The experts in blind riveting

Programme 2012

effective 1st July 2012

Blind rivets and riveting tools

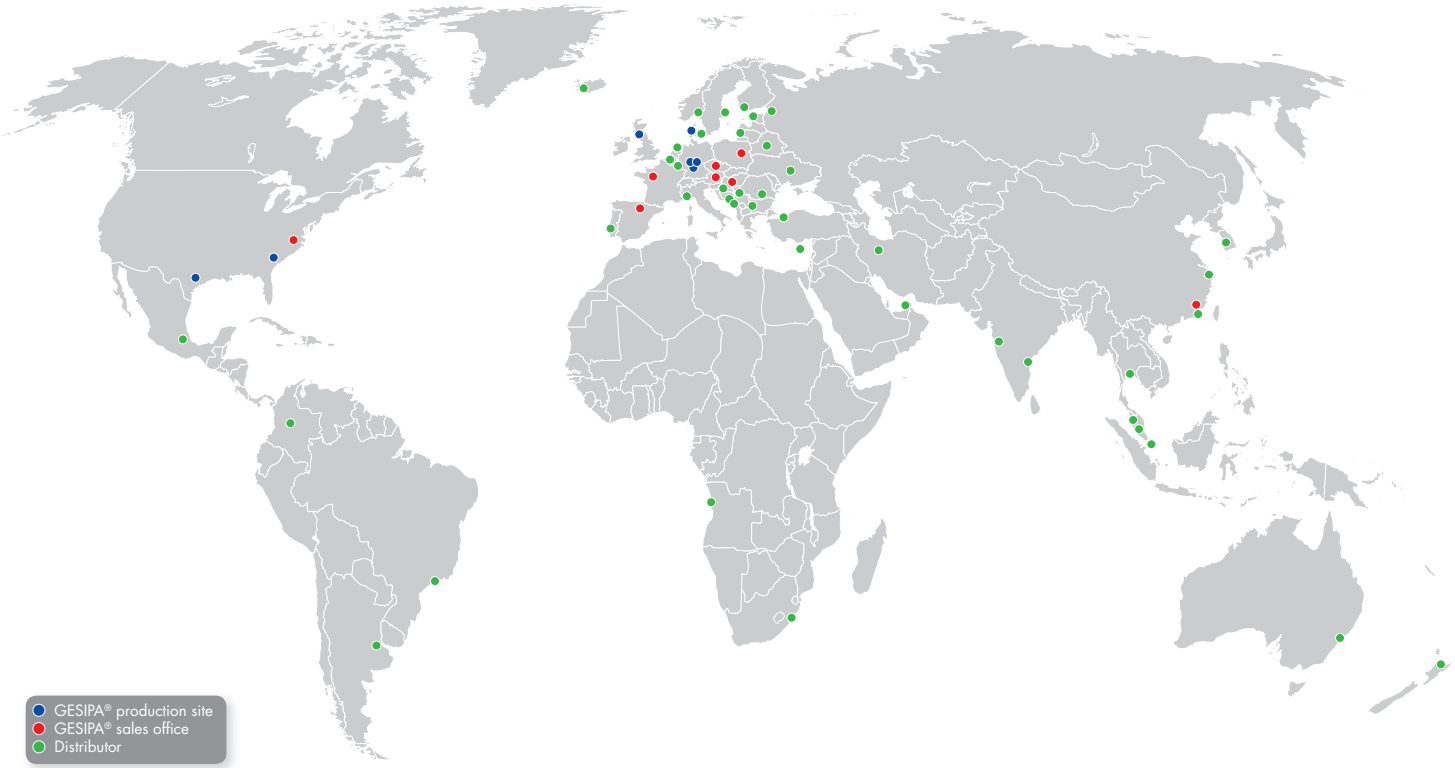
TÜV PROFI CERT ISO 9001 73 100 1057

TÜV PROFI CERT ISO/TS 16949 73 111 1057-1

GESIPA®

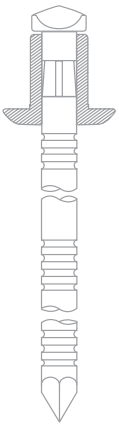
Founded in 1955 by Dr. Hans-Georg Biermann and his wife Ibeth Biermann, GESIPA Blindniettechnik GmbH has developed into a leading international company for blind rivet technology. The high quality and reliability of GESIPA® fasteners and the innovative, high-quality setting tools have made GESIPA® a valued partner to the trade and industry worlwide.

Over 600 employees at seven production sites throughout the world, including three locations in Germany, turn out high-quality and innovative products day after day with dedication and passion. Foreign sales are handled by eight subsidiary companies and more than forty foreign representatives.



Family-owned up to the end of 2008, GESIPA Blindniettechnik GmbH is now part of the international group SFS intec AG, and as such well prepared to meet the future challenges imposed by its partners in trade and industry with new ideas and solutions.

CUSTOMER PROXIMITY and FLEXIBILITY are certainly given top priority at GESIPA®.



As one of the last companies producing fastener technology in Germany, GESIPA® remains absolutely loyal to the specialist trade. The comprehensive external sales force provides expert advice on all questions relating to blind rivet technology, while the internal sales and despatch personnel guarantee smooth working processes and fast, reliable delivery.

The Technical Sales team advises and looks after the demanding requirements of national and international industry customers. The technically and economically optimum solutions are developed together with developers, production planners and quality specialists.
Two of the largest industrial customer groups of GESIPA® are the automotive industry and automotive sub suppliers, which both place stringent demands on reliable and economic fastening solutions.

The readiness for innovation and creativity of all employees contribute to long-term customer satisfaction and partnership cooperation, in order to consolidate and extend the market leadership of GESIPA®.

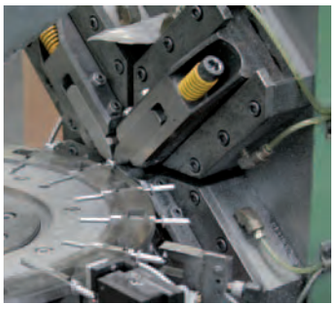
In the product group of setting tools, decisive market leadership is ensured by forward-looking products such as the battery-powered blind riveting tools, the GAV riveting machines, the TAURUS series and the newly-developed FireFox® blind rivet nut setting tool.

Innovative fasteners such as PolyGrip®, G-Bulb® structural rivet and BulbTite® blind rivets, originally developed for industry and the construction sector, also demonstrate their advantages outstandingly in other markets.

Reliability and consistent performance, demonstrated millions of times, is achieved by GESIPA® through its vast experience in production, gained over many years, and a quality concept which is unique in the sector.

Highly qualified employees, the best production machines and the in-production quality organisation guarantee fulfilment of even the most demanding customer requirements. In addition to the checking of dimensions, tolerances and quality of the raw materials, finished products are also submitted to extensive functional checks before they leave the works. All GESIPA® products correspond with the RoHS 2011/65/EU directive.

All German GESIPA® production locations operate a quality management system certified to DIN EN ISO 9001 and ISO TS 16949.



PowerBird® Gold Edition

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Bird versions with spring loaded trigger system

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NEW

FireFox® protective cover

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Angle head for TAURUS 1-4

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FireFox® C

Available from end of 2012

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Head modules for TAURUS 5 and 6

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Blind rivet A2 and A4/ stainless steel large flange

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TAUREX Axial compact

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Available from end of 2012

TAURUS Axial

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Available from end of 2012

TAUREX Axial

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Available from end of 2012

TAURUS Axial eco

Available from end of 2012

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all versions also with spring loaded trigger system

FireFly in cardboard box

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Blind rivet Alu/stainless steel 3.2 mm and 4.8 mm

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Blind rivet A4/stainless steel 4.8 mm and 5.0 mm

Page 24

Contents — Blind rivets

Contents — Blind rivet nuts

Colour key

- Alu
- Steel
- Copper
- Stainless steel A2
- Stainless steel A4
- Plastic
- Monel

Further dimensions and types available upon request

**We reserve the right to make changes to the entire price list.
We do not accept liability for printing errors and mistakes.**

All prices are exclusive of VAT and delivery.

The warranty period for all tools purchased on or after 1st June 2011 is 24 months (according to the terms listed in the operating manual), except the batteries.

GESIPA® – The special blind rivet

GESIPA® always manufactures with state of the art technology. Perfect products are secured by continuous investment in staff qualification and production machinery.
Permanent controls during manufacturing guarantee outstanding setting characteristics and a firm hold, batch after batch after batch…

Better than the standard

The location of the mandrel break-points in GESIPA® blind rivets is matched to the body length in such a way that the setting tool needs only to be triggered once to set the rivet and extract the spent mandrel, no matter how long the body is. GESIPA® rivets also have a longer mandrel than other rivets as a standard, so that nosepieces extended by up to 10 mm can be used without any problem.

A clean solution

GESIPA® blind rivets are thoroughly cleaned and fitted with high-quality, bright-galvanised mandrels. Soiling of the tool's jaws is minimised, thus extending significantly the service life of the setting tools.

Great connection

GESIPA® blind rivets always produce a high-quality and visually attractive finish thanks to their matched geometries and the high-quality materials of the individual components.

Fast and flexible

GESIPA® blind rivets are stocked so that all standard dimensions, and even some non standard sizes, are normally 100 % available.
Orders placed by 2 pm (or by 11 am on Fridays) are usually despatched the same day.
Our repairs department will deal with your tool repairs in the usual, professional manner within 48 hours.

Perfect interaction

GESIPA® blind rivets and GESIPA® setting tools are perfectly matched to each other and use of the correct nosepiece will produce the perfect finish.
GESIPA® setting tools offer minimal wear, short working cycles and a long service life, thereby guaranteeing minimum costs.

56 years of experience

Since 1955, GESIPA® has concentrated on creating the greatest possible customer benefits with the GESIPA® blind rivet and GESIPA® setting tools.
56 years of experience, which fully reflect in our products.

You can rely on GESIPA® quality!

In the best hands at GESIPA®...

Special challenges in industry demand special solutions with regard to efficiency, function and innovation. GESIPA® has decades of experience in consultancy and development of blind rivets for specific applications. Requirements such as surface treatments, appropriate shear strength and/or tensile strength and setting process reliability are defined by Technical Sales according to the project, and guarantee millions of consistent quality fastenings.

Quality

From the traceability and documentation of the raw materials to the checking of dimensions and tolerances during production, GESIPA® attaches the greatest value to quality. But GESIPA® also goes one decisive step further. For blind rivets for specific applications, thorough functional tests are carried out and documented step-by-step.

Functional tests / setting curve

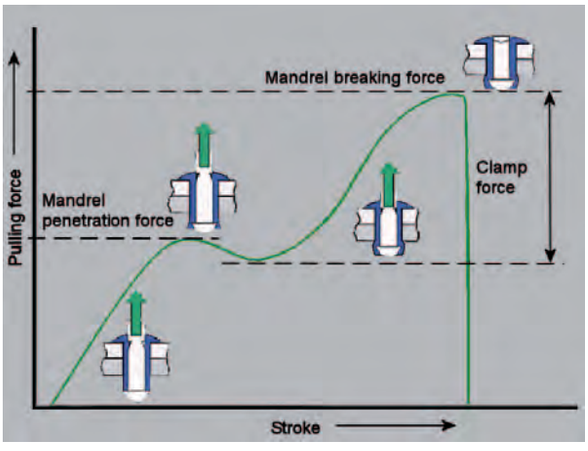
For every production batch of blind rivets for specific applications, the setting curve is measured on a sophisticated test bench. The measured results of shaft deformation, insertion characteristics, mandrel shear load and tensile force are compared with the target values in order to ensure that the blind rivet forms as intended in the application and produces a secure fastening.

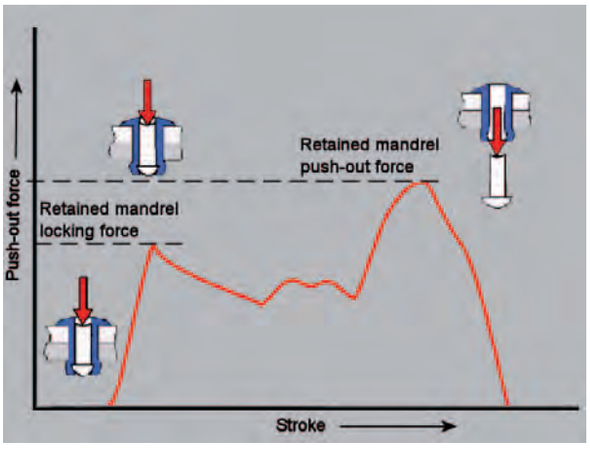
Function tests / mandrel press-out force

The remaining part of the mandrel enclosed in the set rivet is pressed out. The measured force can be used to determine whether the remaining part of the mandrel is properly locked and will not cause any rattling noises or even fall out. The batch is only released if both these values are within tolerance.

Monitored process – reliable connection

Safety relevant processes in the industrial use of blind rivets make 100 % reliability of riveting operations essential. Process-monitored GESIPA® tools of the TAURUS series and the fully automatic GAV 8000 riveting machine enable economic application solutions, from the basic system to systems with barcode scanners and process computers.





One fastener for several applications

The versatility of GESIPA® fasteners often means that several application cases which previously required different fasteners can be served by a single specially designed blind rivet. This saves costs and simplifies handling.

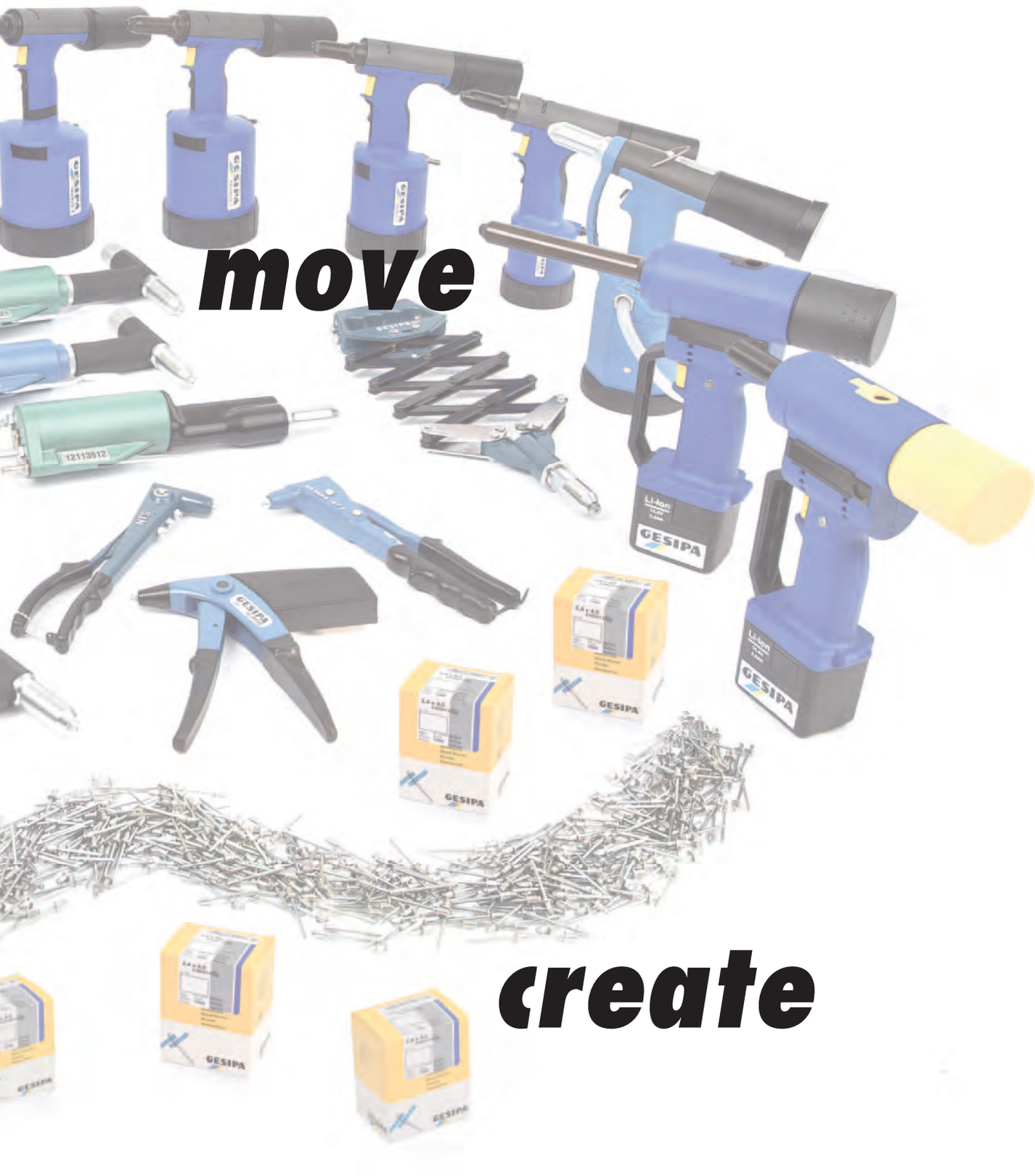
Cost advantages at a glance

- Reduction of downstream quality costs due to GESIPA® setting process monitoring
- Reduction of wearing parts costs due to identical parts strategy and modular design of the tools
- Reduction of logistics costs due to multi-functionality of the fasteners and corresponding reduction of parts diversity.

Challenge us!

Blind rivet technology know understand

trust



move

create

Technical data on

GESIPA® blind rivet - efficient technology

Life without blind rivet technology from GESIPA® can no longer be imagined in modern industry production where connection technology is required due to its efficiency and versatility. It combines the advantages of overcoming restricted component accessibility, permanently safe conenction of different, and sensitive materials, and even documentation of the setting process if required.

Technically speaking, the blind rivet consists of two parts: the hollow rivet and the mandrel. During screw-connecting, clinching and punch riveting etc. the component must always be accessible on both sides but the special thing about blind riveting is that the component only needs to be accessed from one side.

GESIPA® blind rivets - connections that last

During the setting process, the mandrel is pulled with the jaws of the setting tool and forms the hollow rivet to the predefined fixed position in the component. The mandrel then breaks off at the intended point (the target breakage point) and can be recycled. The filling cut (this is the remaining rest of mandrel in the hollow rivet) can provide an additional securing function depending on the application.

GESIPA® blind rivets - for every application

Blind rivets are available in a variety of designs, materials, forms, lengths and even colours. Depending on the task which the blind rivet should fulfil, GESIPA® can choose between a standard model available from stock or a blind rivet specially designed for the application.

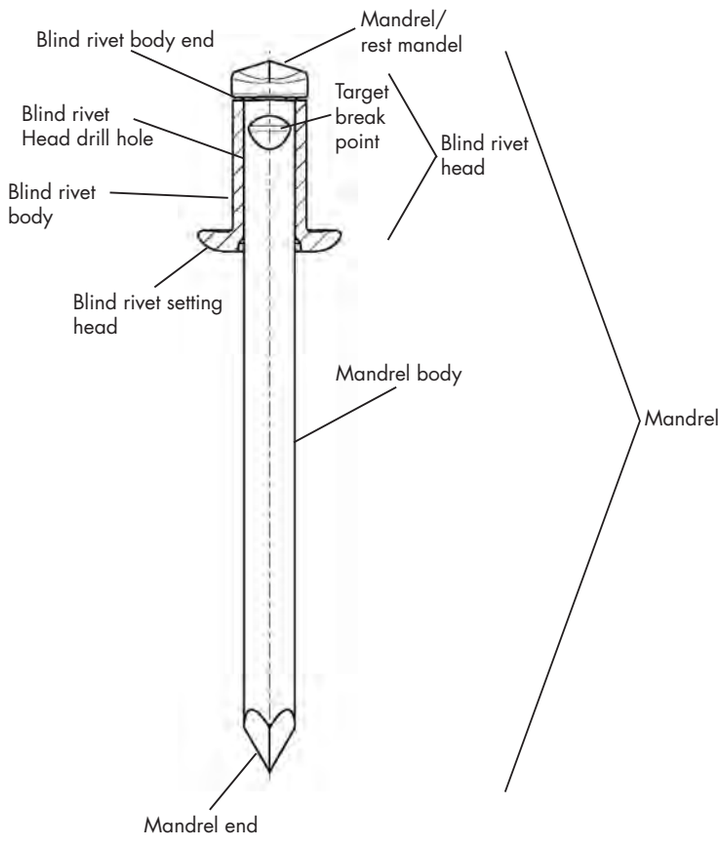
In the standard range, the rule of thumb is that the joint thickness added to the diameter of the hollow rivet results in the necessary rigid body length.

GESIPA® blind rivet - a rule of thumb

Rule of thumb: joint + rivet diameter = rivet body length

GESIPA® blind rivets

GESIPA® blind rivets - concepts



The blind rivet consists of two parts: the hollow rivet and the mandrel.

The hollow rivet consists of the setting head and body.

The setting head is found on the processing side and is variable in diameter and form. There are the dome, countersunk and large flange versions. The rivet body is available in different lengths depending on the material thickness to be riveted.

The rivet mandrel is used to deform the rivet body. It contains the predetermined breaking point. This is where the rivet mandrel breaks after the rivet has deformed.
The filling section is the remaining part of the rivet mandrel in the hollow mandrel. The residual mandrel is the part of the rivet mandrel that is disposed of from the set rivet via the blind rivet setting tool.

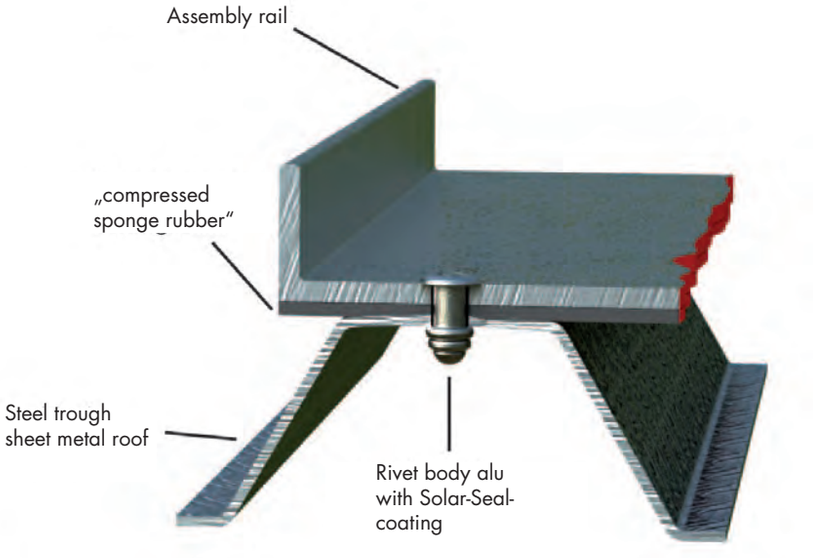
The application-specific GESIPA® connector... ...more than just a standard blind rivet

The basic features of the standard blind rivet are defined by various DIN EN ISO standards. These features primarily involve the geometric dimensions and mechanical properties. Other connector properties, such as the choice of material and surface coating, are defined very generally by the standards and are left up to the manufacturer. These specifications about the blind rivet features seriously limit the tolerances of the connection parameters and the feasible requirements. Blind rivets that comply to the DIN EN ISO standards are always designed for fixed parts.

Customer requirement	GESIPA® solution
Adaption to rubber, wood, plastic and other materials	Definition of max. / min. tightening value or clamping force
Water tightness	Material + stamping + coating
Accessibility problem	Extended nosepiece in combination with a rivet mandrel extension
Corrosion-resistance	Through organic and inorganic surfaces e.g. Zn, ZnNi, Delta Seal, stainless steel A2 and A4 or Monel
No noise	Monitored threaded mandrel protection
Tolerance compensation	Bore-hole diameter larger than DIN
High device and system availability	Device and connector matched to each other, GESIPA®-general system

The application-specific connector can be used for a larger number of tasks and satisfy higher requirements thanks to the targeted specification of the material, surfaces, geometric dimensions and in particular the functional properties. For example the following customer requirements can be satisfied:

- Elimination of access problems to rivet positions
- Adaptation to corrosion requirements to ensure higher resistance to environmental influences
- Production of splashwater protected connections whilst maintaining good mechanical properties
- Compensation of larger fluctuations in the part parameters
- Adaptation of the mechanical connection properties to the various joining materials



Typical requirements on setting process monitoring

Requirement	Possible monitoring criteria
Was a blind rivet processed in the application?	Monitoring of the spent mandrel Use of devices with surface contact trigger
Were all blind rivets processed for the application?	Monitoring and counting of the spent mandrels Use of devices with surface contact trigger
Was the right blind rivet processed?	Monitoring of the break force Use of devices with surface contact trigger
Was the defined connection quality achieved at this blind river point?	Monitoring the break force and path/time

Speak to our technical sales

We offer technical support in the field of fastening technology. This gives you an advantage in terms of efficiency and quality because you always use the correct fastener. We are also able to meet customer requirements thanks to our years of experiece in the fastening technology field.

Blind rivet alu/steel standard

Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
2.4 Hole Ø: 2.5 mm	**2.4 x 4**	0.5 - 1.5	**630** 0014	A 1.000
	2.4 x 6	1.5 - 3.5	**630** 0022	"
	2.4 x 8	3.5 - 5.0	**630** 0030	"
3 Hole Ø: 3.1 mm	**3 x 4**	0.5 - 1.5	**630** 0103	A 500
	3 x 5	1.5 - 2.5	**630** 0111	"
	3 x 6	2.5 - 3.5	**630** 0138	"
	3 x 7	3.5 - 4.5	**630** 0146	"
	3 x 8	4.5 - 5.0	**630** 0154	"
	3 x 10	5.0 - 7.0	**630** 0162	"
	3 x 12	7.0 - 9.0	**630** 0170	"
	3 x 14	9.0 - 11.0	**630** 0189	"
	3 x 16	11.0 - 13.0	**630** 0197	"
	3 x 18	13.0 - 15.0	**630** 0200	A 250
	3 x 20	15.0 - 17.0	**630** 0219	"
	3 x 25	17.0 - 22.0	**630** 0227	"
	3 x 30	22.0 - 26.0	**630** 0235	"
3.2 Hole Ø: 3.3 mm	**3.2 x 4**	0.5 - 1.5	**630** 0308	A 500
	3.2 x 6	1.5 - 3.5	**630** 0316	"
	3.2 x 8	3.5 - 5.0	**630** 0324	"
	3.2 x 10	5.0 - 7.0	**630** 0332	"
	3.2 x 12	7.0 - 9.0	**630** 0340	"
	3.2 x 14	9.0 - 11.0	**630** 0081	"
	3.2 x 16	11.0 - 13.0	**630** 0359	B 500
	3.2 x 18	13.0 - 15.0	**630** 0383	"
	3.2 x 20	15.0 - 17.0	**630** 0367	"
	3.2 x 25	17.0 - 22.0	**630** 0375	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 5**	0.5 - 1.5	**630** 0405	A 500
	4 x 6	1.5 - 3.0	**630** 0413	"
	4 x 7	3.0 - 4.0	**630** 0421	"
	4 x 8	4.0 - 5.0	**630** 0448	"
	4 x 10	5.0 - 6.5	**630** 0456	"
	4 x 12	6.5 - 8.5	**630** 0464	B 500
	4 x 14	8.5 - 10.5	**630** 0472	"
	4 x 16	10.5 - 12.5	**630** 0480	"
	4 x 18	12.5 - 14.5	**630** 0499	"
	4 x 20	14.5 - 16.5	**630** 0502	"
	4 x 25	16.5 - 21.5	**630** 0529	"
	4 x 30	21.5 - 26.0	**630** 0545	B 250
	4 x 35	26.0 - 30.0	**630** 0561	"
	4 x 40	30.0 - 35.0	**630** 0596	"
4.8 Hole Ø: 4.9 mm	**4.8 x 6**	2.0 - 2.5	**630** 0707	B 500
	4.8 x 8	2.5 - 4.5	**630** 0715	"
	4.8 x 10	4.5 - 6.0	**630** 0723	"
	4.8 x 12	6.0 - 8.0	**630** 0731	"
	4.8 x 14	8.0 - 10.0	**630** 0758	"
	4.8 x 16	10.0 - 12.0	**630** 0766	"
	4.8 x 18	12.0 - 14.0	**630** 0774	"
	4.8 x 20	14.0 - 15.0	**630** 0782	B 250
	4.8 x 25	15.0 - 20.0	**630** 0804	"
	4.8 x 30	20.0 - 25.0	**630** 0820	A 100

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
2.4	**350**	(35)	**450**	(46)	1.5	5.0
3	**700**	(71)	**900**	(92)	1.8	6.5
3.2	**720**	(73)	**950**	(97)	1.95	6.5
4 x 5-25	**1,400**	(143)	**2,000**	(204)	2.1	8.0
4 x 30-40 ▪	**850**	(87)	**1,000**	(102)	2.1	8.0
4.8	**1,800**	(184)	**2,700**	(275)	2.7	9.5

▪ **Rivet body: AlMgSi**

Test procedure according to DIN EN ISO 14589

Blind rivet alu/steel standard

Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 Hole Ø: 5.1 mm	**5 x 6**	2.0 - 2.5	**630** 0901	B 500
	5 x 8	2.5 - 4.5	**630** 0928	"
	5 x 10	4.5 - 6.0	**630** 0936	"
	5 x 12	6.0 - 8.0	**630** 0944	"
	5 x 14	8.0 - 10.0	**630** 0952	"
	5 x 16	10.0 - 12.0	**630** 0960	"
	5 x 18	12.0 - 14.0	**630** 0979	"
	5 x 20	14.0 - 15.0	**630** 0987	B 250
	5 x 25	15.0 - 20.0	**630** 1002	"
	5 x 30	20.0 - 25.0	**630** 1029	A 100
	5 x 35	25.0 - 30.0	**630** 1045	"
	5 x 40	30.0 - 35.0	**630** 1061	"
	5 x 45	35.0 - 40.0	**630** 1096	B 100
	5 x 50	40.0 - 45.0	**630** 1126	"
	5 x 55	45.0 - 48.0	**630** 1142	"
	5 x 60	48.0 - 52.0	**630** 1169	"
	5 x 65	52.0 - 57.0	**630** 1185	"
	5 x 70	57.0 - 62.0	**630** 1207	"
	5 x 80	62.0 - 72.0	**630** 1223	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
6 Hole Ø: 6.1 mm	**6 x 8**	2.0 - 3.0	**630** 1304	B 250
	6 x 10	3.0 - 5.0	**630** 1312	"
	6 x 12	5.0 - 7.0	**630** 1320	"
	6 x 16	7.0 - 11.0	**630** 1339	"
	6 x 18	11.0 - 13.0	**630** 1347	"
	6 x 20	13.0 - 15.0	**630** 1355	"
	6 x 25	15.0 - 20.0	**630** 1371	B 200
	6 x 30	20.0 - 24.0	**630** 1401	"
	6 x 35	24.0 - 29.0	**630** 1436	B 100
	6 x 40	29.0 - 34.0	**630** 1452	"
	6 x 50	34.0 - 44.0	**630** 1495	"
6.4 Hole Ø: 6.5 mm	**6.4 x 12**	2.0 - 6.0	**630** 1606	B 250
	6.4 x 16	6.0 - 10.0	**630** 1622	"
	6.4 x 18	10.0 - 12.0	**630** 1940	"
	6.4 x 20	12.0 - 14.0	**630** 1649	B 200
	6.4 x 25	14.0 - 18.0	**630** 1665	"
	6.4 x 30	18.0 - 23.0	**630** 1681	B 100

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
5 x 6 - 35	**2,000**	(204)	**2,800**	(285)	2.7	9.5
5 x 40 - 80	**1,400**	(143)	**2,000**	(204)	2.7	9.5
6	**3,100**	(316)	**3,800**	(388)	3.2	12.0
6.4	**3,400**	(347)	**4,600**	(469)	3.65	13.0

Test procedure according to DIN EN ISO 14589

Blind rivet alu/steel countersunk

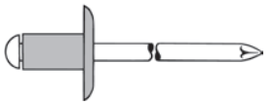
Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

(120°)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 4**	1.0 - 1.5	**630** 2106	A 500
	3 x 6	1.5 - 3.5	**630** 2130	"
	3 x 8	3.5 - 5.0	**630** 2157	"
	3 x 10	5.0 - 7.0	**630** 2165	"
	3 x 12	7.0 - 9.0	**630** 2173	"
	3 x 16	9.0 - 13.0	**630** 2181	"
4 Hole Ø: 4.1 mm	**4 x 6**	1.5 - 3.0	**630** 2416	A 500
	4 x 8	3.0 - 5.0	**630** 2440	"
	4 x 10	5.0 - 6.5	**630** 2459	"
	4 x 12	6.5 - 8.5	**630** 2467	B 500
	4 x 16	8.5 - 12.5	**630** 2483	"
	4 x 18	12.5 - 14.5	**630** 2378	"
	4 x 20	14.5 - 16.5	**630** 2505	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.5	**630** 2920	B 500
	5 x 10	4.5 - 6.0	**630** 2939	"
	5 x 12	6.0 - 8.0	**630** 2947	"
	5x 16	8.0 - 12.0	**630** 2963	"
	5 x 18	12.0 - 14.0	**630** 2793	"
	5 x 20	14.0 - 15.0	**630** 2971	B 250
	5 x 25	15.0 - 20.0	**630** 3005	"
	5 x 30	20.0 - 25.0	**630** 3021	A 100
	5 x 35	25.0 - 30.0	**630** 3048	"

