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AS9100 Rev. C / ISO 9002 Certified

Aerospace Solid Rivets

| Nominal Body Diameter | | | 1/16 | 3/32 | 1/8 | 5/32 | 3/16 | 1/4 | 5/16 | 3/8 |
|-----------------------|--------------------------------|---------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| *Clinch Allowance | | | .062/.093 | .094/.141 | .125/.1875 | .156/.234 | .187/.280 | .250/.375 | .312/.468 | .375/.562 |
| Drill Size | | | 51 (.067) | 40 (.098) | 30 (.129) | 20 (.161) | 11 (.191) | F (.257) | P (.323) | W (.386) |
| | **MS20426 100° COUNTERSUNK | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.159 | .186/.190 | .249/.253 | .311/.315 | .374/.378 |
| | | HEAD DIAMETER | .110/.118 | .175/.183 | .221/.229 | .282/.290 | .349.357 | .472/.480 | .560/.568 | .690/.698 |
| | | HEAD HEIGHT | .022 Ref. | .036 Ref. | .042 Ref. | .055 Ref. | .070 Ref. | .095 Ref. | .106 Ref. | .134 Ref. |
| | **MS20427 100° COUNTERSUNK | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.159 | .186/.190 | .249/.253 | .311/.315 | .374/.378 |
| | | HEAD DIAMETER | .0898/.1346 | .1548/.1900 | .2006/.2360 | .2566/.2976 | .3234/.3654 | .4412/.4890 | .5288/.5772 | .6586/.7074 |
| | | HEAD HEIGHT | .0317 Max. | .0418 Max. | .0483 Max. | .0614 Max. | .0769 Max. | .1034 Max. | .1147 Max. | .1436 Max. |
| | AN430 ROUND HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.1285 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .250/.262 | .296/.328 | .356/.394 | .475.525 | .594/.656 | .713/.787 |
| | | HEAD HEIGHT | .042/.052 | .065/.075 | .089/.099 | .112/.122 | .134/.148 | .179/.197 | .222/.246 | .267/.295 |
| | MS20435 ROUND HEAD | BODY DIAMETER | .059/.066 | .090/.097 | .121/.129 | .152/.160 | .183/.192 | .245/.254 | .305/.317 | .365/.380 |
| | | HEAD DIAMETER | .109 R. | .188 R. | .219 R. | .273 R. | .327 R. | .438 R. | .546 R. | .656 R. |
| | | HEAD HEIGHT | .047 R. | .071 R. | .094 R. | .117 R. | .140 R. | .188 R. | .234 R. | .281 R. |
| | AN441 FLAT HEAD | BODY DIAMETER | .059/.066 | .090/.097 | .121/.129 | .152/.160 | .183/.192 | .245/.254 | .305/.317 | .365/.380 |
| | | HEAD DIAMETER | .126 R. | .188 R. | .219 R. | .273 R. | .327 R. | .438 R. | .546 R. | .656 R. |
| | | HEAD HEIGHT | .021 R. | .071 R. | .094 R. | .117 R. | .140 R. | .188 R. | .234 R. | .281 R. |
| | AN442 FLAT HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.1285 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | .594/.656 | .713/.787 |
| | | HEAD HEIGHT | .020/.030 | .033/.043 | .045/.055 | .057/.067 | .070/.080 | .095/.105 | .120/.130 | .143/.157 |
| | AN455 BRAZIER HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.1285 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .148/.164 | .222/.246 | .296/.328 | .371/.411 | .446/.492 | .594/.656 | .742/.820 | .890/.984 |
| | | HEAD HEIGHT | .026/.036 | .042/.052 | .057/.067 | .073/.083 | .089/.099 | .119/.131 | .148/.164 | .178/.196 |
| | AN456 MODIFIED BRAZIER HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.1285 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .106/.126 | .146/.166 | .225/.245 | .302/.322 | .380/.400 | .458/478 | .613/.637 | .766/.796 |
| | | HEAD HEIGHT | .020/.030 | .026/.036 | .042/.052 | .058/.068 | .073/.083 | .089/.099 | .120/.130 | .151/.161 |
| | MS20470 UNIVERSAL HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.159 | .186/.190 | .249/.253 | .311/.315 | .374/.378 |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | .594/.656 | .713/.787 |
| | | HEAD HEIGHT | .027/.037 | .040/.050 | .054/.064 | .067/.077 | .080/.090 | .107/.117 | .133/.143 | .161/.171 |
| | MS20613 UNIVERSAL HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | .594/.656 | .713/.787 |
| | | HEAD HEIGHT | .027/.037 | .040/.050 | .054/.064 | .067/.077 | .080/.090 | .107/.117 | .133/.143 | .161/.171 |
| | MS20615 UNIVERSAL HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.160 | .186/.191 | .249/.254 | .311/.316 | .374/.379 |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | .594/.656 | .713/.787 |
| | | HEAD HEIGHT | .027/.037 | .040/.050 | .054/.064 | .067/.077 | .080/.090 | .107/.117 | .133/.143 | .161/.171 |
| | NAS508 UNIVERSAL HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.160 | .186/.191 | .249/.254 | | |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | | |
| | | HEAD HEIGHT | .027/.037 | .040/.050 | .054/.064 | .067/.077 | .080/.090 | .107/.117 | | |
| | **NAS1097 100° FLUSH SHEAR | BODY DIAMETER | | .093/.097 | .124/.127 | .155/.158 | .186/.189 | .249/.252 | | |
| | | HEAD DIAMETER | | .1263/.1478 | .1742/.1957 | .2254/.2469 | .2824/.3016 | .3756/.3948 | | |
| | | HEAD HEIGHT | | .021 Ref. | .0286 Ref. | .0372 Ref. | .046 Ref. | .060 Ref. | | |
| | NAS1198 UNIVERSAL HEAD | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.160 | .186/.191 | .249/.254 | | |
| | | HEAD DIAMETER | .119/.131 | .178/.196 | .238/.262 | .296/.328 | .356/.394 | .475.525 | | |
| | | HEAD HEIGHT | .027/.037 | .040/.050 | .054/.064 | .067/.077 | .080/.090 | .107/.117 | | |
| | **NAS1199 100° COUNTERSUNK | BODY DIAMETER | .061/.065 | .093/.097 | .124/.128 | .155/.160 | .186/.190 | .249/.254 | | |
| | | HEAD DIAMETER | .0898/.1346 | .1548/.190 | .2006/.2630 | .2566/.2976 | .3234/.3654 | .4412/.4890 | | |
| | | HEAD HEIGHT | .0317 Max. | .0418 Max. | .0483 Max. | .0614 Max. | .0769 Max. | .1034 Max. | | |






