 - 4,0	13,0	10.892.040.400	500	
SW 6,0	SW ² 6,6	k 0,6	l ₁ max. 7,5	↻ 5,0 Nm	↕ 5000 N
M5	0,7 - 3,0	13,5	10.892.050.300	500	
	3,0 - 5,5	16,0	10.892.050.550	500	
SW 7,0	SW ² 7,7	k 0,7	l ₁ max. 8,5	↻ 7,0 Nm	↕ 9000 N
M6	0,8 - 3,0	15,5	10.892.060.300	500	
	3,0 - 5,5	18,0	10.892.060.550	500	
SW 9,0	SW ² 9,8	k 0,8	l ₁ max. 10,5	↻ 13,0 Nm	↕ 16000 N

M	$\frac{k}{dk}$	l	No.		
M8	0,8 - 3,0	18,5	10.892.080.300	250	
	3,0 - 6,0	21,5	10.892.080.600	250	
SW 11,0	SW ² 11,8	k 0,8	l ₁ max. 13,0	↻ 25,0 Nm	↕ 23000 N
M10	1,0 - 3,5	22,5	10.892.100.350	250	
	3,0 - 6,0	23,5	10.892.100.600	250	
SW 13,0	SW ² 14,3	k 0,9	l ₁ max. 16,5	↻ 55,0 Nm	↕ 36500 N
M12	1,0 - 4,0	24,5	10.892.120.400	100	
SW 16,0	SW ² 17,3	k 0,9	l ₁ max. 17,5	↻ 85,0 Nm	↕ 55000 N



C4C [1.0303]

M	$\frac{SW}{SW^2}$	l	No.		
M4	0,5 - 2,5	16,0	10.887.040.250	500	
SW 6,0	SW ² 6,6	k 0,5	l ₁ max. 10,0	5,0 Nm	5200 N
M5	0,5 - 3,0	20,0	10.887.050.300	500	
SW 7,0	SW ² 7,7	k 0,6	l ₁ max. 12,5	7,0 Nm	9500 N
M6	0,5 - 3,0	22,0	10.887.060.300	500	
SW 9,0	SW ² 9,8	k 0,7	l ₁ max. 16,0	13,0 Nm	16500 N

M	$\frac{SW}{SW^2}$	l	No.		
M8	0,5 - 3,5	25,5	10.887.080.350	250	
	3,0 - 6,0	28,0	10.887.080.600	250	
SW 11,0	SW ² 11,8	k 0,7	l ₁ max. 17,5	25,0 Nm	23500 N
M10	1,0 - 3,5	28,0	10.887.100.350	250	
SW 13,0	SW ² 14,3	k 0,9	l ₁ max. 20,0	55,0 Nm	37000 N

HEXAFORM

Optimum leak tightness

We supply neoprene rings either loose or preassembled by machine, or produce the required connectors with directly moulded and certified sealants.



Blind Rivet Nut HEXATOP-FK

Steel galvanized

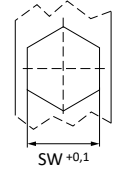
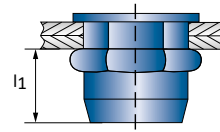
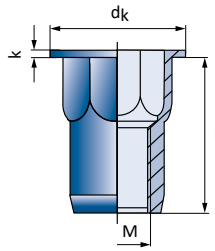
Flat head | Partial hexagonal shank | open

For imperial holes
INCH



CAD DATA ONLINE

Series **867**



C4C [1.0303]

M	$\frac{k}{d_k}$	l	No.		
M4	0,5 - 2,0	10,0	10.867.040.200	500	
SW 6,4	k 0,6	d _k 8,0	l ₁ max. 7,5	↻ 4,0 Nm	↕ 3800 N
M5	0,5 - 3,0	12,5	10.867.050.300	500	
SW 7,2	k 0,7	d _k 9,0	l ₁ max. 9,0	↻ 6,0 Nm	↕ 6000 N
M6	0,5 - 3,0	14,5	10.867.060.300	500	
SW 9,6	k 0,8	d _k 12,0	l ₁ max. 11,5	↻ 11,0 Nm	↕ 9500 N

M	$\frac{k}{d_k}$	l	No.		
M8	0,5 - 3,0	16,5	10.867.080.300	250	
SW 10,6	k 1,5	d _k 16,0	l ₁ max. 13,0	↻ 24,0 Nm	↕ 12500 N
M10	0,5 - 3,0	19,0	10.867.100.300	250	
SW 12,7	k 2,0	d _k 16,5	l ₁ max. 16,5	↻ 50,0 Nm	↕ 37000 N

HEXATOP

Blind Rivet Nut HEXATOP-KLSK

Steel galvanized

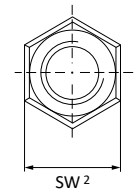
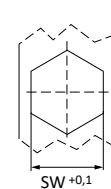
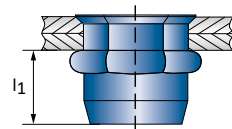
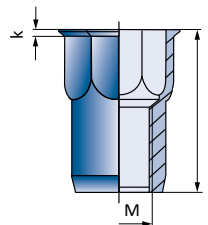
Small countersunk head | Partial hexagonal shank | open

For imperial holes
INCH



CAD DATA ONLINE

Series **893**



C4C [1.0303]

M	$\frac{k}{d_k}$	l	No.		
M4	0,5 - 2,0	10,0	10.893.040.200	500	
SW 6,4	SW ² 7,0	k 0,4	l ₁ max. 7,5	↻ 4,0 Nm	↕ 3800 N
M5	0,6 - 3,0	12,5	10.893.050.300	500	
SW 7,2	SW ² 8,0	k 0,5	l ₁ max. 9,0	↻ 6,0 Nm	↕ 6000 N
M6	0,5 - 3,0	15,5	10.893.060.300	500	
SW 9,6	SW ² 10,5	k 0,5	l ₁ max. 11,5	↻ 11,0 Nm	↕ 9500 N

M	$\frac{k}{d_k}$	l	No.		
M8	0,5 - 3,0	18,0	10.893.080.300	250	
SW 10,6	SW ² 11,5	k 0,6	l ₁ max. 14,0	↻ 24,0 Nm	↕ 12500 N
M10	1,0 - 4,0	22,5	10.893.100.400	250	
SW 12,7	SW ² 14,4	k 0,8	l ₁ max. 16,0	↻ 50,0 Nm	↕ 37000 N

HEXAGONS AND MORE.

Special versions available directly from stock.

In addition to the standard products with torsional resistance available in all areas, a large number of article variants for example with **special surfaces, larger head diameters/heights** are immediately available.