Blind rivet alu/steel large flange



Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 - K 9.5 Hole Ø: 3.3 mm	**3.2 x 6**	1.5 - 3.5	**630** 3315	A 500
	3.2 x 8	3.5 - 5.0	**630** 3323	"
	3.2 x 10	5.0 - 7.0	**630** 3331	"
	3.2 x 12	7.0 - 9.0	**630** 3358	"
	3.2 x 16	9.0 - 13.0	**630** 3366	B 500
4 - K 12 Hole Ø: 4.1 mm	**4 x 6**	1.5 - 3.0	**630** 3412	B 500
	4 x 8	3.0 - 5.0	**630** 3447	"
	4 x 10	5.0 - 6.5	**630** 3455	"
	4 x 12	6.5 - 8.5	**630** 3463	"
	4 x 16	8.5 - 12.5	**630** 3471	"
	4 x 20	12.5 - 16.5	**630** 3501	B 250
4.8 - K 16 Hole Ø: 4.9 mm	**4.8 x 8**	2.5 - 4.5	**630** 3714	B 250
	4.8 x 10	4.5 - 6.0	**630** 3722	"
	4.8 x 12	6.0 - 8.0	**630** 3730	"
	4.8 x 16	8.0 - 12.0	**630** 3765	"
	4.8 x 20	12.0 - 15.0	**630** 3781	"
	4.8 x 25	15.0 - 20.0	**630** 3803	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 - K 11 Hole Ø: 5.1 mm	**5 x 8**	2.5 - 4.5	**630** 3927	B 500
	5 x 10	4.5 - 6.0	**630** 3935	"
	5 x 12	6.0 - 8.0	**630** 3943	"
	5 x 14	8.0 - 10.0	**630** 3897	"
	5 x 16	10.0 - 12.0	**630** 3951	"
	5 x 18	12.0 - 14.0	**630** 3838	B 250
	5 x 20	14.0 - 15.0	**630** 3986	"
Ü	**5 x 25**	15.0 - 20.0	**630** 4001	"
	5 x 30	20.0 - 25.0	**630** 4028	B 100
5 - K 14 Hole Ø: 5.1 mm	**5 x 8**	2.5 - 4.5	**630** 4036	B 250
	5 x 10	4.5 - 6.0	**630** 4044	"
	5 x 12	6.0 - 8.0	**630** 4052	"
	5 x 14	8.0 - 10.0	**630** 4060	"
	5 x 16	10.0 - 12.0	**630** 4079	"
	5 x 18	12.0 - 14.0	**630** 4087	"
	5 x 20	14.0 - 15.0	**630** 4095	"
Ü	**5 x 25**	15.0 - 20.0	**630** 4117	"
	5 x 30	20.0 - 25.0	**630** 4133	B 100

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

Blind rivet alu/stainless steel standard

Rivet body: Alu AlMg 3
Mandrel: Stainless steel A2 – no. 1.4541

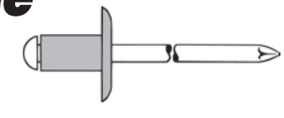
(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 4**	0.5 - 1.5	**632** 0104	A 500
	3 x 6	1.5 - 3.5	**632** 0112	"
	3 x 8	3.5 - 5.0	**632** 0155	"
	3 x 10	5.0 - 7.0	**632** 0163	"
	3 x 12	7.0 - 9.0	**632** 0171	"
	3 x 16	9.0 - 13.0	**632** 0198	"
3.2 Hole Ø: 3.3 mm NEW	**3.2 x 4**	0.5 - 1.5	**632** 0328	A 500
	3.2 x 6	1.5 - 3.5	**632** 0330	"
	3.2 x 8	3.5 - 5.0	**632** 0235	"
	3.2 x 10	5.0 - 7.0	**632** 0238	"
	3.2 x 12	7.0 - 9.0	**632** 0240	"
	3.2 x 14	9.0 - 11.0	**632** 0332	"
	3.2 x 16	11.0 - 13.0	**632** 0335	B 500
	3.2 x 18	13.0 - 15.0	**632** 0340	"
	3.2 x 20	15.0 - 17.0	**632** 0345	"
	3.2 x 25	17.0 - 22.0	**632** 0348	"
4 Hole Ø: 4.1 mm	**4 x 6**	1.5 - 3.0	**632** 0414	A 500
	4 x 8	3.0 - 5.0	**632** 0449	"
	4 x 10	5.0 - 6.5	**632** 0457	"
	4 x 12	6.5 - 8.5	**632** 0465	B 500
	4 x 14	8.5 - 10.5	**632** 0279	"
	4 x 16	10.5 - 12.5	**632** 0481	"
	4 x 18	12.5 - 14.5	**632** 0473	"
	4 x 20	14.5 - 16.5	**632** 0503	"
	4 x 25	16.5 - 21.5	**632** 0511	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm NEW	**4.8 x 6**	2.0 - 2.5	**632** 0199	B 500
	4.8 x 8	2.5 - 4.5	**632** 0200	"
	4.8 x 10	4.5 - 6.0	**632** 0202	"
	4.8 x 12	6.0 - 8.0	**632** 0209	"
	4.8 x 14	8.0 - 10.0	**632** 0212	"
	4.8 x 16	10.0 - 12.0	**632** 0215	"
	4.8 x 18	12.0 - 14.0	**632** 0218	"
	4.8 x 20	14.0 - 15.0	**632** 0222	B 250
	4.8 x 25	15.0 - 20.0	**632** 0225	"
5 Hole Ø: 5.1 mm	**5 x 8**	2.5 - 4.5	**632** 0929	B 500
	5 x 10	4.5 - 6.0	**632** 0937	"
	5 x 12	6.0 - 8.0	**632** 0945	"
	5 x 14	8.0 - 10.0	**632** 0953	"
	5 x 16	10.0 - 12.0	**632** 0961	"
	5 x 18	12.0 - 14.0	**632** 0988	"
	5 x 20	14.0 - 15.0	**632** 0996	B 250
	5 x 25	15.0 - 20.0	**632** 1003	"
	5 x 30	20.0 - 25.0	**632** 1011	A 100
	5 x 35	25.0 - 30.0	**632** 1046	"
	5 x 40	30.0 - 35.0	**632** 1062	"

Material surcharge will be added at a daily rate

Blind rivet alu/stainless steel large flange



Rivet body: Alu AlMg 3
Mandrel: Stainless steel A2 – no. 1.4541

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 - K 11 Hole Ø: 5.1 mm Ü	**5 x 8**	2.5 - 4.5	**632** 3928	B 500
	5 x 10	4.5 - 6.0	**632** 3936	"
	5 x 12	6.0 - 8.0	**632** 3944	"
	5 x 14	8.0 - 10.0	**632** 3847	"
	5 x 16	10.0 - 12.0	**632** 3952	"
	5 x 18	12.0 - 14.0	**632** 3855	B 250
	5 x 20	14.0 - 15.0	**632** 3987	"
	5 x 25	15.0 - 20.0	**632** 4002	"
	5 x 30	20.0 - 25.0	**632** 4029	B 100

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 - K 14 Hole Ø: 5.1 mm Ü	**5 x 8**	2.5 - 4.5	**632** 4037	B 250
	5 x 10	4.5 - 6.0	**632** 4045	"
	5 x 12	6.0 - 8.0	**632** 4053	"
	5 x 14	8.0 - 10.0	**632** 4150	"
	5 x 16	10.0 - 12.0	**632** 4061	"
	5 x 18	12.0 - 14.0	**632** 4169	"
	5 x 20	14.0 - 15.0	**632** 4096	"
	5 x 25	15.0 - 20.0	**632** 4118	"
	5 x 30	20.0 - 25.0	**632** 4134	B 100

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

Material surcharge will be added at a daily rate

Tabl valid for pages 18 and 19:

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø Alu/steel mm	Max. head Ø Alu / Nirosta mm
3	**700**	(71)	**900**	(91)	1.8	6.0	6.5
4	**1,400**	(143)	**2,000**	(204)	2.1	7.5	8.0
5	**2,000**	(204)	**2,800**	(285)	2.7	9.0	9.5
3.2 K 9.5 alu/steel only	**720**	(73)	**950**	(97)	1.95	9.5	–
4 K 12 alu/steel only	**1,400**	(143)	**2,000**	(204)	2.1	12.0	–
4.8 K 16 alu/steel only	**1,800**	(184)	**2,700**	(275)	2.7	16.0	–
5 K 11	**2,000**	(204)	**2,800**	(285)	2.7	11.0	11.0
5 K 14	**2,000**	(204)	**2,800**	(285)	2.7	14.0	14.0

Test procedure according to DIN EN ISO 14589

Blind rivet alu/alu standard

Rivet body: Alu AlMg 2.5
Mandrel: Alu AlMg 5

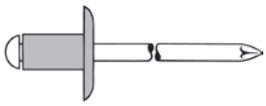
(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.1**	0.8 - 3.2	**647** 0017	A 500
	3.2 x 7.6	3.2 - 4.8	**647** 0033	"
	3.2 x 9.2	4.8 - 6.4	**647** 0076	"
	3.2 x 12.3	6.4 - 9.5	**647** 0114	"
	3.2 x 15.5	9.5 - 12.7	**647** 0130	B 500
4 Hole Ø: 4.1 mm	**4 x 6.6**	1.5 - 3.2	**647** 0238	B 500
	4 x 9.8	3.2 - 6.4	**647** 0254	"
	4 x 12.9	6.4 - 9.5	**647** 0297	"
	4 x 16.1	9.5 - 12.7	**647** 0335	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 7.2**	1.5 - 3.2	**647** 0416	B 500
	4.8 x 10.3	3.2 - 6.4	**647** 0432	"
	4.8 x 13.5	6.4 - 9.5	**647** 0475	"
	4.8 x 16.7	9.5 - 12.7	**647** 0513	"
	4.8 x 19.9	12.7 - 15.9	**647** 0556	"
	4.8 x 23.0	15.9 - 19.0	**647** 0572	B 250
6.4 Hole Ø: 6.5 mm	**6.4 x 12.0**	1.5 - 6.4	**647** 0610	B 250
	6.4 x 14.9	6.4 - 9.5	**647** 0637	"
	6.4 x 18.1	9.5 - 12.7	**647** 0653	A 100
	6.4 x 24.4	12.7 - 19.0	**647** 0688	"

Blind rivet alu/alu large flange

Rivet body: Alu AlMg 2.5
Mandrel: Alu AlMg 5



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 - K 9.5 Hole Ø: 3.3 mm	**3.2 x 6.1**	0.8 - 3.2	**647** 4217	A 500
	3.2 x 9.2	3.2 - 6.4	**647** 4233	"
	3.2 x 12.3	6.4 - 9.5	**647** 4268	B 500

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 - K 16 Hole Ø: 4.9 mm	**4.8 x 10.3**	1.5 - 6.4	**647** 4314	B 250
	4.8 x 13.5	6.4 - 9.5	**647** 4330	"
	4.8 x 16.7	9.5 - 12.7	**647** 4357	"
	4.8 x 19.9	12.7 - 15.9	**647** 4373	"
	4.8 x 23.0	15.9 - 19.0	**647** 4381	"

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	head Ø mm
3.2	**530**	(54)	**660**	(67)	1.95	6.5
4	**840**	(85)	**1,020**	(103)	2.45	8.0
4.8	**1,150**	(117)	**1,420**	(144)	2.9	9.5
6.4	**2,040**	(207)	**2,490**	(253)	3.85	12.9
3.2 K 9.5	**725**	(74)	**930**	(95)	1.95	9.5
4.8 K 16	**1,520**	(155)	**1,960**	(200)	2.9	16.0

Test procedure according to DIN EN ISO 14589

Blind rivet steel/steel standard

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 5**	0.5 - 2.0	**631** 0117	A 500
	3 x 6	2.0 - 3.0	**631** 0133	"
	3 x 8	3.0 - 5.0	**631** 0141	"
	3 x 10	5.0 - 6.5	**631** 0168	"
	3 x 12	6.5 - 8.5	**631** 0176	"
	3 x 16	8.5 - 12.5	**631** 0192	B 500
	3 x 18	12.5 - 14.5	**631** 0206	"
	3 x 20	14.5 - 16.5	**631** 0214	"
3.2 Hole Ø: 3.3 mm	**3.2 x 6**	0.5 - 3.0	**631** 0303	A 500
	3.2 x 8	3.0 - 5.0	**631** 0311	"
	3.2 x 10	5.0 - 6.5	**631** 0338	"
	3.2 x 12	6.5 - 8.5	**631** 0346	"
	3.2 x 16	8.5 - 12.5	**631** 0354	B 500
	3.2 x 18	12.5 - 14.5	**631** 0249	"
	3.2 x 20	14.5 - 16.5	**631** 0362	"
4 Hole Ø: 4.1 mm	**4 x 6**	0.5 - 2.5	**631** 0419	A 500
	4 x 8	2.5 - 4.5	**631** 0443	"
	4 x 10	4.5 - 6.5	**631** 0451	B 500
	4 x 12	6.5 - 8.5	**631** 0478	"
	4 x 16	8.5 - 12.0	**631** 0486	"
	4 x 18	12.0 - 14.0	**631** 0516	"
	4 x 20	14.0 - 16.0	**631** 0508	"
	4 x 25	16.0 - 21.0	**631** 0524	"
4.8 Hole Ø: 4.9 mm	**4.8 x 8**	2.0 - 4.0	**631** 0710	B 500
	4.8 x 10	4.0 - 6.0	**631** 0729	"
	4.8 x 12	6.0 - 8.0	**631** 0737	"
	4.8 x 16	8.0 - 11.0	**631** 0761	"
	4.8 x 20	11.0 - 15.0	**631** 0788	B 250
	4.8 x 25	15.0 - 20.0	**631** 0818	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.0	**631** 0915	B 500
	5 x 10	4.0 - 6.0	**631** 0923	"
	5 x 12	6.0 - 8.0	**631** 0931	"
	5 x 14	8.0 - 9.5	**631** 0958	"
	5 x 16	9.5 - 11.0	**631** 0966	"
	5 x 18	11.0 - 13.0	**631** 0974	"
	5 x 20	13.0 - 15.0	**631** 0982	B 250
	5 x 25	15.0 - 20.0	**631** 1008	"
	5 x 30	20.0 - 25.0	**631** 1024	A 100
	5 x 35	25.0 - 30.0	**631** 1040	"
	5 x 40	30.0 - 34.0	**631** 1067	"
	5 x 45	34.0 - 39.0	**631** 1091	"
	5 x 50	39.0 - 44.0	**631** 1121	B 100
6 Hole Ø: 6.1 mm	**6 x 10**	2.5 - 4.5	**631** 1202	B 250
	6 x 12	4.5 - 6.5	**631** 1210	"
	6 x 14	6.5 - 8.5	**631** 1229	"
	6 x 16	8.5 - 10.5	**631** 1237	"
	6 x 20	10.5 - 14.5	**631** 1245	"
	6 x 25	14.5 - 19.5	**631** 1253	"
6.4 Hole Ø: 6.5 mm	**6.4 x 8**	1.0 - 3.0	**631** 1598	B 250
	6.4 x 12	3.0 - 6.0	**631** 1601	"
	6.4 x 16	6.0 - 9.0	**631** 1628	"
	6.4 x 18	9.0 - 11.0	**631** 1563	B 200
	6.4 x 20	11.0 - 13.0	**631** 1644	"
	6.4 x 25	13.0 - 17.0	**631** 1660	"

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3	**1,000**	(102)	**1,300**	(133)	1.95	6.5
3.2	**1,200**	(122)	**1,500**	(153)	2.0	6.5
4	**2,000**	(204)	**2,500**	(255)	2.5	8.0
4.8	**2,900**	(296)	**4,000**	(408)	3.0	9.5
5	**3,100**	(316)	**4,400**	(449)	3.0	9.5
6	**4,400**	(449)	**6,000**	(612)	3.65	12.0
6.4	**4,900**	(500)	**6,800**	(694)	3.85	13.0

Test procedure according to DIN EN ISO 14589

Blind rivet steel/steel countersunk

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

(120°)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	1.0 - 3.0	**631** 2136	A 500
	3 x 8	3.0 - 5.0	**631** 2152	"
	3 x 10	5.0 - 6.5	**631** 2160	"
	3 x 12	6.5 - 8.5	**631** 2179	"
4 Hole Ø: 4.1 mm	**4 x 6**	1.5 - 2.5	**631** 2411	A 500
	4 x 8	2.5 - 4.5	**631** 2446	"
	4 x 10	4.5 - 6.5	**631** 2454	B 500
	4 x 12	6.5 - 8.5	**631** 2462	"
	4 x 16	8.5 - 12.0	**631** 2489	"
	4 x 20	12.0 - 16.0	**631** 2500	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.0	**631** 2926	B 500
	5 x 10	4.0 - 6.0	**631** 2934	"
	5 x 12	6.0 - 8.0	**631** 2942	"
	5 x 14	8.0 - 9.5	**631** 2810	"
	5 x 16	9.5 - 11.0	**631** 2969	"
	5 x 20	11.0 - 15.0	**631** 2977	B 250
	5 x 25	15.0 - 20.0	**631** 3000	"

Blind rivet copper/steel standard

Rivet body: Copper
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 4**	0.5 - 1.5	**634** 0105	A 500
	3 x 6	1.5 - 3.0	**634** 0121	"
	3 x 8	3.0 - 5.0	**634** 0156	"
	3 x 10	5.0 - 7.0	**634** 0164	"
	3 x 12	7.0 - 9.0	**634** 0172	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 6**	0.5 - 3.5	**634** 0415	A 500
	4 x 8	3.5 - 4.5	**634** 0431	"
	4 x 10	4.5 - 6.5	**634** 0458	"
	4 x 12	6.5 - 8.5	**634** 0466	"

Blind rivet copper/bronze standard

Rivet body: Copper
Mandrel: Bronze

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 4**	0.5 - 1.5	**635** 0100	A 500
	3 x 6	1.5 - 3.0	**635** 0135	"
	3 x 8	3.0 - 5.0	**635** 0151	"
	3 x 10	5.0 - 7.0	**635** 0178	"
	3 x 12	7.0 - 9.0	**635** 0186	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 6**	0.5 - 3.5	**635** 0410	A 500
	4 x 8	3.5 - 4.5	**635** 0445	"
	4 x 10	4.5 - 6.5	**635** 0453	"
	4 x 12	6.5 - 8.5	**635** 0461	"

Steel/steel countersunk

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3	**1,000**	(102)	**1,300**	(133)	1.95	6.0
4	**2,000**	(204)	**2,500**	(255)	2.5	7.5
5	**3,100**	(316)	**4,400**	(449)	3.0	9.0

Copper/steel and copper/bronze

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3	**800**	(82)	**1,000**	(102)	1.8	6.5
4	**1,500**	(163)	**2,200**	(225)	2.1	8.0

Test procedure according to DIN EN ISO 14589

Blind rivet A2-stainless steel (Dome head) standard

Rivet body: Stainless steel A2 – no. 1.4567
Mandrel: Stainless steel A2 – no. 1.4541

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	1.0 - 3.0	**633** 0134	A 500
	3 x 8	3.0 - 5.0	**633** 0150	"
	3 x 10	5.0 - 6.5	**633** 0169	"
	3 x 12	6.5 - 8.5	**633** 0177	"
	3 x 14	8.5 - 10.5	**633** 0185	"
	3 x 16	10.5 - 12.5	**633** 0193	"
3.2 Hole Ø: 3.3 mm	**3.2 x 6**	1.0 - 3.0	**633** 0312	A 500
	3.2 x 8	3.0 - 5.0	**633** 0320	"
	3.2 x 10	5.0 - 6.5	**633** 0339	"
	3.2 x 12	6.5 - 8.5	**633** 0347	"
	3.2 x 14	8.5 - 10.5	**633** 0363	"
	3.2 x 16	10.5 - 12.5	**633** 0355	"
4 Hole Ø: 4.1 mm	**4 x 6**	1.0 - 2.5	**633** 0401	A 500
	4 x 8	2.5 - 4.5	**633** 0444	"
	4 x 10	4.5 - 6.5	**633** 0452	B 500
	4 x 12	6.5 - 8.5	**633** 0460	"
	4 x 14	8.5 - 10.5	**633** 0533	"
	4 x 16	10.5 - 12.0	**633** 0487	"
Ü	**4 x 20**	12.0 - 16.0	**633** 0509	"
	4 x 25	16.0 - 21.0	**633** 0525	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 8**	2.0 - 4.0	**633** 0614	B 500
	4.8 x 10	4.0 - 6.0	**633** 0622	"
	4.8 x 12	6.0 - 8.0	**633** 0630	"
	4.8 x 14	8.0 - 9.5	**633** 0649	"
	4.8 x 16	9.5 - 11.0	**633** 0657	"
	4.8 x 20	11.0 - 15.0	**633** 0673	B 250
	4.8 x 25	15.0 - 20.0	**633** 0680	B 250
	4.8 x 30	20.0 - 25.0	**633** 0690	A 100
	4.8 x 35	25.0 - 30.0	**633** 0700	"
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.0	**633** 0924	B 500
	5 x 10	4.0 - 6.0	**633** 0932	"
	5 x 12	6.0 - 8.0	**633** 0940	"
	5 x 14	8.0 - 9.5	**633** 0959	"
	5 x 16	9.5 - 11.0	**633** 0967	"
	5 x 20	11.0 - 15.0	**633** 0983	B 250
	5 x 25	15.0 - 20.0	**633** 1009	"
	5 x 30	20.0 - 25.0	**633** 1025	A 100
	5 x 35	25.0 - 30.0	**633** 1041	"
	5 x 40	30.0 - 34.0	**633** 1033	"

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

Material surcharge will be added at a daily rate

Blind rivet A2 stainless steel countersunk

Rivet body: Stainless steel A2 – no. 1.4567
Mandrel: Stainless steel A2 – no. 1.4541

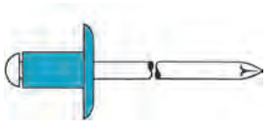
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	1.5 – 3.0	**633** 2013	A 500
	3 x 8	3.0 – 5.0	**633** 2024	"
	3 x 10	5.0 – 6.5	**633** 2035	"
	3 x 12	6.5 – 8.5	**633** 2046	"
3.2 Hole Ø: 3.3 mm	**3.2 x 6**	1.5 – 3.0	**633** 2114	A 500
	3.2 x 8	3.0 – 5.0	**633** 2125	"
	3.2 x 10	5.0 – 6.5	**633** 2136	"
	3.2 x 12	6.5 – 8.5	**633** 2147	"
4 Hole Ø: 4.1 mm	**4 x 8**	1.5 – 4.5	**633** 2201	A 500
	4 x 10	4.5 – 6.5	**633** 2213	B 500
	4 x 12	6.5 – 8.5	**633** 2225	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 8**	2.5 – 4.0	**633** 2323	B 500
	4.8 x 10	4.0 – 6.0	**633** 2334	"
	4.8 x 12	6.0 – 8.0	**633** 2335	"
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 – 4.0	**633** 2508	B 500
	5 x 10	4.0 – 6.0	**633** 2510	"
	5 x 12	6.5 – 8.5	**633** 2512	"

Material surcharge will be added at a daily rate

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on page 25.

Blind rivet A2 stainless steel large flange



Rivet body: Stainless steel A2 – no. 1.4567
Mandrel: Stainless steel A2 – no. 1.4541

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 - K 15 Hole Ø: 5.1 mm	**4.8 x 14**	8.0 - 9.5	**633** 0800	B 250
	4.8 x 16	9.5 - 11.0	**633** 0825	"
	4.8 x 20	11.0 - 15.0	**633** 0850	"
	4.8 x 25	15.0 - 20.0	**633** 0870	B 200
	4.8 x 30	20.0 - 25.0	**633** 0880	B 100
	4.8 x 35	25.0 - 30.0	**633** 0890	"

NEW

Material surcharge will be added at a daily rate

Blind rivet A4-stainless steel standard

Rivet body: Stainless steel A4 – no. 1.4578
Mandrel: Stainless steel A4 – no. 1.4571

(Dome head)

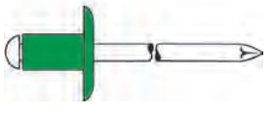
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	1.0 - 3.0	**648** 0004	A 500
	3 x 8	3.0 - 5.0	**648** 0012	"
	3 x 10	5.0 - 6.5	**648** 0020	"
	3 x 12	6.5 - 8.5	**648** 0039	"
3.2 Hole Ø: 3.3 mm	**3.2 x 6**	1.0 - 3.0	**648** 0005	A 500
	3.2 x 8	3.0 - 5.0	**648** 0016	"
	3.2 x 10	5.0 - 6.5	**648** 0027	"
	3.2 x 12	6.5 - 8.5	**648** 0049	"
4 Hole Ø: 4.1 mm	**4 x 6**	1.0 - 2.5	**648** 0047	A 500
	4 x 8	2.5 - 4.5	**648** 0055	"
	4 x 10	4.5 - 6.5	**648** 0063	B 500
	4 x 12	6.5 - 8.5	**648** 0071	"
	4 x 14	8.5 - 10.5	**648** 0076	"
	4 x 16	8.5 - 12.0	**648** 0098	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 6**	1.5 - 3.0	**648** 0102	B 500
	4.8 x 8	3.0 - 4.5	**648** 0113	"
	4.8 x 10	4.5 - 6.0	**648** 0124	"
	4.8 x 12	6.0 - 7.5	**648** 0135	"
	4.8 x 14	8.0 - 9.5	**648** 0125	"
NEW	**4.8 x 16**	9.5 - 11.0	**648** 0126	"
	4.8 x 20	11.0 - 15.0	**648** 0127	B 250
	4.8 x 25	15.0 - 20.0	**648** 0129	"
	4.8 x 30	20.0 - 25.0	**648** 0130	A 100
	4.8 x 35	25.0 - 30.0	**648** 0131	"
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.0	**648** 0128	B 500
	5 x 10	4.0 - 6.0	**648** 0136	"
	5 x 12	6.0 - 8.0	**648** 0144	"
	5 x 14	8.0 - 9.5	**648** 0146	"
NEW	**5 x 16**	8.0 - 11.0	**648** 0152	"
	5 x 20	11.0 - 15.0	**648** 0160	B 250
	5 x 25	15.0 - 20.0	**648** 0163	"
	5 x 30	25.0 - 30.0	**648** 0168	A 100
	5 x 35	25.0 - 30.0	**648** 0170	"

Material surcharge will be added at a daily rate

Blind rivet A4/ stainless steel large flange

Rivet body: Stainless steel A4 – no. 1.4578
Mandrel: Stainless steel A4 – no. 1.4571



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 - K 15 Hole Ø: 5.1 mm	**4.8 x 14**	8.0 - 9.5	**648** 0202	B 250
	4.8 x 16	9.5 - 11.0	**648** 0210	"
	4.8 x 20	11.0 - 15.0	**648** 0215	"
	4.8 x 25	15.0 - 20.0	**648** 0220	B 200
	4.8 x 30	20.0 - 25.0	**648** 0225	B 100
	4.8 x 35	25.0 - 30.0	**648** 0230	"

NEW

Material surcharge will be added at a daily rate

Blind rivet Stinox standard

Rivet body: Stainless steel A2 – no. 1.4567
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	1.0 - 3.0	**636** 0130	A 500
	3 x 8	3.0 - 5.0	**636** 0157	"
	3 x 10	5.0 - 6.5	**636** 0165	"
3.2 Hole Ø: 3.3 mm	**3.2 x 6**	1.0 - 3.0	**636** 0319	A 500
	3.2 x 8	3.0 - 5.0	**636** 0327	"
	3.2 x 10	5.0 - 6.5	**636** 0335	"

Material surcharge will be added at a daily rate

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 6**	1.0 - 2.5	**636** 0416	A 500
	4 x 8	2.5 - 4.5	**636** 0440	"
	4 x 10	4.5 - 6.5	**636** 0459	B 500
	4 x 12	6.5 - 8.5	**636** 0467	"
	4 x 14	8.5 - 10.5	**636** 0473	"
	4 x 16	8.5 - 12.0	**636** 0483	"
4.8 Hole Ø: 4.9 mm	**4.8 x 8**	2.0 - 4.0	**636** 0621	B 500
	4.8 x 10	4.0 - 6.0	**636** 0634	"
	4.8 x 12	6.0 - 8.0	**636** 0648	"
5 Hole Ø: 5.1 mm	**5 x 8**	2.0 - 4.0	**636** 0920	B 500
	5 x 10	4.0 - 6.0	**636** 0939	"
	5 x 12	6.0 - 8.0	**636** 0947	"

A2 stainless steel / A4 stainless steel/ Stinox Standard / A2 stainless steel countersunk

Rivet Ø	Shear strength		Tensile strength		Mandrel Ø	Max. head Ø
mm	**N**	(kp)	**N**	(kp)	mm	mm
3	**1,600**	(163)	**2,000**	(205)	2.0	6.5
3.2	**1,900**	(275)	**2,500**	(255)	2.0	6.5
4	**2,700**	(275)	**3,600**	(367)	2.6	8.0
4 x 20 - 25	**3,800**	(385)	**4,500**	(479)	2.6	8.0
4.8	**4,000**	(408)	**5,000**	(510)	3.2	9.5
5	**4,700**	(479)	**5,900**	(602)	3.2	9.5
5 x 40	**5,900**	(602)	**7,200**	(735)	3.2	9.5

A2 stainless steel large flange/ A4 stainless steel large flange

Rivet Ø	Shear strength		Tensile strength		Mandrel Ø	Max. head Ø
mm	**N**	(kp)	**N**	(kp)	mm	mm
4.8	**4,000**	(408)	**5,000**	(510)	3.2	15.0

Test procedure according to DIN EN ISO 14589

PolyGrip® – A most versatile small fellow

The GESIPA® PolyGrip® range of blind rivets, originally meant to be only a multigrip rivet has meanwhile shown other multiple talents. This makes it a favourite choice for difficult and demanding applications in industrial environment. Whether in aluminium, steel or stainless steel, outdoor or indoor, with hard or soft application materials, critical hole diameters and tolerances, when nothing seems to work properly, GESIPA® PolyGrip® will usually save the day.

Main features

A wide grip range: A single PolyGrip® blind rivet can replace to up to five different dimensions of DIN standard blind rivets.

Outstanding hole filling capability: The rivet body expands radially during the setting process and compensates hole tolerances, centering deviations and differences in diameter, thus always building up a playfree and tight joint.

Safe rest mandrel locking: PolyGrip® blind rivets neither generate rattling noises due to free moving rest mandrels nor do they allow the risk of loss of the rest mandrel.

Splash waterproof are the PolyGrip® blind rivets under certain conditions too. Hole filling and rest mandrel locking make of them a real alternative to closed end rivets when it is essential to prevent water flowing through the whole joint and not only through the rivet body.

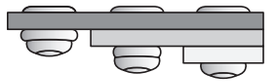
A large closing head: for a high tensile and unbuttoning resistance

High flexibility in design

The setting process of PolyGrip® blind rivets is fully predictable and the shaft deformation can be programmed for every special application through intelligent locating of the shaft grooves. This allows to be reliably predetermined the clamp force, radial shaft expansion and closing head build-up.

The production of PolyGrip® blind rivets is one of the core specialities of the GESIPA® factory in Thal, Thuringia.

PolyGrip® rivets



Alu/steel Standard

(Dome head)

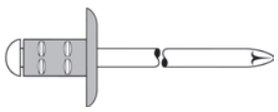
Rivet body: AlMg 2.5
Mandrel: Steel, zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 8**	0.5 - 5.0	**670** 0012	P 1.000
	3.2 x 9.5	1.5 - 6.5	**670** 0020	"
	3.2 x 11	3.0 - 8.0	**670** 0039	"
4.0 Hole Ø: 4.1 mm	**4 x 10**	0.5 - 6.5	**670** 0071	P 500
	4 x 13	3.5 - 9.5	**670** 0098	"
	4 x 17	7.0 - 13.0	**670** 0101	"
4.8 Hole Ø: 4.9 mm **Ü**	**4.8 x 10**	0.5 - 6.5	**670** 0144	P 500
	4.8 x 15	4.5 - 11.0	**670** 0152	"
	4.8 x 17	6.5 - 13.0	**670** 0160	"
	4.8 x 25	11.0 - 19.5	**670** 0217	P 250
	4.8 x 30	16.0 - 24.0	**670** 0225	"
6.4 Hole Ø: 6.5 mm	**6.4 x 15**	1.5 - 9.0	**670** 0268	P 250
	6.4 x 20	6.0 - 14.0	**670** 0276	"
	6.4 x 25	10.0 - 18.0	**670** 0284	"

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

Alu/steel Large flange

Rivet body: AlMg 2.5
Mandrel: Steel, zinc-plated

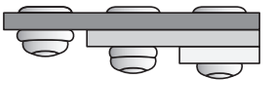


	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 - K 9.5 Hole Ø: 3.3 mm	**3.2 x 8**	0.5 - 5.0	**670** 0047	P 1.000
	3.2 x 9.5	1.5 - 6.5	**670** 0055	"
	3.2 x 11	3.0 - 8.0	**670** 0063	"
4.0 - K 12 Hole Ø: 4.1 mm	**4 x 10**	0.5 - 6.5	**670** 0128	P 500
	4 x 13	3.5 - 9.5	**670** 0136	"
	4 x 17	7.0 - 13.0	**670** 0209	"
4.8 - K 16 Hole Ø: 4.9 mm	**4.8 x 10**	0.5 - 6.5	**670** 0179	P 250
	4.8 x 15	4.5 - 11.0	**670** 0187	"
	4.8 x 17	6.5 - 13.0	**670** 0195	"
	4.8 x 25	11.0 - 19.5	**670** 0233	P 100
	4.8 x 30	16.0 - 24.0	**670** 0241	"

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on page 29.

