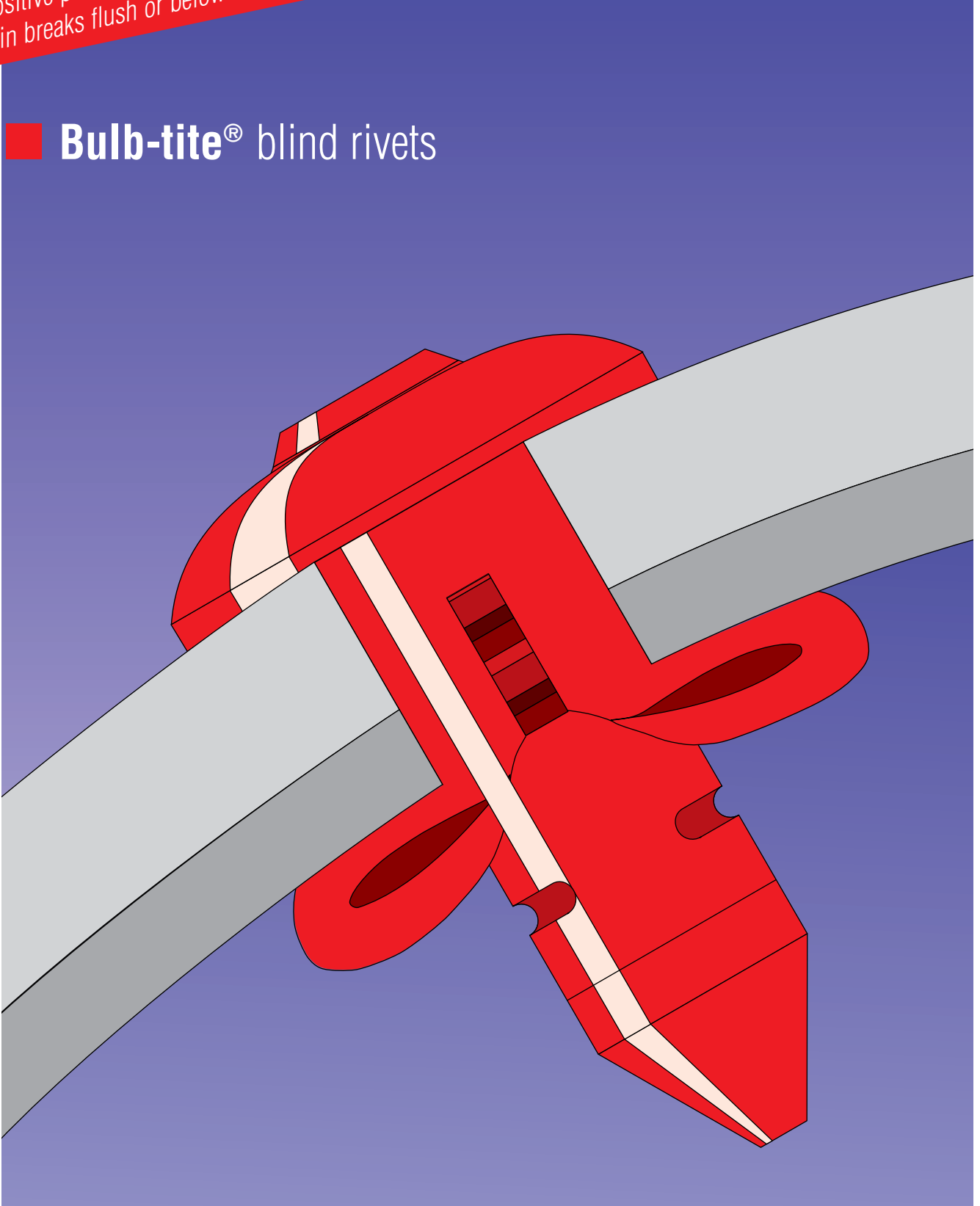


- large blind-side footprint
- high clamp load
- positive pin retention
- pin breaks flush or below head