* Clinch Allowance is equal to 1 to 1.5x body diameter

** Countersunk Head Diameters are measured to a theoretical point




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Mil-Spec Material & Head Markings


| |  |  |  |  |  |  |
|------------------------------------|---|---|---|---|--|---|
| MATERIAL & HEAD MARK | UNIVERSAL HEAD | 100° COUNTERSUNK | ROUND HEAD | FLAT HEAD | BRAZIER HEAD | MODIFIED BRAZIER |
| 1100-F ALUMINUM No Head Mark | MS20470A | MS20426A | AN430A | AN442A | AN455A | AN456A |
| 2117-T4 ALUMINUM Dimple | MS20470AD | MS20426AD | AN430AD | AN442AD | AN455AD | AN456AD |
| 5056-H32 ALUMINUM Raised Cross | MS20470B | MS20426B | AN430B | AN442B | AN455B | AN456B |
| 2017-T4 ALUMINUM Raised Dot | MS20470D | MS20426D | AN430D | AN442D | AN455D | AN456D |
| 7050-T73 ALUMINUM Indented Ring | MS20470E | MS20426E | | | | |
| CARBON STEEL Varies | MS20613_P | MS20427 | MS20435 | AN441 | | |
| COPPER No Head Mark | MS20615_CU | MS20427C | MS20435C | AN441C | | |
| BRASS No Head Mark | MS20615_B | MS20427B | MS20435B | AN441B | | |
| 300 SERIES STAINLESS Varies | MS20613_C | MS20427F | MS20435F | AN441F | | |
| MONEL Varies | MS20615_M | MS20427M | MS20435M | AN441M | | |

Compression Rivet Squeezers


Hand Held "C" Yoke

|  | RIVET CAPACITY DIAMETER | | STANDARD YOKE | | MAX FORCE with 90 PSI AIR PRESSURE | SET HOLDER | |
|---|-------------------------|-------------|---------------|---------------|---------------------------------------|------------|------------------------|
| | ALUMINUM | STEEL | REACH | GAP | | MAX TRAVEL | STROKE at MAX POWER |
| 30C15 | 1/8 (3.17) | 3/32 (2.36) | 1 1/2 (38.1) | 1 1/4 (31.75) | 3000 | 9/16 | 1/16 |
| 60C15 | 3/16 (4.75) | 5/32 (3.96) | 1 1/2 (38.1) | 1 1/4 (31.75) | 6000 | 9/16 | 1/16 |
| 90C15 | 1/4 (6.35) | 3/16 (4.75) | 1 1/2 (38.1) | 1 1/4 (31.75) | 9000 | 9/16 | 1/16 |

Bench Mount "C" Yoke

|  | YOKE THICKNESS | REACH | GAP | MAX FORCE WITH 90 PSI AIR PRESSURE |
|---|----------------|-----------|-------|---------------------------------------|
| 30C90B | 1 3/8 | 6 (152.4) | 3 1/2 | 3000 |
| 60C90B | 1 5/8 | 9 (228.6) | 3 1/2 | 6000 |

Alligator Squeezers

|  | RIVET CAPACITY DIAMETER | | STANDARD YOKE DIMENSIONS | | MAX FORCE with 90 PSI (6.21 BAR) AIR PRESSURE PSI (KN) | MOVING JAW | |
|---|-------------------------|-------|--------------------------|---------------|--|----------------|-------------------|
| | ALUM | STEEL | REACH in INCHES | CLOSED HEIGHT | | MAXIMUM TRAVEL | MAXIMUM STROKE |
| 30A15HD | 1/8 | 3/32 | 1 1/2 | 7/8 | 3000 | 5/8 | 1/16 |
| 30A22HD | 3/32 | 3/32 | 2 1/4 | 7/8 | 2400 | 7/8 | 3/32 |
| 30A30HD | 3/32 | 1/16 | 3 | 7/8 | 1800 | 1 1/4 | 1/8 |
| 60A15HD | 3/16 | 5/32 | 1 1/2 | 7/8 | 6000 | 5/8 | 1/16 |
| 60A22HD | 3/16 | 1/8 | 2 1/4 | 7/8 | 4600 | 7/8 | 3/32 |
| 60A30HD | 5/32 | 3/32 | 3 | 7/8 | 3400 | 1 1/4 | 1/8 |
| 90A15HD | 1/4 | 3/16 | 1 1/2 | 7/8 | 9000 | 5/8 | 1/16 |
| 90A22HD | 3/16 | 5/32 | 2 1/4 | 7/8 | 7000 | 7/8 | 3/32 |
| 90A30HD | 3/16 | 5/32 | 3 | 7/8 | 5200 | 1 1/4 | 1/8 |