All GESIPA® PolyGrip® blind rivets are guaranteed to be splash proof under certain conditions.

PolyGrip® rivets



Alu/stainless steel Standard

(Dome head)

Rivet body: Alu AlMg 2.5
Mandrel: Stainless steel A2 – no. 1.4541

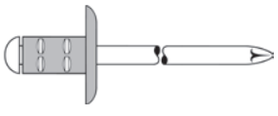
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 8**	0.5 - 5.0	**672** 0013	P 1.000
	3.2 x 9.5	1.5 - 6.5	**672** 0021	"
	3.2 x 11	3.0 - 8.0	**672** 0048	"
4.0 Hole Ø: 4.1 mm	**4 x 10**	0.5 - 6.5	**672** 0080	P 500
	4 x 13	3.5 - 9.5	**672** 0099	"
	4 x 17	7.0 - 13.0	**672** 0102	"
4.8 Hole Ø: 4.9 mm **Ü**	**4.8 x 10**	0.5 - 6.5	**672** 0145	P 500
	4.8 x 15	4.5 - 11.0	**672** 0153	"
	4.8 x 17	6.5 - 13.0	**672** 0161	"
	4.8 x 25	11.0 - 19.5	**672** 0188	P 250
	4.8 x 30	16.0 - 24.0	**672** 0196	"
6.4 Hole Ø: 6.5 mm	**6.4 x 15**	1.5 - 9.0	**672** 0269	P 250
	6.4 x 20	6.0 - 14.0	**672** 0277	"
	6.4 x 25	10.0 - 18.0	**672** 0285	"

Material surcharge will be added at a daily rate

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

Alu/stainless steel Large flange

Rivet body: Alu AlMg 2.5
Mandrel: Stainless steel A2 – no. 1.4541



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 - K 9.5 Hole Ø: 3.3 mm	**3.2 x 8**	0.5 - 5.0	**672** 0056	P 1.000
	3.2 x 9.5	1.5 - 6.5	**672** 0064	"
	3.2 x 11	3.0 - 8.0	**672** 0072	"
4.0 - K 12 Hole Ø: 4.1 mm	**4 x 10**	0.5 - 6.5	**672** 0110	P 500
	4 x 13	3.5 - 9.5	**672** 0129	"
	4 x 17	7.0 - 13.0	**672** 0137	"
4.8 - K 16 Hole Ø: 4.9 mm	**4.8 x 10**	0.5 - 6.5	**672** 0218	P 250
	4.8 x 15	4.5 - 11.0	**672** 0226	"
	4.8 x 17	6.5 - 13.0	**672** 0234	"
	4.8 x 25	11.0 - 19.5	**672** 0242	P 100
	4.8 x 30	16.0 - 24.0	**672** 0250	"

Material surcharge will be added at a daily rate

Steel/steel Standard

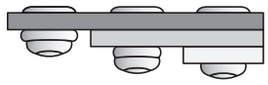
(Dome head)

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 8**	1.0 - 5.0	**671** 0018	P 1.000
	3.2 x 9.5	2.0 - 6.5	**671** 0026	"
	3.2 x 11	3.0 - 8.0	**671** 0034	"
4.0 Hole Ø: 4.1 mm	**4 x 10**	1.5 - 6.5	**671** 0077	P 500
	4 x 13	4.5 - 9.0	**671** 0085	"
	4 x 17	8.5 - 13.0	**671** 0093	"
4.8 Hole Ø: 4.9 mm	**4.8 x 10**	1.5 - 6.5	**671** 0131	P 500
	4.8 x 15	6.0 - 11.0	**671** 0158	"
	4.8 x 17	8.5 - 13.0	**671** 0166	"
6.4 Hole Ø: 6.5 mm	**6.4 x 15**	2.0 - 8.0	**671** 0263	P 250
	6.4 x 20	5.0 - 13.0	**671** 0285	"
	6.4 x 25	10.0 - 18.0	**671** 0294	P 200

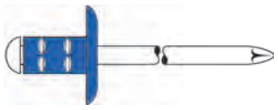
All GESIPA® PolyGrip® blind rivets are guaranteed to be splash proof under certain conditions.

PolyGrip® rivets



Steel/steel Large flange

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 - K 9.5 Hole Ø: 3.3 mm	**3.2 x 8**	1.0 - 5.0	**671** 0042	P 1.000
	3.2 x 9.5	2.0 - 6.5	**671** 0050	"
	3.2 x 11	3.0 - 8.0	**671** 0069	"
4.0 - K 12 Hole Ø: 4.1 mm	**4 x 10**	1.5 - 6.5	**671** 0107	P 500
	4 x 13	4.5 - 9.0	**671** 0115	"
	4 x 17	8.5 - 13.0	**671** 0123	"
4.8 - K 16 Hole Ø: 4.9 mm	**4.8 x 10**	1.5 - 6.5	**671** 0174	P 250
	4.8 x 15	6.0 - 11.0	**671** 0182	"
	4.8 x 17	8.5 - 13.0	**671** 0190	"

A2 stainless steel Standard

(Dome head)

Rivet body: Stainless steel A2 - no. 1.4567
Mandrel: Stainless steel A2 - no. 1.4541

Material surcharge will be added at a daily rate

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 8**	1.0 - 5.0	**673** 0019	P 1.000
	3.2 x 9.5	2.0 - 6.0	**673** 0027	"
	3.2 x 11	3.0 - 8.0	**673** 0035	"
4.0 Hole Ø: 4.1 mm	**4 x 10**	1.0 - 6.5	**673** 1007	P 500
	4 x 13	3.0 - 8.0	**673** 1015	"
	4 x 17	7.0 - 11.0	**673** 1023	"
4.8 Hole Ø: 4.9 mm	**4.8 x 10**	1.0 - 6.5	**673** 2032	P 500
	4.8 x 15	5.0 - 10.0	**673** 2059	"
	4.8 x 17	8.0 - 12.0	**673** 2067	"
6.4 Hole Ø: 6.5 mm	**6.4 x 13**	2.0 - 6.5	**673** 3057	P 250
	6.4 x 15	3.5 - 8.5	**673** 3034	"
	6.4 x 20	7.0 - 12.5	**673** 3061	"

PolyGrip® alu/steel and alu/stainless steel

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm Standard	Max. head Ø mm Large flange
3.2	**720**	(73)	**1,050**	(107)	1.8	6.5	9.5
4.0	**1,060**	(108)	**1,680**	(171)	2.3	8.0	12.0
4.8	**1,500**	(163)	**2,300**	(231)	2.7	9.5	16.0
6.4	**2,800**	(285)	**4,000**	(405)	3.65	13.0	-

PolyGrip® steel/steel

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm Standard	Max. head Ø mm Large flange
3.2	**1,200**	(122)	**1,600**	(163)	2.1	6.5	9.5
4.0	**1,650**	(168)	**2,400**	(245)	2.6	8.0	12.0
4.8	**2,400**	(245)	**3,200**	(326)	3.2	9.5	16.0
6.4	**4,900**	(499)	**6,200**	(632)	4.25	13.0	-

PolyGrip® stainless steel

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3.2	**1,450**	(148)	**2,300**	(235)	2.2	6.5
4.0	**2,650**	(271)	**3,600**	(367)	2.7	8.0
4.8	**4,000**	(408)	**5,000**	(510)	3.2	9.5
6.4	**7,800**	(795)	**8,800**	(897)	4.25	13.0

Test procedure according to DIN EN ISO 14589

All GESIPA® PolyGrip® blind rivets are guaranteed to be splash proof under certain conditions.

SolarGrip® special rivet for flexible use in solar panel installation

SolarGrip® – the solar fastener

- DIBt approval Z-14.1-537
- Matching grip range for many solar applications
- Ideal for working on trapezoid panel roofs
- SolarSeal coating for 4,8 mm rivets
- Riveting of sponge rubber or EPDM washers possible
- Function documentation available on request at extra cost

SolarGrip® – the basic characteristics

- Large grip range coverage with a single blind rivet
- Wide closing head
- Outstanding hole filling capability
- Compact closing head
- For use with all GESIPA® setting tools

The perfect processing tool, the PowerBird®-Solar, can be found on page 62.

SolarGrip – the demand of our customer Contecta

The task
- An efficient fastener for two applications

The pre-requisites:
- Reliable connection
- Varying grip ranges
- Limited accessibility

The result:
- A blind rivet with a large grip range and large hole tolerance
- SolarSeal coating for 4.8 size rivets
- Processing tool: PowerBird® Solar

SolarGrip® – The verdict of our customer Contecta

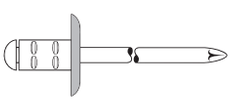
Our customer Contecta, a developer and manufacturer of solar installation systems from Kirchheim, about SolarGrip®:
Easy, fast, reliable: With our TÜV-certified installation system DICONAL®, we offer flexible solutions direct from the manufacturer.
For attachment to trapezoid plate roofs, we were looking for a solution which fulfilled our requirements for watertightness and easy, fast installation. There was one thing it had to be above all: Economical!

In GESIPA®, we found a reliable, flexible partner who perfectly meets our many requirements.

Thanks to the open and cooperative partnership with GESIPA®, we have in the 2010 season already used hundreds of thousands of blind rivets tailored exactly to our needs, and to the complete satisfaction of our customers.

www.DICONAL®.de CONTECTA

SolarGrip® Program



	Rivet body D_1 x L mm	Material	Grip range mm	Tensile strength in N	Shear strength in N	Part no.	Quantity per box	
4.8 Hole Ø: 5.1- 5.2 mm Ü	4.8 x 12.0 F K 11.4	Rivet body: Alu AlMg 2.5 (colour: silver) Mandrel: Stainless steel A2 — no. 1.4541	3.0 - 5.0	2,300	1,500	**672** 1013	P 500	*
	4.8 x 15.0 F K 11.4	Rivet body: Alu AlMg 2.5 (Colour: black) Mandrel: Stainless steel A2 — no. 1.4541	5.0 - 8.0	2,300	1,500	**672** 1024	"	*
6.4 Hole Ø: 6.5- 6.9 mm Ü	6.4 x 14.0 F K 11.4	Rivet body: Alu AlMg 2.5 (blank) Mandrel: Steel, zinc-plated	3.0 - 8.0	4,000	2,800	**670** 1011	P 250	

Ü: DIBt approval No. Z-14.1-4 and Z-14.1-537
Please refer to approval documents

*** Material surcharge will be added at a daily rate**
All sizes on request - also available in bulk packs

Many millions of connections prove the reliability of the GESIPA®- SolarGrip® blind rivet day after day in storms, rain, snow and sun, above is the applications for the company mp tec.

Speak to us, we will be happy to advise you!

GESIPA CAP® – naturally air and watertight

The GESIPA CAP® blind rivet – A closed end rivet

The rivet body of the GESIPA CAP® blind rivet is absolutely air and watertight. Liquids cannot seep through, could however seep around the set rivet, if the setting hole is too large. Therefor great care must be brought to fullfilling the hole tolerances.

The GESIPA CAP® blind rivet – the structure

For technical reasons, the rivet mandrel of the GESIPA CAP® blind rivet must be fixed in the hollow rivet. However this means that the rivet body can only deform slightly during the setting process. As a result, the cap blind rivet only has marginal bearing stress properties. However these are necessary to be able to compensate large bore-hole tolerances.

The GESIPA CAP® blind rivet – Tight connections with care

The above-mentioned technical situations make careful preparation of the application imperative. The hole diameter should be as tight as possible to ensure a flawless function in the application for a long period.

If the GESIPA CAP® blind rivet is processed carefully, it forms the basis for a reliably "tight" connection.

CAP- blind rivet alu/steel standard

Rivet body: Alu AlMg 5
Mandrel: Steel, phosphate coated

Closed end rivet

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.5**	0.5 - 2.0	**610** 0016	A 500
	3.2 x 8.0	2.0 - 3.5	**610** 0032	"
	3.2 x 9.5	3.5 - 5.0	**610** 0059	"
	3.2 x 10.5	5.0 - 6.5	**610** 0075	"
	3.2 x 12.5	6.5 - 8.0	**610** 0091	"
4 Hole Ø: 4.1 mm	**4 x 8.0**	0.5 - 3.5	**610** 0709	B 500
	4 x 9.5	3.5 - 5.0	**610** 0717	"
	4 x 11.0	5.0 - 6.5	**610** 0725	"
	4 x 12.5	6.5 - 8.0	**610** 0733	"
	4 x 15.0	8.0 - 11.0	**610** 0741	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm Ü	**4.8 x 8.0**	1.0 - 3.5	**610** 0350	B 500
	4.8 x 9.5	3.5 - 5.0	**610** 0377	"
	4.8 x 11.0	5.0 - 6.5	**610** 0393	"
	4.8 x 12.5	6.5 - 8.0	**610** 0415	"
	4.8 x 14.0	8.0 - 9.5	**610** 0431	"
	4.8 x 16.0	9.5 - 11.0	**610** 0873	"
	4.8 x 18.0	11.0 - 13.0	**610** 0857	"
	4.8 x 21.0	13.0 - 16.0	**610** 0865	B 250

Ü: DIBt approval No. Z-14.1-4
Please refer to approval documents

CAP- blind rivet alu/stainless steel standard

Rivet body: Alu AlMg 5
Mandrel: Stainless steel

Closed end rivet

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.5**	0.5 - 2.0	**612** 2000	A 500
	3.2 x 8.0	2.0 - 3.5	**612** 2019	"
	3.2 x 9.5	3.5 - 5.0	**612** 2027	"
	3.2 x 10.5	5.0 - 6.5	**612** 2035	"
	3.2 x 12.5	6.5 - 8.0	**612** 2043	"
4 Hole Ø: 4.1 mm	**4 x 8.0**	0.5 - 3.5	**612** 2108	B 500
	4 x 9.5	3.5 - 5.0	**612** 2116	"
	4 x 11.0	5.0 - 6.5	**612** 2124	"
	4 x 12.5	6.5 - 8.0	**612** 2132	"

Material surcharge will be added at a daily rate

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm Ü	**4.8 x 8.0**	1.0 - 3.5	**612** 2205	B 500
	4.8 x 9.5	3.5 - 5.0	**612** 2213	"
	4.8 x 11.0	5.0 - 6.5	**612** 2221	"
	4.8 x 12.5	6.5 - 8.0	**612** 2248	"
	4.8 x 14.0	8.0 - 9.5	**612** 2256	"
	4.8 x 16.0	9.5 - 11.0	**612** 2264	"
	4.8 x 18.0	11.0 - 13.0	**612** 2272	"
	4.8 x 21.0	13.0 - 16.0	**612** 2280	B 250

Ü: DIBt approval No. Z-14.1-4; Please refer to approval documents

CAP- blind rivet A2-stainless steel standard

Rivet body: Stainless steel A2 — no. 1.4301
Mandrel: Stainless steel A1 — no. 1.4021

Closed end rivet

EDELSTAHL Rost frei

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.0**	0.8 - 2.0	**613** 0001	A 500
	3.2 x 8.0	2.0 - 4.0	**613** 0002	"
	3.2 x 10.0	4.0 - 6.0	**613** 0003	"
	3.2 x 12.0	6.0 - 8.0	**613** 0004	"
4 Hole Ø: 4.1 mm	**4 x 6.0**	0.8 - 1.5	**613** 0011	A 500
	4 x 8.0	1.5 - 3.5	**613** 0012	"
	4 x 10.0	3.5 - 5.5	**613** 0013	B 500
	4 x 12.0	5.5 - 7.5	**613** 0014	"
	4 x 16.0	7.5 - 11.5	**613** 0015	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 8.0**	0.8 - 3.0	**613** 0031	B 500
	4.8 x 10.0	3.0 - 5.0	**613** 0032	"
	4.8 x 12.0	5.0 - 7.0	**613** 0033	"
	4.8 x 16.0	7.0 - 11.0	**613** 0034	"
	4.8 x 20.0	11.0 - 15.0	**613** 0035	B 250

Material surcharge will be added at a daily rate

CAP- blind rivet copper / steel standard

Rivet body: Cu-mat
Mandrel: Steel, lightly oiled

Closed end rivet

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.0**	0.5 - 1.5	**614** 1012	A 500
	3.2 x 7.5	1.5 - 3.0	**614** 1039	"
	3.2 x 9.0	3.0 - 4.5	**614** 1055	"
	3.2 x 12.0	4.5 - 8.0	**614** 1071	"
4 Hole Ø: 4.1 mm	**4 x 9.5**	1.0 - 4.5	**614** 1101	A 500

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 4.9 mm	**4.8 x 11.5**	3.5 - 6.5	**614** 1233	B 500
	4.8 x 13.0	6.5 - 8.0	**614** 1241	"
	4.8 x 15.0	8.0 - 9.5	**614** 1268	"

CAP- blind rivet copper / stainless steel standard

Rivet body: Cu-mat
Mandrel: Stainless steel

Closed end rivet

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.3 mm	**3.2 x 6.0**	0.5 - 1.5	**617** 3007	A 500
	3.2 x 7.5	1.5 - 3.0	**617** 3015	"
	3.2 x 9.0	3.0 - 4.5	**617** 3023	"

Material surcharge will be added at a daily rate

CAP-Alu/steel and **CAP-Alu/stainless steel**						
Rivet Ø mm	**Shear strength** N	(kp)	**Tensile strength** N	(kp)	**Mandrel Ø** mm	**Max. head Ø** mm
3.2	**1,050**	(107)	**1,250**	(127)	1.7	6.5
4.0	**1,550**	(158)	**2,100**	(214)	2.2	8.5
4.8	**2,400**	(245)	**3,500**	(356)	2.7	10.0

CAP-A2 stainless steel						
Rivet Ø mm	**Shear strength** N	(kp)	**Tensile strength** N	(kp)	**Mandrel Ø** mm	**Max. head Ø** mm
3.2	**1,900**	(194)	**2,400**	(245)	1.9	6.5
4.0	**2,900**	(296)	**3,700**	(377)	2.3	8.5
4.8	**4,300**	(439)	**5,400**	(551)	2.9	10.0

Test procedure according to DIN EN ISO 14589

CAP-Copper/steel and **CAP-Copper/stainless steel**						
Rivet Ø mm	**Shear strength** N	(kp)	**Tensile strength** N	(kp)	**Mandrel Ø** mm	**Max. head Ø** mm
3.2	**1,000**	(102)	**1,400**	(143)	1.7	6.0
4.0	**1,500**	(153)	**2,200**	(224)	2.2	8.0
4.8	**2,100**	(214)	**3,100**	(316)	2.7	9.5

Coloured blind rivets and special blind rivets

Coloured blind rivets

GESIPA® blind rivets are also available in colour to match the application.

To guarantee the best possible durability the hollow rivets are painted using a two-component epoxy resin paint in a stove enamelling process.

In addition to the visual benefits, the painted blind rivet also has added protection against corrosion.
Aluminium blind rivets are best suited for this procedure. In the long-term they achieve the desired visual effect when joining coloured parts.

GESIPA® blind rivets are available in the standard RAL colours. On request, steel blind rivets are also available in RAL colours or even special colours.

Another method for colouring blind rivets and for protecting them against corrosion is to anodise them. GESIPA® blind rivets are anodised in a direct current sulphuric acid process. The term Eloxal is used to describe the electrolytic oxidation of aluminium. Eloxal itself is actually colourless. Applying a second coat using metal salts creates the desired light-fast colour. The Eloxal method is more complex but is the most durable process for coloured blind rivets.

Special blind rivets

There are numerous applications that require the use of special blind rivets. For this reason GESIPA® has come up with some variations to meet these requirements.
Grooved blind rivets are suitable for riveting pocket holes in soft materials. They are used in the furniture industry, for interior construction, in the wood and plastics processing industry, in car body construction and lots more.
Important: Before processing grooved blind rivets, the bore-hole diameter must be determined in trials and the minimim bore-hole depth must be observed.

Peel blind rivets are required if soft or porous parts such as wood, hard-fibre, fibreglass or plasterboards need to be joined together. In the setting process, the rivet mandrel falls out of the hollow rivet, and on the closing head side the rivet mandrel splits the hollow rivet into four parts. These then grip into the material. Typical application fields are the assembly of plastic and wooden elements, caravan constructions and the attachment of interior panels.

The blind rivet connection itself is a permanent connection. However to attach further detachable parts, GESIPA® has the **threaded blind rivet** in its range. The threaded blind rivet has a stud bolt with an M5 or M6 outer thread to which other parts can be attached using an additional nut. The GESIPA® blind rivet stud range is listed on page 109 for parts that need greater clamping forces.

The **GESIPA®-clamp profile blind rivet** are excellently suited to comply with defined clearances when mounting parts or to set stoppers in rails. Accordingly, this special rivet is also used in the white goods and furniture industry.

Painted blind rivet alu/steel standard

Rivet body: Alu, painted AlMg 3
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L in mm	Colour	RAL no.	Grip range mm	Part no.	Quantity per box
3 Hole Ø: 3.1 mm	**3 x 6**	**black**	9005	0.5 - 3.5	**630** 0049	A 500
	3 x 6	**white**	9010	0.5 - 3.5	**630** 4680	"
	3 x 8	**black**	9005	3.5 - 5.0	**630** 0057	"
	3 x 8	**white**	9010	3.5 - 5.0	**630** 0065	"
4 Hole Ø: 4.1 mm	**4 x 6**	**black**	9005	0.5 - 3.0	**630** 0073	"
	4 x 6	**white**	9010	0.5 - 3.0	**630** 4699	"
	4 x 6	**brown**	8014	0.5 - 3.0	**630** 0243	
	4 x 8	**black**	9005	3.0 - 5.0	**630** 0251	"
	4 x 8	**white**	9010	3.0 - 5.0	**630** 0278	"
	4 x 8	**brown**	8014	3.0 - 5.0	**630** 0286	"
	4 x 10	**black**	9005	5.0 - 6.5	**630** 0294	"
	4 x 10	**white**	9010	5.0 - 6.5	**630** 0510	"
	4 x 10	**brown**	8014	5.0 - 6.5	**630** 0537	"
	4 x 12	**black**	9005	6.5 - 8.5	**630** 0553	B 500
	4 x 12	**white**	9010	6.5 - 8.5	**630** 0588	"
	4 x 12	**brown**	8014	6.5 - 8.5	**630** 0618	"
	4 x 16	**white**	9010	10.5 - 12.5	**630** 4702	"
5 Hole Ø: 5.1 mm	**5 x 10**	**black**	9005	1.5 - 6.0	**630** 0626	"
	5 x 10	**white**	9010	1.5 - 6.0	**630** 0634	"
	5 x 12	**black**	9005	6.0 - 8.0	**630** 0642	"
	5 x 12	**white**	9010	6.0 - 8.0	**630** 0650	"

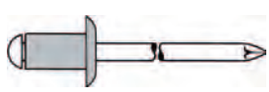
Anodised blind rivet alu/steel standard

Rivet body: Alu anodised AlMg 3
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L in mm	Colour	RAL no.	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 8**	**dark bronze**	8017	2.0 - 5.0	**630** 0669	A 500
	4 x 10	**black**	9005	5.0 - 6.5	**630** 0677	"
	4 x 10	**dark bronze**	8017	5.0 - 6.5	**630** 0685	"
	4 x 12	**black**	9005	6.5 - 8.5	**630** 0693	B 500
	4 x 12	**dark bronze**	8017	6.5 - 8.5	**630** 0839	"
	4 x 16	**dark bronze**	8017	8.5 - 12.5	**630** 0847	"

Anodised blind rivet alu/stainless steel standard *(Dome head)*



Rivet body: Alu anodised AlMg 3
Mandrel: Stainless steel A2 no. 1.4541

	Rivet body D_1 x L in mm	Colour	RAL no.	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 12**	**dark bronze**	8017	6.5 - 8.5	**632** 0325	B 500

Painted and anodised blind rivet alu/steel and anodised blind rivet alu/stainless steel					
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3	**700**	(71)	**900**	(92)	1.8	6.5
4	**1,400**	(143)	**2,000**	(204)	2.1	8.0
5	**2,000**	(204)	**2,800**	(285)	2.7	9.5

Material surcharge will be added at a daily rate

Test procedure according to DIN EN ISO 14589

Other sizes and colours on request

Grooved blind rivets alu/steel standard

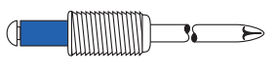
Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

(Dome head)

	Rivet body D_1 x L mm	max. thickness for parts to be riveted on mm	Part no.	Quantity per box
3.2 Hole Ø: 3.4 mm	**3.2 x 10**	6	**630** 3536	A 500
	3.2 x 16	12	**630** 3552	"
4 Hole Ø: 4.3 mm	**4 x 8**	4	**630** 3595	A 500
	4 x 12	8	**630** 3633	B 500
	4 x 16	12	**630** 3676	"

	Rivet body D_1 x L mm	max. thickness for parts to be riveted on mm	Part no.	Quantity per box
4.8 Hole Ø: 5.1 mm	**4.8 x 10**	6	**630** 3757	B 500
	4.8 x 14	10	**630** 3773	B 250
	4.8 x 18	13	**630** 3560	"
	4.8 x 20	15	**630** 3811	"
	4.8 x 25	20	**630** 3870	"

Threaded blind rivets steel/steel

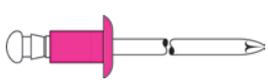


Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

Thread Hole Ø: 3.1 mm G x l mm	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 5 x 10	**3 x 6**	0.5 - 3.0	**638** 0018	A 250
M 5 x 15	**3 x 9**	3.0 - 6.0	**638** 0034	"

Thread Hole Ø: 4.1 mm G x l mm	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 6 x 10	**4 x 5**	1.0 - 2.0	**638** 0131	A 250
M 6 x 15	**4 x 8**	2.0 - 5.0	**638** 0158	"

Plastic blind rivets standard



Rivet body: Polyamide, PA 6.6
Mandrel: Polyamide, PA 6.6

(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4 Hole Ø: 4.1 mm	**4 x 8**	0.5 - 5.0	**640** 0019	B 500
	4 x 12	5.0 - 9.0	**640** 0035	"
5 Hole Ø: 5.1 mm	**5 x 8**	0.5 - 5.0	**640** 0116	B 500
	5 x 12	5.0 - 9.0	**640** 0132	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
6 Hole Ø: 6.1 mm	**6 x 8**	0.5 - 5.0	**640** 0213	B 250
	6 x 12	5.0 - 9.0	**640** 0256	"

Grooved alu/steel					
Rivet Ø mm	**Shear strength** **N**	(kp)	**Tensile strength** **N**	(kp)	**Mandrel Ø** mm
3.2	**720**	(73)	**950**	(97)	1.95
4	**1,400**	(143)	**2,000**	(204)	2.1
4.8	**1,800**	(184)	**2,700**	(275)	2.7

Thread steel/steel			
Rivet Ø mm	**Shear strength** **N**	(kp)	**Mandrel Ø** mm
3	**1,100**	(112)	1.95
4	**2,000**	(204)	2.5

Plastic			
Rivet Ø mm	**Shear strength** **N**	(kp)	**Mandrel Ø** mm
4	**180**	(18)	2.5
5	**290**	(30)	3.0
6	**440**	(45)	3.5

Test procedure according to DIN EN ISO 14589

Peel blind rivets alu/steel standard

Rivet body: Alu AlMg 3
Mandrel: Steel, zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
3.2 Hole Ø: 3.6 mm	**3.2 x 10**	2.5 - 5.0	**646** 0232	A 500
	3.2 x 12	4.5 - 7.0	**646** 0240	"
	3.2 x 16	6.5 - 11.0	**646** 0267	"
4 Hole Ø: 4.4 mm	**4 x 8**	1.0 - 3.0	**646** 0003	A 500
	4 x 10	2.5 - 5.0	**646** 0216	B 500
	4 x 12	4.5 - 6.5	**646** 0038	"
	4 x 14	6.0 - 8.0	**646** 0046	"
	4 x 16	7.5 - 10.0	**646** 0054	"
	4 x 18	9.0 - 12.0	**646** 0062	"
	4 x 20	11.5 - 14.0	**646** 0070	"

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 5.2 mm	**4.8 x 10**	2.5 - 5.0	**646** 0208	B 500
	4.8 x 12	4.5 - 7.0	**646** 0127	"
	4.8 x 14	6.5 - 9.0	**646** 0135	B 250
	4.8 x 16	8.5 - 10.0	**646** 0143	"
	4.8 x 18	9.5 - 12.0	**646** 0186	"
	4.8 x 20	11.5 - 14.0	**646** 0151	"
	4.8 x 25	13.5 - 19.0	**646** 0275	"

Profile clinching rivets alu/steel

Rivet body: Aluminium, RoHS compliant
Mandrel: Steel, zinc-plated

Profile Type Hole Ø: 3.1 mm	Rivet body Ø x L mm	Grip Material-range mm	Part no.	Quantity per box
HA	**3 x 5**	1.0 - 2.5	**620** 0012	A 500
HA	**3 x 7**	2.5 - 4.5	**620** 0039	"
HB	**3 x 5**	1.0 - 2.5	**620** 0055	A 500
HB	**3 x 7**	2.5 - 4.5	**620** 0071	"
W	**3 x 5**	1.0 - 2.5	**620** 0098	A 500

Profile Type Hole Ø: 4.1 mm	Rivet body Ø x L mm	Grip Materal-ge mm	Part no.	Quantity per box
A	**4 x 7**	1.0 - 4.0	**620** 0233	B 500
BR	**4 x 7**	1.0 - 4.0	**620** 0276	"
C	**4 x 7**	1.0 - 4.0	**620** 0314	"
KF	**4 x 7**	1.0 - 4.0	**620** 0330	"

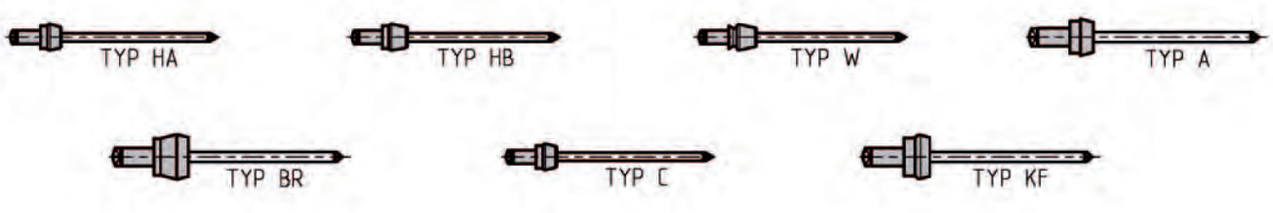
Spread alu/steel

Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
3.2	**800**	(81)	**950**	(97)	1.95	6.5
4	**1,400**	(143)	**2,000**	(204)	2.1	8.0
4.8	**2,000**	(204)	**2,700**	(275)	2.7	9.5

Clinching profile alu/steel

Rivet Ø mm	Shear strength N	(kp)	Mandrel Ø mm
3	**450**	(46)	1.8
4	**850**	(87)	2.1

Test procedure according to DIN EN ISO 14589



G-Bulb® – High strength in steel and stainless steel

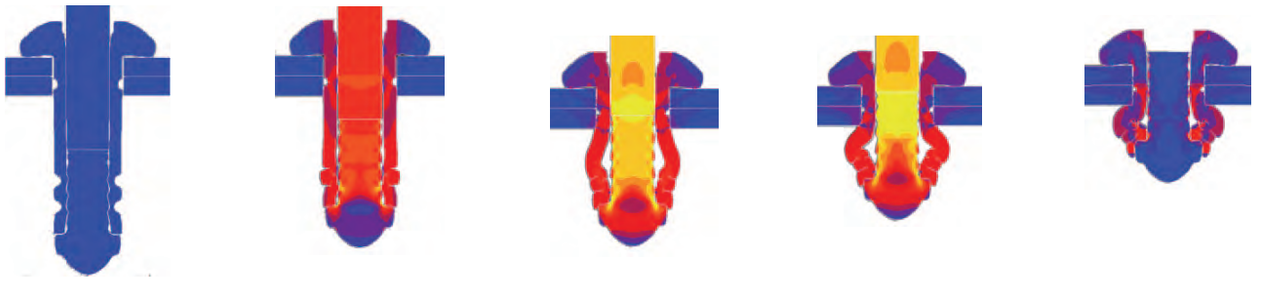
GESIPA® has developed a new range of high strength structural blind rivets called G-Bulb® with diameters of 4.8 and 6.4mm in steel and A2 stainless steel, to fit grip ranges from 1.5 up to 15.5 mm.

The G-Bulb® rivet features a wide grip range, together with high shear and tensile strengths generated by the rivet function, the formation of a large closing head and the mechanical lock of the rest mandrel in the rivet body.

In combination with the patented function crimping on the rivet body, the G-Bulb® provides tight and sealed joints in a large variation of hole sizes.

