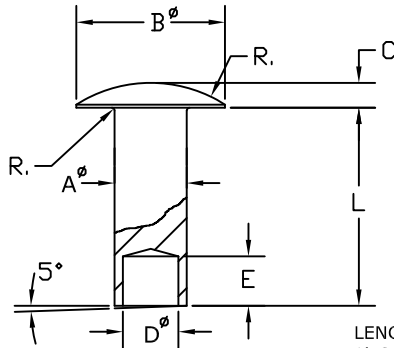


STANDARD SEMI-TUBULAR RIVETS



PART NUMBER IDENTIFICATION

SAMPLE PART# XTT375048SZ

XT-(T-375)-048-S-Z

DEFINED AS BELOW:

XT = SEMI-TUBULAR RIVET

T-375 = IRF PART CODE (3/16" Dia w/ .375 head)

048 = LENGTH IN 32nds (1.500" Long)

S = RAW MATERIAL (Steel)

Z = PLATING (Zinc)

LENGTH INFO:

1) SPECIFY LENGTH IN 32nds.

2) SEE PART# TO IDENTIFY LENGTH.

3) SEE TABLE A-1, COLUMN L. RIVET LENGTH FOR THE USER'S APPLICATION.

TABLE A-1

NOM RIVET SIZE	A		B		C		D		E	R1	R2	L	FUNCTION PARAMETERS		
	BODY Ø		HEAD Ø		HEAD HEIGHT		HOLE Ø		HOLE DEPTH	HEAD RADIUS	HEAD TYPE	FILLET RADIUS	ASSEMBLY HOLE SIZE	CLINCH ALLOWANCE	IRF PART CODE
	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	NOM	REF.		MAX.	REF.	REF.	REF.
1/16	.061	.058	.114	.104	.019	.015	.044	.039	.046*	.16	OVAL	.008	.067	.032	B-109
	.061	.058	.130	.120	.019	.015	.044	.039	.046*	.13	TRUSS	.008	.067	.032	B-125
3/32	.089	.085	.152	.142	.026	.020	.068	.062	.064*	.22	OVAL	.012	.093	.045	F-147
	.089	.085	.161	.151	.026	.022	.068	.062	.064*	.24		.012	.093	.045	F-156
	.099	.095	.192	.182	.032	.026	.076	.070	.077*	.22	OVAL	.012	.104	.055	G-187
1/8	.123	.118	.223	.213	.038	.030	.090	.084	.094*	.31	OVAL	.016	.128	.062	J-218
	.123	.118	.286	.276	.038	.032	.090	.084	.094*	.38	TRUSS	.016	.128	.062	J-281
	.146	.141	.239	.229	.045	.035	.107	.100	.126*	.27	OVAL	.020	.152	.093	M-234
9/64	.146	.141	.286	.276	.045	.039	.107	.100	.126*	.49		.020	.152	.093	M-281
	.146	.141	.318	.306	.045	.035	.107	.100	.126*	.45	TRUSS	.020	.152	.093	M-312
	.146	.141	.381	.369	.065	.060	.107	.100	.126*	.53		.020	.152	.093	M-375
5/32	.157	.152	.318	.306	.068	.058	.110	.103	.126*	.31		.020	.165	.093	N-312
	.188	.182	.318	.306	.065	.055	.141	.134	.155*	.25	OVAL	.025	.196	.110	T-312
3/16	.188	.182	.381	.369	.065	.055	.141	.134	.155*	.53	TRUSS	.025	.196	.110	T-375
7/32	.217	.210	.444	.430	.090	.085	.162	.154	.189*	.45	OVAL	.057	.234	.140	U-437
	.252	.244	.444	.430	.075	.061	.184	.176	.219*	.65		.030	.265	.156	Y-437
1/4	.252	.244	.507	.493	.085	.071	.184	.176	.219*	.72	OVAL	.030	.265	.156	Y-500
9/32	.290	.280	.444	.430	.100	.090	.200	.190	.225*	.41		.030	.302	.175	V-437
	.310	.302	.507	.493	.090	.085	.213	.206	.243*	.59		.030	.328	.187	Z-500
5/16	.310	.302	.570	.554	.100	.095	.213	.206	.243*	.69	OVAL	.030	.328	.187	Z-562
	.377	.368	.570	.554	.100	.095	.286	.276	.312*	.69		.035	.390	.218	W-562
3/8	.377	.368	.632	.618	.125	.115	.286	.276	.312*	.63		.035	.390	.218	W-625