■ **Bulb-tite**® blind rivets



Bulb-tite® blind rivets

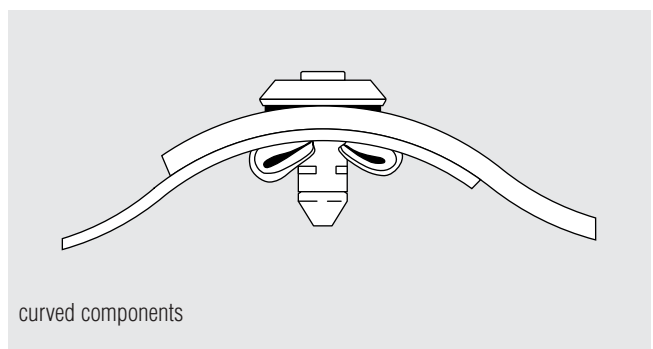
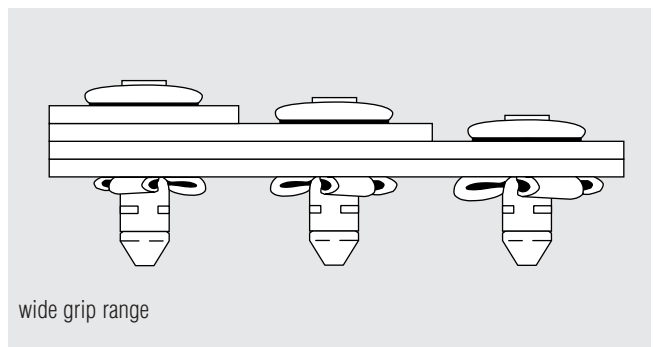
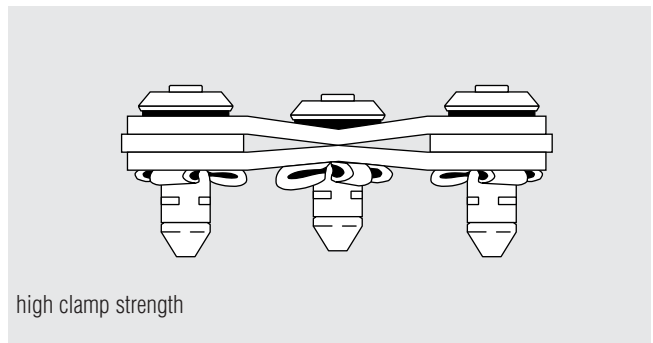
Bulb-tite® rivets differ from standard blind rivets because they form 3 folded legs on the blind-side when upset. The 3 legs provide a large blind-side footprint and high clamp load.

Bulb-tite® rivets are ideally suited for fastening soft or sensitive materials. Large hole tolerance, variable material thickness and uneven surfaces are, in most applications, no problem for Bulb-tite®. Installed parts are vibration resistant and high strength. When fitted with neoprene washers Bulb-tite® rivets can be made air and watertight. Installing with a special nosepiece positively retains pins.

Bulb-tite® rivets have been used for many years in the commercial vehicle, roofing, cladding and many other industries.

Special features:

- installed from one side - no access to blind-side required
- simple installation - pin breaks flush or just below surface of head
- positive retention of pin after installation
- wide grip range - reduces parts inventory
- corrosion resistant materials - aluminium and zinc passivated steel
- vibration resistant through patented design
- very low radial pressure applied to hole - does not damage surface finish of application material
- versatility - can be used in flat or curved components
- watertight when used with neoprene washer
- special parts manufactured on request - subject to minimum quantity



Installation

Hole tolerance:

Correct installation is possible even if the holes are slightly offset (as long as the rivet can be inserted through both components).