The G-Bulb® rivet generates a large closing head which transfers high strain and clamping load to the application. With a mandrel breakload of max. 16 kN, the G-Bulb® rivets can be installed with standard tooling.

The setting process



Main features

- **Excellent hole filling capability**
- **High clamping force**
- **Excellent tensile strength through large closing head**
- **Excellent shear strength through mandrel locking**
- **Processing with standard setting tools**
- **Process control compatible with the TAURUS C**
- **RoHS compliant**

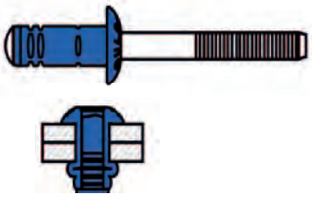
Materials:
Rivet body: Steel, zinc plated CrVI-free, or stainless steel A2 No. 1.4567
Mandrel: Steel, zinc plated CrVI-free, or stainless steel A2 No. 1.4541
Other surface treatments on request

G-Bulb® high strength blind rivet

Steel/steel

Dome head

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

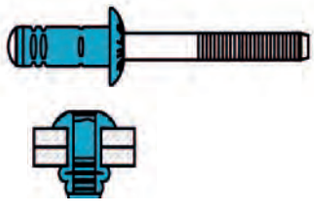


	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 5.0 - 5.2 mm	**4.8 x 10**	1.5 - 3.5	**681** 2037	B 500
	4.8 x 13	3.5 - 6.0	**681** 2045	"
	4.8 x 15	6.0 - 8.0	**681** 2064	"
6.4 Hole Ø: 6.7 - 6.9 mm	**6.4 x 13**	2.0 - 4.5	**681** 3014	B 250
	6.4 x 17	4.5 - 7.0	**681** 3027	"
	6.4 x 20	7.0 - 10.5	**681** 3048	B 200
	6.4 x 23	10.5 - 13.0	**681** 3052	B 150
	6.4 x 25	13.0 - 15.5	**681** 3064	"

A2 stainless steel

Dome head

~~Rivet body:~~ Stainless steel A2 – no. 1.4567
Mandrel: Stainless steel A2 – no. 1.4541



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
4.8 Hole Ø: 5.0 - 5.2 mm	**4.8 x 10**	1.5 - 3.5	**683** 2030	B 500
	4.8 x 13	3.5 - 5.5	**683** 2040	"
	4.8 x 15	5.5 - 7.5	**683** 2068	"
6.4 Hole Ø: 6.7 - 6.9 mm	**6.4 x 13**	2.0 - 4.0	**683** 3015	B 250
	6.4 x 15	4.0 - 6.0	**683** 3020	"
	6.4 x 17	6.0 - 8.0	**683** 3028	"
	6.4 x 20	8.0 - 10.5	**683** 3039	B 200
	6.4 x 23	10.5 - 12.5	**683** 3042	B 150
	6.4 x 25	12.5 - 14.5	**683** 3056	B 150

Material surcharge will be added at a daily rate

Further dimensions and surfaces upon request

G-Bulb steel/steel						
Rivet Ø mm	**Shear strength** **N**	(kp)	**Tensile strength** **N**	(kp)	**Mandrel Ø** mm	**Max. head Ø** mm
4.8 x 10	**3,600**	(367)	**3,500**	(357)	3.2	9.5
4.8 x 13	**4,000**	(408)	**3,500**	(357)	3.2	9.5
4.8 x 15	**5,600**	(571)	**3,500**	(357)	3.2	9.5
6.4 x 13	**8,500**	(867)	**8,000**	(816)	4.25	13.0
6.4 x 17	**10,000**	(1,019)	**8,000**	(816)	4.25	13.0
6.4 x 20	**11,000**	(1,120)	**8,000**	(816)	4.25	13.0
6.4 x 23	**11,000**	(1,120)	**8,000**	(816)	4.25	13.0
6.4 x 25	**11,000**	(1,120)	**8,000**	(816)	4.25	13.0

G-Bulb A2 stainless steel						
Rivet Ø mm	**Shear strength** **N**	(kp)	**Tensile strength** **N**	(kp)	**Mandrel Ø** mm	**Max. head Ø** mm
4.8 x 10	**4,400**	(431)	**5,400**	(550)	3.2	9.5
4.8 x 13	**4,550**	(446)	**5,400**	(550)	3.2	9.5
4.8 x 15	**4,700**	(461)	**5,400**	(550)	3.2	9.5
6.4 x 13	**8,000**	(816)	**8,800**	(897)	4.25	13.0
6.4 x 15	**10,000**	(1,019)	**8,800**	(897)	4.25	13.0
6.4 x 17	**10,000**	(1,019)	**8,800**	(897)	4.25	13.0
6.4 x 20	**11,000**	(1,120)	**8,800**	(897)	4.25	13.0
6.4 x 23	**11,000**	(1,120)	**8,800**	(897)	4.25	13.0
6.4 x 25	**11,000**	(1,120)	**8,800**	(897)	4.25	13.0

Test procedure according to DIN EN ISO 14589

MEGA GRIP® blind rivet

MEGA GRIP® blind rivet - perfect efficiency

The GESIPA® MEGA GRIP® is a high strength structure blind rivet with a very large clamping range. The variable clamping range allows efficient use and, owing to the merging of up to five blind rivet lengths into one MEGA GRIP® dimension, reduces the handling costs.

MEGA GRIP® blind rivet - the setting process

During the setting process, the hollow mandrel head presses the hollow rivet body with great force against the rivet hole. The radial deformation here ensures that an above-average, large clamping area is covered. The stable position of the rivet mandrel throughout the entire setting process guarantees compliance with the high shear force through double locking. The excellent bearing stress properties also protect ideally against splashwater.

MEGA GRIP® blind rivet — standard or special production?

The GESIPA® MEGA GRIP® is available in a flat round head or recessed head form and comes in the material combinations alu/alu or steel/steel as standard. Supplied in large or small packages, the MEGA GRIP® is always available in the quantity required. We can supply special dimensions on request.

MEGA GRIP® blind rivet - the advantages

- Perfectly splash proof
- Efficient use with large grip range coverage
- High shear strength due to double rest mandrel locking
- Outstanding hole filling capability
- Flush removal on the setting head without sharp edges.

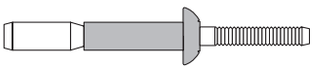
Please note that to achieve the best possible values from the GESIPA®-MEGA GRIP®, use of special tools/nosepieces is required.

MEGA GRIP® structure blind rivets

Alu/alu

Flat head

Rivet body: AlMg 5
Mandrel: Alu mat

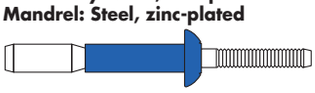


	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. small pack	Quantity per box
4.8 Hole Ø: 4.9- 5.2 mm	**4.8 x 10.0**	1.6 - 6.4	**RV6900-6-4**	**663** 0014	5,000	**663** 3015	B500
	4.8 x 14.0	1.6 - 11.1	**RV6900-6-7**	**663** 0022	3,000	**663** 3023	B250
6.4 Hole Ø: 6.6- 6.9 mm	**6.4 x 14.1**	2.0 - 9.5	**RV6900-8-6**	**663** 0111	2,000	**663** 3112	B200
	6.4 x 20.5	2.0 - 15.9	**RV6900-8-10XG**	**663** 0146	1,500	**663** 3147	B100

Steel/steel

Flat head

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated



	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. small pack	Quantity per box
4.8 Hole Ø: 4.9- 5.2 mm	**4.8 x 10.0**	1.6 - 6.4	**RV6977-6-4**	**664** 0028	5,000	**664** 3029	B500
	4.8 x 14.0	1.6 - 11.1	**RV6977-6-7**	**664** 0036	3,000	**664** 3037	B250
6.4 Hole Ø: 6.6- 6.9 mm	**6.4 x 14.1**	2.0 - 9.5	**RV6977-8-6**	**664** 0117	2,000	**664** 3118	B200
	6.4 x 20.5	2.0 - 15.9	**RV6977-8-10XG**	**664** 0133	1,500	**664** 3134	B100

Steel/steel

Countersunk

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. small pack	Quantity per box
4.8 Hole Ø: 4.9- 5.2 mm	**4.8 x 10.0**	2.6 - 6.4	**RV6177-6-5**	**664** 2004	3,500	**664** 3005	B250
	4.8 x 14.0	5.5 - 11.1	**RV6177-6-8**	**664** 2012	2,500	**664** 3013	B250
6.4 Hole Ø: 6.6- 6.9 mm	**6.4 x 15.8**	3.0 - 11.1	**RV6177-8-7**	**664** 2101	2,000	**664** 3102	B200

Caution: Use special tools/nosepieces for MEGA GRIP® blind rivets

MEGA GRIP® alu/alu						
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
4.8	**3,330**	(340)	**2,400**	(245)	2.95	9.2
6.4	**5,910**	(600)	**4,450**	(450)	3.9	12.4

MEGA GRIP® steel/steel						
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
4.8	**6,850**	(700)	**4,500**	(460)	2.95	9.2
6.4	**12,500**	(1,275)	**8,200**	(835)	3.9	12.4

Test procedure according to DIN EN ISO 14589

MEGA GRIP® blind rivets are available in small packs, too!

GESIPA® BULB-TITE® blind rivets - the multi-talents

Originally designed for the construction industry, the GESIPA®-BULB-TITE® rivets have proven their worth in many other application fields thanks to their multifunctional properties.
The majority of the BULB-TITE® program has been approved by the Deutschen Institutes für Bautechnik in Berlin thereby guaranteeing extra security when used in steel constructions or on facades.

BULB-TITE® blind rivet — Powerful wherever used

Thanks to the shear zone overlap of the BULB-TITE®-rivet mandrel in the application, permanent and very high shear forces can be achieved.

BULB-TITE® blind rivets — weather resistance

The use of a special nosepiece when processing the BULB-TITE®-rivet locks the mandrel into the sealing part on the setting head side to prevent dirt and/or damp penetrating the application. The sealing washer, which is available as an optional accesory, offers added protection against wet and damp below the closing head.

BULB-TITE® blind rivet — Excellent clamping force

The three large pressure plates distribute the clamping forces evenly across a large area of the surface so that even soft, thin, supple or brittle materials can be riveted safely without destroying or damaging the surface.

BULB-TITE® blind rivet — Complex applications

BULB-TITE®- rivets also guarantee a safe function where other rivets have already given up. The three plates of the closing head adapt and form to fit even curved application surfaces so that safe riveting is possible even on pipes, beads and other unusually formed applications.

BULB-TITE® blind rivets — Multi-Grip

GESIPA®-BULB-TITE®-rivets cover larger clamping ranges. Less dimensions are required thereby reducing handling and warehouse costs.

BULB-TITE® blind rivets — Application areas

Facades, shipbuilding, containers, lorry production and passenger traffic, trailers, trapezoidal sheet metal roof

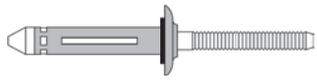
BULB-TITE® blind rivets - advantages at a glance

- Large grip range
- Vibration-proof
- Use on straight and curved application parts
- Waterproof with neoprene sealing disc
- Large distribution of the grip force over a large surface

BULB-TITE® blind rivets alu/alu

Rivet body: Alu AlMg 5
Mandrel: Alu AlCuMg 1

Dome head



	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. small pack	Quantity per box
4 Hole Ø: 4.1- 4.2 mm	**4 x 20.3**	1.5 - 6.4	**RV 6604-5-4**	**660** 0018	3,500	**660** 3019	B 250
	4 x 25.1	6.4 - 12.7	**RV 6604-5-8**	**660** 0026	"	**660** 3027	"
with EPDM seal disc	**4 x 20.3**	1.5 - 6.4	**RV 6604-5-4 W**	**660** 0514	"	**660** 3515	"
5.2 Hole Ø: 5.3- 5.5 mm	**5.2 x 17.5**	1.3 - 4.8	**RV 6604-6-3**	**660** 0115	3,000	**660** 3116	B 250
	5.2 x 19.1	1.6 - 6.4	**RV 6604-6-4**	**660** 0123	"	**660** 3124	"
	5.2 x 22.2	4.7 - 9.5	**RV 6604-6-6**	**660** 0131	"	**660** 3132	"
	5.2 x 25.4	7.9 - 12.7	**RV 6604-6-8**	**660** 0158	"	**660** 3159	"
Ü	**5.2 x 28.6**	11.1 - 15.9	**RV 6604-6-10**	**660** 0166	2,000	**660** 3167	B 200
	5.2 x 31.8	14.3 - 19.1	**RV 6604-6-12**	**660** 0174	"	**660** 3175	B 200
	5.2 x 34.9	17.4 - 22.2	**RV 6604-6-14**	**660** 0184	1,500	**660** 3185	B 150
	5.2 x 38.1	20.6 - 25.4	**RV 6604-6-16**	**660** 0196	"	**660** 3197	"
	5.2 x 41.3	23.8 - 28.6	**RV 6604-6-18**	**660** 0199	"	**660** 3198	"
with EPDM seal disc	**5.2 x 17.5**	0.5 - 4.8	**RV 6604-6-3 W**	**660** 0603	3,000	**660** 3604	B 250
	5.2 x 19.1	1.6 - 6.4	**RV 6604-6-4 W**	**660** 0611	"	**660** 3612	"
	5.2 x 22.2	4.7 - 9.5	**RV 6604-6-6 W**	**660** 0638	"	**660** 3639	"
	5.2 x 25.4	7.9 - 12.7	**RV 6604-6-8 W**	**660** 0646	"	**660** 3647	"
Ü	**5.2 x 28.6**	11.1 - 15.9	**RV 6604-6-10 W**	**660** 0654	2,000	**660** 3655	B 200
	5.2 x 31.8	14.3 - 19.1	**RV 6604-6-12 W**	**660** 0662	"	**660** 3663	
	5.2 x 34.9	17.4 - 22.2	**RV 6604-6-14 W**	**660** 0673	1,500	**660** 3674	B 150
	5.2 x 38.1	20.6 - 25.4	**RV 6604-6-16 W**	**660** 0684	"	**660** 3685	"
	5.2 x 41.3	23.8 - 28.6	**RV 6604-6-18 W**	**660** 0695	"	**660** 3696	"
6.3 Hole Ø: 6.4- 6.6 mm	**6.3 x 20.2**	1.6 - 6.4	**RV 6604-8-4**	**660** 0212	2,000	**660** 3211	B 200
	6.3 x 23.4	3.2 - 9.5	**RV 6604-8-6**	**660** 0220	"	**660** 3221	"
	6.3 x 26.5	6.4 - 12.7	**RV 6604-8-8**	**660** 0239	"	**660** 3238	"
	6.3 x 29.7	9.5 - 15.9	**RV 6604-8-10**	**660** 0247	1,500	**660** 3246	B 150
with EPDM seal disc	**6.3 x 20.2**	1.6 - 6.4	**RV 6604-8-4 W**	**660** 0700	2,000	**660** 3701	B 200
	6.3 x 23.4	3.2 - 9.5	**RV 6604-8-6 W**	**660** 0719	"	**660** 3718	"
	6.3 x 26.5	6.4 - 12.7	**RV 6604-8-8 W**	**660** 0727	"	**660** 3726	"
	6.3 x 29.7	9.5 - 15.9	**RV 6604-8-10 W**	**660** 0735	1,500	**660** 3734	B 150
7.7 Hole Ø: 7.8 - 8.2 mm Ü	**7.7 x 27.7**	1.0 - 9.5	**RV 6603-9-6**	**660** 0301	1,000	**660** 3302	B 100
with EPDM seal disc Ü	**7.7 x 27.7**	1.0 - 9.5	**RV 6603-9-6 W**	**660** 0808	"	**660** 3809	"

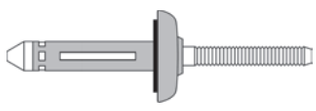
Refer to corresponding approval document

Ü: DIBt approval No. Z-14.1-4

BULB-TITE® blind rivets alu/alu

Rivet body: Alu AlMg 5
Mandrel: Alu AlCuMg 1

Large flange



	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. Small pack	Quantity per box
7.7 - K19 Hole Ø: 7.8- 8.2 mm	**7.7 x 27.7**	1.1 - 9.5	**RV 6605-9-6 W**	**660** 0905	1,000	**660** 3904	B 100
with EPDM seal disc Ü	**7.7 x 34.0**	6.4 - 15.9	**RV 6605-9-10 W**	**660** 0913	1,000	**660** 3912	B 100

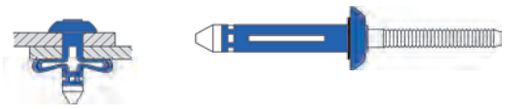
Refer to corresponding approval document

Ü: DIBt approval No. Z-14.1-4

BULB-TITE® blind rivet steel/steel

Rivet body: Steel, zinc-plated
Mandrel: Steel, zinc-plated

Round head



	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. Small pack	Quantity per box
6.3 Hole Ø: 6.4- 6.6 mm	**6.3 x 20.2**	1.0 - 6.4	**RV6676-8-4**	**661** 0013	1,500	**661** 3014	B 100
	6.3 x 23.4	3.2 - 9.5	**RV6676-8-6**	**661** 0021	"	**661** 3022	"

BULB-TITE® blind rivet monel/stainless steel

Rivet body: Monel
Mandrel: Stainless steel

Round head

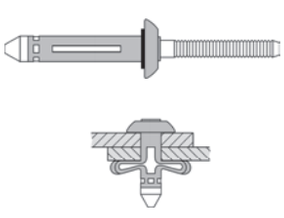
	Rivet body D_1 x L mm	Grip range mm	Type	Part no. bulk pack	Quantity per box	Part no. Small pack	Quantity per box
6.3 Hole Ø: 6.4- 6.6 mm	**6.3 x 20.2**	1.0 - 6.4	**RV6696-8-4**	**662** 0019	1,500	**662** 3018	B 100

Material surcharge will be added at a daily rate

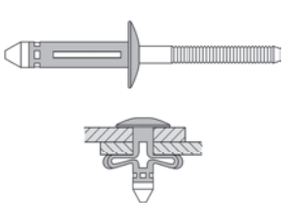
Caution: Use special tools/nosepieces for BULB-TITE® blind rivets

The following heads are also available on request:

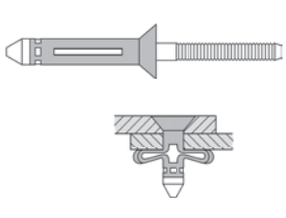
Alu/alu
Round head



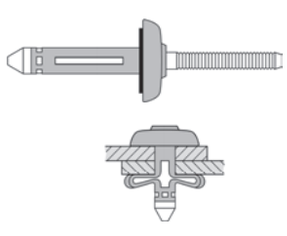
Alu/alu
Flat head



Alu/alu
Countersunk (82°)



Alu/alu
Large flange



BULB-TITE® steel/steel					
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm
6.3	**8,200**	(835)	**4,550**	(465)	3.9

BULB-TITE® Monel/stainless steel					
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm
6.3	**7,800**	(765)	**4,400**	(433)	3.9

BULB-TITE® alu/alu					
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm
4	**2,000**	(210)	**1,050**	(110)	2.4
5.2	**2,700**	(284)	**1,950**	(198)	2.9
6.3	**4,850**	(500)	**3,000**	(305)	3.9
7.7	**6,650**	(680)	**4,850**	(500)	4.5

Test procedure according to DIN EN ISO 14589

***BULB-TITE®* blind rivets are available in small packs, too!**

TRI-FOLD® folding type blind rivets

The function

The GESIPA® TRI-FOLD® blind rivet forms three press plates on the closing head side during setting.

The advantages

The large moulded press plates distribute the exerted clamping force evenly and gently onto the riveted material.
Also, the large surface of the press plates offer excellent protection against the rivet being pulled through very soft, porous or brittle application parts.
Thanks to its special design, the TRI-FOLD® is also able to compensate over-dimensional or irregular drill hole diameters.

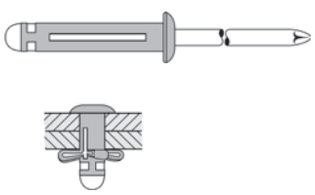
Application areas

TRI-FOLD® blind rivets are excellently suited for the automotive field, e.g. for plastic panelling, car body parts and for the interior work inside vehicles, but also for all other applications that are particularly soft, brittle, easily deformed or porous.

Alu/Alu

Dome head

Rivet body: Alu AlMg 5
Mandrel: Alu AlMg 5



	Rivet body D_1 x L mm	Grip range mm	Typ	Art. Nummer	Quantity per box
4.1 Hole Ø: 4.2 mm	**4.1 x 14.5**	1.0 - 3.0	GAMD52ATF	**666** 0002	B 500
	4.1 x 19.5	1.0 - 6.3	GAMD54ATF	**666** 0010	"
	4.1 x 21.1	1.0 - 9.5	GAMD56ATF	**666** 0029	"
	4.1 x 24.3	3.2 - 12.7	GAMD58ATF	**666** 0037	"
4.8 Hole Ø: 4.9 mm	**4.8 x 19.0**	1.6 - 6.3	GAMD64ATF	**666** 0045	B 250
	4.8 x 22.2	4.7 - 9.5	GAMD66ATF	**666** 0053	"
	4.8 x 25.4	7.9 - 12.7	GAMD68ATF	**666** 0061	"
	4.8 x 28.5	11.1 - 15.9	GAMD610ATF	**666** 0088	"
	4.8 x 31.7	14.2 - 19.0	GAMD612ATF	**666** 0096	A 100

TRI-FOLD® Alu/Alu						
Rivet Ø mm	Shear strength N	(kp)	Tensile strength N	(kp)	Mandrel Ø mm	Max. head Ø mm
4.1	**650**	(66)	**850**	(87)	2.4	8.2
4.8	**1,100**	(112)	**1,400**	(143)	2.9	10.1

Test procedure according to DIN EN ISO 14589

Blind rivet

t setting tools

What rivets what?

Units	Energy	Blind rivet Ø mm									
		2.4	3.0	3.2	4.0	4.8	5.0	6.0	6.4	8.0	10.0
NTS	H				A S E	A S	A S				
NTX / NTX F	H				A S E	A S	A S				
Flipper®	H				A S E	A S	A S				
SN2	H										
HN2	H										
HN2 BT	H										
AccuBird®	B										
PowerBird®	B										
PowerBird® Gold Edition	B										
PowerBird® Solar	B										
PH1	P	X									
PH1 VAS	P	X									
PH2	P	X					A S				
PH2 VAS	P	X					A S				
PH2 VK	P					A S					
PH Axial	P	X					A S				
PH 2000	P	X									
PH 2000 BT	P										
TAURUS 1	P				A S						
TAURUS 2	P						A S E	A S			
TAURUS 3	P										
TAURUS 4	P									A	
TAURUS 5	P										
TAURUS 6	P										
TAUREX 1	P				A S						
TAUREX 2	P							A S			
TAUREX 3	P										
TAUREX 4	P									A	
TAUREX 5	P										
TAUREX 6	P										

What rivets what?

Tools	Energy	PolyGrip®				G-Bulb®		MegaGrip®*	Bulb-Tite®*
		3.2	4.0	4.8	6.4	4.8	6.4		
NTS	H								
NTX / NTX F	H								
Flipper®	H								
SN2	H								
HN2	H				SE with X		X	X	X
HN2 BT	H								
AccuBird®	B								X to 6.3 A S
PowerBird®	B				A			6,4 A S E	X at 7.7
PowerBird® Gold Edition	B				A			6.6 A S	X at 7.7
PowerBird® Solar	B				A			6.4 A S E	X at 7.7
PH1	P								
PH1 VAS	P								
PH2	P								
PH2 VAS	P								
PH2 VK	P			A S					
PH Axial	P								
PH 2000	P				A				
PH 2000 BT	P								
TAURUS 1	P		A						
TAURUS 2	P								
TAURUS 3	P				A S		S		
TAURUS 4	P				A S E				
TAURUS 5	P								
TAURUS 6	P								
TAUREX 1	P		A						
TAUREX 2	P								
TAUREX 3	P				A S		S		
TAUREX 4	P								
TAUREX 5	P								
TAUREX 6	P								

H: Handtool
B: Battery-powered tool
P: Hydro-pneumatic tool

X: Special accessories required
*: A special nosepiece is **always** required when setting MEGA GRIP®-blind rivets and BULB-TITE®-blind rivets

A: Alu
S: Steel
E: Stainless steel

Blind rivet hand tools

NTS

Part no. 703 0010

(with self opening spring)

Working range

Processes all blind rivets up to 5 mm Ø aluminium and 4 mm Ø in steel and stainless steel

Technical data

Weight:	480 g
Total length:	275 mm
Stroke:	8 mm

Nosepieces / accessories

Nosepieces:
10/18, 10/24, 10/27 and 10/32
1 maintenance wrench
Operating instructions with spare parts list

Advantages

- Body casing in high-quality die cast aluminium
- Body head made of forged steel
- Narrow head for difficult to access rivets
- Opening spring for automatic ejection of the mandrel
- Ergonomic handles

Jaws (2 parts)

For NTS, NTX, NTX-F and Flipper
Part no. 705 2057

NTX

Part no. 705 0011

Working range

Processes all blind rivets up to 5 mm Ø aluminium and 4 mm Ø in steel and stainless steel

Technical data

Weight:	575 g
Total length:	260 mm
Stroke:	8 mm

Nosepieces / accessories

Nosepieces:
10/18, 10/24 and 10/32
1 maintenance wrench
Operating instructions with spare parts list

Advantages

- Body casing in high-quality die cast aluminium
- Body head made of chrome-vanadium steel, forged
- Steel inserts on all bearing points subject to wear
- Intermediate lever system reduces the force required and dampens the tear-off effect
- Narrow pliers head for difficult to access rivets
- Ergonomic slip handles
- Simple maintenance - fast jaw change

NTX F

Part no. 705 0054

(With opening spring for automatic ejection of the mandrel)

Working range

Processes all blind rivets up to 5 mm Ø aluminium and 4 mm Ø in steel and stainless steel

Technical data

Weight:	575 g
Total length:	260 mm
Stroke:	8 mm

Nosepieces / accessories

Nosepieces:
10/24, 10/27 and 10/32
1 maintenance wrench
Operating instructions with spare parts list

Advantages

- Opening spring for automatic ejection of the mandrel
- Body casing in high-quality die cast aluminium
- Body head made of chrome-vanadium steel, forged
- Steel inserts on all bearing points subject to wear
- Intermediate lever system reduces the force required and dampens the tear-off effect
- Narrow head for difficult to access rivets
- Ergonomic handles
- Simple maintenance - fast jaw change

MADE IN GERMANY

Riveting kit

Contents:
Hand riveter **NTX** and **12 blind rivet sizes**, 1 maintenance wrench
Weight: approx. 3.75 kg
Dimensions: 340 x 205 x 40 mm

Part no. 754 0027

The 12 blind rivet sizes:

Alu/steel 3.0 x 8.0
Alu/steel 3.0 x 10.0
Alu/steel 3.0 x 12.0
Alu/steel 4.0 x 5.0
Alu/steel 4.0 x 6.0
Alu/steel 4.0 x 8.0
Alu/steel 4.0 x 10.0
Alu/steel 4.0 x 12.0
Copper/steel 3.0 x 6.0
Copper/steel 4.0 x 6.0
Alu/steel 3.0 x 5.0
Alu/steel 3.0 x 7.0

Junior riveting kit

Contents:
Hand riveter **NTX**
and 5 blind rivet sizes,
1 maintenance wrench
Weight:
approx. 2.5 kg
Dimensions:
275 x 145 x 40 mm

Part no. 754 1023

The 5 blind rivet sizes:

Alu/steel 3.0 x 6.0
Alu/steel 3.0 x 8.0
Alu/steel 4.0 x 6.0
Alu/steel 4.0 x 10.0
Steel/steel 3.0 x 6.0

Blind rivet hand tools

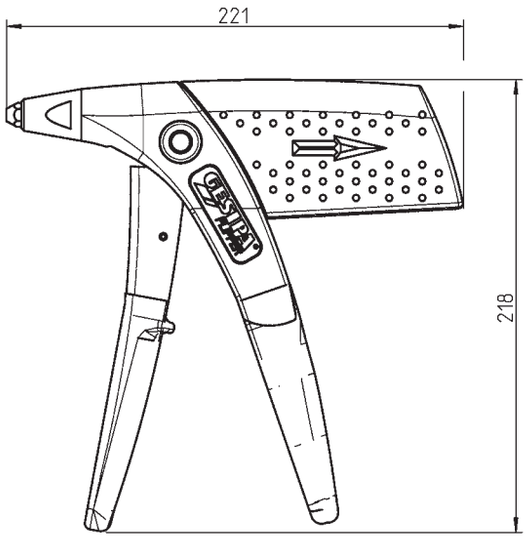
Flipper®

Working range

Processes all blind rivets up to 5 mm Ø alu and 4 mm Ø steel and stainless steel

Technical data

Weight:	750 g
Total length:	212 mm
Total stroke:	16.2 mm
Single action stroke:	1.8 mm



Conversion kit for plastic blind rivets:
Part no. 701 3000

Nosepieces / accessories

Nosepieces:
10/18, 10/24 and 10/29
1 maintenance wrench (on magazine)
Operating instructions with spare parts list

Part no. 701 0001

Advantages

- The force increases when the handle is closed. This is made use of via the special arrangement of the lever when setting blind rivets: ergonomic design
- The required manual force is reduced by around 40 percent if actuated several times.
- Actuation lever with an opening spring for easy single-handed operation
- Jaw mechanism with spring reset for safe and automatic mandrel ejection
- Rivet mandrel collection tank can be clipped to the body casing and is easy to empty
- Larger device lift: a benefit when handling extra long blind rivets
- Sturdy body casing in high-quality die cast aluminium
- Sturdy actuation lever made of tempered steel
- Link pin on anti-twist bearings
- Ergonomic lever positions and handle design

Flipper®-Box

Equipment and technical data

Contents:
Blind rivet hand tool **Flipper®** and **3 PolyGrip® blind rivet sizes**, in a lightweight plastic carrying case

Weight:	approx. 0.9 kg
Dimensions:	220 x 200 x 40 mm

The 3 blind rivet sizes:
PolyGrip alu/steel 3.2 x 8.0
PolyGrip alu/steel 4.0 x 10.0
PolyGrip alu/steel 4.8 x 10.0

Mini pack refills can be found on page 123.

Part no. 701 0002

Lever riveting tool

HN 2

Part no. 713 0015

Working range

Blind rivets from 3.0 to 6.4 mm Ø steel all materials, except PolyGrip® blind rivet with Ø 6.4 mm made of stainless steel and G-Bulb® blind rivets.