*HOLE DEPTH TOLERANCE LISTED IN TABLE B-1

LENGTH IS DETERMINED BY AND ACCORDING TO CUSTOMERS REQUIREMENT. LENGTH TOLERANCES ARE LISTED IN TABLE B-1.

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TABLE B-1

NOMINAL DIAMETER (PART CODE)	SHORTEST STANDARD LENGTH	LENGTH	LENGTH & HOLE DEPTH TOLERANCE	CUTOFF VARIANCE AT 5" MAX.
1/16"	.062	.062 - .250	±.007	.062
		.251 - .500	±.008	
		OVER .501	±.010	
3/32" (F-147 & F-156)	.078	.078 - .375	±.007	.078
		.376 - .750	±.008	
		OVER .751	±.010	
3/32" (G-187)	.078	.078 - .406	±.007	.078
		.407 - .812	±.008	
		OVER .813	±.010	
1/8"	.093	.093 - .500	±.010	.093
		.501 - .984	±.012	
		OVER .985	±.015	
9/64"	.125	.125 - .593	±.007	.125
		.594 - 1.187	±.007	
		OVER 1.188	±.010	
3/16"	.156	.156 - .750	±.010	.156
		.751 - 1.50	±.012	
		1.501 +	±.015	
1/4"	.187	.187 - 1.00	±.010	.187
		1.001 - 2.000	±.015	
		OVER 2.001	±.020	
5/16"	.250	.250 - 1.250	±.010	.250
		1.251 - 2.500	±.015	
		OVER 2.501	±.020	
3/8"	.312	.312 - 1.500	±.012	.312
		1.501 - 3.000	±.015	
		OVER 3.000	±.020	

REV. DESCRIPTION						DATE
POST TREATMENT	IRF APPROVED WAX	IRF APPROVED WAX	IRF APPROVED WAX	IRF APPROVED WAX	IRF APPROVED WAX	IRF APPROVED WAX
SURFACE TREATMENT	ZINC CLEAR .00015 MIN.	CLEAN & FREE OF OIL	CLEAN & FREE OF OIL	CLEAN & FREE OF OIL	BRIGHT & FREE OF OIL	CLEAN & FREE OF OIL
ACCEPTABLE MATERIALS	STEEL C-1009 $\frac{1}{8}$ 1008	ALUMINUM 305 $\frac{1}{8}$ 2026	STAINLESS-3 316 $\frac{1}{8}$ 304	STAINLESS-4 430	BRASS CDA240 $\frac{1}{8}$ CDA270	COPPER CDA119 $\frac{1}{8}$ CDA102
DRAWN: SBS		DATE: 7-25-05		CHECKED:		SHEET 1 OF 1
DESCRIPTION: SEMI-TUBULAR RIVETS						
LIMITS UNLESS STATED	DECIMAL .005	ANGULAR ±1°	ALL DIMENSIONS IN INCHES. REMOVE ALL BURRS AND SHARP EDGES. ALL DIMENSIONS ARE POST PLATING. THIS DRAWING REPRESENTS IRF STANDARDS AND IS A VARIATION OF ANSI B18.76 (F-114-1986).			ORIGINAL SHEET SIZE: 11"X17"
Industrial Rivet & Fastener Co.		RIVET KING		200 PARIS AVENUE NORTHVALE, NJ, 07647 TEL: (201) 750 1040 Info@rivet.com		
DRAWING NUMBER:		XT-2005-01				REVISION LEVEL: B
1-800-BUY-RIVET						