Blind rivets:

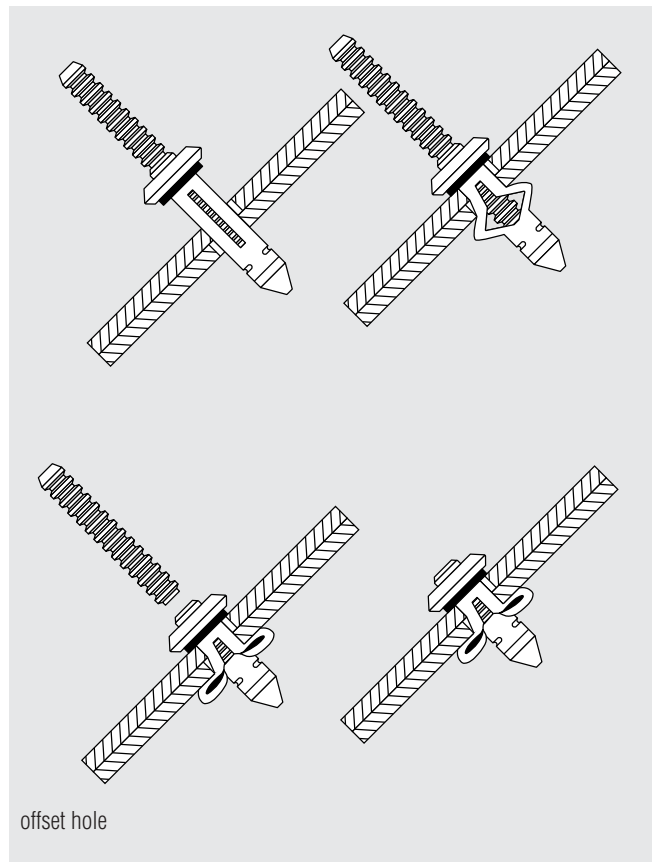
Can be installed in applications that may only be accessed from one side.

Break pin:

Installation is complete when the mandrel breaks flush or just below the head.

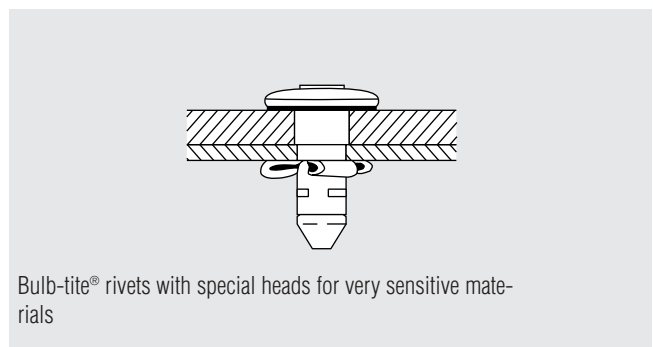
Clamp load:

Positive retention of the pin and the 3 blind-side folded legs provide a very high clamp load.



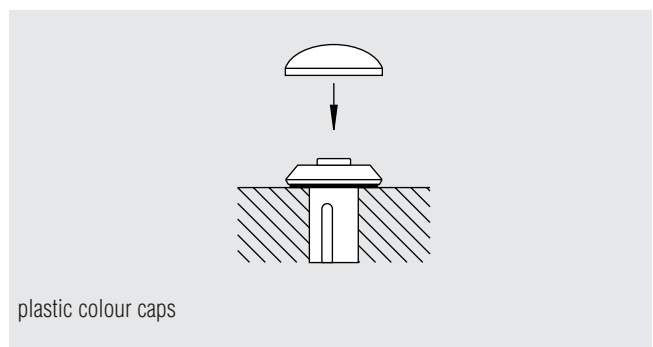
Sensitive materials

Bulb-tite® rivets with special head forms for very sensitive materials are available on request.



Plastic colour caps

Bulb-tite® flat head rivets type RV 6604 6 can be fitted with plastic colour caps - available on request.