Technical data

Weight:	1.85 g
Total length:	570 mm
Stroke:	10 mm

Nosepieces / accessories

Nosepieces:
16/29, 16/32, 16/36, 16/40 and 16/45
Spent mandrel container
Maintenance instructions with spare parts list

Jaws (3 parts)

Part no. 710 2151

HN 2-BT

Part no. 713 0023

(only for BULB-TITE®)

Also for 7.7mm Ø

Working range

Sets blind rivets up to 7.7 mm Ø all materials

Technical data

Weight:	1.85 g
Total length:	570 mm
Stroke:	10 mm

Nosepieces / accessories

Nosepieces:
16/26 BT, 16/32 BT, 16/42 BT and 16/48 BT
Spent mandrel container
Maintenance instructions with spare parts list

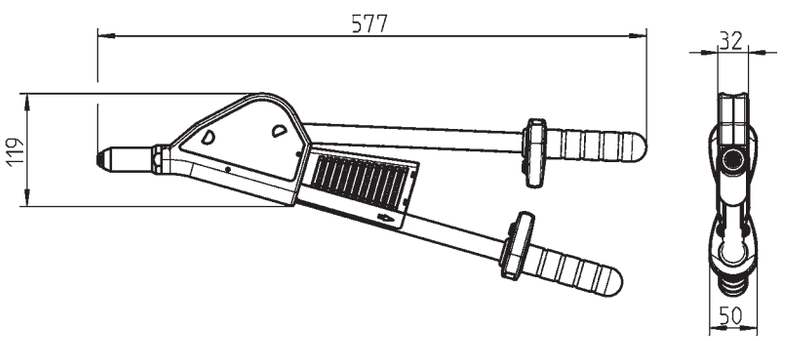
Jaws (3 parts): HN 2 BT

Part no. 715 1527

Nosepieces and performance - see page 55

Advantages

- Pliers casing in high-quality die cast aluminium, its sturdy design protects it against soiling
- Link pin on anti-twist bearings and with inner axial protection, wear-proof and smooth running
- Tooth segment transmission with favourable lever arm arrangement reduces the force required and dampens the tear-off effect
- Fixed casing lever and ergonomic handle design: simple and easy handling
- Actuation lever: repeated re-engagement very easy, even on workpiece; highly beneficial for oversized blind rivets
- Gear rack: supported on a brass plate; smooth running
- Rivet mandrel collection tank: swivel-mounted to the casing; can be emptied easily and safely



Lazy tong riveting tool

SN 2

Part no. 712 0028

Working range

Sets blind rivets from 3.0 to 6.4 mm Ø all materials

Technical data

Weight:	1.93 g
Length when closed:	310 mm
Length when opened:	810 mm
Stroke:	10.5 mm

Nosepieces / accessories

Nosepieces for Ø 3.2 mm, 4.0 mm, 4.8 mm, 6.0 mm and 6.4 mm
1 maintenance wrench
Operating instructions with spare parts list

Advantages

- Pliers casing and handle in high-quality die cast aluminium
- Shear system in high strength steel, galvanised
- Moulded handle — double bearing
- Narrow casing for difficult to access rivets
- Enclosed pliers casing prevents soiling
- Favourable lever arm arrangement with 4-joint slide block bearing — reduced effort

Jaws (3 parts)

Part no. 725 1613

Nosepiece assignment for manual, lazy tongue and lever rivet devices

Rivet Ø	Rivet material	NTS, NTX, NTX-F, Flipper	SN2	HN2	HN"-BT
2.4	Alu	10/18	–	–	–
3.2	CAP-Alu, CAP-Cu	10/18	–	–	–
3 and 3.2	Alu, Cu, steel, stainless steel, Stinox, Alu, PG-alu, PG-steel	10/24	17/24	16/24	–
4	Alu, Cu	10/24	17/24	16/24	–
4	Steel, CAP-Alu, CAP-Cu, Alu, PG-Alu	10/27	17/27	16/27	–
4	Stainless steel, Stinox, PG-steel	10/29	17/29	16/29	–
4.8	CAP-Alu, CAP-Cu	10/29	17/29	16/29	–
5 and 4.8	Alu, PG-Alu	10/32	17/29	16/29	–
5 and 4.8	Steel, alu	–	17/32	16/32	–
5 and 4.8	Stainless steel, Stinox, PG-steel	–	17/36	16/36	–
6	Alu	–	17/36	16/36	–
6	Steel	–	17/40	16/40	–
6.4	Alu, PG-Alu	–	17/40	16/40	–
6.4	Steel, alu	–	17/45	16/45	–
4	all **BULB-TITE**®	–	–	–	16/26 BT
5.2	all **BULB-TITE**®	–	–	–	16/32 BT
6.3	all **BULB-TITE**®	–	–	–	16/42 BT
7.7	all **BULB-TITE**®	–	–	–	16/48 BT

Article numbers for nosepieces

Article	Part no.
10/18	**705** 1182
10/24	**705** 1247
10/27	**705** 1271
10/29	**705** 1298
10/32	**705** 1328
16/18	**717** 1196
16/24	**717** 1234
16/27	**717** 1277
16/29	**717** 1293
16/32	**717** 1323
16/36	**717** 1366
16/40	**717** 1390
16/45	**717** 1455
16/26 BT	**717** 1471
16/32 BT	**717** 1498
16/42 BT	**717** 1501
16/48 BT	**717** 1528

Nosepieces SN2 see page 57

The Bird family

The Bird family comprises of the rechargeable blind rivet setting devices AccuBird® and PowerBird® and the rechargeable blind rivet nut setting device FireBird®. The development of this device series for professional use by specialists and industrial users made **GESIPA® the inventor of the cable-free and hose-free blind rivet technology.**
In 2012 the first of the devices, the AccuBird®, will celebrate its twentieth birthday.
The maintenance-friendly Bird device series thanks its enormous success to the following benefits.

The Bird family — Production

- Made in Germany
- GESIPA® development, market launch and further development since 1992 (AccuBird®), 1996 (PowerBird®), 1995 (FireBird®)

The Bird family — Packaging

AccuBird®, PowerBird® and FireBird® are supplied in a metal carrying case (34.5 x 26.5 x 9 cm)
the special versions of PowerBird® Solar and PowerBird® Gold Edition in a high quality plastic carrying case (43.7 x 37.9 x 13.0 cm)

The Bird family — Casing and accessories

Exchange for nosepieces and wrench for the AccuBird® and PowerBird® on the device, for the FireBird® in the spent mandrel container
The spent mandrel container, has an approx. volume of 190 cm^3, which means it does not need to be emptied frequently
Accessories and special models have been continuously expanded since the market launch

The Bird family — Wiring

Only two large cables each with a cross-section of 4 mm^2 are used

The Bird family – With Li-Ion energy

- No memory-effect
- High energy yield through high voltage and low weight for easy and fast operation
- Extremely low self discharge
- New battery shape allows the tool to be stored standing on its battery

The Bird family – Practical aspects

- Exchange nosepieces and wrench always included in the tool
- Compact, shockproof tool housing
- Spent mandrel evacuation into the mandrel container through backfilling and forwards through the nosepiece by gravity
- Fatigue-free working through well balanced weight repartition and ergonomic grip

The Bird family – Mechanics, control system and battery

- Reliable connection of the mechanics and control system
- Cast control system is water and dust-tight
- User-friendly pluggable rechargeable battery

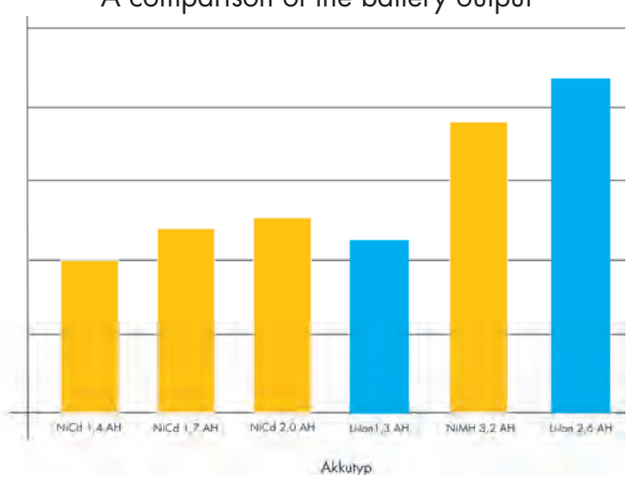
Intelligent energy

As part of the implementation of Directive 2006/66/EC of the European Community on the withdrawal of NiCd batteries, GESIPA® decided in favour of the Lithium-Ion technology as a mobile power source for battery powered setting tools. GESIPA® switched over to the new technology two years ago.

The most important advantages of Li-Ion technology

- Currently the most efficient mobile power supply
- Low weight
- High energy storage capacity (90-110 Wh/kg)
- Long storage capability due to low self-discharging
- No memory- or lazy-battery effect – low maintenance requirement
- Constant output voltage over the complete discharge period
- Large number of loading cycles
- Long service life

A comparison of the battery output



The GESIPA® battery-powered setting tools AccuBird® and FireBird® are equipped as standard with a 1.3 Ah Li-Ion battery. The GESIPA® PowerBird® is supplied with a 2.6 Ah Li-Ion battery.

The powerful 2.6 Ah battery is also optionally available as a special accessory for the AccuBird® and FireBird®. Older tools can of course also be operated with the new Li-Ion batteries. Due to the different charging principle used in the Li-Ion technology, the charging unit must also be replaced when switching over to Li-Ion batteries; the proven charging units for NiCd batteries are however still available.

Charging technology

A special, intelligent circuit in the GESIPA® Li-Ion batteries protects against deep discharging, and ensures that the last setting cycle can be completed, before the battery signals its empty condition by switching off.
The empty battery is ready for use again after a charging time of only about one hour.

The new GESIPA® Li-Ion charging units are of course also available for the alternating voltages of 110 VAC and 230 VAC.

AccuBird®

AccuBird® – Reliability

- Electronic control
- No mechanical switching components
- Electronic temperature and overload protection
- High reliability through low loss power transmission via a highly efficient ball screw drive

AccuBird® – Freedom

Cablefree tool for flexible operation in installation jobs and industry production

AccuBird® – High performance

- High pulling force for safe setting of blind rivets up to 5 mm diameter in all materials
- High yield per battery charge
- Large 20mm stroke

AccuBird® – Versatility

Blind rivets up to 5 mm Ø all materials. BULB-TITE® blind rivets 4 mm; 5.2 and 6.3 mm Ø alu and steel

AccuBird® with battery 14.4 V / 1.3 Ah,
and charger in carrying case
Part no. 725 0037

AccuBird® with two batteries 14.4 V / 1.3 Ah,
and charger in carrying case
Part no. 725 0019

AccuBird® with battery 14.4 V / 1.3 Ah,
and charger in cardboard box
Part no. 725 0029

AccuBird® with battery 14.4 V / 1.3 Ah,
in cardboard box
Part no. 725 0010

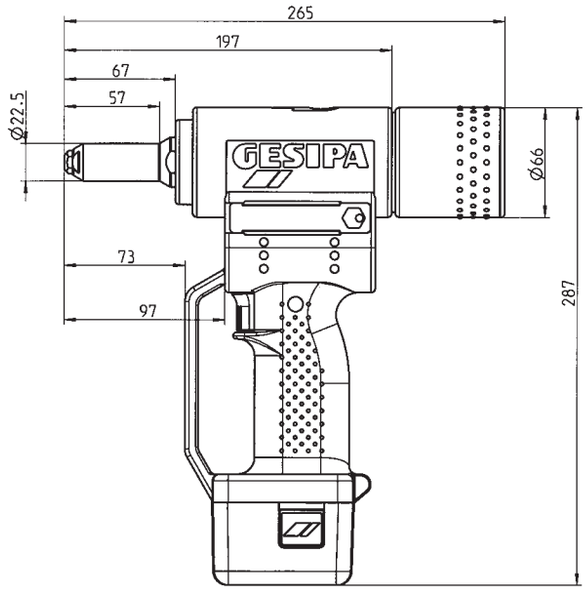
AccuBird® with battery 14.4 V / 1.3 Ah,
and charger with spring loaded trigger system in carrying case
Part no. 725 0015

AccuBird® – with Li-Ion energy

- Choice of 1.3 Ah and 2.6 Ah Li-Ion batteries

AccuBird® – High speed

- High speed of operation through automatic resetting of the jaw mechanism immediately after each setting process



Rechargeable 14.4 Volt riveting tool with Li-Ion battery

Working range

Sets blind rivets up to 5 mm Ø all materials. BULB-TITE® blind rivets 4 mm; 5.2 and 6.3 mm Ø alu and steel

Nosepieces / accessories

Nosepieces: 17/24, 17/27, 17/29 and 17/32

Technical data

Weight:	2.0 kg with battery
Stroke:	20 mm
Drive:	DC motor
Traction power:	10,000 N

Jaws (3 parts)

Part no. 725 1613

Nosepiece - power per battery charge

Blind rivet Ø in mm	Material	approx. pc/ battery charge	Nosepiece	Part no.
2.4	Alu	**1,500**	17/18*	**725** 2075
3.2	CAP-Alu, CAP-Cu	**1,000**	17/18*	**725** 2075
3 and 3.2	Alu	**800**	17/24	**725** 1583
3 and 3.2	Steel	**800**	17/24	**725** 1583
3 and 3.2	Stainless steel	**800**	17/24	**725** 1583
4	Alu	**800**	17/24	**725** 1583
4	Steel	**700**	17/27	**725** 2040
4	Stainless steel	**640**	17/29	**725** 2059
4.8 and 5	Alu	**550**	17/29	**725** 2059
4.8 and 5	Steel	**420**	17/32	**725** 2067
4.8 and 5	Stainless steel	**320**	17/36*	**725** 2083
6	Alu	**240**	17/36*	**725** 2083

Special nosepieces are available on request

BULB-TITE® blind rivet Ø in mm	Material	approx. pc/ battery charge	Nosepiece	Part no.
4	Alu	**1,000**	17/26 BT*	**725** 2202
5.2	Alu	**800**	17/32 BT*	**725** 2210
6.3	Alu	**600**	17/42 BT*	**725** 2229
6.3	Steel	**300**	17/42 BT*	**725** 2229

* Available as special accessory

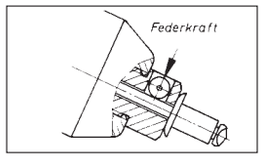
Universal nosepiece – 17
To suit AccuBird®

Part no. 725 1637

Detailed information can be found on page 85

Special accessory: Retaining nosepiece

- Inserted rivet remains in any position
- Rivets may be set with only one hand
- Safer working



Retaining nose-piece	Part no.	Retaining nose-piece	Part no.
17/18 R	**725** 4078	17/29 R	**725** 4108
17/24 R	**725** 4086	17/32 R*	**725** 4116
17/27 R	**725** 4094	17/36 R*	**725** 4124

*also for **PowerBird®**

Changeover set (Part 50) for BULB-TITE® blind rivet:
Part 54 (jaw pusher), Part 55 (jaws) and 3 nosepieces
Part no. 725 9290

Charger 14.4 V Li-Ion

Part no. 725 1134

Technical data

Input voltage:	230 V / 50 Hz
Output voltage:	14.4 V DC
Recharging time:	50 to 100 minutes (battery depending)
Weight:	0.6 g

Battery 14.4 V/1.3 Ah (Li-Ion)

Part no. 725 1045
Weight: 0.35 g

Power battery 14.4 V/2.6 Ah (Li-Ion)

Part no. 725 1049
Available as special accessory
Weight: 0.5 g

Akku RECYCLING

Charger 12 V NiCd
Part no. 725 1035

Extended spent mandrel container
to suit AccuBird® and PowerBird®
Part no. 725 9328

PowerBird®

PowerBird® – Innovation

As a stronger brother to the well-known AccuBird® the PowerBird® is the powerful extension of the so-called "Bird family" from GESIPA® able to cope with all high structure blind rivets.

PowerBird® – Practical aspects

- User oriented scope of delivery: metal carrying case with one battery charger, one battery and four nosepieces

PowerBird® – Economy

- Good price-performance ratio
- Large working range
- Short processing times
- High service life thanks to 2.6 Ah power battery

PowerBird® – With Li-Ion energy

- 2.6 Ah battery, alternatively 1.3 Ah on request

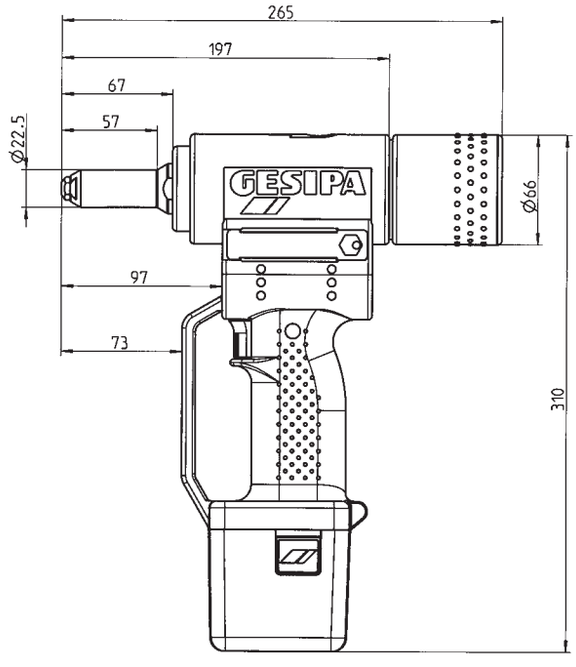
PowerBird® with power battery 14.4 Volt / 2.6 Ah and charger, in carrying case,
Part no. 724 0031

PowerBird® with two power batteries 14.4 Volt / 2.6 Ah and charger, in carrying case,
Part no. 724 0040

PowerBird® with power battery 14.4 Volt / 2.6 Ah and charger, in carrying case with spring loaded trigger system
Part no. 724 0160

PowerBird® – Versatility

Blind rivets from 4.8 mm Ø steel, up to 6.4 mm Ø all materials and up to 8 mm alu, except G-Bulb® Ø 6.4 mm. Bulb-tite® blind rivets up to 7.7 mm Ø all materials. Mega Grip® blind rivets up to 6.4 mm Ø all materials.



Rechargeable 14.4 volt power battery riveting tool with Li-Ion battery for even higher performance

Working range

Blind rivets from 4.8 mm Ø steel , up to 8 mm Ø alu and up to 6.4 mm all materials, except G-Bulb® Ø 6.4 mm.
BULB-TITE® blind rivets up to 7.7 mm Ø all materials.
MEGA GRIP® blind rivets up to 6.4 mm Ø all materials.

Technical data

Weight:	2.2 kg with battery
Stroke:	20 mm
Drive:	DC motor
Traction power:	14,000 N

Nosepieces / accessories

Nosepieces: 17/32, 17/36, 17/40 and 17/45

Jaws (3 parts)

Part no. 710 2208

Nosepiece - power per battery charge

Rivet Ø mm	Rivet material	approx. pc/battery charge	Nosepiece	Part no.
4.8 and 5.0	Steel, Alu	**700**	17/32	**725** 2067
4.8 and 5.0	Stainless steel	**560**	17/36	**725** 2083
6.0	Alu	**560**	17/36	**725** 2083
6.0	Steel	**300**	17/40	**725** 2560
6.4	Alu, PG-Alu	**420**	17/45	**724** 3065
6.4	Steel	**250**	17/45	**724** 3065
8	Alu	**350**	17/45	**724** 3065

BULB-TITE® blind rivet

4.0	Alu	**1,000**	17/26 BT*	**725** 2202
5.2	Alu	**900**	17/32 BT*	**725** 2210
6.3	Alu	**590**	17/42 BT*	**725** 2229
6.3	Steel	**310**	17/42 BT*	**725** 2229
6.3	Monel	**380**	17/42 BT*	**725** 2229
7.7	Alu	**470**	17/48 BT*	**725** 2237
			and jaws	**715** 1527

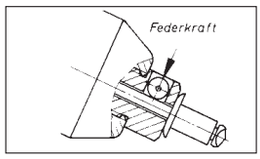
MEGA GRIP® blind rivet

4.8	Alu	**600**	17/31 MG*	**725** 2250
6.4	Alu	**420**	17/41 MG*	**724** 3146
4.8	Steel	**420**	17/31 MG*	**725** 2250
6.4	Steel	**150**	17/41 MG*	**724** 3146
4.8	Stainless steel	**420**	17/31 MG*	**725** 2250
6.4	Stainless steel	**150**	17/41 MG*	**724** 3146

* Available as special accessory
Special design nosepieces are available on request

Special accessory: Retaining nosepiece

- Inserted rivet remains in any position
- Rivets may be set with only one hand
- Safer work



Retaining nosepiece	Part no.	Retaining nosepiece	Part no.
17/40 R	**725** 4125	17/45 R	**725** 4126

Charger 14.4 V Li-Ion

Part no. 725 1134

Technical data

Input voltage:	230 V / 50 Hz
Output voltage:	14.4 V DC
Recharging time:	50 to 100 minutes (battery depending)
Weight:	0.6 g

Battery 14.4 V/1.3 Ah (Li-Ion)

Part no. 725 1045
Available as special accessory
Weight: 0.35 g

Power battery 14.4 V/2.6 Ah (Li-Ion)

Part no. 725 1049
Weight: 0.5 g

Akku
RECYCLING

Charger 12 V NiCd
Part no. 725 1035

One-piece, slim extension unit to approx. 110 mm, Ø 22.5 mm, for setting rivets in deep positions and with difficult access
Part no. 724 2054

One-piece, slim extension unit to approx. 160 mm, Ø 22.5 mm, for setting rivets in deep positions and with difficult access
Part no. 724 2055

Further dimensions available upon request

PowerBird® Solar

Part no. 724 0041

Special design for solar applications
Ideal for deep, difficult to access areas

Working range

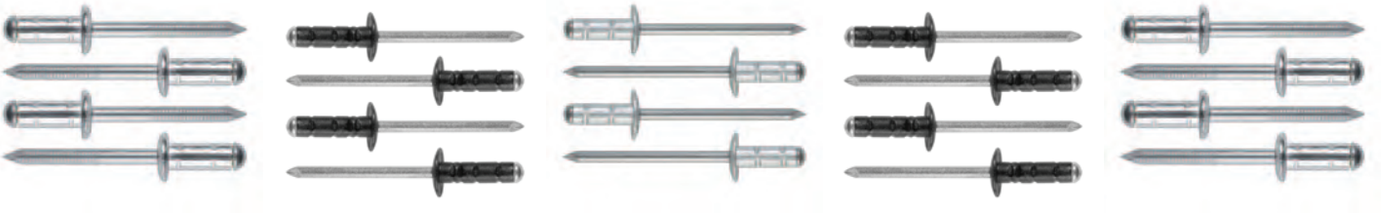
Blind rivets from 4.8 mm Ø steel and up to 6.4 mm all materials, except G-Bulb® Ø 6.4 mm.
BULB-TITE® blind rivets up to 7.7 mm Ø all materials.
MEGA GRIP® blind rivets up to 6.4 mm Ø all materials.

Technical data

Weight:	2.36 kg with battery
Stroke:	20 mm
Drive:	DC motor
Traction power:	14,000 N
Extension unit:	approx. 160 mm

Nosepieces / accessories

approx. overall length160 mm extension
two Li-Ion power batteries 2.6 Ah/14.4 V
Quick charger
Nosepieces 17/32, 17/36, 17/40, 17/45, and 17/48 BT
Plastic carrying c



The GESIPA® SolarGrip® blind rivet program can be found on page 30.

PowerBird® Gold Edition

The exclusive Gold Edition with 18,000 N traction power

Strong - stronger – PowerBird® Gold Edition

PowerBird®, the all-rounder of the Bird family by GESIPA® with its wide range of application possibilities, is now available in an even stronger version: with a setting force of 18.000 N it can even set G-Bulb® and PolyGrip® blind rivets up to a diameter of 6.4 mm of all materials.

Practical - even more practical – PowerBird® Gold Edition

- Fatigue-free working through well balanced weight repartition and ergonomic grip
- Gravity controlled evacuation of spent mandrels: forward through the nosepiece or backwards into the mandrel container
- The immediate and automatic reset after each riveting process saves energy and speeds up the operation
- Exchange nosepieces and wrench always included in the tool eliminate work interruptions
- Compact, shockproof tool housing for all application conditions
- User oriented scope of delivery: plastic carrying case with one battery charger, one battery and four nosepieces (17/32, 17/36, 17/40, 17/45)

Nosepiece - power per battery charge

BULB-TITE®, PolyGrip®, G-Bulb® and standard blind rivet

Blind rivet Ø in mm	Material	approx. pc/battery charge	Nose-piece	Part no.
4.8 and 5.0	Steel, Alu	**700**	17/32	**725** 2067
4.8 and 5.0	Stainless steel, Stinox, PG-steel, PG stainless steel	**560**	17/36	**725** 2083
6.0	Alu	**560**	17/36	**725** 2083
6.0	Steel	**300**	17/40	**725** 2560
6.4	Alu	**420**	17/40	**725** 2560
6.4	Steel, PG-steel, Alu/alu, Stainless steel	**250**	17/45	**724** 3065
8	Alu	**350**	17/45	**724** 3065

G-Bulb® Blind rivet

4.8	Steel/steel	**530**	17/32	**725** 2067
6.4	Steel/steel	**390**	17/45	**724** 3065
4.8	Stainless steel/stainless steel	**470**	17/32	**725** 2067
6.4	Stainless steel/stainless steel	**390**	17/45	**724** 3065

MEGA GRIP® blind rivet

4.8	Alu	**600**	17/31 MG*	**725** 2250
6.4	Alu	**420**	17/41 MG*	**724** 3146
4.8	Steel	**420**	17/31 MG*	**725** 2250
6.4	Steel	**150**	17/41 MG*	**724** 3146
4.8	Stainless steel	**420**	17/31 MG*	**724** 2250
6.4	Stainless steel	**150**	17/41 MG*	**724** 3146

BULB-TITE® blind rivet

4.0	Alu	**1,000**	17/26 BT*	**725** 2202
5.2	Alu	**900**	17/32 BT*	**725** 2210
6.3	Alu	**590**	17/42 BT*	**725** 2229
6.3	Steel	**310**	17/42 BT*	**725** 2229
6.3	Monel/stainless steel	**380**	17/42 BT*	**725** 2229
7.7	Alu	**470**	17/48 BT*	**725** 2237
			and jaws*	**715** 1527

* Available as special accessory. Special design nosepieces are available on request

The all-round talent – PowerBird® Gold Edition

Processes blind rivets from Ø 4.8 mm steel to Ø 6.4 mm all materials, BULB-TITE® blind rivets up to Ø 7.7 mm, all materials, MEGA GRIP® blind rivets up to Ø 6.6 mm alu and steel, G-Bulb® blind rivets up to Ø 6.4 mm all materials, PolyGrip® blind rivet up to Ø 6.4 mm all materials.

PowerBird® Gold Edition – Technical data

Traction power: 18,000
Weight (incl. power battery): 2.2 kg
Drive: DC motor
Working stroke: 20 mm

PowerBird® Gold Edition
with power battery 14.4 Volt / 2.6 Ah and charger, in plastic carrying case,
Part no. 724 0001

PowerBird® Gold Edition with spring loaded trigger system
with power battery 14.4 Volt / 2.6 Ah and charger, in plastic carrying case,
Part no. 724 0002

Jaws (3 parts) for PowerBird® Gold Edition
Part no. 710 2208

Versions with spring

The proven surface contact trigger of the TAURUS series is now also available for AccuBird® and PowerBird®

This feature ensures that the materials of the riveting application will be pressed together before the rivet is installed, thus avoiding gaps in between. Moreover the operator will be certain that the rivet has reached its end position in the application and that the setting head is in contact with the upper side of the material. The spring force can be designed variably with springs depending on the application.

AccuBird® with spring loaded trigger system

AccuBird® with battery 14.4 V / 1.3 Ah and charger **in metal carrying case, with spring loaded trigger system**

Art.-Nr. 725 0015

Nosepieses

17/24, 17/27, 17/29 and 17/32

PowerBird® with spring loaded trigger system

PowerBird® with power battery 14.4 Volt / 2.6 Ah and charger**, in metal carrying case, with spring loaded trigger system**

Part no. 724 0160

Nosepieses

17/32, 17/36, 17/40 and 17/45

PowerBird® Solar with spring loaded trigger system

PowerBird® Solar with power battery 14.4 Volt / 2.6 Ah and charger**, in plastic carrying case, with spring loaded trigger system**

Part no. 724 0026

NEW

Nosepieses

17/32, 17/36, 17/40 and 17/45
approx. overall length 160 mm extension

PowerBird® Gold Edition with spring loaded trigger system

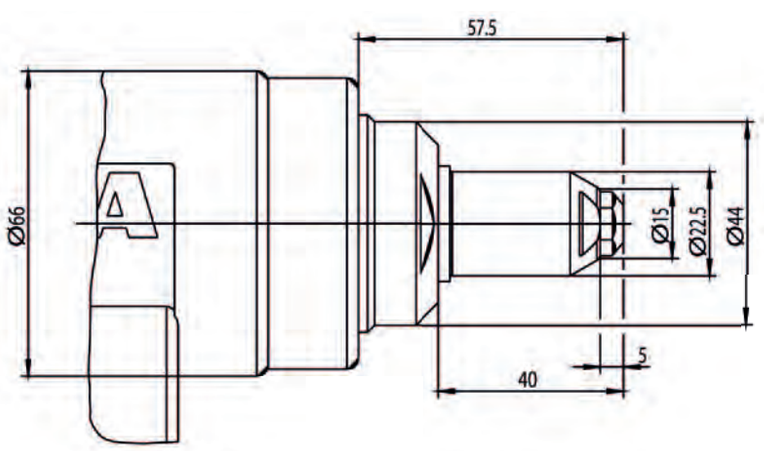
PowerBird® Gold Edition with power battery 14.4 Volt / 2.6 Ahand charger**, in plastic carrying case, with spring loaded trigger system**

Part no. 724 0002

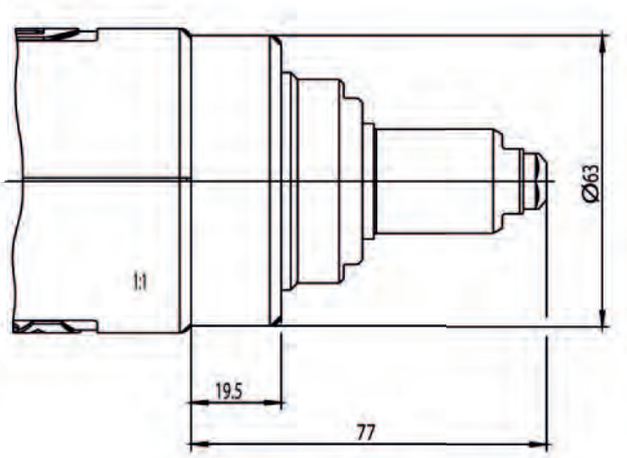
NEW

Nosepieses

17/32, 17/36, 17/40 and 17/45

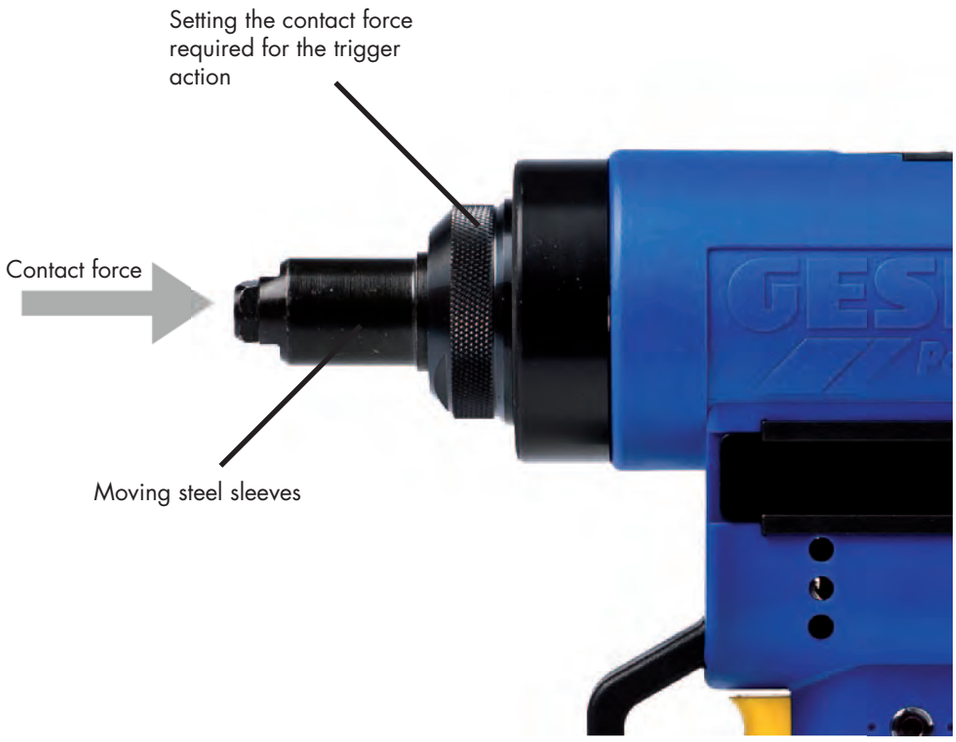


PowerBird® dimension drawing with spring loaded trigger system



loaded trigger system

Ensuring correct processing of the blind rivets by means of a defined contact pressure



Process-secure blind riveting even of parts with gaps or recoiling elements

The function

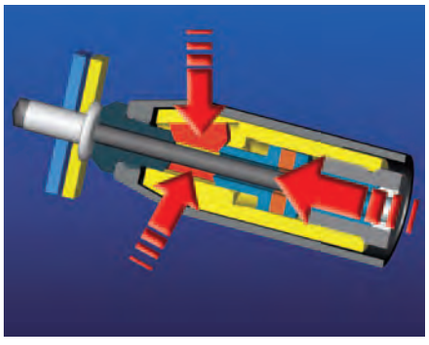
The surface contact trigger mechanism is also installed on the trigger button of the device. It only allows the rivet device to be triggered if a settable compressive force on the part is reached. This ensures that the various components of the application are pressed correctly onto each other before the riveting process. In turn, this means that the uncontrolled deformation of the rivet body between the materials is prevented, which would otherwise go undetected.

The surface contact force may vary in five steps. It is set by either adding or removing springs. This rules out the possibility of unintentionally adjusting the defined surface contact force. Push buttons are arranged in series in front of the standard trigger button. The rivet process can only be triggered by pressing the yellow trigger button when the spring force has been overcome and the defined surface contact force has been reached.

The pressure trigger is only supplied completely mounted. It cannot be retrofitted.

What makes the TAURUS tool series so unique

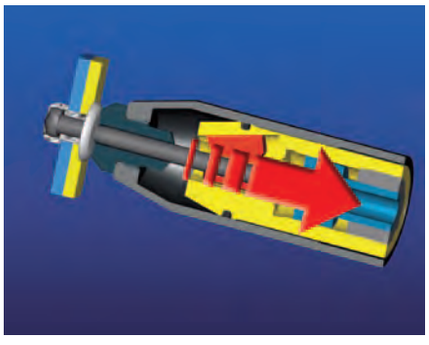
The GESIPA® System – a patented jaw system unique throughout the world



The TAURUS tool series is equipped with a high-performance, patented grip mechanism and jaw system:

- The three jaws move under perfect control in separate channels.
- The jaws are pressed on to the mandrel by the air pressure instead of spring force — with ten times the usual force.
- The jaws claw themselves onto the pins immediately upon actuating the riveting process due to the high pressure, before the pulling movement starts.