For example

- HEXAFORM M6-45 K 18 x 2.5 20.868.060.450-1
Blind rivet nut with M6 hexagon shaft, steel, large flat head (diameter 18.0 x height 2.5 mm),
clamping range 3.0 - 4.5 mm
- HEXAFORM M8-30 K 20 x 1.5 20.868.800.000-4
Blind rivet nut with M8 hexagon shaft, steel, large flat head (diameter 20.0 x height 1.5 mm),
clamping range 0.5 - 3.0 mm



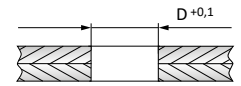
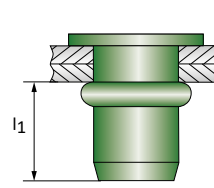
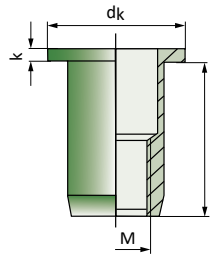
Blind Rivet Nut EFM

Stainless steel A2

Flat head | Round shank | open



Series **858**



[1.4567]

M	$\frac{D}{2}$	l	No.		
M4	0,5 - 2,5	11,0	10.858.040.250	500	
	2,5 - 4,0	12,5	10.858.040.400	500	
D 6,0	k 1,0	dk 9,0	l₁ max. 8,0	↻ 4,0 Nm	↕ 7000 N
M5	0,5 - 3,0	12,0	10.858.050.300	500	
	3,0 - 4,5	13,5	10.858.050.450	500	
D 7,0	k 1,5	dk 10,0	l₁ max. 8,5	↻ 6,0 Nm	↕ 11000 N
M6	0,5 - 3,0	14,0	10.858.060.300	500	
	3,0 - 5,0	16,0	10.858.060.500	500	
D 9,0	k 1,5	dk 12,0	l₁ max. 10,0	↻ 11,0 Nm	↕ 18000 N

M	$\frac{D}{2}$	l	No.		
M8	0,5 - 3,0	16,0	10.858.080.300	500	
	3,0 - 5,5	18,5	10.858.080.550	250	
D 11,0	k 1,5	dk 15,0	l₁ max. 11,5	↻ 24,0 Nm	↕ 27000 N
M10	1,0 - 3,5	19,0	10.858.100.350	250	
D 13,0	k 2,0	dk 17,0	l₁ max. 14,0	↻ 50,0 Nm	↕ 40000 N
M12	1,0 - 4,0	24,0	10.858.120.400	100	
D 16,0	k 2,0	dk 23,0	l₁ max. 16,5	↻ 85,0 Nm	↕ 57000 N

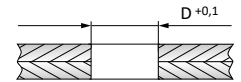
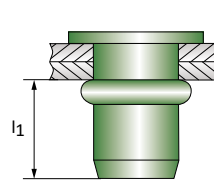
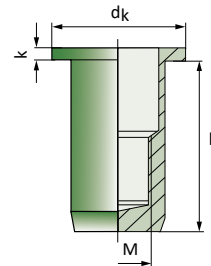
Blind Rivet Nut EFM-G

Stainless steel A2

Flat head | Round shank | closed



Series **860**

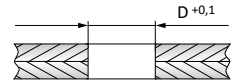
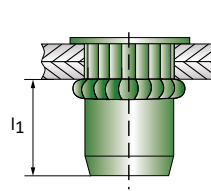
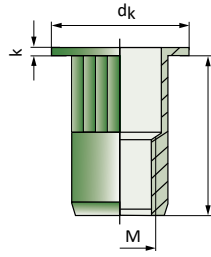


[1.4567]

M	$\frac{D}{2}$	l	No.		
M4	0,5 - 2,5	16,0	10.860.040.250	500	
D 6,0	k 1,0	dk 9,0	l₁ max. 13,0	↻ 4,0 Nm	↕ 7000 N
M5	0,5 - 3,0	18,0	10.860.050.300	500	
D 7,0	k 1,0	dk 10,0	l₁ max. 14,5	↻ 6,0 Nm	↕ 11000 N
M6	0,5 - 3,0	21,0	10.860.060.300	500	
D 9,0	k 1,5	dk 12,0	l₁ max. 16,0	↻ 11,0 Nm	↕ 18000 N

M	$\frac{D}{2}$	l	No.		
M8	0,5 - 3,0	23,5	10.860.080.300	250	
D 11,0	k 1,5	dk 15,0	l₁ max. 19,0	↻ 24,0 Nm	↕ 27000 N
M10	1,0 - 3,5	26,5	10.860.100.350	100	
D 13,0	k 2,0	dk 17,0	l₁ max. 21,0	↻ 50,0 Nm	↕ 40000 N

Larger grip ranges, closed end versions or threads measured in inches?
A large number of products not included in this catalogue are available from stock. Ask for minimum quantities for production of blind rivet nuts according to your specification.



[1.4567]

M		l	No.	
M3	0,5 - 2,0	9,0	10.848.030.200	500
	2,0 - 3,5	9,0	10.848.030.350	500
D 5,0	k 0,8	dk 8,0	l₁ max. 7,0	↓ 4000 N
M4	0,5 - 2,5	11,0	10.848.040.250	500
	2,5 - 4,0	12,5	10.848.040.400	500
D 6,0	k 0,8	dk 9,0	l₁ max. 8,0	↓ 6500 N
M5	0,5 - 3,0	12,0	10.848.050.300	500
	3,0 - 4,5	13,5	10.848.050.450	500
D 7,0	k 1,0	dk 10,0	l₁ max. 8,5	↓ 10000 N

M		l	No.	
M6	0,5 - 3,0	14,5	10.848.060.300	500
	3,0 - 5,0	16,0	10.848.060.500	500
D 9,0	k 1,5	dk 12,0	l₁ max. 10,0	↓ 17000 N
M8	0,5 - 3,0	16,0	10.848.080.300	500
	3,0 - 5,5	18,5	10.848.080.550	250
D 11,0	k 1,5	dk 15,0	l₁ max. 12,0	↓ 25000 N
M10	1,0 - 3,5	19,0	10.848.100.350	250
	3,5 - 6,0	21,5	10.848.100.600	250
D 13,0	k 2,0	dk 17,0	l₁ max. 14,0	↓ 38000 N

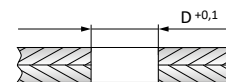
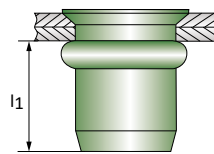
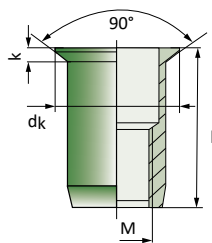
Blind Rivet Nut ESM

Stainless steel A2

Countersunk head | Round shank | open



Series **859**



[1.4567]

