

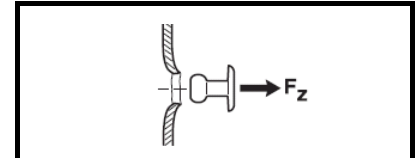


Bulb-tite RV6604/6/...

Rivet body $\varnothing = 5,2$ mm
 Predrill $\varnothing = 5,3 - 5,5$ mm



Pull-out load F_z (N)



Material type

Fastener:

Rivet body:

Aluminum EN AW-AMg 5

Mandrel:

Aluminum EN AW-AICuMg 1

Metal sheet:

Steel & aluminum

Mandrel \varnothing :

$\varnothing = 2,9$ mm

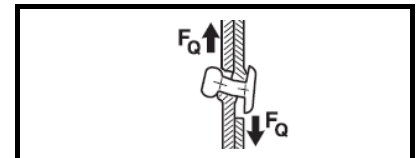
Part II (blind side)

Part I (setting side)

Material grade	$R_{m,min}$	t_{II} (mm)	Material grade	t_I (mm)	KL in mm	Test results (N)		
						$F_{z,avg}$	s	R_k
Steel Sheet								
S350 GD	390 N/mm ²	0.50	S355	7.50	8.00	1622	25	1195
S320 GD	390 N/mm ²	0.75	S355	7.50	8.25	1957	26	1564
S320 GD	390 N/mm ²	1.00	S355	7.50	8.50	1988	55	1510
Aluminum Sheet								
AlMgSi1 1/4ha	285 N/mm ²	0.50	S355	7.50	8.00	745	43	674
AlMg3 1/4hart	220 N/mm ²	0.70	S355	7.50	8.20	1579	62	1150
PE300 1/2hart	220 N/mm ²	1.00	S355	7.50	8.50	1978	26	1422

Shear load F_q (N)

$F_{q,avg}$ is measured between a displacement of max 3 mm



Part II (blind side)

Part I (setting side)

Material grade	$R_{m,min}$	t_{II} (mm)	Material grade	t_I (mm)	KL in mm	Test results (N)		
						$F_{q,avg}$	s	R_k
Steel Sheet			Steel					
S350GD	420 N/mm ²	0.50	S355	7.50	8.00	1702	84	1341
S350GD	420 N/mm ²	0.75	S355	7.50	8.25	2339	106	2018
S350GD	420 N/mm ²	1.00	S355	7.50	8.50	2737	101	2364
Aluminum Sheet								
AlMgSi1 1/4ha	285 N/mm ²	0.50	S355	7.50	8.00	862	38	583
AlMg3 1/4 hart	220 N/mm ²	0.70	S355	7.50	8.20	1742	145	1602
PE300 1/2hart	220 N/mm ²	1.00	S355	7.50	8.50	2306	79	1602

Variable description:

$R_{m,min}$ = is the minimum standard tensile strength of Part II

t = is the nominal steel thickness of Part I or II

$F_{z,avg}$ = arithmetic mean values of test result

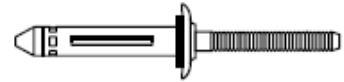
s = is the standard deviation

R_k = is the characteristic resistance of fastenings according to the EN requirements



Bulb-tite RV6604/6/...

Rivet body $\varnothing = 5,2$ mm
 Predrill $\varnothing = 5,4$ mm



Material type

Fastener:

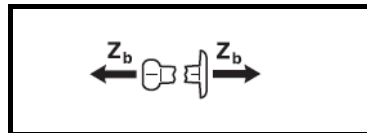
Rivet body:

Aluminum EN AW-AMg 5

Mandrel:

Aluminum EN AW-AICuMg 1

Tensile breaking load Z_b (N)



$$Z_b \geq 1.950 \text{ N}$$

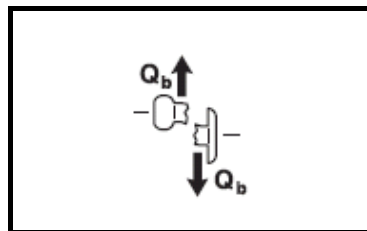
Metal sheet:

Steel & aluminum

Mandrel \varnothing :

$\varnothing = 2,9$ mm

Shear breaking load Q_b (N)



$$Q_b \geq 2.700 \text{ N}$$

All calculations, measurements, fasteners and design methods have to be verified by a responsible designer or engineer, regarding the corresponding structure and load. Please consult your national norms and approvals.