The GESIPA® System – the decisive advantages



This system offers the user decisive advantages:

- The complete stroke of the tool is used for setting the rivet, which guarantees a reliable setting process
- Soiling of the jaw profiles due to abrasion of material from the mandrel is significantly reduced because of less friction.w
- Since the jaws do not slip along the mandrel, the wear of the jaw profiles is greatly reduced
- In short, lower costs due to longer service life, low maintenance requirement and low spare parts requirement

The GESIPA® System – optimum utilisation of the compressed air ensures maximum efficiency

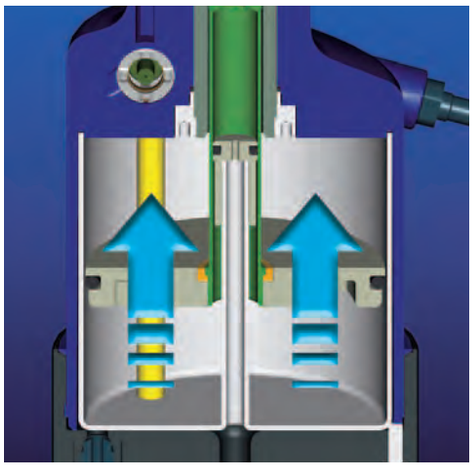
Compressed air is used very frequently in industrial production because of its flexibility, although it has the disadvantage that it incurs relatively high costs, and the consumption places stress on the environment.

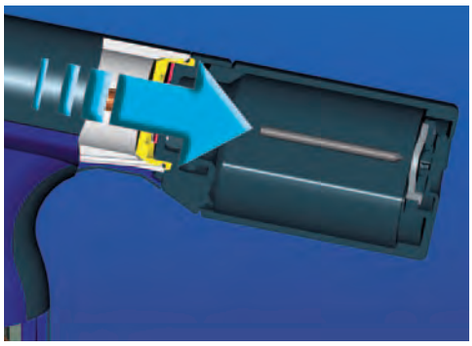
For GESIPA®, more than enough reasons to equip the TAURUS tool series with a compressed air-saving technique unique throughout the world.

The compressed air required for the setting of the blind rivet is used a second time for ejection of the rivet mandrel. The dual use of the compressed air therefore requires no additional air for ejection of the broken mandrels, whereas in other tools, continuous airflow is necessary for the same.

This also allows the TAURUS tool series to operate with extremely low noise emissions.

In two-shift operation and with compressed air costs of approx. € 0.03/m³ this innovative technique can produce savings of up to € 720 per year and per tool. A TAURUS 2 can pay for itself in less than one year.





The TAURUS series — advantages at a glance

The pneumatic-hydraulic blind rivet setting series, ***TAURUS,*** is celebrating its 10th anniversary this year. Since the market introduction of the ***TAURUS 2*** in the year 2002, the ***TAURUS*** series has managed to convince a thousand times over in trade and industry.

The following information particularly apply to the high performance series of devices:

Modular principle for full series

- Compatible same parts — low spare part stocks required and simple maintenance

Power

- High setting forces combined with low weight
- Fast work cycle
- Optimised lift for the entire series

Efficiency

- Little compressed air consumption thanks to dual function: setting the rivets and extracting the spent mandrels
- Extraction unit can also be connected via lockable slide switch

Work comfort / safety

- Rubberised, moulded grip
- Balanced centre of gravity
- Low-vibration and soundproofed
- Little activation force required
- Mandrel collection unit with swivelling air deflector
- Overpressure valve for prevention of overload
- Very little recoil
- Integrated protection feature prevents the ejection of spent mandrels when the collection unit is in working position

Patented handel mechanism

- With forcibly actuated gripper jaws and pneumatic pressing
- Very long service lives
- Safe, non-slip gripping of the rivet mandrel
- Just one model for all dimensions

TAURUS series Pneumatic-

TAURUS 1

Part no. 756 0001

Working range

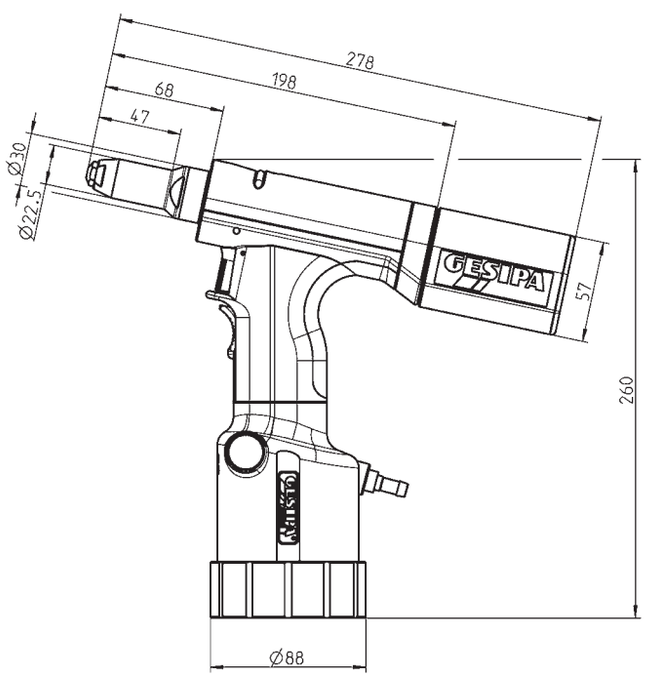
Blind rivets from 2.4 to 3.2 mm Ø all materials and up to 4 mm Ø alu/steel (max. mandrel dia. 2.5 mm)

Technical data

Weight:	1.3 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 1.0 ltr. per rivet
Traction power:	4,200 N at 5 bar
Stroke:	15 mm

Nosepieces / accessories

Nosepieces
17/18, 17/24 and 17/27
Maintenance wrench SW12/14, SW14/17
1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



TAURUS 2

Part no. 757 0007

Working range

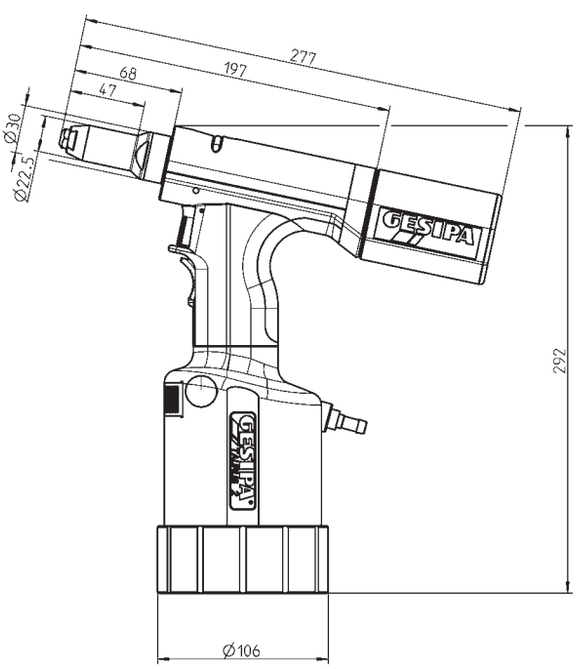
Blind rivets up to 5 mm Ø all materials and up to 6 mm Ø alu/steel (max. mandrel Ø 3.2 mm)

Technical data

Weight:	1.6 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 2.3 ltr. per rivet
Traction power:	9,000 N at 5 bar
Stroke:	18 mm

Nosepieces / accessories

Nosepieces
17/27, 17/29 und 17/32 und 17/36
Maintenance wrench SW12/14, SW14/17
1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



hydraulic blind rivet setting tools

TAURUS 3

Part no. 758 0002

Working range

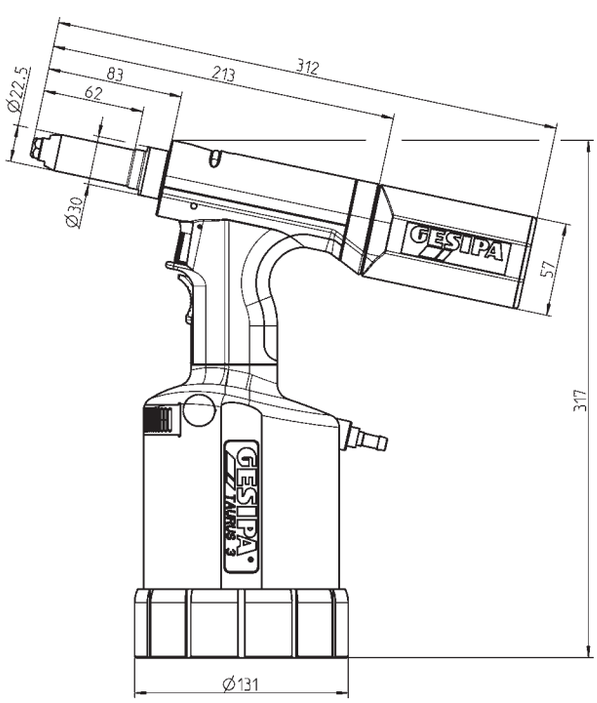
Blind rivets up to 6.4 mm Ø all materials
(max. mandrel Ø 4.5 mm)

Technical data

Weight:	1.9 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 4.8 ltr. per rivet
Traction power:	14,000 N at 5 bar
Stroke:	25 mm

Nosepieces / accessories

Nosepieces
17/36, 17/40 und 17/45
Maintenance wrench SW12/14, SW14/17
1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



TAURUS 4

Part no. 759 0001

Working range

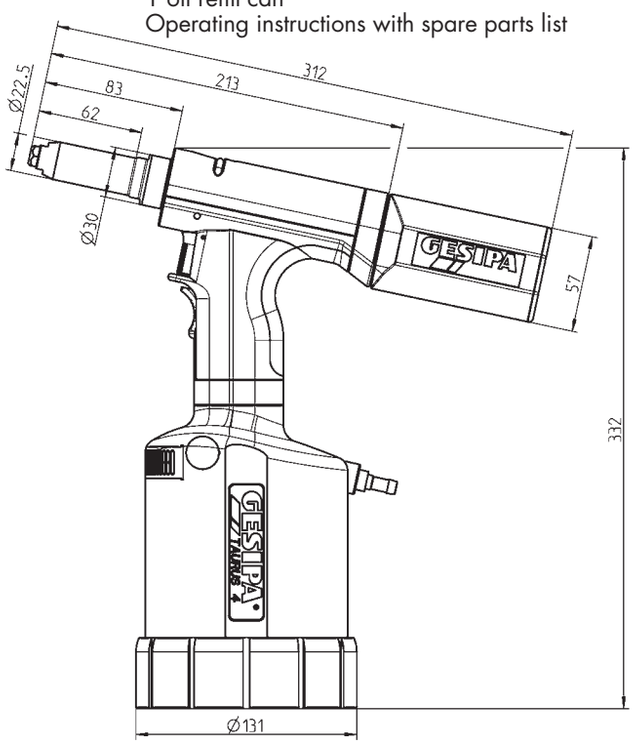
Blind rivets up to 6.4 mm Ø all materials
and up to 8 mm Ø alu (max. mandrel Ø 4.5 mm)

Technical data

Weight:	2.0 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 4.8 ltr. per rivet
Traction power:	20,000 N at 5 bar
Stroke:	19 mm

Nosepieces / accessories

Nosepieces
17/36, 17/40 and 17/45
Maintenance wrench SW12/14, SW14/17
1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



TAURUS series Pneumatic-

TAURUS 5

Basic tool
Part no. 760 0001

Working range

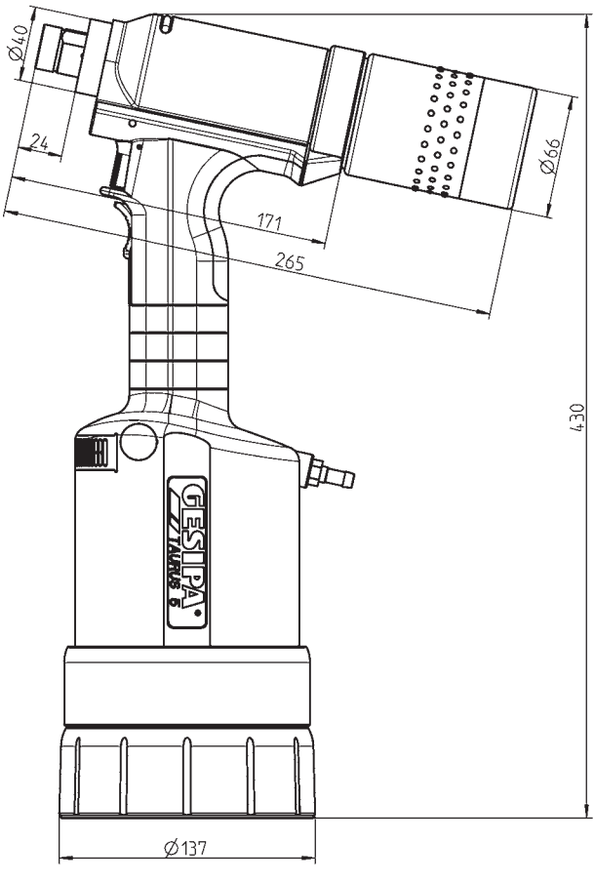
Blind rivets above 6.4 mm Ø all materials and lockbolts up to 10 mm Ø with corresponding pulling heads

Technical data

Weight:	3.4 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 6.9 ltr. per rivet
Traction power:	42,000 N at 7 bar
Stroke:	17 mm

Nosepieces / accessories

1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



TAURUS 6

Basic tool
Part no. 761 0002

Working range

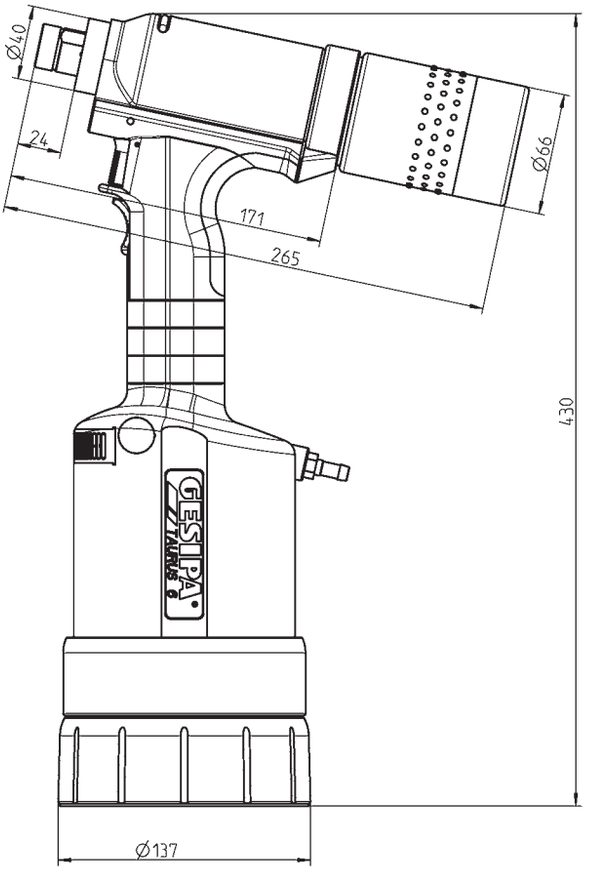
Blind rivets above 6.4 mm Ø all materials and lockbolts up to 10 mm Ø with corresponding pulling heads

Technical data

Weight:	3.4 g
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 6.9 ltr. per rivet
Traction power:	50,000 N at 7 bar
Stroke:	15 mm

Nosepieces / accessories

1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



TAURUS 5 and ***6*** need to be fitted with nosepieces to match the application.
Will be produced on request.

hydraulic blind rivet setting tools

Jaws (3 parts)

For the full ***TAURUS*** series
Part no. 756 1172

Swivel air connector

For the full ***TAURUS*** series
Part no. 756 1023

TAURUS conversion kit

For conversion to the PH 2000 spent mandrel container
(description and full offer on page 74)

for ***TAURUS 1***
Part no. 756 1104
For ***TAURUS 2-4***
Part no. 756 1107

Mandrel extraction tube

For the full ***TAURUS*** series
Part no. 757 1356

Nosepieces

Rivet Ø mm	Rivet material	Nosepiece	Part no.
2.4	Alu	17/18	**725** 2075
3.2	CAP-Alu, CAP-Cu	17/18	**725** 2075
3 and 3.2	Alu, Cu, stainless steel, Stinox, PG-alu, PG-steel, PG stainless steel	17/24	**725** 1583
4	Alu, Cu, CAP-Alu, CAP-Cu	17/24	**725** 1583
4	Steel, Alu, PG-Alu	17/27	**725** 2040
4	Stainless steel, Stinox, PG-steel, PG stainless steel	17/29	**725** 2059
4.8 and 5	Alu, CAP-Alu, CAP-CU, PG-Alu	17/29	**725** 2059
4.8 and 5	Steel, Alu	17/32	**725** 2067
4.8 and 5	Stainless steel, Stinox, PG-steel, PG stainless steel G-BULB®	17/36	**725** 2083
6	Alu	17/36	**725** 2083
6	Steel	17/40	**725** 2560
6.4	Alu	17/40	**725** 2560
6.4	Stainless steel, alu, PG stainless steel, G-BULB®	17/45	**724** 3065
8	Alu	17/45	**724** 3065

BULB-TITE® blind rivets

4	Alu	17/26 BT*	**725** 2202
5.2	Alu	17/32 BT*	**725** 2210
6.3	Alu, steel, monel	17/42 BT*	**725** 2229
7.7	Alu	17/48 BT*	**725** 2237

MEGA GRIP® **blind rivet**

4.8	Alu, steel, stainless steel	17/31 MG*	**725** 2250
6.4	Alu, steel, stainless steel	17/41 MG*	**724** 3146

* Extended nosepieces and other special designs available on request

Head modules for TAURUS 5 and 6

Adaptation takes priority

The ***TAURUS 5*** and ***6*** riveting tools must be adapted to the different kinds of rivets and lockbolts through specific pulling head modules.

Head module for 7.8mm Titgemeyer TIBULB*
Part no. 760 0201

Head module for 9.8mm Huck Magna-Lok®*
Part no. 760 0202

NEW Head module for lockbolt 6 (3/16“) Huck C6L®*
Part no. 760 1070

NEW Head module for lockbolt 8 (1/4“) Huck C6L®*
Part no. 760 1071

NEW Head module for lockbolt 8 (3/16“) Huck Magna-Grip®*
Part no. 760 1072

NEW Head module for lockbolt 8 (1/4“) Huck C6L®* Huck Magna-Grip®*
Part no. 760 1073

Other head modules on request

* Some registered trademarks of the companies TITGEMEYER GmbH & Co. KG and Alcoa Fastening Systems

TAURUS versions

TAURUS with counter device

The tool is equipped with a sensor which detects the evacuation of the spent mandrel after the setting process is complete. The sensor is installed just in front of the mandrel container and connected either to a local control and display unit GRivCount or to a centralized monitoring system via the line amplifier GRivAmp.

GRiv-Count

GRiv-Amp

TAURUS 1-4 (with counter device)

TAURUS tools for stationary use in production systems

The TAURUS tools can be integrated as stationary units in automatic production systems, and operated by remote control if required.
The presence of the blind rivet in the nosepiece can optionally be detected with the aid of a low-pressure connection.
The spent mandrel can be disposed of by means of an evacuation tube if required, and also monitored by a sensor.
In such stationary production systems, several tools can be operated automatically and simultaneously, enabling a high level of efficiency.

TAURUS with setting process monitoring

The setting process monitoring is achieved by a direct on-line analysis of traction force and traction course recorded during the setting of the rivet. All system components necessary for operation are included in the tool itself. The setting analysis takes less than 1 microsecond and its result is directly displayed by a green or red LED installed in the tool base and, optionally, by a warning tone. Moreover, a collective analysis of the complete work piece is also included. The tool stores more than 260.000 individual setting processes, which can be recalled at any time. The system also identifies failure patterns and memorizes those for failure analysis and troubleshooting. The tools can be operated as stand-alone or as part of integrated production systems using the GESIPA® interface.

TAURUS 1-4 (with setting process monitoring)

GESIPA®-Interface

TAURUS versions

C-frame for TAURUS 1 to 6

After replacing the blind rivet setting head with the C-frame adapter, all the tools of the ***TAURUS*** series are capable of setting tubular, semi-tubular and solid rivets.

Every tool of the ***TAURUS*** series can be equipped with a C-frame adapter for the setting of tubular, semi-tubular and solid rivets and the production or repair of semi-tubular and solid rivet joints. Further application options include clinching, hole punching and caulking.
The C-frame adapter can be changed quickly and easily for the original blind rivet head of the ***TAURUS*** series or for another C-frame adapter.

The C-frame adapters have a 360° swivel capability, efficient working sequence and an accurately adjustable setting stroke.

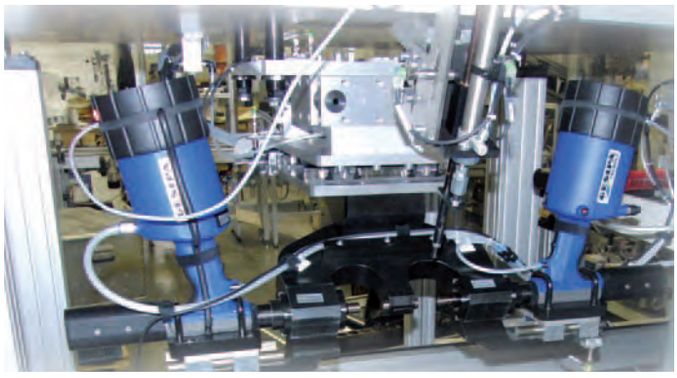
Technical data

Drive force:	5,000 to 50,000 N
Stroke:	15 mm to 25 mm
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")

Weight: approx. 1.9 to 3.9 kg (without C-frame)

Advantages

- Flexible use
- Simple and safe pneumatic force control
- Faster, simpler and reversible exchange of the original blind rivet head for a frame unit in any standard ***TAURUS*** series tool
- Pneumatic extraction of the punched piece
- Simple tool change



Double-C-frame in use

The design, order and delivery of the ***TAURUS-***C-frame and the corresponding connector takes place through the GESIPA® subsidiary W+O Niettechnik GmbH. Speak to our technical sales.

All of the above TAURUS variants are special productions, which are configured or manufactured according to the application case. For advice further questions and price information, please contact our Technical Sales team.

TAURUS with spring loaded trigger system

This feature ensures that the materials of the riveting application will be pressed together before the rivet is installed, thus avoiding gaps in between. Moreover the operator will be certain that the rivet has reached its end position in the application and that the setting head is in contact with the upper side of the material before the riveting process is started. The spring force can be designed variably with springs depending on the application.

TAURUS 1 (with spring loaded trigger system)
Part no. 756 0021

TAURUS 2
(with spring loaded trigger system)
Part no. 757 0016

TAURUS 3 (with spring loaded trigger system)
Part no. 758 0005

TAURUS 4
(with spring loaded trigger system)
Part no. 759 0002

TAURUS versions

TAURUS with PH 2000 spent mandrel container

The fixed mounted, large PH 2000 mandrel container is very sturdy and particularly suited to long mandrels from 50 to 70 mm in length. The container fits all ***TAURUS versions*** 1 to 4.

TAURUS 1 (with PH 2000 mandrel container)
Part no. 756 0005

TAURUS 3 (with PH 2000 mandrel container)
Part no. 758 0011

TAURUS 2 (with PH 2000 mandrel container)
Part no. 757 0018

TAURUS 4 (with PH 2000 mandrel container)
Part no. 759 0007

You will find the corresponding conversion kits on page 71

Angle head 90° for TAURUS 1-4

NEW

Description

Using the angular head 90° for the Taurus 1-4 means that, depending on the device type, standard blind rivets up to a diameter of 6.4 mm can be set in all materials. The smallest edge clearance is 15 mm, the head length is 110 mm. The angular head can be freely positioned anywhere (360°) along the Taurus tensile axis.

Application

The angular head is designed for use in tight spaces. Its sturdy design allows it to apply large setting forces when fitting blind rivets even in difficult to access work areas.

Advantages

- Realisation of small edge clearances (15 mm)
- High setting force with low installation area (up to 20 kN)
- Large stroke (up to 23 mm)
- Simple assembly
- Compact and robust design
- Simple jaws maintenance
- Use of standard jaws
- Low vibration, even at high breaking force level

Part no. 758 0101

Small jaw assembly for TAURUS 1 and 2

for *TAURUS 1*
Part no. 756 1120

for *TAURUS 2*
Part no. 757 1077

Area of use

- Processing alu/steel blind rivets up to Ø 5mm and steel/steel up to Ø 4mm with ***TAURUS 1*** and ***2***
- Particularly suitable for hard to access rivet points

Technical data

Length :	100 mm
Head Ø:	18 mm

TAUREX 1 to 6

The complete TAURUS series with remote mounted pressure transducer, for versatility in critical applications

Areas of use

- All blind rivets and lockbolts up to a mandrel breaking force of 50 kN.
- Same performance and technical characteristics as the respective individual units in the ***TAURUS*** series 1-4, 5-6 with different stroke
- 3 metre hose length between pressure transducer and setting pistol

Common technical data

Operating air pressure:	5-7 bar
Air hose connection:	6 mm (1/4")
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

Advantages at a glance

- Low weight of the handheld tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side: No oil leak and no air bleeding
- Ideally suited for setting of blind rivets and lockbolts in poorly accessible locations
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Can be combined with almost all supplements and options of the TAURUS series: head extensions, mandrel containers, rivet counting units, process control, pressure trigger and remote control

TAUREX 1
Part no. 764 0001
TAUREX 2
Part no. 765 0001

TAUREX 3
Part no. 766 0001
TAUREX 4
Part no. 767 0001

TAUREX 5
Part no. 768 0001
TAUREX 6
Part no. 769 0001

TAUREX 5 multiple riveting head

Description

The multiple riveting head is designed to set several standard blind rivets with a body diameter of 6.4 mm simultaneously in all materials with low axial spacing. The axial spacing of the head module is adjusted for the relevant application. The axial spacing can be set from 20 mm to 35 mm.

Application

The multiple riveting head is intended for use in riveting stations with multiple riveting and for semi-automatic operation. The flexible hose connection from the air cylinder to the riveting head enables space-saving installation in a riveting station.

Advantages

- Realisation of small rivet spacings
- High setting force with low installation area
- Easy installation in riveting stations or riveting machines
- Compact and robust design
- Jaw system driven by pneumatic air pressure
- Use of standard TAURUS jaws
- Switchable air intake
- Low vibration, even at high breaking force level
- Overpressure valve for prevention of overload

Delivery time on request

TAURUS Axial eco

The TAURUS-series 1-4 in axial version – the cost-efficient introductory version for special applications

Available from end of 2012

Applications

The special pistols of ***TAURUS Axial eco*** offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility and even ones that required riveting from above.

In order to ensure that the components to be riveted can align with a gap and the setting head can make contact, the ***TAURUS Axial eco*** can be additionally supplied with a spring loaded trigger system.

Area of use

- Processing blind rivets from 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the ***TAURUS*** series

Technical data

Operating air pressure:	5-7 bar
Air hose connection:	6 mm (1/4'')
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

TAURUS Axial eco — advantages at a glance

- Cost-efficient introductory version
- Perfectly designed for fixed installations on production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- This can be equipped with almost all ***TAURUS*** series options:
  e.g. extension units, blind rivet counter, set processing monitoring, spring loaded trigger system and remote control
- Can be suspended on a balancer
- Integrated mandrel evacuation for disposal of the spent mandrel

TAURUS 1 Axial eco	**Part no. 756 0017**
TAURUS 2 Axial eco	**Part no. 757 0042**
TAURUS 3 Axial eco	**Part no. 758 0033**
TAURUS 4 Axial eco	**Part no. 759 0022**
TAURUS 1 Axial eco with spring loaded trigger system	**Part no. 756 0018**
TAURUS 2 Axial eco with spring loaded trigger system	**Part no. 757 0043**
TAURUS 3 Axial eco with spring loaded trigger system	**Part no. 758 0034**
TAURUS 4 Axial eco with spring loaded trigger system	**Part no. 759 0023**

TAURUS Axial

The TAURUS-series 1-4 in axial version – for special applications

Available from end of 2012

Applications

The special pistols of ***TAURUS Axial*** offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility and even ones that required riveting from above.

In order to ensure that the components to be riveted can align without a gap and the setting head can make contact, the ***TAURUS Axial*** can be additionally supplied with a spring loaded trigger system.

Area of use

- Processing blind rivets from 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the ***TAURUS*** series 1-4

Technical data

Operating air pressure:	5-7 bar
Air hose connection:	6 mm (1/4")
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

TAURUS Axial — advantages at a glance

- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- This can be equipped with almost all ***TAURUS*** series options:
  e.g. extension units, blind rivet counter, set processing monitoring, spring loaded trigger system and remote control
- The handle in the rivet axis allows ergonomic work - especially in vertical applications.
- Affordable alternative to ***TAUREX Axial*** or ***TAUREX Axial compact***
- Can be suspended on a balancer

TAURUS 1 Axial	**Part no. 756 0023**
TAURUS 2 Axial	**Part no. 757 0039**
TAURUS 3 Axial	**Part no. 758 0028**
TAURUS 2 Axial	**Part no. 757 0040**

TAURUS 1 Axial with spring loaded trigger system	**Part no. 756 0024**
TAURUS 2 Axial with spring loaded trigger system	**Part no. 757 0040**
TAURUS 3 Axial with spring loaded trigger system	**Part no. 758 0029**
TAURUS 4 Axial with spring loaded trigger system	**Part no. 759 0019**

TAUREX Axial compact

NEW

The TAURUS series 1-4 with an axial pressure intensifier mounted directly to the device – for use in tight working spaces

Applications

The ***TAUREX Axial compact*** is a particular advantage in enclosed spaces due to the pressure transducer mounted in the working direction.

The special pistols of ***TAUREX Axial compact*** offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility and even ones that required riveting from above.

In order to ensure that the components to be riveted can align without a gap and the setting head can make contact, the TAUREX ***Axial compact*** can be additionally supplied with a spring loaded trigger system.

Available from end of 2012

Area of use

- Processing blind rivets from 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the ***TAURUS*** series 1-4

Technical data

Operating air pressure:	5-7 bar
Air hose connection:	6 mm (1/4'')
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

TAUREX Axial compact — advantages at a glance

- Pressure intensifier attached in a space-saving manner directly to the device, i.e. also in applications in tight spaces
- The technical layout corresponds with the ***TAUREX Axial***
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- This can be equipped with almost all ***TAURUS*** series options:
  e.g. extension units, blind rivet counter, set processing monitoring, spring loaded trigger system and remote control
- The handle in the rivet axis allows ergonomic work - especially in vertical applications.
- Can be suspended on a balancer

TAUREX 1 Axial compact	**Part no. 764 0004**
TAUREX 2 Axial compact	**Part no. 765 0005**
TAUREX 3 Axial compact	**Part no. 766 0011**
TAUREX 4 Axial compact	**Part no. 767 0006**
TAUREX 1 Axial compact with spring loaded trigger system	**Part no. 764 0005**
TAUREX 2 Axial compact with spring loaded trigger system	**Part no. 765 0006**
TAUREX 3 Axial compact with spring loaded trigger system	**Part no. 766 0012**
TAUREX 4 Axial compact with spring loaded trigger system	**Part no. 767 0007**

TAUREX Axial

NEW

The TAUREX series 1-4 with remote mounted pressure transducer in axial version, making it move flexible, versatile and erconomic

Applications

The TAUREX Axial is a particular advantage in enclosed spaces due to the separate pressure transducer mounted in the working direction.

The special pistols of ***TAUREX Axial*** offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility and even ones that require riveting from above.

In order to ensure that the components to be riveted can align without a gap and the setting head can make contact, the ***TAUREX Axial*** can be additionally supplied with a spring loaded trigger system.

Area of use

- Processing blind rivets from 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the ***TAURUS*** series 1-4
- 3 metre hose length between pressure transducer and setting pistol

Technical data

Operating air pressure:	5-7 bar
Air hose connection:	6 mm (1/4")
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

Available from end of 2012

TAUREX Axial — advantages at a glance

- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Low weight of the hand held tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side: No oil leak and no air bleeding
- This can be equipped with almost all ***TAURUS*** series options:
  e.g. extension units, blind rivet counter, set processing monitoring, spring loaded trigger system and remote control
- The handle in the rivet axle allows ergonomic work - especially in vertical applications.
- Can be suspended on a balancer

TAUREX 1 Axial	**Part no. 764 0002**
TAUREX 2 Axial	**Part no. 765 0003**
TAUREX 3 Axial	**Part no. 766 0009**
TAUREX 4 Axial	**Part no. 767 0003**
TAUREX 1 Axial with spring loaded trigger system	**Part no. 764 0003**
TAUREX 2 Axial with spring loaded trigger system	**Part no. 765 0004**
TAUREX 3 Axial with spring loaded trigger system	**Part no. 766 0010**
TAUREX 4 Axial with spring loaded trigger system	**Part no. 767 0004**

Hydro-pneumatic blind rivet setting tool

PH 1

Part no. 716 0011

Working range

Blind rivets up to 4 mm Ø all materials. Not suitable for setting stainless steel CAP blind rivets.