M	$\frac{D}{k}$	l	No.		
M4	1,5 - 4,0	12,0	10.859.040.400	500	
D 6,0	k 1,5	dk 9,0	l ₁ max. 8,0	↻ 4,0 Nm	↓ 7000 N
M5	1,5 - 4,5	13,5	10.859.050.450	500	
	4,5 - 6,0	15,0	10.859.050.600	500	
D 7,0	k 1,5	dk 10,0	l ₁ max. 8,5	↻ 6,0 Nm	↓ 11000 N
M6	1,5 - 4,5	16,0	10.859.060.450	500	
	4,5 - 6,5	18,0	10.859.060.650	500	
D 9,0	k 1,5	dk 12,0	l ₁ max. 10,0	↻ 11,0 Nm	↓ 16000 N

M	$\frac{D}{k}$	l	No.		
M8	1,5 - 4,5	18,0	10.859.080.450	500	
	4,5 - 6,5	20,0	10.859.080.650	250	
D 11,0	k 1,5	dk 14,0	l ₁ max. 11,5	↻ 24,0 Nm	↓ 27000 N
M10	1,5 - 4,0	22,0	10.859.100.400	250	
	D 13,0	k 1,6	dk 16,0	l ₁ max. 14,5	↻ 50,0 Nm
M12	1,7 - 4,5	26,0	10.859.120.400	100	
	D 16,0	k 2,0	dk 19,0	l ₁ max. 18,0	↻ 85,0 Nm

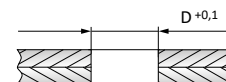
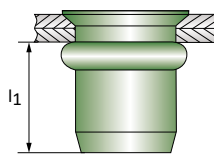
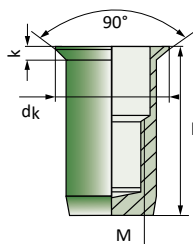
Blind Rivet Nut ESM-G

Stainless steel A2

Countersunk head | Round shank | closed



Series **861**

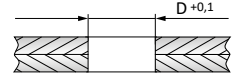
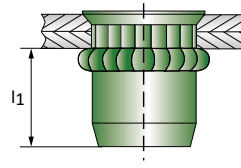
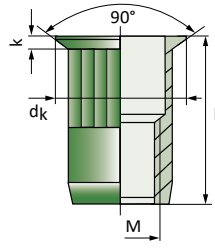


[1.4567]

M	$\frac{D}{k}$	l	No.		
M4	1,5 - 4,0	17,0	10.861.040.400	500	
D 6,0	k 1,5	dk 8,3	l ₁ max. 10,5	↻ 3,0 Nm	↓ 6800 N
M5	1,5 - 4,5	19,5	10.861.050.450	500	
	D 7,0	k 1,5	dk 9,3	l ₁ max. 15,5	↻ 6,0 Nm

M	$\frac{D}{k}$	l	No.		
M6	1,5 - 4,5	23,0	10.861.060.450	500	
	D 9,0	k 1,5	dk 11,3	l ₁ max. 17,0	↻ 11,0 Nm
M8	1,5 - 4,5	26,0	10.861.080.450	500	
	D 11,0	k 1,5	dk 13,3	l ₁ max. 19,0	↻ 24,0 Nm





[1.4567]

M	$\frac{D}{k}$	l	No.	
M3	2,0 - 3,5	10,5	10.865.030.350	500
D 5,0	k 1,5	dk 8,0	l ₁ max. 6,5	↕ 3700 N
M4	1,5 - 4,0	12,0	10.865.040.400	500
D 6,0	k 1,5	dk 9,0	l ₁ max. 8,0	↕ 6500 N
M5	1,5 - 4,5	13,0	10.865.050.450	500
D 7,0	k 1,5	dk 10,0	l ₁ max. 8,5	↕ 10000 N

M	$\frac{D}{k}$	l	No.	
M6	1,5 - 4,5	16,0	10.865.060.450	500
	4,5 - 6,5	18,0	10.865.060.650	500
D 9,0	k 1,5	dk 12,0	l ₁ max. 10,0	↕ 15000 N
M8	1,5 - 4,5	18,0	10.865.080.450	500
	4,0 - 6,5	21,0	10.865.080.650	250
D 11,0	k 1,5	dk 14,0	l ₁ max. 12,0	↕ 25000 N
M10	2,0 - 4,5	21,0	10.865.100.450	250
D 13,0	k 1,6	dk 16,0	l ₁ max. 14,5	↕ 38000 N

ESM



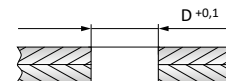
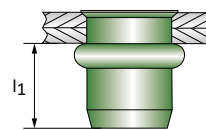
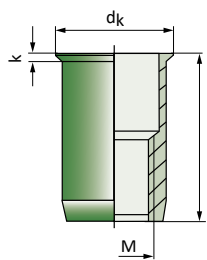
Blind Rivet Nut ESM-KLSK

Stainless steel A2

Small countersunk head | Round shank | open

CAD
DATA
ONLINE

Series
802



[1.4567]

M	$\frac{D}{k}$	l	No.		
M4	0,5 - 2,5	11,0	10.802.040.250	500	
D 6,0	k 0,5	dk 7,0	l ₁ max. 8,0	↻ 4,0 Nm	↕ 6500 N
M5	0,5 - 3,0	12,0	10.802.050.300	500	
D 7,0	k 0,5	dk 8,0	l ₁ max. 8,5	↻ 6,0 Nm	↕ 10000 N
M6	0,5 - 3,0	14,0	10.802.060.300	500	
D 9,0	k 0,5	dk 10,0	l ₁ max. 10,0	↻ 11,0 Nm	↕ 15000 N

M	$\frac{D}{k}$	l	No.		
M8	0,5 - 3,0	16,0	10.802.080.300	500	
D 11,0	k 0,5	dk 12,0	l ₁ max. 11,5	↻ 24,0 Nm	↕ 25000 N
M10	1,0 - 3,5	19,2	10.802.100.350	250	
D 13,0	k 0,7	dk 14,0	l ₁ max. 14,0	↻ 50,0 Nm	↕ 38000 N

Blind Rivet Nut ESM-KLSK-G

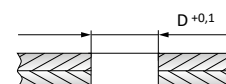
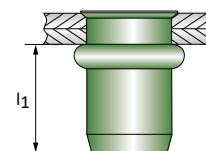
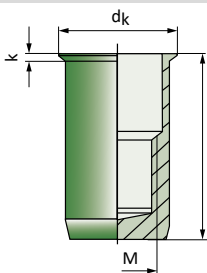
Stainless steel A2

Small countersunk head | Round shank | closed



CAD
DATA
ONLINE

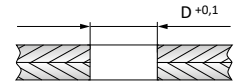
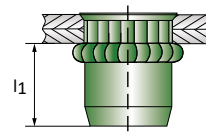
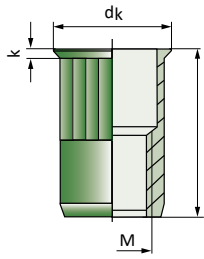
Series
840