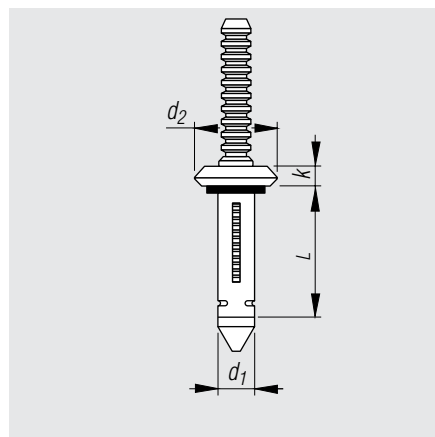
Bulb-tite® blind rivets

flat head

Material

 sleeve
aluminium AlMg5, waxed
melting temperature 650 °C

 mandrel
aluminium AlCuMg1, waxed



Nom. Ø d1 Hole Ø mm	Sleeve d1 x L max. mm	Grip range max -min mm	Head		Shear strength* max. N	Tensile strength* max. N	Type	Part No.	
			Ø d2 max. mm	height k max. mm 2,6				with neoprene washer	without neoprene washer
								AlMg 5	AlMg 5
<u>4,0</u>	4,1 x 20,3	1,7 - 6,4	8,9		2080	1100	RV 6604 5 - 4	410 002	410 032
4,2	4,1 x 25,1	6,4 - 12,7		3,1			RV 6604 5 - 8	410 003	410 033
<u>5,0</u>	5,2 x 17,5	0,5 - 4,8	11,6		3300	2060	RV 6604 6 - 3	410 008	410 038
5,4	5,2 x 19,1	1,6 - 6,4					RV 6604 6 - 4	410 009	410 039
	5,2 x 22,2	4,8 - 9,5					RV 6604 6 - 6	410 010	410 040
	5,2 x 25,4	7,9 - 12,7					RV 6604 6 - 8	410 011	410 041
	5,2 x 28,6	11,1 - 15,9					RV 6604 6 -10	410 012	410 042
	5,2 x 31,8	14,2 - 19,1					RV 6604 6 -12	410 013	410 043

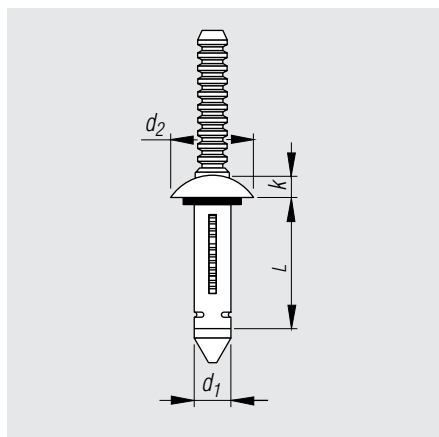
* shear and tensile strengths are based on rivet failure

Also available with other head styles on request.

Installation tools must be fitted with special nosepiece.

Plastic colour caps for Bulbtite type 6604 6 are available on request.

We reserve the right to amend specifications at any time.

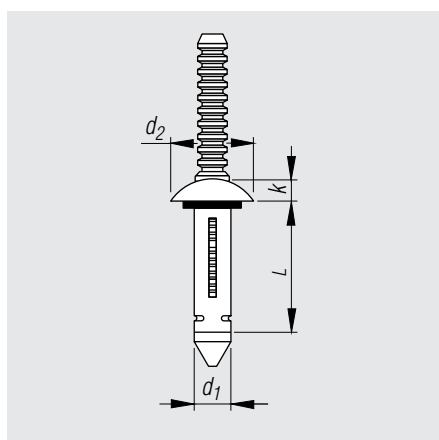


dome head

Material

- sleeve
aluminium AlMg5, waxed
melting temperature 650 °C
- mandrel
aluminium AlCuMg1, waxed