Technical data

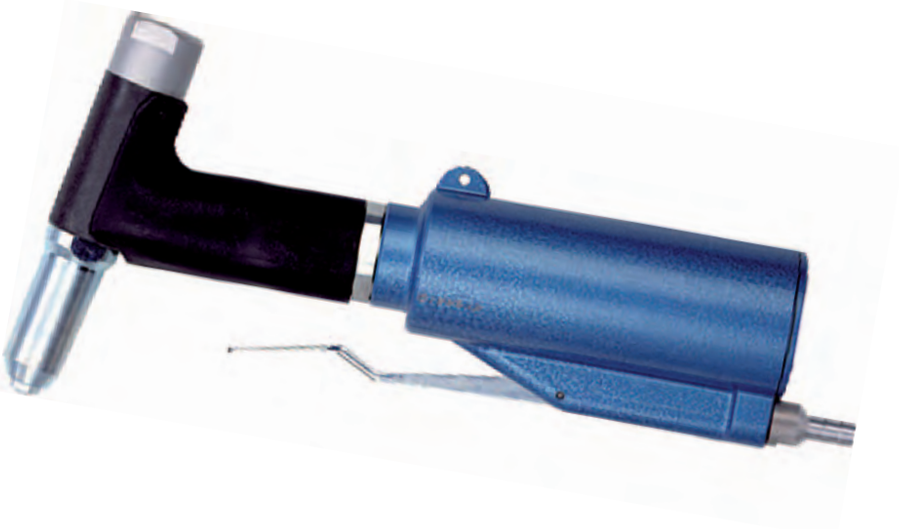
Weight:	1.2 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	0.8-1.2 ltr. per rivet (0.2 ltr. compr. air)
Traction power:	5,200 N at 5 bar
Stroke:	15 mm

Nosepieces / accessories

Nosepieces:
16/18, 16/24, 16/27 and 16/29
1 set of jaws, 1 spent mandrel bottle
1 maintenance wrench each of MSU and MSZ
Maintenance instructions with spare parts list

Jaws (2 parts) for PH 1

Part no. 705 2057



Features

- Hydraulic head in aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- The piston made of hardened and hard chromium plated steel make the device easy to handle and wear-proof
- Compact seals are wear-proof for a long service life
- Fast venting valve for fast return and high working sequence
- Low-noise pneumatic switching
- Simple, low-interruption valve design
- Hydraulic head can be adjusted by 360°
- Favourable centre of gravity and handle design for fatigue-free handling

Nosepieces for PH tools

Rivet Ø	Rivet material	PH 1	PH 2	PH 2-VK	PH-Axial	PH 2000	PH 2000-BT
2.4	Alu	16/18	10/18*	10/18	10/18*	10/18*	–
3.2	CAP-Alu, CAP-Cu	16/18	10/18*	10/18	10/18*	10/18*	–
3 and 3.2	Alu, Cu, steel, stainless steel, Stinox, Alu, PG-alu, PG-steel	16/24	10/24*	10/24	10/24*	10/24*	–
4	Alu, Cu, CAP-Alu, CAP-Cu	16/24	16/24	10/24	16/24	16/24	–
4	PG-Alu, Steel, Alu	16/27	16/27	10/27	16/27	16/27	–
4	Stainless steel, Stinox, PG-steel	16/29	16/29	–	16/29	16/29	–
5 and 4.8	Alu, CAP-Alu, CAP-Cu, PG-Alu	–	16/29	–	16/29	16/29	–
5 and 4.8	Steel, Alu	–	16/32	–	16/32	16/32	–
5 and 4.8	Stainless steel, Stinox, PG-steel	–	16/36	–	–	16/36	–
6	Alu	–	–	–	–	16/36	–
6	Steel	–	–	–	–	16/40	–
6.4	Alu, PG-Alu	–	–	–	–	16/40	–
6.4	Steel, Alu	–	–	–	–	16/45	–
4	Plastic	–	–	–	–	16/30K	–
5	Plastic	–	–	–	–	16/35K	–
6	Plastic	–	–	–	–	16/40K	–
4.8	all **MEGA GRIP**®	–	–	–	–	16/31MG	–
6.4	all **MEGA GRIP**®	–	–	–	–	16/41MG**	–
4	all **BULB-TITE**®	–	–	–	–	–	16/26BT
5.2	all **BULB-TITE**®	–	–	–	–	–	16/32BT
6.3	all **BULB-TITE**®	–	–	–	–	–	16/42BT
7.7	all **BULB-TITE**®	–	–	–	–	–	16/48BT

* Small jaw assembly required (see page 85)

** Conversion kit necessary (**715** 9714)

Hydro-pneumatic blind rivet setting tool

PH 2

Part no. 717 0017

Working range

Processes blind rivets from 3 to 5 mm Ø all materials and blind rivets with 2.4 mm Ø with small jaws (page 72)
Not suitable for stainless steel CAP blind rivets

Technical data

Weight:	1.3 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	7,375 N at 5 bar
Stroke:	15 mm

Nosepieces / accessories

Nosepieces:
16/24, 16/27, 16/29, 16/32 and 16/36
1 set of jaws, 1 spent mandrel bottle
1 maintenance wrench each of MSU and MSZ
Maintenance instructions with spare parts list

Jaws (3 parts) for PH 2 and PH 2000

Part no. 710 2151

Features

- Hydraulic head made of aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Pistons: Steel hardened and chrome-plated — smooth operation and wear-proof
- Compact seals are wear-proof for a long service life
- Fast venting valve for fast return and high working sequence
- Low-noise pneumatic switching
- Simple, low-interruption valve design
- Hydraulic head can be adjusted by 360°
- Favourable centre of gravity and handle design for fatigue-free handling

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PH1 and PH2 with VAS
(vacuum absorption system)

(See page 85 for description)

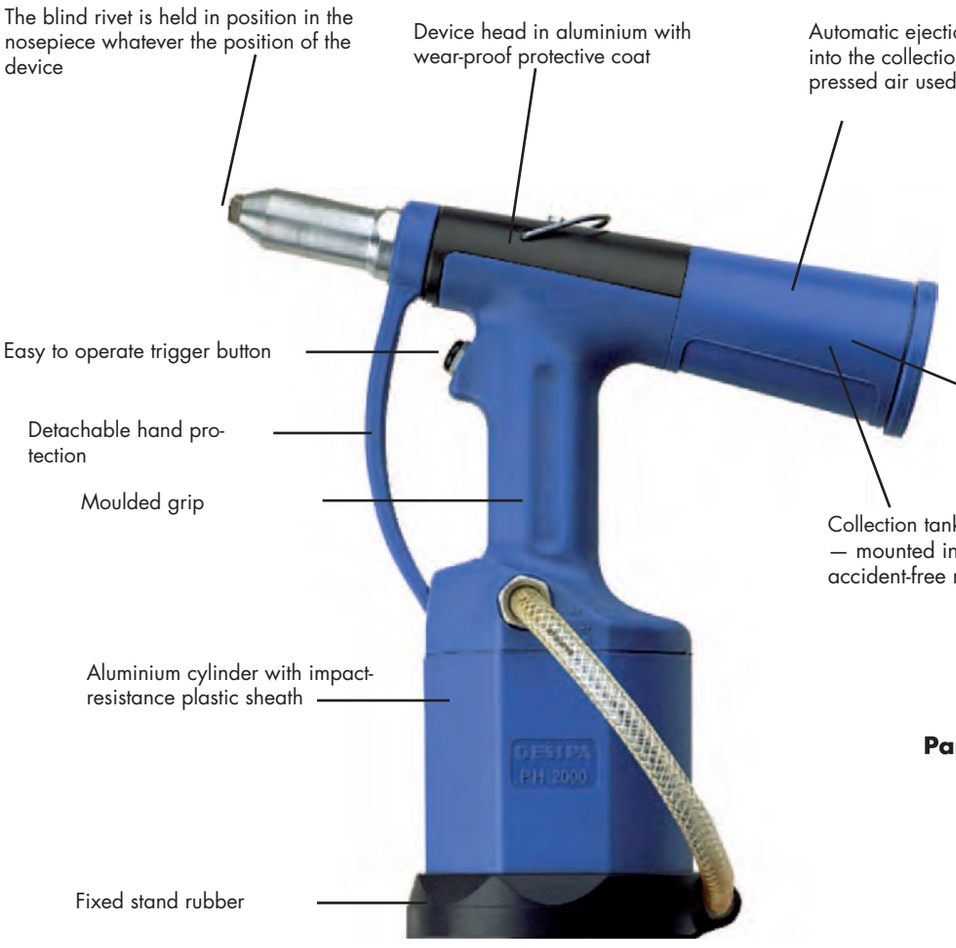
PH 1 assembled with VAS
Part no. 716 0070

PH 2 assembled with VAS
Part no. 717 0033

This device (VAS) absorbs the spent mandrel after the riveting operation and transports it automatically into the mandrel container. A further advantage is offered when the rivet, inserted into the nosepiece, is held in the jaw mechanism even if the tool head is in the vertical position. The vacuum absorption device is available as a complete built-in set and can also be retrofitted to existing GESIPA® riveting power tools at any time.

Hydro-pneumatic blind rivet setting tool

PH 2000



Part no. 715 0016

Working range

Blind rivets from 3 to 6.4 mm Ø all materials and blind rivets with 2.4mmØ with small jaw assembly (page 85)

Technical data

Weight:	1.9 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	2.8-3.6 ltr. per rivet (0.6 ltr. compr. air)
Traction power:	10,000 N at 5 bar
Stroke:	22 mm

Nosepieces / accessories

Nosepieces:
16/24, 16/27, 16/29, 16/32, 16/36, 16/40 and 16/45
1 set of jaws, 1 air deflector (No. 896)
1 wrench MSU
1 ball headed screw driver SW 2.5
1 oil refill can with hydraulic oil
Maintenance instructions with spare parts list

Features

- The patented residual blind rivet mandrel disposal system with the extraction option is an intergal part of the device. No retrofitting required.
- The compressed air used for the setting process is then used to automatically eject the threaded mandrel, an efficient solution.
- High setting force with low weight
- Universal use, easy handling
- Large device lift (22 mm) — guarantees setting without re-engagement and increases the oil refilling intervals
- Pneumatic piston return — high working sequence
- Hydraulic head: Aluminium with wear-proof cylinder surface
- Pneumatic cylinder: Aluminium with impact-resistant plastic sheath
- Trigger valve: Direct pneumatic triggering — fast and functionally reliable

Hydro-pneumatic blind rivet setting tool

PH 2000-BT

Working range

Blind rivets up to 7.7 mm Ø all materials

Technical data

Weight:	1.9 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	2.8-3.6 ltr. per rivet (0.6 ltr. compr. air)
Traction power:	10,000 N at 5 bar
Stroke:	22 mm

Nosepieces / accessories

Nosepieces: 16/26 BT, 16/32 BT, 16/42 BT and 16/48 BT
1 nozzle tube no. 8080 a (built-in)
1 nozzle tube 8080 b (as accessory)
1 wrench MSU
1 ball headed screw driver SW 2.5
1 oil refill can with hydraulic oil
1 air deflector (part no. 896)
Maintenance instructions with spare parts list

Jaws (3 parts) for PH 2000-VK PH and 2000-BT

Part no. 715 1527

Part no. 715 0040

(only for BULB-TITE®)

Universal nosepiece

The universal nosepiece replaces five nosepiece sizes.

The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece.

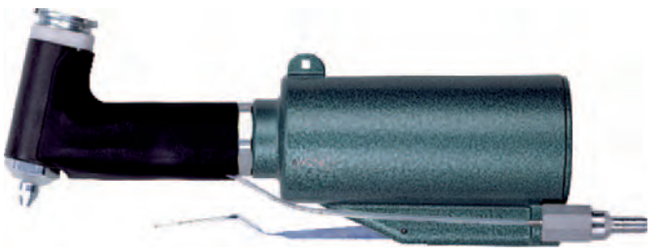
More information on the universal nosepiece can be found on page 85

Article numbers for nosepieces

Article	Part no.	Article	Part no.	Article	Part no.	Article	Part no.	Article	Part no.
10/18	**705** 1182	16/18	**717** 1196	16/30K	**714** 1300	16/31MG	**717** 9669	16/26BT	**717** 1471
10/24	**705** 1247	16/24	**717** 1234	16/35K	**714** 1351	16/41MG	**717** 9677	16/32BT	**717** 1498
		16/27	**717** 1277	16/40K	**714** 1408			16/42BT	**717** 1501
		16/29	**717** 1293					16/48BT	**717** 1528
		16/32	**717** 1323						
		16/36	**717** 1366						
		16/40	**717** 1390						
		16/45	**717** 1455						
€ per pc	**2.90**		**3.10**		**6.35**		**24.50**		**19.90**

Hydro-pneumatic blind rivet setting tools

PH 2-VK



Part no. 717 0068

Working range

Blind rivets up to 4 mm Ø alu, steel and copper

Technical data

Weight:	1.3 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	5,200 N at 5 bar
Stroke:	14 mm

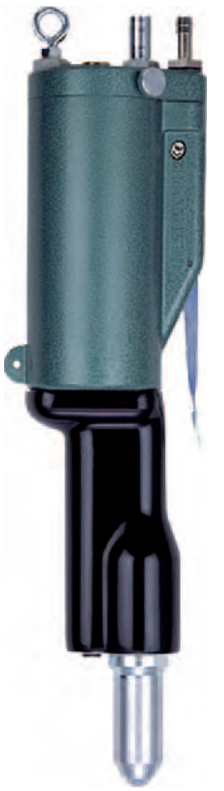
Nosepieces / accessories

Nosepieces: 10/18, 10/24 and 10/27
1 spent mandrel bottle
1 maintenance wrench each of MSU and MSZ Maintenance instructions and spare parts list

VK: Shorter version of the pistol head for difficult to access rivets

Jaws (2 parts) for PH 2-VK

Part no. 705 2057



PH Axial

Part no. 770 0008

Working range

Blind rivets from 4 to mm Ø steel and 2.4 to 3.2 mmØ with small jaw assembly (page 85)

Technical data

Weight:	1.8 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	7,375 N at 5 bar
Stroke:	15 mm

Nosepieces / accessories

Nosepieces:
16/24, 16/27, 16/29 and 16/32
Jaw pusher with reducing tube no. 125 for 4 mm Ø blind rivets in alu and copper
Ejection tube with socket for spent mandrels
Maintenance instructions and spare parts list

Jaws (3 parts) for PH Axial

Part no. 710 2151

Features

- Pneumatic cylinder and hydraulic head with jaw mechanism arranged axially behind each other: simple and easy handling when used vertically (e.g. desktop assembly points)
- Integrated blind rivet suction and rivet mandrel ejection system: does not need to be retrofitted, secure disposal of the spent mandrels in a central tank via a hose
- Hydraulic head in aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Working piston made of hardened and hard chromium plated steel macke the device easy to handle and wear-proof
- Compact seals are wear-proof with large scraper effect, long service life
- Fast venting system: faster return; high work sequence
- Low-noise pneumatic switching
- Simple valve structure: interruption free

Special accessories for blind rivet setting tools

VAS

Vacuum absorption system for PH1 and PH2

Part no. 728 0017

This device absorbs the spent mandrel after the riveting operation and transports it automatically into the mandrel container. A further advantage is offered when the rivet, inserted into the nosepiece, is held in the jaw mechanism even if the tool head is in the vertical position. The vacuum absorption device is available as a complete built-in and can also be retrofitted to existing GESIPA® riveting power tools at any time.

Technical data

Weight of kit:	430 g
Operating air pressure:	4-6 bar

Equipment / accessories

1 air deflector (part no. 896)
1 wrench MSU
Maintenance instructions with spare parts list

Small jaw assembly for PH 1, PH2, PH 2000 and PH-Axial

With reduced head diameter (20 mm) and 2 part jaws

Working range

up to 4 mm Ø stainless steel and 5 mm Ø alu

Part number 198 (PH 1 and PH 2)
Part no. 717 1986

Part number 898 (PH 2000)
Part no. 715 8971

Part number 298 (PH Axial)
Part no. 770 2981

Equipment / accessories

Standard: nosepiece 10/24
(also with optional nosepiece 10/18 10/27, 10/29, 10/32)

Universal nosepiece for blind rivet tools HN 2, PH 1, PH2, PH2000 and AccuBird®

The universal nosepiece replaces five nosepiece sizes.

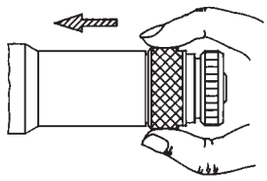
The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece.

Working range

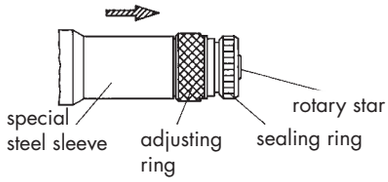
Blind rivets from 2.4 to 5 mm Ø alu, steel and copper and 4 mm Ø stainless steel

Operation

Operate the tool and hold the trigger, then push back adjusting ring to end position.



By turning the rotary star select required nosepiece and release the trigger which automatically locks the rotary star.



The universal nosepiece comprises: Special steel sleeve, complete adjusting ring, rotary star and sealing ring.

For HN 2, PH 1, PH 2, PH 2-KA and PH 2000
Universal nosepiece – 16
Part no. 717 1188

For AccuBird®
Universal nosepiece – 17
Part no. 725 1637

Extension unit

For setting rivets in deep positions and with difficult access

for **PH 1 and PH 2**
Part no. 717 1641 (100mm)
Total length: approx. 160 mm

for **PH 2000**
Part no. 715 9994 (100mm)
Total length: approx. 160 mm

for **AccuBird®**
Part no. 725 2293 (100mm)
Total length: approx. 160 mm

for **PowerBird®**
Part no. 724 3278 (100mm)
Total length: approx. 160 mm

For **PowerBird® with spring loaded trigger system**
Part no. 724 2194 (50mm)
Part no. 724 3023 (100mm)
Total lengths: approx. 110 mm or 160 mm

For **TAURUS 1**
Part no. 756 2013 (50mm)
Part no. 756 2015 (100mm)
Total lengths: approx. 100 mm or 150 mm

For **TAURUS 2**
Part no. 757 1016 (50mm)
Part no. 757 1019 (100mm)
Part no. 757 1072 (200mm)
Total lengths: approx. 100 mm, 150 mm or 200 mm

For **TAURUS 3** and **4**
Part no. 758 1021 (50mm)
Part no. 758 1023 (100mm)
Part no. 758 1035 (150mm)
Total lengths: approx. 100 mm, 150 mm or 200 mm

Further dimensions available upon request

Angle head for PH1 and PH2

For setting rivets in places with difficult access and in corners

Angle head for PH1 with 2 part jaws
Part no. 704 0016

Angle head for PH2 with 3 part jaws
Part no. 704 0024

GAV 8000 eco
GAV 8000 electronic
GAV HF

GESIPA®-Blind rivet machines: fully-automatic – practical – reliable

Comparison of GAV 8000 eco, electronic and GAV HF

	GAV 8000 eco and GAV 8000 electronic	GAV HF
Supply unit		
Weight	100 kg	270 kg
Spent mandrel container volume	approx. 1,800 to 5,500 pcs (3.5 l) depending on size	approx. 1,800 to 5,500 pcs (3.5 l) depending on size
Electrics		
Nominal voltage	230 Volt ~ 50 Hz	230 Volt ~ 50 Hz
Nominal current	< 2.5 A	< 8 A
Protection class	IP 54	IP 54
Pneumatics		
Supply pressure	< 10 bar	< 10 bar
Operating pressure	6 - 7 bar	5.2 bar
Air consumption/riveting	15 NL	30 NL
Air consumption/spent mandrel extraction	340 NL / min.	340 NL / min.
Connection line	½" (12.5 mm) max. length 5 m	3/4" (18.75 mm) max. length 5 m
Rest mandrel extraction tube	Outer Ø 8 mm/ Inner Ø 5 mm	Outer Ø 10 mm/ Inner Ø 6 mm
Pressure transducer	hydro-pneumatic	hydro-pneumatic
Rivet pistol		
Weight	approx. 2.5 kg	approx. 7 kg
Stroke	16 - 20 mm	20 mm
Traction power	11,770 N	25,000 N
Standard tube package length	3.75 m	6 m
Working cycle (theoretical)	1.25 sec.	2 sec.

On request our technical sales team will send you more information about application possibilities in your company.

Automatic riveting machine GAV 8000 eco

Fully-automatic blind rivet processing system and cost-optimised variant of the GAV 8000 electronic without setting process monitoring

Working range

- Blind rivets up from 2.4 mm to 6.4 mm Ø alu and copper
- Blind rivets up to 6 mm Ø steel
- Blind rivets up to 5 mm Ø stainless steel
- Blind rivets up to flange diameter 11.4 mm
- Rivet body lengths above 30 mm
- Traction power up to 11,770 N at 6-7 bar air pressure

Advice and delivery time on request

Productivity and savings potential

- Up to 40 blind rivets can be processed every minute
- No trained personnel required for operation
- Can be easily integrated into fully-automatic poduction systems

Subsequent upgrade to GAV 8000 electronic possible in our Walldorf factory at extra price

System description

- Electronic system controls
- Intuitive menu guidance via navigation and function keys
- Function display
- Maintenance display and simple fault diagnosis
- Customer-specific software modification is possible
- Ideal for applications that do not require any process monitoring
- Rivet mandrels are disposed of via a vacuum system
- Surface contact trigger available as an optional extra
- Can be integrated into the system or operated independently
- Interface for external memory-programmable control system (SPS) can be realised via the GESIPA®-Interface

Automatic riveting machine GAV 8000 electronic

Fully automatic blind rivet system for industrial production with setting process monitoring

Working range

- Blind rivets up from 2.4 mm to 6.4 mm Ø alu and copper
- Blind rivets up to 6 mm Ø steel
- Blind rivets up to 5 mm Ø stainless steel
- Blind rivets up to flange diameter 11.4 mm
- Rivet body lengths above 30 mm
- Traction power up to 11,770 N at 6-7 bar air pressure

Advice and delivery time on request

Productivity and savings potential

- Cost-effective from an annual quantity of around 500.000 blind rivets (in relation to the German market)
- Up to 50 % time and costs savings compared to standard blind rivet devices
- Rivet pistol has a large action radius thanks to the hose package that is up to 5 m in length (standard length 3.75 m)
- No trained personnel required for operation
- Can be easily integrated into fully-automatic poduction systems
- Up to 40 blind rivets can be processed every minute

System description

- Electronic system controls
- Intuitive menu guidance via navigation and function keys
- Function display
- Maintenance display and simple fault diagnosis
- Customer-specific software modification is possible
- Rivet mandrels are disposed of via a vacuum system
- Surface contact trigger available as an optional extra
- Can be integrated into the system or operated independently
- Interface for external memory-programmable control system (SPS) can be realised via the GESIPA®-Interface

Pistol versions for GAV 8000 eco and GAV 8000 electronic

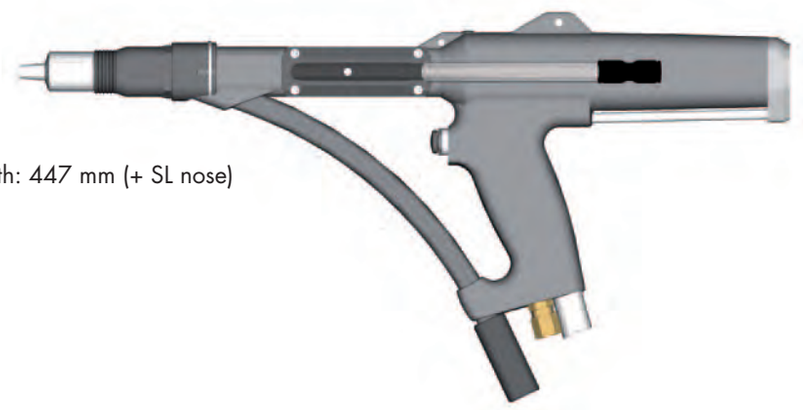
Specific workstation configuration

For all GAV versions, three different setting pistol variants are available for the ideal configuration of the workstation.

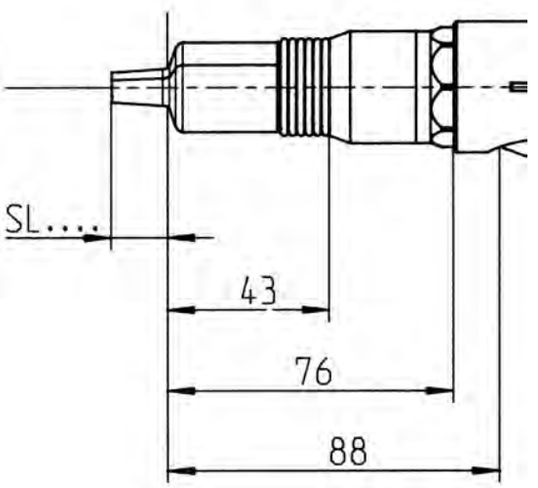
For manual workstations, pistols are available as overhead versions with overhead hose assembly or standard pistols with floor-mounted hose assembly. Both versions are equipped with a balancer to ensure fatigue-free working. The robotic pistol has been developed exclusively for use in fully automatic production systems or robot-controlled systems. It is supplied from stock with corresponding drilled holes for easy installation. For further questions, please contact our Technical Sales team.

A setting pistol suitable for your application is supplied at time of delivery.

Standard pistol



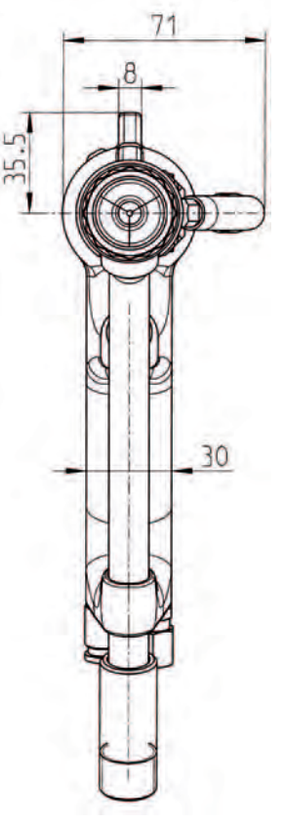
Total length: 447 mm (+ SL nose)



The standard pistol is primarily used for manual operator-controlled use.

The advantages

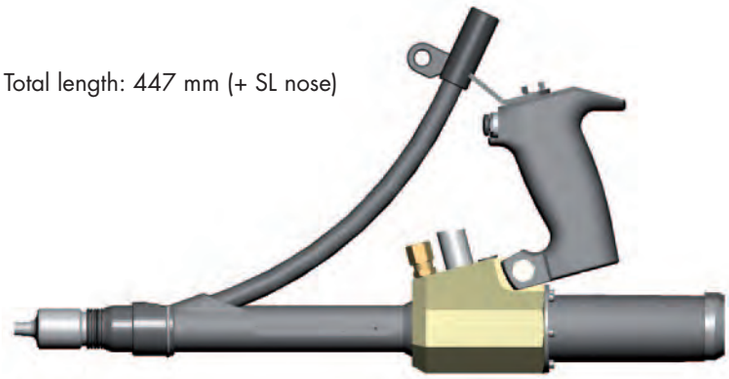
- Can be used for vertical and horizontal riveting
- Inexpensive variant
- On request, it can be fitted with an extra handle to improve ergonomics, in particular for applications involving vertical riveting.

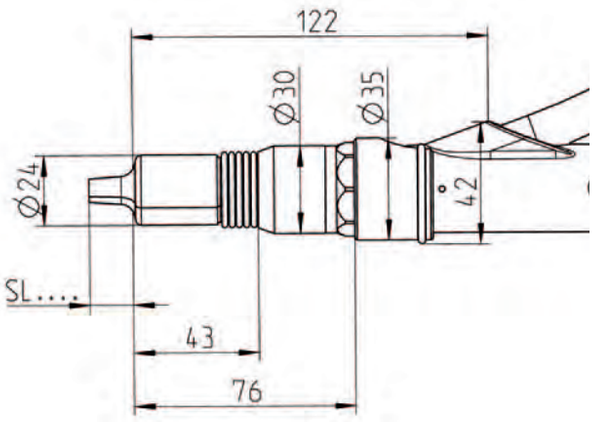


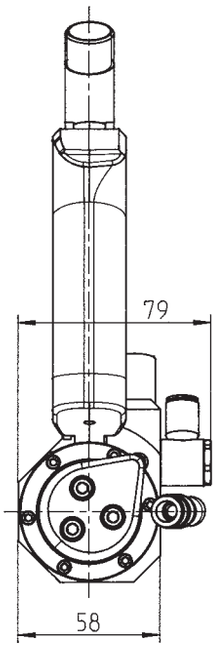
All drawing sizes in mm

Overhead pistols

Total length: 447 mm (+ SL nose)







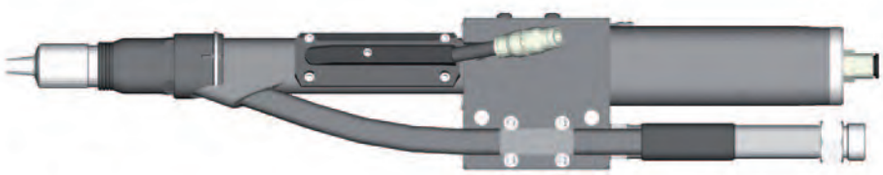
The overhead pistol can be used everywhere where the hose package is cumbersome or where it could come into contact with sensitive surfaces.

The advantage:

- Available with contact pressure monitoring

All drawing sizes in mm

Robotic pistol

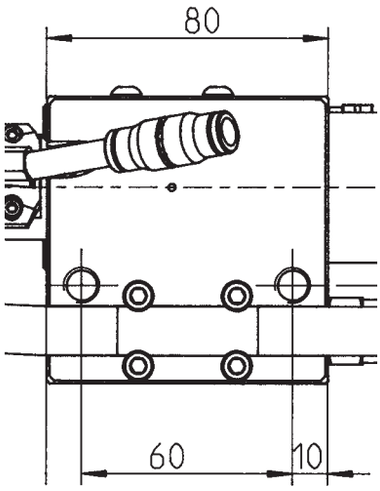


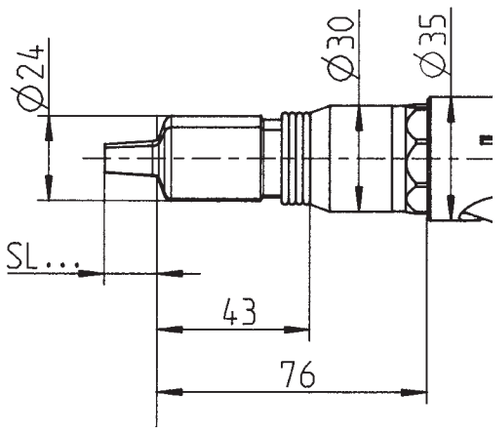
Total length: 441 mm (+ SL nose)

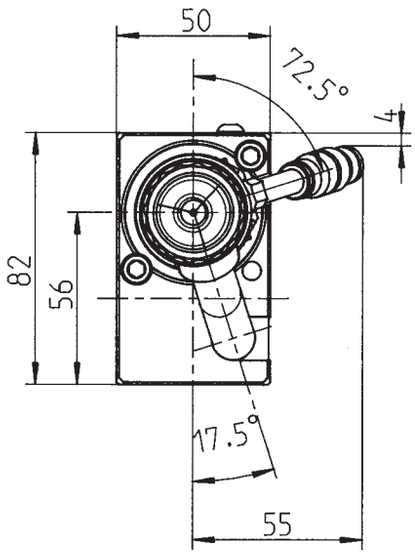
The robotic pistol has been developed primarily for use in fully automatic production applications/system (linear units/robots).

The advantages

- Ideal for integration in a production system
- On request, it can also be fitted with an extra handle (with trigger button) for vertical riveting so that it can be used manually.







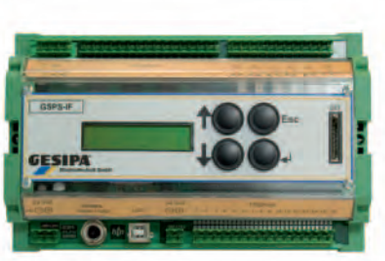
All drawing sizes in mm

Accessories for GAV 8000 (both versions)

The accessories for GAV 8000 eco and GAV 8000 electronic allow an individual system configuration for each different application case

Interface for connection to external control

As an in-house development by GESIPA®, the GESIPA®-Interface 16 has digital inputs and outputs for controlling, a card writer for processing data and a USB slot for fast data transmission.



GESIPA® interface

GAV carriage

The trolley that has been specially designed for the GAV enables it to be mobile thereby allowing the workplace to be changed quickly and easily.

Foot pedal

The foot pedal is a good solution wherever applications require both hands to affix the parts that need to be riveted.

Foot pedal

Special length tube packages

A larger working radius can be achieved, e.g. for use on fully automatic production lines, by using packages of special hose lengths. These are available in various dimensions between 3.75 m and 5.0 m to meet the requirements of the various applications.

Comparison of GAV 8000 eco and GAV 8000 electronic

Properties	GAV 8000 eco	GAV 8000 electronic
Range of possible sizes 2.4 mm - 6.4 mm (Alu)	x	x
up to 40 rivet settings per min.	x	x
Independent system operation possible	x	x
PLC control possible	x	x
Intelligent control - excellent process safety	x	x
Setting of all operating parameters via the display	x	x
Customer-specific software modification	x	x
Maintenance display	x	x
Process monitoring		x
Process parameter memory for up to 9,999 different parts		x
Online transfer of the process data		x
The last 2 million rivet processes are saved in the device		x

The practical modular principle guarantees efficiency and quality

Individual concept for efficiency and flexibility

GESIPA®'s fully-automatic blind rivet processing systems are constructed to meet the customer's special production environment. All factors, such as workplace design, production type, application, securing of flawless work processes, integration into the sequential organisation and also process documentation for safety-relevant parts, are taken into consideration.