[1.4567]

M	$\frac{D}{k}$	l	No.		
M4	0,5 - 2,5	16,0	10.840.040.250	500	
D 6,0	k 0,5	dk 7,0	l ₁ max. 13,0	↻ 4,0 Nm	↕ 7000 N
M5	0,5 - 3,0	18,0	10.840.050.300	500	
D 7,0	k 0,5	dk 8,0	l ₁ max. 14,5	↻ 6,0 Nm	↕ 11000 N
M6	0,5 - 3,0	21,0	10.840.060.300	500	
D 9,0	k 0,5	dk 10,0	l ₁ max. 16,0	↻ 11,0 Nm	↕ 18000 N

M	$\frac{D}{k}$	l	No.		
M8	0,5 - 3,0	23,5	10.840.080.300	500	
D 11,0	k 0,5	dk 12,0	l ₁ max. 19,0	↻ 24,0 Nm	↕ 27000 N
M10	1,0 - 3,5	26,5	10.840.100.350	100	
D 13,0	k 0,7	dk 14,0	l ₁ max. 22,0	↻ 50,0 Nm	↕ 40000 N



[1.4567]

M	$\frac{D}{d}$	l	No.	
M3	0,5 - 2,0	9,0	10.849.030.200	500
	2,0 - 3,5	10,5	10.849.030.350	500
D 5,0	k 0,4	dk 6,0	l₁ max. 7,0	↓ 3500 N
M4	0,5 - 3,0	10,0	10.849.040.300	500
	2,5 - 4,0	12,5	10.849.040.400	500
D 6,0	k 0,4	dk 7,0	l₁ max. 8,0	↓ 6500 N
M5	0,5 - 3,0	11,5	10.849.050.300	500
	3,0 - 4,5	13,5	10.849.050.450	500
D 7,0	k 0,5	dk 8,0	l₁ max. 8,5	↓ 10000 N
M6	0,5 - 3,0	14,0	10.849.060.300	500
	3,0 - 5,0	16,0	10.849.060.500	500
D 9,0	k 0,5	dk 10,0	l₁ max. 10,0	↓ 15000 N

M	$\frac{D}{d}$	l	No.	
M8	0,5 - 3,0	16,0	10.849.080.300	500
	3,0 - 6,0	19,5	10.849.080.600	500
D 11,0	k 0,5	dk 12,0	l₁ max. 11,5	↓ 25000 N
M10	1,0 - 3,5	19,2	10.849.100.350	250
D 13,0	k 0,7	dk 14,0	l₁ max. 14,0	↓ 38000 N
M12	1,0 - 4,0	24,0	10.849.120.400	100
D 16,0	k 0,7	dk 17,0	l₁ max. 16,0	↓ 50000 N

Please ask for our extensive possibilities of stainless steel blind rivet nuts in turned quality.



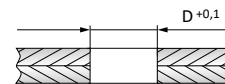
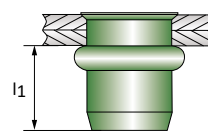
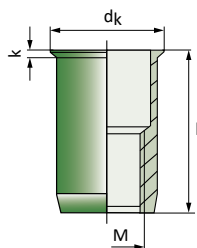
Blind Rivet Nut UNIVERSAL-E

Stainless steel A2

Small countersunk head | Round shank | open

CAD
DATA
ONLINE

Series
873



[1.4567]

M	$\frac{D}{k}$	l	No.	
M4	0,5 - 3,0	10,5	10.873.400.000	500

D 7,0 k 0,4 d_k 8,0 l₁ max. 8,0 \curvearrowright 3,0 Nm \updownarrow 7000 N

M	$\frac{D}{k}$	l	No.	
M5	0,5 - 3,0	11,5	10.873.500.000	500

D 7,0 k 0,4 d_k 8,0 l₁ max. 8,5 \curvearrowright 5,0 Nm \updownarrow 11000 N

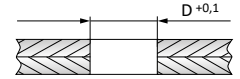
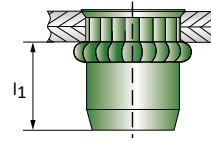
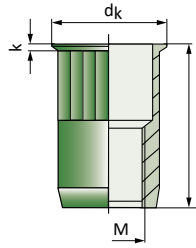
M	$\frac{D}{k}$	l	No.	
M6	0,5 - 3,0	13,0	10.873.600.000	500

D 8,0 k 0,4 d_k 9,0 l₁ max. 10,0 \curvearrowright 10,0 Nm \updownarrow 18000 N



M	$\frac{D}{k}$	l	No.	
M8	0,5 - 3,0	15,5	10.873.800.000	500



D 10,0 k 0,4 d_k 11,0 l₁ max. 11,5 \curvearrowright 20,0 Nm \updownarrow 27000 N





[1.4567]

M		l	No.	
M4	0,5 - 3,0	10,5	10.891.400.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 8,0	⇕ 6800 N
M5	0,5 - 3,0	11,5	10.891.500.000	500
D 7,0	k 0,4	dk 8,0	l ₁ max. 8,5	⇕ 10000 N
M6	0,5 - 3,0	13,0	10.891.600.000	500
D 8,0	k 0,4	dk 9,0	l ₁ max. 10,0	⇕ 14000 N

M		l	No.	
M8	0,5 - 3,0	15,5	10.891.800.000	500
D 10,0	k 0,4	dk 11,0	l ₁ max. 11,5	⇕ 25000 N
M10	0,5 - 3,0	17,5	10.891.100.000	250
D 12,0	k 0,5	dk 13,0	l ₁ max. 14,0	⇕ 37000 N

UNIVERSAL

29.000 N setting force!

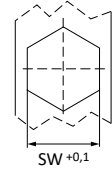
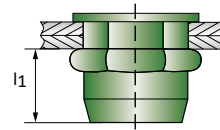
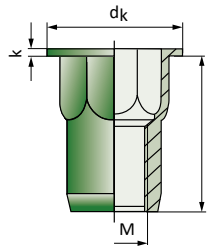
VNG 903

The power pack.

For blind rivet nuts up to M10 – optionally up to M12!