Nom. Ø d1 Hole Ø	Sleeve d1 x L max. mm	Grip range mm	Head		Shear strength*	Tensile strength*	Type	Part No.	
			Ø d2 max. mm	height k max. mm				with neoprene washer AlMg 5	without neoprene washer AlMg 5
6,5	6,3 x 23,4	3,2 - 9,5	14,4	3,9	4900	3030	RV 6606 8 - 6	410 022	410 052
6,6	6,3 x 26,5	6,4 - 12,7					RV 6606 8 - 8	410 023	410 053
	6,3 x 29,7	9,5 - 15,9					RV 6606 8 -10	410 024	410 054



dome head

Material

- sleeve
steel, zinc clear passivate,
waxed
- mandrel
steel, zinc clear passivate,
waxed

Nom. Ø d1 Hole Ø	Sleeve d1 x L max. mm	Grip range von - bis mm	Head		Shear strength*	Tensile strength*	Type	Part No.	
			Ø d2 max. mm	height k max. mm				with neoprene washer Stahl	without neoprene washer Stahl
6,5	6,3 x 20,2	1,0 - 6,4	14,4	3,9	7400	3930	RV 6676 8 - 4	410 120	410 150
6,6	6,3 x 23,4	3,2 - 9,5					RV 6676 8 - 6	410 121	410 151
	6,3 x 26,5	6,4 - 12,7					RV 6676 8 - 8	410 122	410 152
	6,3 x 29,7	9,5 - 15,9					RV 6676 8 -10	410 123	—

* shear and tensile strengths are based on rivet failure

Also available in other materials and head styles on request.
Installation tools must be fitted with special nosepiece.

We reserve the right to amend specifications at any time.

Tools

MS15

hydropneumatic installation tool
for Bulb-tite® blind rivets 4.0 + 5.0 mm ø and standard blind rivets
2.4 to 4.0 mm ø

Part No. 431 410

Technical data

Maximum operating pressure:	7 bar
Tractive effort:	9.5 kN at 6 bar
Stroke:	22 mm
Weight:	1.6 kg
Air consumption per operation:	2 litres
Height:	265 mm
Length:	285 mm

Nosepieces and jaws

Rivet diameter mm	Part No.	
	Bulbtite® nosepiece	Jaws
4,0	431 369	431 455
5,0	431 370	431 455



MS60

hydropneumatic installation tool
for Bulb-tite® blind rivets 6.5 mm ø and standard and structural
blind rivets to 6.4 mm ø

Part No. 431 500

Technical data

Maximum operating pressure:	7 bar
Tractive effort:	18 kN at 6 bar
Stroke:	25 mm
Weight:	2.6 kg
Air consumption per operation:	4.8 litres
Height:	340 mm
Length:	320 mm

Nosepieces and jaws

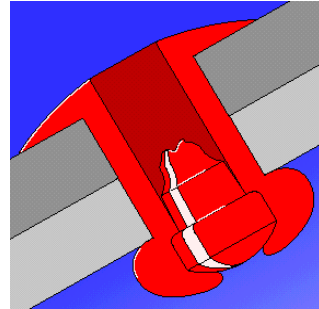
Rivet diameter mm	Part No.	
	Bulbtite® nosepiece	Jaws
6,5	431 534	326 583



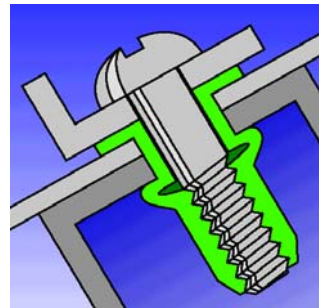
Note:

Please state that the installation tools are to be used for Bulb-tite® blind rivets when ordering.

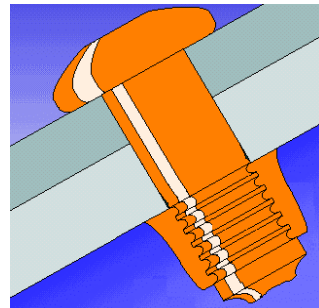
Blind Rivets



Threaded Inserts



Assembly Systems



Installation Tools

