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IFI NOTES:

1. This specification is under the jurisdiction of the IFI Standards and Technical Practices Committee and directly under the Technical Committee of IFI's Division I. First published in 1982 it has been revised and reissued in 1999. Sizes in this document are based on a soft conversion from inch practice and reflect the needs of major users.
2. There are no national consensus standards or ISO standards for this product at this time.

1.0 Introductory Notes

1.1 Scope. This standard establishes the dimensional, mechanical, and performance requirements of metric break mandrel closed end blind rivets suitable for use in joining the component parts of an assembly.

1.2 Definitions

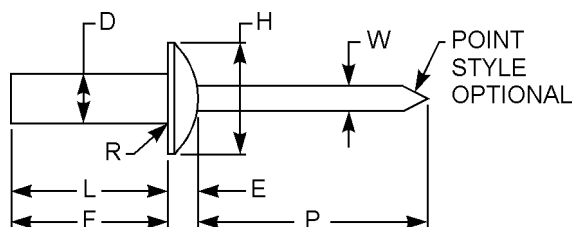


Table 1 Dimensions of Protruding Head Style Break Mandrel Closed End Blind Rivets

Rivet Series No.	Nom Rivet Size	D		H		E	R	W	P	F
		Body Dia		Style 1 – Regular Head			Radius of Fillet	Mandrel Dia	Mandrel Protrusion	Blind Side Protrusion
				Head Dia		Head Height				
		Max	Min	Max	Min	Max	Max	Max	Max	Min
4	3.2	3.25	3.10	6.40	5.69	1.27	0.7	1.85	25	Equal to "L" Rivet Length
5	4.0	4.04	3.89	8.33	7.52	1.65	0.7	2.31	27	
6	4.8	4.85	4.65	10.01	9.04	2.03	0.7	2.77	27	
8	6.3	6.48	6.25	13.33	12.07	2.54	0.7	3.71	27	
See Notes							3			4

NOTES:

1. All dimensions are in millimeters.
2. For application data see Table 2.
3. The junction of head and shank shall have a fillet with a max radius as shown.
4. The blind side protrusion (F) equals the max length of rivet (L) as given in Table 2 for the applicable grip. Minimum blind side clearance may be calculated by subtracting the actual grip (G), (i.e., the total thickness of the material to be joined), from the blind side protrusion (F). (Example: To join two plates each 2.5 mm thick with a No. 5 rivet, a No. 54 rivet would be used. Minimum blind side clearance necessary to permit proper rivet setting would be $L - G$, which is $12.7 - 5.0$, and equals 7.7 mm).

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**Table 2 Application Data for Protruding Head Style
Break Mandrel Closed End Blind Rivets**

Rivet Series No.	Nom Rivet Size	Recom- mended Metric Drill Size	Recommended Hole Size		Rivet No.	Grip Range	Rivet Length L
			Max	Min			Max
4	3.2	3.3	3.38	3.28	41	0.5 to 1.6	7.5
					42	1.7 to 3.2	9.1
					43	3.3 to 4.8	10.7
					44	4.9 to 6.4	12.3
					45	6.5 to 7.9	13.9
					46	8.0 to 9.5	15.5
					48	9.6 to 12.7	18.7
5	4.0	4.1	4.16	4.06	52	0.5 to 3.2	9.5
					53	3.3 to 4.8	11.1
					54	4.9 to 6.4	12.7
					55	6.5 to 7.9	14.3
					56	8.0 to 9.5	15.9
					58	9.6 to 12.7	19.1
6	4.8	4.9	4.98	4.88	62	0.5 to 3.2	10.3
					63	3.3 to 4.8	11.9
					64	4.9 to 6.4	13.5
					66	6.5 to 9.5	16.7
					68	9.6 to 12.7	19.8
					610	12.8 to 15.9	23.0
					612	16.0 to 19.1	26.1
8	6.3	6.5	6.63	6.53	82	0.5 to 3.2	11.3
					84	3.3 to 6.4	14.5
					86	6.5 to 9.5	17.7
					88	9.6 to 12.7	20.8
					810	12.8 to 15.9	24.0
					812	16.0 to 19.1	27.2
					814	19.2 to 22.2	30.4
					816	22.3 to 25.4	33.5
See Notes		2					

NOTES:

1. All dimensions are in millimeters.
2. Recommended drill sizes are those which normally produce holes within the specified hole size limits.

1.2.1 Blind Rivet. A blind rivet is a blind fastener which has a self-contained mechanical, chemical or other feature which permits the formation of an upset on the blind end of the rivet and expansion of the rivet shank during rivet setting to join the component parts of an assembly.

1.2.2 Break mandrel closed end blind rivets are pull mandrel type blind rivets where during the setting operation the mandrel is pulled within the rivet body and breaks at or near the junction of the mandrel shank and its upset end.

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