Blind Rivet Nut HEXATOP-E-FK

Stainless steel A2
Flat head | Partial hexagonal shank | open



[1.4567]

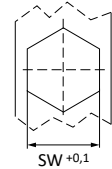
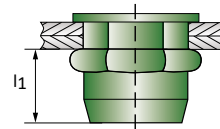
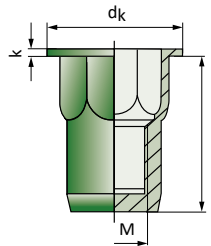
M	$\frac{d}{h}$	l	No.		
M3	0,5 - 2,0	9,0	10.877.030.200	500	
SW 5,0	k 0,8	d _k 8,0	l ₁ max. 6,5	↻ 2,0 Nm	↕ 4000 N
M4	0,5 - 2,5	12,0	10.877.040.250	500	
SW 6,0	k 1,0	d _k 9,5	l ₁ max. 8,5	↻ 5,0 Nm	↕ 6500 N
M5	0,5 - 3,0	13,5	10.877.050.300	500	
SW 7,0	k 1,0	d _k 10,5	l ₁ max. 9,0	↻ 7,0 Nm	↕ 10000 N

M	$\frac{d}{h}$	l	No.		
M6	0,5 - 3,0	15,5	10.877.060.300	500	
SW 9,0	k 1,5	d _k 12,5	l ₁ max. 10,0	↻ 13,0 Nm	↕ 17000 N
M8	0,5 - 3,0	17,5	10.877.080.300	250	
SW 11,0	k 1,5	d _k 14,5	l ₁ max. 11,5	↻ 25,0 Nm	↕ 27000 N
M10	1,0 - 3,5	19,0	10.877.100.350	250	
SW 13,0	k 2,0	d _k 16,5	l ₁ max. 13,5	↻ 55,0 Nm	↕ 39000 N

HEXATOP

Blind Rivet Nut HEXATOP-E-FK-G

Stainless steel A2
Flat head | Partial hexagonal shank | closed



[1.4567]

M	$\frac{d}{h}$	l	No.		
M6	0,5 - 3,0	21,0	10.804.060.300	500	
SW 9,0	k 1,5	d _k 12,0	l ₁ max. 17,0	↻ 13,0 Nm	↕ 17000 N

M	$\frac{d}{h}$	l	No.		
M8	0,5 - 3,0	23,5	10.804.080.300	250	
SW 11,0	k 1,5	d _k 14,5	l ₁ max. 19,0	↻ 25,0 Nm	↕ 27000 N



Series
879

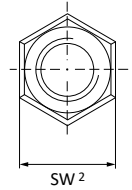
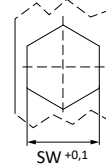
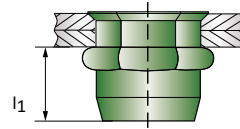
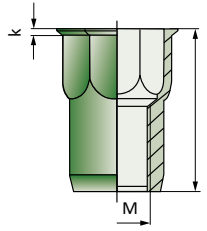
CAD
DATA
ONLINE



Blind Rivet Nut HEXATOP-E-KLSK

Stainless steel A2

Small countersunk head | Partial hexagonal shank | open



[1.4567]

M	$\frac{\pm}{\text{mm}}$	l	No.	
M3	0,5 - 2,0	9,0	10.879.030.200	500
SW 5,0	SW ² 6,0	k 0,5	l ₁ max. 5,5	↻ 2,0 Nm ⬆ 3800 N
M4	0,5 - 2,5	11,0	10.879.040.250	500
	2,5 - 4,0	12,5	10.879.040.400	500
SW 6,0	SW ² 6,8	k 0,5	l ₁ max. 8,5	↻ 5,0 Nm ⬆ 6000 N
M5	0,5 - 3,0	12,0	10.879.050.300	500
	3,0 - 4,5	13,5	10.879.050.450	500
SW 7,0	SW ² 8,0	k 0,5	l ₁ max. 9,0	↻ 7,0 Nm ⬆ 9500 N
M6	0,5 - 3,0	14,0	10.879.060.300	500
	3,0 - 5,0	16,0	10.879.060.500	500
SW 9,0	SW ² 10,0	k 0,5	l ₁ max. 10,0	↻ 13,0 Nm ⬆ 16000 N

M	$\frac{\pm}{\text{mm}}$	l	No.	
M8	0,5 - 3,0	16,0	10.879.080.300	250
	3,0 - 5,5	18,5	10.879.080.550	250
SW 11,0	SW ² 12,0	k 0,5	l ₁ max. 11,5	↻ 25,0 Nm ⬆ 26000 N
M10	1,0 - 3,5	19,0	10.879.100.350	250
SW 13,0	SW ² 14,4	k 0,7	l ₁ max. 14,0	↻ 55,0 Nm ⬆ 39000 N
M12	1,0 - 4,0	24,0	10.879.120.400	100
SW 16,0	SW ² 17,3	k 0,7	l ₁ max. 19,0	↻ 85,0 Nm ⬆ 55000 N

HEXATOP

Series
805

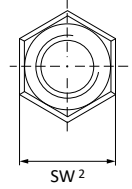
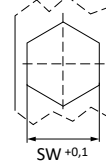
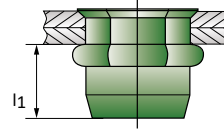
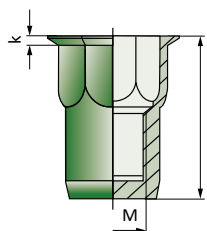
CAD
DATA
ONLINE



Blind Rivet Nut HEXATOP-E-KLSK-G

Stainless steel A2

Small countersunk head | Partial hexagonal shank | closed



[1.4567]

M	$\frac{\pm}{\text{mm}}$	l	No.	
M4	0,5 - 2,5	16,0	10.805.040.250	500
SW 6,0	SW ² 6,8	k 0,5	l ₁ max. 10,5	↻ 5,0 Nm ⬆ 6000 N
M5	0,5 - 3,0	18,0	10.805.050.300	500
SW 7,0	SW ² 7,8	k 0,5	l ₁ max. 12,5	↻ 7,0 Nm ⬆ 9500 N

M	$\frac{\pm}{\text{mm}}$	l	No.	
M6	0,5 - 3,0	21,0	10.805.060.300	500
SW 9,0	SW ² 9,8	k 0,7	l ₁ max. 16,0	↻ 13,0 Nm ⬆ 16000 N
M8	0,5 - 3,0	23,5	10.805.080.300	250
SW 11,0	SW ² 11,8	k 0,7	l ₁ max. 17,5	↻ 25,0 Nm ⬆ 26000 N



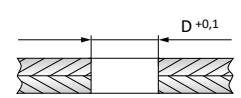
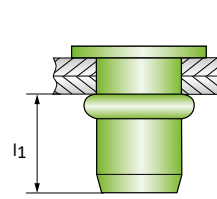
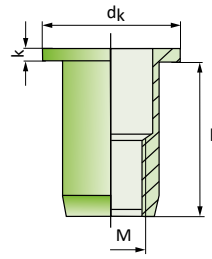
You can use the classic brief description of our blind rivet nuts for your inquiries or orders:

Serial name: **ESM-KLSK-G**
 + Thread size: **M8**
 + Maximum grip range: **3,0 mm**
 = Brief description: **ESM-KLSK 8-30 G**

Blind Rivet Nut EFM A4

Stainless steel A4

Flat head | Partial hexagonal shank | open



M	$\frac{D}{k}$	l	No.	
M4	0,5 - 2,0	10,2	10.858.040.200/79	500

D 6,0 k 0,8 dk 9,0 l₁ max. 8,0 \curvearrowright 5,0 Nm \updownarrow 7000 N

M5	0,5 - 3,0	12,0	10.858.050.300/79	500
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D 7,0 k 1,0 dk 10,0 l₁ max. 8,0 \curvearrowright 8,0 Nm \updownarrow 11000 N

M	$\frac{D}{k}$	l	No.	
M6	0,5 - 3,0	14,5	10.858.060.300/79	500

D 9,0 k 1,5 dk 12,0 l₁ max. 10,0 \curvearrowright 15,0 Nm \updownarrow 18000 N

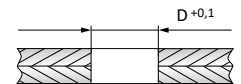
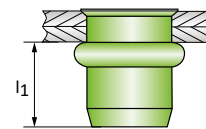
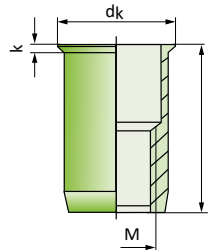
M8	0,5 - 3,0	16,0	10.858.080.350/79	250
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D 11,0 k 1,5 dk 15,0 l₁ max. 11,5 \curvearrowright 26,0 Nm \updownarrow 27000 N

Blind Rivet Nut ESM-KLSK A4

Stainless steel A4

Small countersunk head | Partial hexagonal shank | open



M	$\frac{D}{k}$	l	No.	
M4	0,5 - 2,0	10,0	10.802.040.200/79	500

D 6,0 k 0,5 dk 6,8 l₁ max. 8,0 \curvearrowright 3,0 Nm \updownarrow 6500 N

M5	0,5 - 3,0	12,0	10.802.050.300/79	500
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D 7,0 k 0,5 dk 8,0 l₁ max. 8,5 \curvearrowright 6,0 Nm \updownarrow 10000 N

M	$\frac{D}{k}$	l	No.	
M6	0,5 - 3,0	14,0	10.802.060.300/79	500

D 9,0 k 0,5 dk 10,0 l₁ max. 10,0 \curvearrowright 11,0 Nm \updownarrow 15000 N

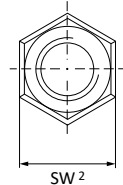
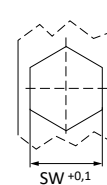
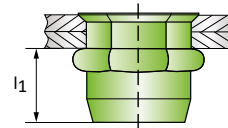
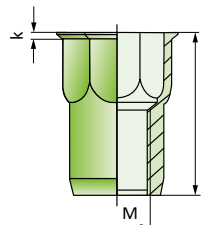
M8	1,0 - 4,0	16,5	10.802.080.400/79	250
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D 11,0 k 0,6 dk 12,0 l₁ max. 11,5 \curvearrowright 20,0 Nm \updownarrow 25000 N

Blind Rivet Nut HEXATOP A4

Stainless steel A4

Small countersunk head | Partial hexagonal shank | open



M	$\frac{D}{k}$	l	No.	
M4	0,5 - 2,0	10,0	10.879.040.200/79	500

SW 6,0 SW² 6,8 k 0,5 l₁ max. 8,5 \curvearrowright 5,0 Nm \updownarrow 6500 N

M5	0,5 - 2,0	12,0	10.879.050.200/79	500
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SW 7,0 SW² 8,0 k 0,6 l₁ max. 9,0 \curvearrowright 8,0 Nm \updownarrow 10000 N

M	$\frac{D}{k}$	l	No.	
M6	0,5 - 3,0	14,0	10.879.060.300/79	500

SW 9,0 SW² 10,0 k 0,6 l₁ max. 10,0 \curvearrowright 15,0 Nm \updownarrow 15000 N

M8	0,5 - 3,5	16,5	10.879.080.350/79	250
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SW 11,0 SW² 12,0 k 0,6 l₁ max. 11,5 \curvearrowright 26,0 Nm \updownarrow 25000 N

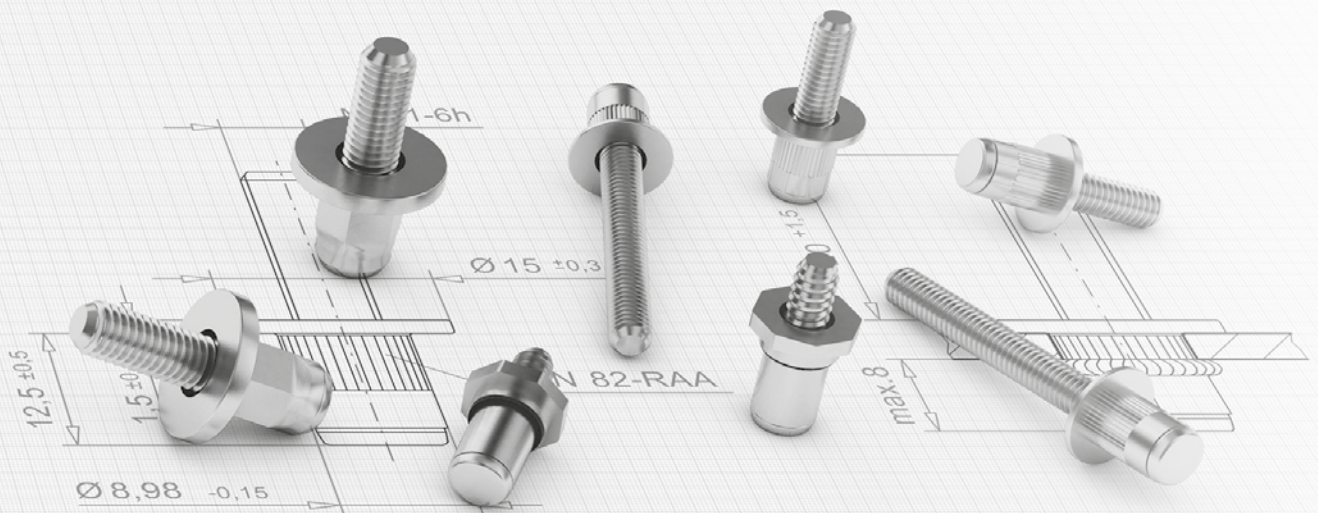
Seawater-proof and more.

High-quality materials such as stainless steel A4 or nickel-copper are rapidly growing in importance. Added to these are various surface finishes, such as zinc-nickel coatings that give our connecting elements the best possible resistance to corrosion, salts or acids. A large number of sizes are available from stock – please ask us.

