

## Blind rivet systems – Blind rivets



Note: When inquiring about 5 digit part numbers beginning with 8, please preface the number with R264-. Example: 88111 should be R264-88111.

### Blind rivets: Function and assembly process

Blind rivet technology was developed as a fastening procedure for hollow profiles and similar single-side access use fields.

The simple, fast, and thus very economical, blind rivet principle has since replaced conventional fastening tasks in many assembly fields and is continually finding new fields of application.

Maryland Metrics has a comprehensive range with blind rivets that a suitable design is available for every purpose. The placement devices provided are ergonomically formed and designed for long-term professional use.

	<p>① The blind rivet is inserted into the drill hole from the front of the work piece. The drift pin is incorporated until the head fits from the die of the setting tool. The blind rivet size is based on load and material strength.</p>
	<p>② Through operation of the setting tool the protruding end of the rivet body is reformed through the drift pin head into a closing-head. At the same time the materials are compressed.</p>
	<p>③ The rivet pin is pre-programmed to snap off at the predetermined breaking point – a secure rivet fastening is completed.</p>

### Dimensions blind rivets

R264 - article	Dimensions	2.4	3	3.2	4	4.8	5	6	6.4	
Rivet Mandrel										
Open-end blind rivet with protruding head acc. to DIN 7337-A	d <sub>2</sub>	5	6.5	6.5	8	9.5	9.5	12	13	
	k	0.65	1.0	1.0	1.2	1.3	1.3	1.5	1.8	
	d <sub>m</sub> (steel/Al)	1.55/1.55	2.00/2.05	2.00/2.05	2.45/2.65	2.95/3.30	2.95/3.30	3.40/3.80	3.90/4.00	
	drill Ø	2.5	3.1	3.3	4.1	4.9	5.1	6.1	6.5	
88401 steel zinc plated/steel zinc plated	Material rivet	Shear strength <sub>min</sub> in N <sub>max</sub> <sup>1)</sup> (Tensile strength <sub>min</sub> in N <sub>max</sub> <sup>1)</sup> )								
		Al alloy	350 (300)	550 (480)	650 (550)	800 (900)	1400 (1800)	1600 (2000)	2500 (3000)	2800 (3500)
	steel	650 (700)	900 (1100)	950 (1200)	1500 (2200)	2500 (3300)	2800 (3600)	3800 (4300)	4500 (5500)	
	A2, A4	1000 (1400)	1800 (2200)	1900 (2500)	2700 (3500)	400 (5000)	4700 (5800)	-	7500 (10100)	
88402 Al alloy/steel zinc plated	copper	-	650 (800)	750 (850)	1200 (1700)	-	-	-	-	
88403 Al alloy/A2										
88404 A2/A2										
88405 A 2/steel zinc plated	Length	Clamping length range (min – max) <sup>2)</sup>								
		4	0.5-1.5	0.5-1.5	0.5-1.5	-	-	-	-	-
88406 copper/steel zinc plated	Length	5	-	1.5-2.5	-	0.5-1.5	-	-	-	-
		6	1.5-3.5	2.5-3.5	1.5-3.5	1.5-3.0	2.0-2.5	2.0-2.5	-	-
88407 copper/bronze	Length	8	3.5-5.0	4.5-5.0	3.5-5.0	4.0-5.0	2.5-4.5	2.5-4.5	2.0-3.0	-
		10	-	5.0-7.0	5.0-7.0	5.0-6.5	4.5-6.0	4.5-6.0	3.0-5.0	-
88410 Al alloy/Al alloy	Length	12	-	7.0-9.0	7.0-9.0	6.5-8.5	6.0-8.0	6.0-8.0	5.0-7.0	2.0-6.0
		14	-	9.0-11.0	9.0-11.0	8.5-10.5	8.0-10.0	8.0-10.0	-	-
88415 A4/A4	Length	16	-	11.0-13.0	11.0-13.0	10.5-12.5	10.0-12.0	10.0-12.0	7.0-11.0	6.0-10.0
		18	-	13.0-15.0	13.0-15.0	10.5-12.5	12.0-14.0	12.0-14.0	11.0-13.0	10.0-12.0
88417 Al alloy/steel zinc plated	Length	20	-	15.0-17.0	15.0-17.0	14.5-16.5	14.0-15.0	14.0-15.0	13.0-15.0	12.0-14.0
		25	-	17.0-22.0	17.0-22.0	16.5-21.5	15.0-20.0	15.0-20.0	15.0-20.0	14.0-18.0
	Length	30	-	22.0-26.0	-	21.5-26.0	20.0-25.0	20.0-25.0	20.0-24.0	18.0-23.0
		35	-	-	-	26.0-30.0	-	25.0-30.0	24.0-29.0	-
	Length	40	-	-	-	30.0-35.0	-	30.0-35.0	29.0-34.0	-
		45	-	-	-	-	-	35.0-40.0	-	-
	Length	50	-	-	-	-	-	40.0-45.0	34.0-44.0	-
		60	-	-	-	-	-	48.0-52.0	-	-
	Length	65	-	-	-	-	-	52.0-57.0	-	-
		70	-	-	-	-	-	57.0-62.0	-	-
	Length	80	-	-	-	-	-	62.0-72.0	-	-

<sup>1)</sup> acc. to DIN 7337  
<sup>2)</sup> field with value = stock/  
 without = special part