

# D•F® RIVET SPECIFICATIONS



Give us a call... you can ask for Rosie, I'm your D•F rivet boss!

## RIVET BOSS®

**AA** = 5052 Aluminum Body/Aluminum Mandrel, IFI-114 Grade 11, RoHS compliant.  
**AF** = 5056 Aluminum Body/Steel Mandrel, IFI-114 Grade 19, RoHS compliant.  
**CB** = 110 Copper Body/Brass Mandrel, IFI-114 Grade 20, RoHS compliant.  
**FF®** = 1006 Steel Body/Steel Mandrel, IFI-114 Grade 30, RoHS compliant.  
**NF** = 304 Stainless Steel Body/Steel Mandrel, IFI-114 Grade 50, RoHS compliant.  
**NN®** = 304 Stainless Steel Body/Stainless Steel Mandrel, IFI-114 Grade 51, RoHS compliant.  
 In addition to standard dome head rivets, we also stock: Countersunk, large flange, closed-end & multi-grip. Our open-end rivets are made per IFI-114 spec's & our closed-end rivets are made per IFI-126 spec's.

Our rivet P/N explanation is as follows:

First letter is the material of the rivet body: A = Aluminum, C = Copper, F = (Ferrous) Steel, N = (Non-ferrous) Stainless steel.

Second letter is the material of the mandrel: A = Aluminum, B = Brass, F = (Ferrous) Steel, N = (Non-ferrous) Stainless steel.

If it is a standard dome head rivet then there are no more letters. Otherwise, CS = 120° countersunk head, CE = Closed end, LF = Large flange, MG = Multi-grip

Then, the first number is the rivet diameter. As an industry standard, simply take this # and divide by 32 to determine body diameter.

The second number is the max grip range. Also as an industry standard, take this # and divide by 16 to determine the maximum grip. 1/8" is the "range of grip" for a standard D•F Rivet.

When one is working with copper, a copper rivet with a copper mandrel would, *theoretically*, be desired. But a copper mandrel is not practical because the material is too soft to be able to "upset" (or bucked/deformed) & collapse the rivet tightly. The closest, highest quality option is a copper rivet with a brass mandrel.

Unfortunately for the contractor, the other common answer is a copper rivet with a copper plated *steel* mandrel. Although these rivets look beautiful in the box and they are substantially cheaper to buy and make - **WARNING:** once the copper plated steel mandrel is pulled, then the result is an unprotected broken steel mandrel in the center of a copper rivet which will display the ugly shimmer of cold steel against your otherwise beautiful (& expensive!) copper mastery. Plus, one should expect the almost instantaneous rust streaks that an uncoated, severed steel fastener would routinely display.

When buying copper rivets, always insist on brass mandrels.



BODY DIA.	REC DRILL BIT	DOME HEAD DIA.	ACTUAL GRIP RANGE OF MTRL	BODY LENGTH	AA	AF	CB	FF®	NF	NN®
1/8"	#30	.250"	.031 - .062	.188	AA41	AF41		FF41	NF41	NN41
			.031 - .125	.250	AA42	AF42	CB42	FF42	NF42	NN42
			.062 - .187	.313	AA43	AF43	CB43	FF43	NF43	NN43
			.125 - .250	.375	AA44	AF44	CB44	FF44	NF44	NN44
			.187 - .312	.438	AA45	AF45		FF45	NF45	NN45
			.250 - .375	.500	AA46	AF46		FF46	NF46	NN46
			.375 - .500	.625	AA48	AF48		FF48	NF48	NN48
			.500 - .625	.750	AA410	AF410		FF410	NF410	NN410
5/32"	#20	.312"	.031 - .125	.275	AA52	AF52		FF52	NF52	NN52
			.062 - .187	.338	AA53	AF53		FF53	NF53	NN53
			.125 - .250	.400	AA54	AF54		FF54	NF54	NN54
			.250 - .375	.525	AA56	AF56		FF56	NF56	NN56
			.375 - .500	.650	AA58	AF58		FF58	NF58	NN58
3/16"	#11	.375"	.031 - .125	.300	AA62	AF62		FF62	NF62	NN62
			.062 - .187	.362	AA63	AF63		FF63	NF63	NN63
			.125 - .250	.425	AA64	AF64		FF64	NF64	NN64
			.250 - .375	.550	AA66	AF66		FF66	NF66	NN66
			.375 - .500	.675	AA68	AF68		FF68	NF68	NN68
			.500 - .625	.800	AA610	AF610		FF610	NF610	NN610
			.625 - .750	.925	AA612	AF612		FF612	NF612	NN612
			.750 - .875	1.050	AA614	AF614		FF614	NF614	NN614
.875 - 1.00	1.175	AA616	AF616		FF616	NF616	NN616			
1/4"	F	.500"	.125 - .250	.475	AA84	AF84		FF84	NF84	NN84
			.250 - .375	.600	AA86	AF86		FF86	NF86	NN86
			.375 - .500	.725	AA88	AF88		FF88	NF88	NN88
			.500 - .625	.850	AA810	AF810		FF810	NF810	NN810