Our experts will be happy to advise you..



SPECIAL BLIND RIVET BOLTS



The HONSEL Group is one of the **leading developers** of the RIFBOLT® blind rivet bolt developed on the basis of the setting principle of the blind rivet nut.

High-strength 360° laser welded variants or a partial scratch protection coating to avoid damage to delicate surfaces are just a few of the many innovations in this field.

In this product segment, too, it is possible to design and produce individual special versions for your application if there is sufficient demand.

Parameters such as bolt length, thread type (coarse thread, etc.), sleeve designs (knurled, hexagonal) or head form (flat, countersunk and large dome head, small countersunk head) can be modified, where necessary.

Aluminium, steel and stainless steel are available as materials. Fitted or injection moulded seals can be applied for perfect sealing.





Blind Rivet Bolts

A blind rivet bolt consists of a **blind rivet nut** and a **bolt** that are joined together by welding or crimping.

Both parts can be produced in-house so that quick and flexible implementation of individual solutions in development and production is guaranteed.

Blind rivet bolts offer the **multiple benefits**,

- >> of joining different parts reliably together, and
- >> being able to integrate a thread carrier
- >> to which a further component can be connected.

As with all other blind rivet products, processing is possible on parts that are accessible from **only one side** and is **quick without damaging the surface** – for example, with our standard tools for blind rivet nuts from the VNG Series.

Blind rivet bolts are an outstanding **alternative to the classic welded bolt** and are being increasingly used accordingly, also as substitution.

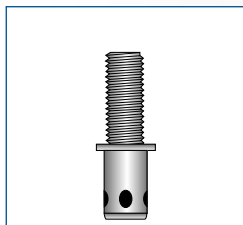
For the greatly risen demand for this **safe, reliable and inexpensive assembly process in industrial series production**, we have a wide range of products available from stock to meet needs at short notice.



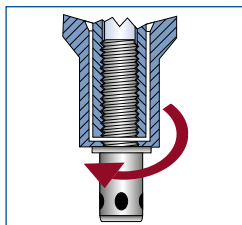
TECHNICAL EXPLANATIONS

Blind rivet threaded bolts principally work in the same way as blind rivet nuts. It is only necessary to replace the threaded mandrels of the setting device with threaded sleeves (interior threads).

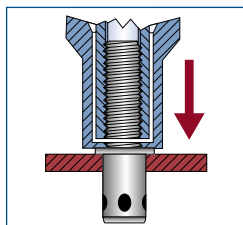
The sleeve of the blind rivet bolt is inserted into the prepared borehole and deformed by the stroke of the tool. Knurled types or versions with (partial) hexagonal shaft are available to decrease the danger of the fasteners rotation in the hole.



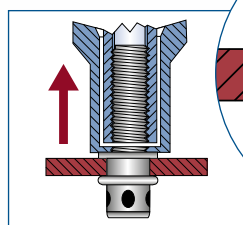
1. RIFBOLT®-Blind rivet bolt



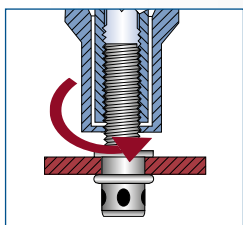
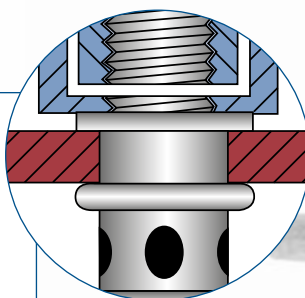
2. Screwing into the device nose piece



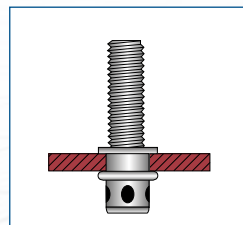
3. Insertion into the take-up hole of the workpiece



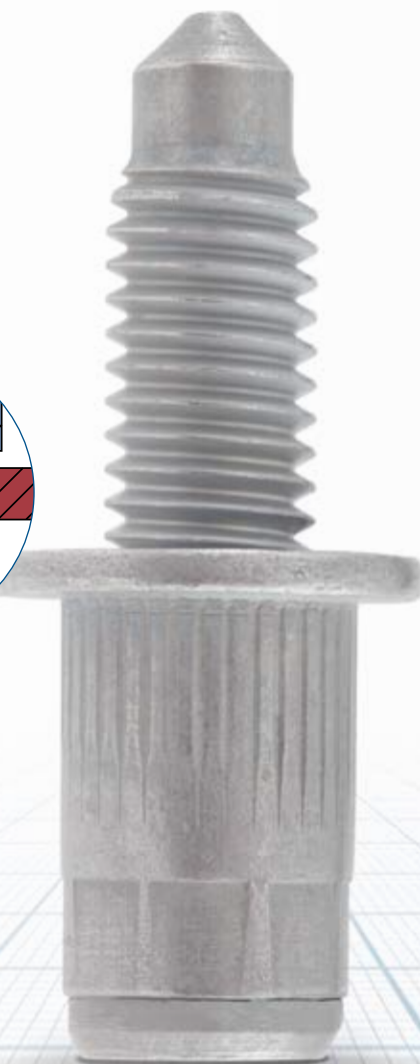
4. Riveting by tightening

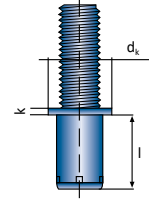
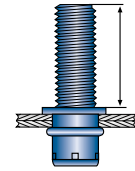
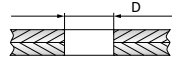


5. Spindling of the blind rivet bolt.



6. Lowering the installed RIFBOLT® blind rivet bolt.



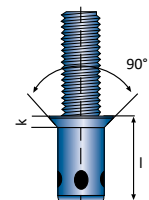
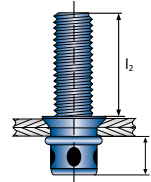
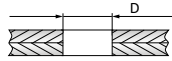


M	$\frac{D}{2}$	l	l ₂	No.		€/ 1.000
M4	0,3 - 2,0	8,5	10	10.880.042.010	500	349,60
	2,0 - 3,0	10,0	15	10.880.043.015	500	370,00
l ₁ max. 5,0 D 5,5 d ₁ 8,0 k 0,5 7000 N 4 Nm 5000 N						
M5	0,5 - 2,0	9,4	10	10.880.052.010	500	386,30
	2,0 - 3,5	10,9	15	10.880.053.515	500	401,50
l ₁ max. 6,0 D 6,6 d ₁ 9,0 k 0,8 9500 N 6 Nm 8000 N						

M	$\frac{D}{2}$	l	l ₂	No.		€/ 1.000
M6	0,5 - 2,5	10,9	10	10.880.062.510	500	417,00
	0,5 - 2,5	10,9	15	10.880.062.515	500	430,00
	2,5 - 4,0	12,4	15	10.880.064.015	500	437,90
l ₁ max. 7,0 D 7,8 d ₁ 10,0 k 1,0 12000 N 11 Nm 9500 N						
M8	1,0 - 3,0	14,0	15	10.880.083.015	250	602,90
	3,0 - 5,0	16,0	15	10.880.085.015	250	648,10
	3,0 - 5,0	16,0	20	10.880.085.020	250	653,30
l ₁ max. 9,0 D 9,9 d ₁ 12,0 k 1,5 23500 N 24 Nm 12000 N						

l₂ = length of the screw after setting; it depends on grip range and tool adjustment.

Property class of the screw: 8.8



M	$\frac{D}{2}$	l	l ₂	No.		€/ 1.000
M5	1,5 - 2,9	10,5	10	10.881.053.110	500	391,20
	1,5 - 2,9	10,5	15	10.881.053.115	500	396,00
l ₁ max. 6,0 D 6,6 k 1,1 9500 N 6 Nm 8000 N						
M6	1,5 - 3,4	12,0	10	10.881.063.610	500	420,50
	1,5 - 3,4	12,0	15	10.881.063.615	500	433,50
l ₁ max. 7,0 D 7,8 k 1,1 12000 N 11 Nm 9500 N						

M	$\frac{D}{2}$	l	l ₂	No.		€/ 1.000
M8	1,5 - 3,9	15,0	10	10.881.084.115	250	628,70
	1,5 - 3,9	15,0	20	10.881.084.120	250	640,40
l ₁ max. 9,0 D 9,9 k 1,2 23500 N 24 Nm 12000 N						

l₂ = length of the screw after setting; it depends on grip range and tool adjustment.

Property class of the screw: 8.8

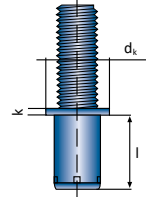
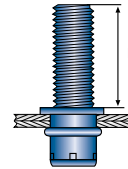
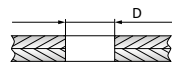
Blind Rivet Bolt RIFBOLT® -FK2

Steel galvanized

Flat head | Round shank

CAD
DATA
ONLINE

Series
884



M	$\frac{D}{d_k}$	l	l ₂	No.	
M5	0,5 - 2,0	13,0	15	10.884.053.015	500

D 7,0 d_k 10,0 k 1,0 ↻ 7 Nm ↓ 7000 N

M6	0,5 - 2,5	15,0	20	10.884.063.020	250
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D 9,0 d_k 12,0 k 1,2 ↻ 10 Nm ↓ 10000 N

M	$\frac{D}{d_k}$	l	l ₂	No.	
M8	0,5 - 3,0	15,5	20	10.884.083.020	250

D 11,0 d_k 15,0 k 1,5 ↻ 26 Nm ↓ 23500 N

l₂ = length of the screw after setting; it depends on grip range and tool adjustment.

RIFBOLT®

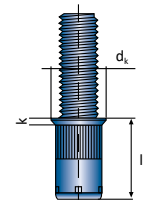
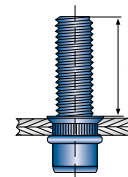
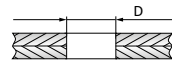
Blind Rivet Bolt RIFBOLT® -KLSK R

Steel galvanized

Small countersunk head | Round Shank knurled

CAD
DATA
ONLINE

Series
883



M	$\frac{D}{d_k}$	l	l ₂	No.	
M4	0,5 - 2,0	11,0	10	10.883.043.010	500

D 6,0 d_k 6,8 k 0,5 ↓ 5000 N

M5	0,5 - 2,0	13,0	15	10.883.053.015	500
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D 7,0 d_k 8,0 k 0,6 ↓ 7000 N

M	$\frac{D}{d_k}$	l	l ₂	No.	
M6	0,5 - 2,5	15,0	20	10.883.063.020	250

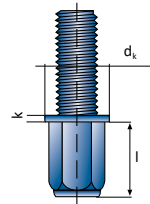
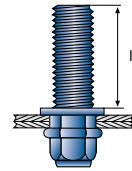
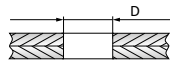
D 9,0 d_k 10,0 k 0,6 ↓ 10000 N



M8	1,0 - 3,0	18,0	20	10.883.083.020	250
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D 11,0 d_k 12,0 k 0,6 ↓ 18000 N

l₂ = length of the screw after setting; it depends on grip range and tool adjustment.







M		l	l ₂	No.	
M5	0,5 - 3,0	11,0	15	10.885.053.015	500

SW 7 d_k 10,0 k 1,0 ↻ 7 Nm ↓ 7000 N

M6	0,5 - 3,0	13,0	20	10.885.063.020	500
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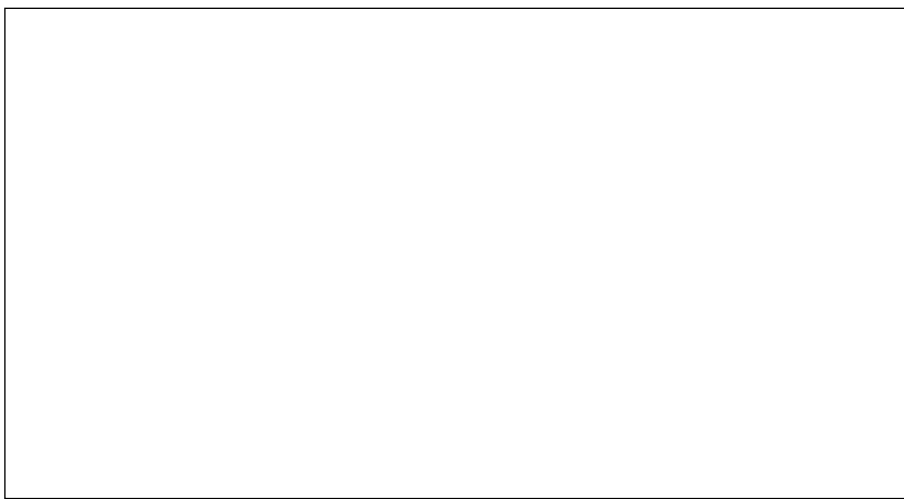
SW 9 d_k 13,0 k 1,5 ↻ 10 Nm ↓ 10000 N

M		l	l ₂	No.	
M8	0,5 - 3,0	14,0	20	10.885.083.020	250

SW 11 d_k 16,0 k 1,5 ↻ 26 Nm ↓ 23500 N

l₂ = length of the screw after setting; it depends on grip range and tool adjustment.





Price 3.00 €

All prices exclusive of VAT.

Subject to technical and
editorial changes.