GAV are therefore available with various pistol models, hose length packages, special accessories for various rivet dimensions and production requirements.

This results in a large variety of models and a high level of efficiency thanks to the solutions that are adapted to meet requirements.

The GAV can be integrated into the system or operated independently. If the application changes, the system can be quickly and easily adapted to the new environment.

GAV 8000 – use in robot applications

Use by industry in robot-controlled applications

Both versions of the GAV 8000 can be integrated into robot systems. Industrial robots are used almost everywhere in the production environment. They can be programmed to carry out various movements and can therefore be used highly efficiently in combination with the GESIPA® rivet equipment.

With the controlled, fast and secure production processes it is possible to achieve the following benefits by using a fully-automatic GAV combined with a multi-axle robot:

- First rate precision
- High efficiency
- Short cycle times
- High flexibility

Blind rivet function documentation and setting process monitoring

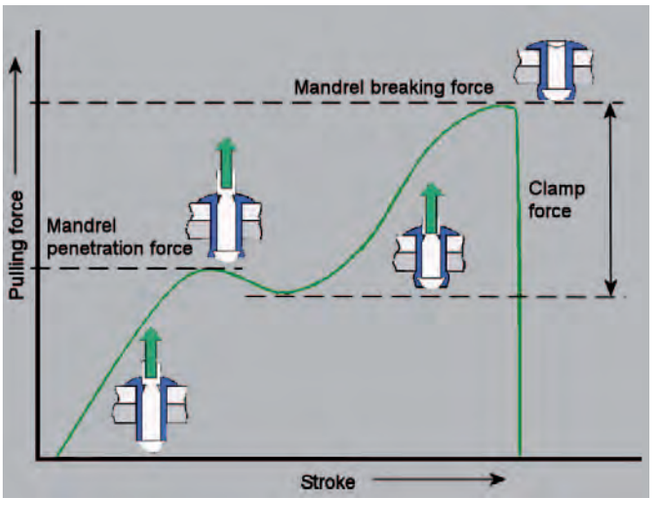
The integrated GESIPA® quality management system guarantees precision and accuracy right from the very first production step through to the processed blind rivet.

The combination of the use of function-documented blind rivets and the use of the setting process monitoring function of the GAV 8000 electronic guarantees process-secure connections.

The quality management system comprises of three areas:

- Dimensional review
- Function test
- Setting process monitoring

The dimensional review and the function test are carried out at GESIPA®, whilst the setting process is monitored during the riveting process at the customer's premises.

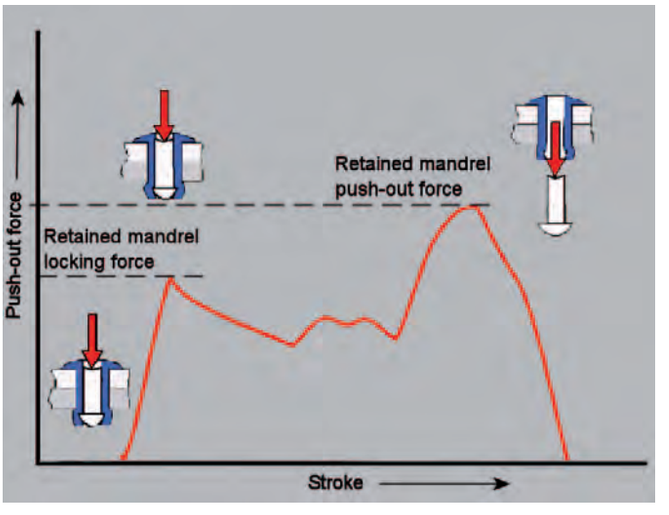


Function-documentation / setting curve

In addition to other parameters, the setting curve is measured using calibrated testing equipment for every batch of application-specific blind riveting. The measuring results of the shaft deformation, slip-in behaviour, mandrel break load and torque are compared to target values to ensure that the blind rivet in the application is deformed as required and creates a secure connection.

Function documentation / mandrel ejection force

The remaining part of the mandrel enclosed in the set rivet is pressed out with the aid of a needle. The measured force can be used to determine whether the remaining part of the pin is properly locked and will not cause any rattling noises or fall out. The batch is only released if both these values are within tolerances.



Monitored process – reliable connection

100% inspections of the riveting processes are required for safety-relevant applications for industrial processing of blind rivets. In this case, the fully-automatic rivet device GAV 8000 electronic allows application-compatible efficient solutions ranging from the basic system through to a system with a barcode scanner.

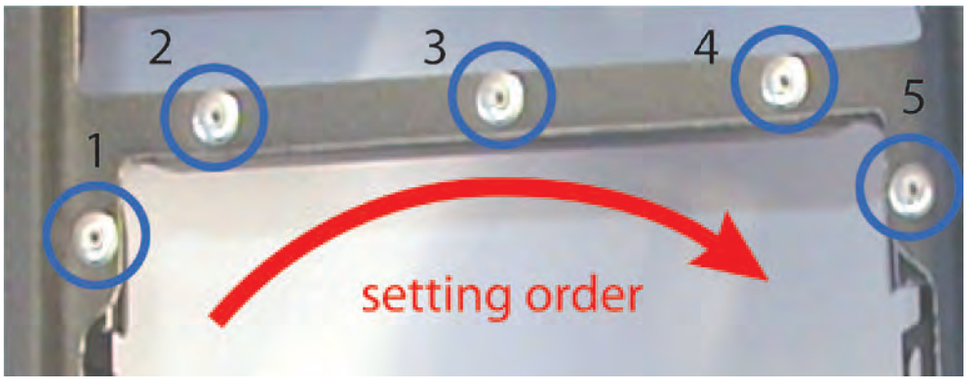
The concept of the integrated setting process monitoring

**The process monitoring system is an integral part of the GAV 8000 electronic.
It offers the following benefits:**

- Optimum process security thanks to integrated quality concept
- Blind rivet-specific process monitoring
- System can be operated independently
- No memory-programmable control system (SPS) required to operate the device
- No system calibration required when system is exchanged
- Little installation effort required
- Interfaces to the control integration

Display of a GAV 8000 electronic indicating the setting curve as part of the setting process monitoring

Programming the setting process monitoring



The setting sequence

Step 1: Setting up blind rivet position-specific profiles

Recording and archiving of the relevant process parameters to create a blind rivet connection with reference process curves after defining the analysis window

Step 2: Generation of part-specific profile lists

Summary of the profile in the setting sequence as a control file for the process sequence and process assessment

Step 3: Operating the device

Online analysis and saving of the setting process data with process interruption if deviations are detected

Automatic riveting unit GAV HF

Fully-automatic blind rivet system for very strong blind rivets

Working range

- Blind rivet sizes from 4.8 mm to 8.0 mm Ø all materials
- Rivet body lengths up to 35 mm
- Setting head diameter up to 19 mm
- Mandrel up to 5.5 mm Ø
- Traction power up to 20,000 N at 5 bar air pressure

Advantages

- Conveyor pot filling level display
- Operating pressure: 5 bar
- Vibration-dampened pressure intensifier attachment
- Multiple monitoring of the blind rivet pistol by means of sensors
- Industrial control with an 8″ colour display
- Conveyor distances of up to 25 m are possible when used in fully-automatic production systems
- Electronic system controls
- Intuitive menu guidance via navigation and function keys
- Function display
- Maintenance display and simple fault diagnosis
- Customer-specific software modification is possible
- Ideal for applications that do not require any process monitoring

Advice and delivery time on request

A comparison of the size of a blind rivet that can be set with GAV HF and a GESIPA®-PolyGrip® rivet and a 1 Euro coin

- Rivet mandrels are disposed of via a vacuum system
- Surface contact trigger available as an optional extra
- Can be integrated into the system or operated independently
- Interface for external memory-programmable control system (SPS) can be realised via the GESIPA®-Interface

Accessories for GAV HF

The accessories for GAV HF allow an individual system configuration for each different application case

Foot pedal

The foot pedal is a practical solution wherever applications require both hands to affix the parts that need to be riveted.

Foot pedal

Surface contact monitoring with dual-hand operation

This special type of surface contact monitoring guarantees the manipulation-proof process-secure joining of parts. In applications that are relevant for safety, it is often necessary to completely rule out manipulations in the riveting process.

GSM radio module

In the event of any deviations to the target status e.g. nearly empty feed unit, the GSM radio module (GSM = Global System for Mobile Communications) reports this to a mobile telephone or a process control centre via a call or an SMS. This allows short response times.

Electronic key system and safety switch

An electronic key system and a safety switch guarantee safe access control for at least two user groups and lock the covering hood to prevent unauthorised access to the components in the supply unit.

Special length tube packages

A larger working radius can be achieved, e.g. for use on fully automatic production lines, by using packages of special hose lengths. These are available in various dimensions up to around 25 m to meet the requirements of the various applications.

Operatingstatus display

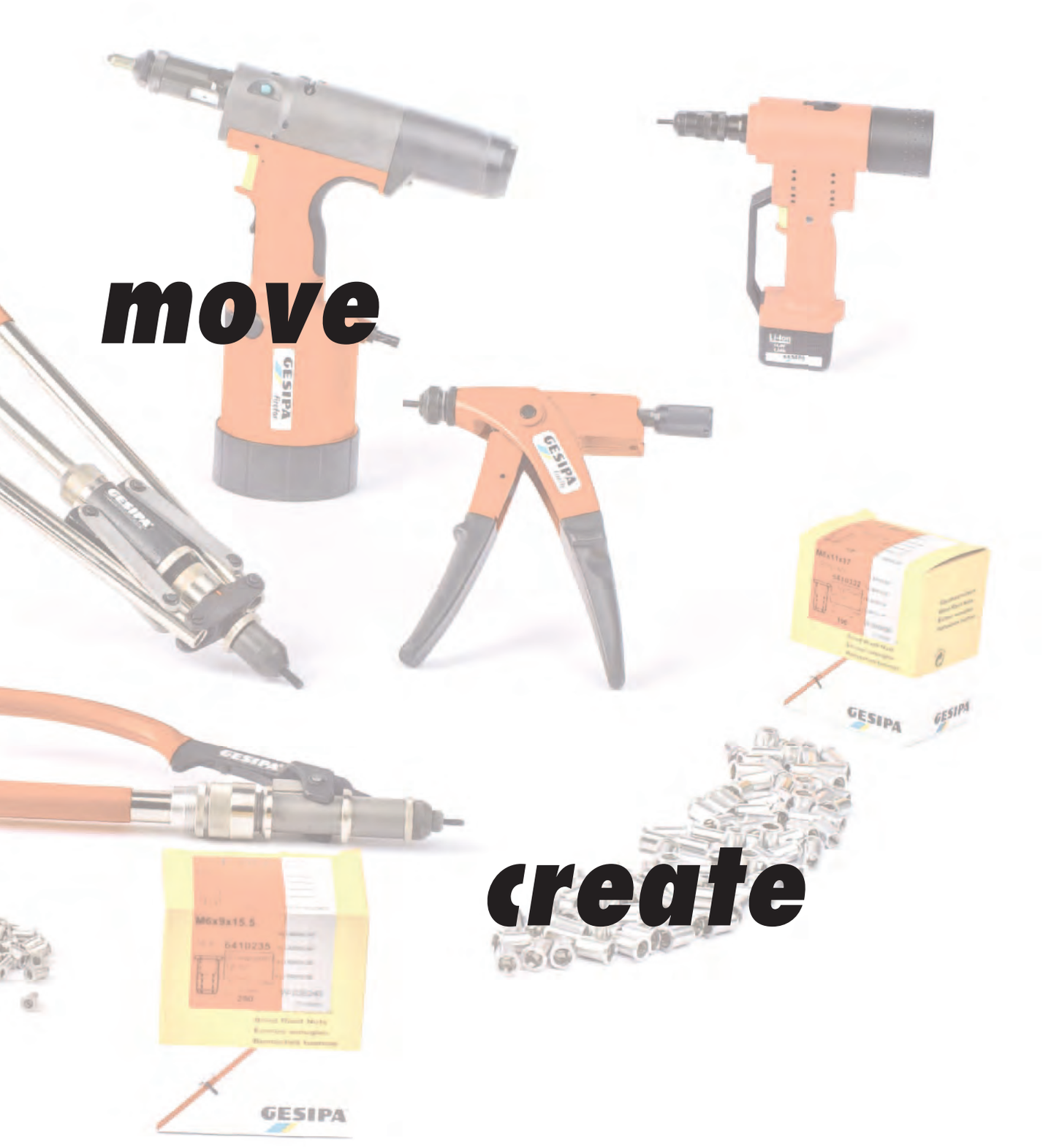
The signal lamps attached to the device in the colours red, green and white indicate the operating status of the system. An empty rivet tank, any deviations from the target operating status etc. are indicated immediately.

Signal lamps indicate the operating status

Blind rivet nuts technology know trust

understand

move



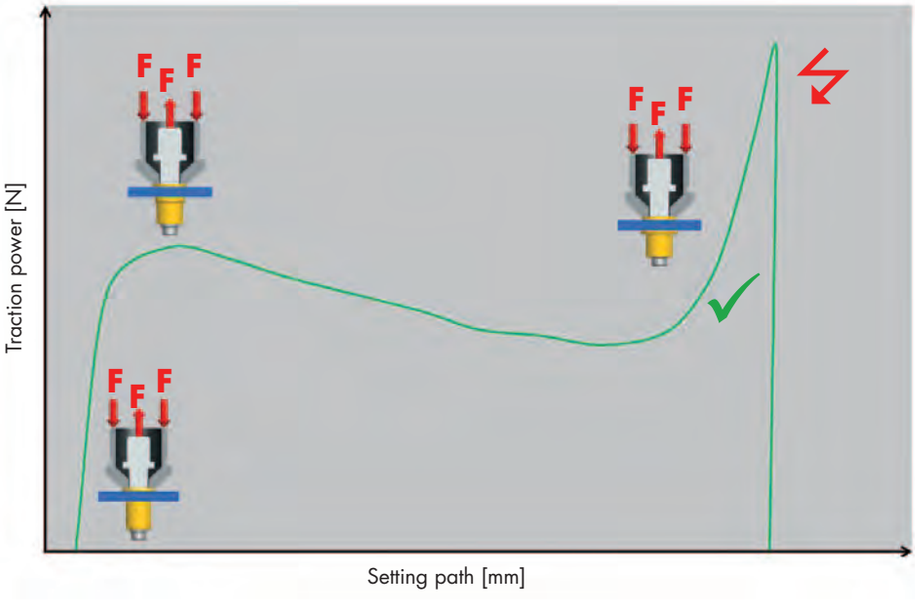
create

Technical data

Your benefit

The specified forces and torques correspond to calculated values or values determined in tests. They aim to help the user select the suitable connector. GESIPA® recommends testing the blind rivet nuts in application. The actual values may differ from the information in the catalogue due to the different circumstances.
Please contact our technical team for further help and advice.

The setting process

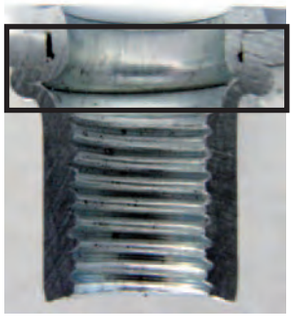


Force diagram for a setting process

The picture shows a diagram of the force-distance curve for setting a blind rivet nut in the lower clamping range. Initially the force rises steeply because the deformation zone of the blind rivet nut is first compressed. Once a certain force is reached, the deformation zone starts to fold outwards. Due to the fact that the resistance of the material is lower during the deformation and creation of the closing head, the force drops slightly.

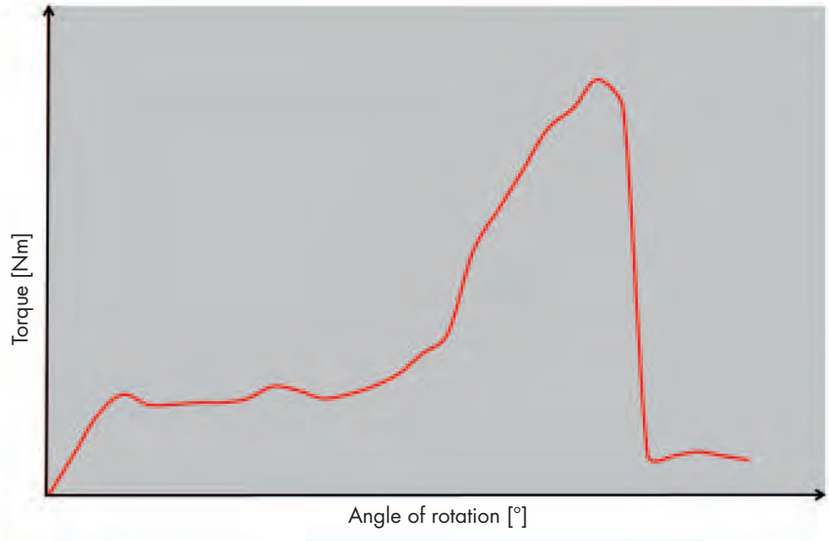
If the closing head meets the joining material, the force curve increases again. To ensure that the blind rivet nut sits tightly on the joining material and does not slip when a screw is subsequently subject to torque, the closing head must lie completely flat on the joining material (see cross-sections of the blind rivet nuts on the following page). If the setting process is not interrupted, the force will continue to rise until the thread is destroyed.

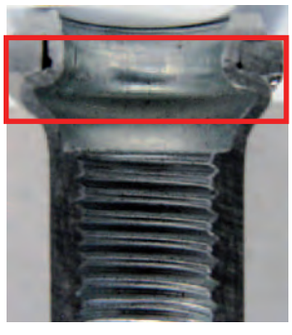
on GESIPA® blind rivets



Setting stroke 5.0 mm

Torque-angle of rotation diagram with the stroke set correctly





Setting stroke 3.5 mm

Torque-angle of rotation diagram with the stroke set correctly

The two charts show the torque curve when screwing differently set blind rivet nuts. The pictures show a cross section of blind rivet nuts set in analogue. The upper picture shows the flat and completely formed closing head in the black frame. In contrast, the setting lift of the blind rivet nut in the picture below is lower. This means that the closing head is not completely formed. A gap is still visible here in the folded forming zone. The incomplete closing head is framed in red.

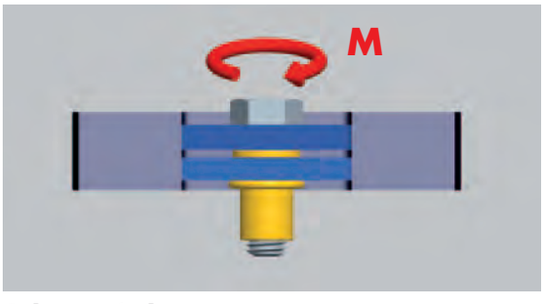
In the upper chart, the torque curve increases until the maximum thread load is reached before it fails. In the case of incompletely set blind river nuts, the torque curve runs as shown in the lower chart. The torque only increase briefly and then runs at almost the same level for some time. The screw is screwed in further, however the preload force does not increase. Almost all the force resulting from the torque is used to form the final closing head. The torque only increases again once the forming zone is completely folded as shown in the upper picture.
In an angle-controlled screwing process, the process is always stopped after the pre-set rotational angle. If the blind rivet is not set properly, the screwing process is interrupted, again after the same rotational angle. However in this case, the required clamping force has not yet been reached.

The tightening torque (Nm) and (lb-ft)

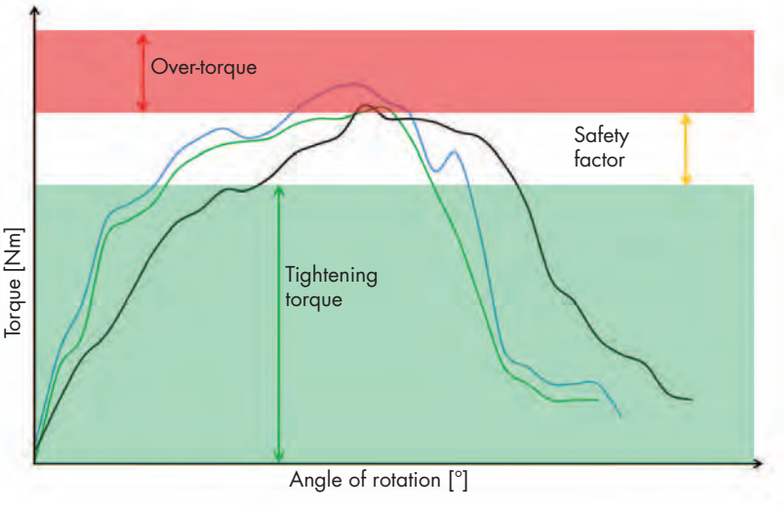
	Alu		Steel		Stainless steel	
	Nm	(lb-ft)	**Nm**	(lb-ft)	**Nm**	(lb-ft)
M4	**2.5**	1.8	**3.0**	2.2	**5.5**	4.1
M5	**5.0**	3.7	**8.0**	5.9	**14.0**	10.3
M6	**9.5**	7.0	**12.0**	8.9	**27.0**	19.9
M8	**17.5**	12.9	**30.0**	22.1	**40.0**	29.5
M10	**28.0**	20.7	**38.0**	28.0	-	

The tightening torque [(Nm) and (lb-ft)] specifies the maximum torque with which the screw can be tightened.
The overtorque is the fail limit of the thread. This is greater than the maximum recommended tightening torque and primarily depends on the type of thread and the friction partner. Reduced friction surfaces, borehole tolerances or lower friction coefficients μ, can greatly reduce the overtorque so that the thread of the blind rivet nut fails even before the specified value is reached.

GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants for the test. A hardened washer is used as the clamping part.
The test is carried out in the lower and the upper clamping range, where the blind rivet nuts are loaded with the specified torque. Then the screw is screwed out again. The thread must still turn smoothly in order to pass the test. Then the blind rivet nut is loaded again up to the overtorque.



Schematic layout for the torque test

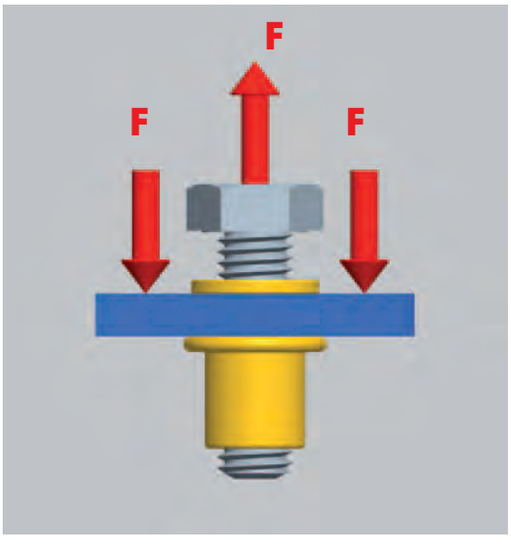


Torque-angle of rotation diagram

The diagram above shows examples of three torque rotational angle curves.
The highest torque value that is reached when screwing a screw into a blind rivet is the overtorque. This is the piont at which the connector will fail.
All values in the green range can be selected as the torque. The range between the tightening torque and the overtorque is the safety factor.

Thread breakage force (N) and (kp)

	Alu		Steel		Stainless steel	
	N	(kp)	**N**	(kp)	**N**	(kp)
M4	**4,800**	489	**8,000**	815	**10,000**	1,019
M5	**5,700**	581	**11,500**	1,172	**15,000**	1,529
M6	**9,500**	968	**21,500**	2,191	**> 25,000**	2,548
M8	**13,000**	1,325	**28,000**	2,853	**> 30,000**	3,057
M10	**14,000**	1,427	**30,000**	3,057	-	



The maximum bearable axial load on the thread is the thread breaking force [(N) and (kp)].
GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants for the test. The test takes place in the lower and upper clamping range.

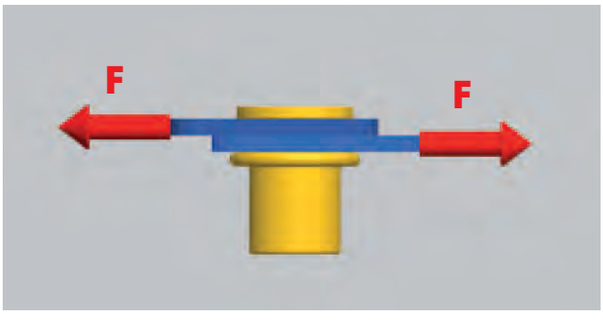
Schematic layout for the thread tear-out test

Shear strength (N) and (kp)

	Alu		Steel		Stainless steel	
	N	(kp)	**N**	(kp)	**N**	(kp)
M4	**1,000**	102	**1,500**	153	**2,250**	229
M5	**1,400**	143	**2,200**	224	**3,200**	326
M6	**2,200**	224	**3,900**	397	**5,750**	586
M8	**3,000**	306	**5,100**	520	**7,600**	774
M10	**3,600**	367	**6,000**	611	-	

The shear force [(N) and (kp)] states the minimum transverse force up to which the set blind rivet can be loaded before it fails. The load is exerted as a single shear and without a screw at a clamping length of 3.0 mm.

The stated values only apply to round flat head blind rivet nuts. The values for other models depend on the material that is being joined and the form of the head. These can be determined on request.

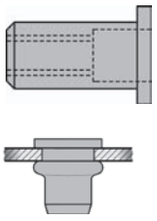


Schematic layout for the shear force test

Alu blind rivet nuts

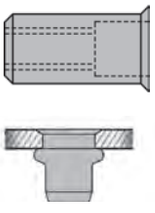
Material: AlMg 3

Standard
(Dome head)



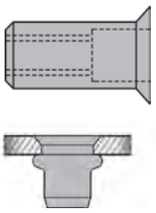
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 11.0**	0.25 - 3.0	**641** 0030	A 500
	6 x 13.0	2.5 - 4.5	**641** 0073	"
M 5 Hole Ø: 7.1 mm	**7 x 11.5**	0.25 - 3.0	**641** 0138	A 500
	7 x 13.5	2.5 - 5.0	**641** 0170	"
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**641** 0235	A 250
	9 x 18.0	3.0 - 5.5	**641** 0278	"
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**641** 0332	A 100
	11 x 20.0	3.0 - 6.0	**641** 0367	"
M 10 Hole Ø: 12.1 mm	**12 x 17.5**	0.25 - 3.5	**641** 0456	A 100
	12 x 20.5	3.0 - 6.0	**641** 0480	"

Small head



	Rivet body D_1 x L mm	Rivet body D_1 x L mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	0.5 - 3.0	**641** 0553	A 500
M 5 Hole Ø: 7.1 mm	**7 x 12.5**	0.5 - 3.0	**641** 0650	A 500
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.5 - 3.5	**641** 0758	A 250
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.5 - 3.5	**641** 0766	A 100

Countersunk
(90°)



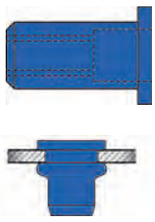
	Rivet body D_1 x L mm	Rivet body D_1 x L mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	1.5 - 3.5	**641** 2017	A 500
	6 x 13.5	3.0 - 5.0	**641** 2041	"
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	1.5 - 4.0	**641** 2130	A 500
	7 x 15.5	3.5 - 6.0	**641** 2149	"
M 6 Hole Ø: 9.1 mm	**9 x 17.0**	1.5 - 4.5	**641** 2238	A 250
	9 x 19.0	4.0 - 6.5	**641** 2246	"
M 8 Hole Ø: 11.1 mm	**11 x 18.5**	1.5 - 4.5	**641** 2335	A 100
	11 x 20.5	4.0 - 6.5	**641** 2343	"
M 10 Hole Ø: 12.1 mm	**12 x 19.0**	1.5 - 4.5	**641** 2432	A 100
	12 x 21.0	4.0 - 6.5	**641** 2440	"

The maximum tightening torque and the thread breaking force and shear strengths for all blind rivet nuts can be found on pages 102 and 103.

Steel blind rivet nuts

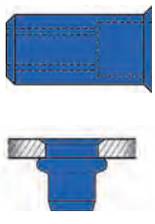
Material: **Steel, zinc-plated**

Standard
(Dome head)



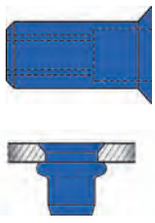
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 11.0**	0.25 - 3.0	**642** 0052	A 500
	6 x 13.0	2.5 - 4.5	**642** 0095	"
M 5 Hole Ø: 7.1 mm	**7 x 11.5**	0.25 - 3.0	**642** 0176	A 500
	7 x 13.5	2.5 - 5.0	**642** 0214	"
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**642** 0273	A 250
	9 x 18.0	3.0 - 5.5	**642** 0338	"
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**642** 0397	A 100
	11 x 20.0	3.0 - 6.0	**642** 0427	"
M 10 Hole Ø: 12.1 mm	**12 x 17.5**	0.25 - 3.5	**642** 0494	A 100
	12 x 20.5	3.0 - 6.0	**642** 0524	"

Small head



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	0.25 - 3.0	**642** 0613	A 500
M 5 Hole Ø: 7.1 mm	**7 x 12.5**	0.25 - 3.0	**642** 0710	A 500
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**642** 0818	A 250
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**642** 0826	A 100

Countersunk
(90°)



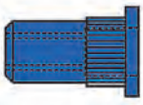
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	1.5 - 3.5	**642** 2012	A 500
	6 x 13.5	3.0 - 5.0	**642** 2047	"
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	1.5 - 4.0	**642** 2144	A 500
	7 x 15.5	3.5 - 6.0	**642** 2152	"
M 6 Hole Ø: 9.1 mm	**9 x 17.0**	1.5 - 4.5	**642** 2233	A 250
	9 x 19.0	4.0 - 6.5	**642** 2241	"
M 8 Hole Ø: 11.1 mm	**11 x 18.5**	1.5 - 4.5	**642** 2330	A 100
	11 x 20.5	4.0 - 6.5	**642** 2349	"
M 10 Hole Ø: 12.1 mm	**12 x 19.0**	1.5 - 4.5	**642** 2438	A 100
	12 x 21.0	4.0 - 6.5	**642** 2446	"

The maximum tightening torque and the thread breaking force and shear strengths for all blind rivet nuts can be found on pages 102 and 103.

Blind rivet nuts
Steel-splined

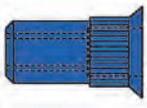
Material: Steel, zinc-plated

Standard (Dome head)



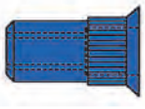
	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 11.0**	0.25 - 3.0	**642** 4503	A 500
	6 x 13.0	2.5 - 4.5	**642** 4511	"
M 5 Hole Ø: 7.1 mm	**7 x 11.5**	0.25 - 3.0	**642** 4538	A 500
	7 x 13.5	2.5 - 5.0	**642** 4546	"
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**642** 4554	A 250
	9 x 18.0	3.0 - 5.5	**642** 4562	"
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**642** 4570	A 100
	11 x 20.0	3.0 - 6.0	**642** 4589	"

Small head



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	0.25 - 3.0	**642** 4708	A 500
M 5 Hole Ø: 7.1 mm	**7 x 12.5**	0.25 - 3.0	**642** 4716	A 500
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**642** 4724	A 250
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**642** 4732	A 100

Countersunk

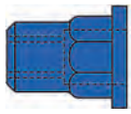


	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	1.5 - 3.5	**642** 4600	A 500
	6 x 13.5	3.0 - 5.0	**642** 4619	"
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	1.5 - 4.0	**642** 4627	A 500
	7 x 15.5	3.5 - 6.0	**642** 4635	"
M 6 Hole Ø: 9.1 mm	**9 x 17.0**	1.5 - 4.5	**642** 4643	A 250
	9 x 19.0	4.0 - 6.5	**642** 4651	"
M 8 Hole Ø: 11.1 mm	**11 x 18.5**	1.5 - 4.5	**642** 4678	A 100
	11 x 20.5	4.0 - 6.5	**642** 4686	"

Blind rivet nuts
Steel-hexagonal

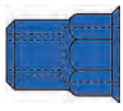
Material: Steel, zinc-plated

Standard (Dome head)



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 SW6 +0.1	**6 x 11.0**	0.5 - 2.0	**642** 4007	A 500
M 5 SW7 +0.1	**7 x 12.0**	0.5 - 3.0	**642** 4015	A 500
M 6 SW9 +0.1	**9 x 15.5**	0.5 - 3.0	**642** 4023	A 250
M 8 SW11 +0.1	**11 x 17.0**	0.5 - 3.0	**642** 4031	A 100

Small head



	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 SW6 +0.1	**6 x 11.0**	0.5 - 2.0	**642** 4309	A 500
M 5 SW7 +0.1	**7 x 12.5**	0.5 - 3.0	**642** 4317	A 500
M 6 SW9 +0.1	**9 x 15.5**	0.5 - 3.0	**642** 4325	A 250
M 8 SW11 +0.1	**11 x 17.0**	0.5 - 3.0	**642** 4333	A 100

The maximum tightening torque and the thread breaking force and shear strengths for all blind rivet nuts can be found on pages 102 and 103.

Blind rivet nuts

Stainless steel

Material:
Stainless steel A2 1.4567

Standard
(Dome head)

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 11.0**	0.25 - 3.0	**643** 0007	A 500
	6 x 13.0	2.5 - 4.0	**643** 0015	"
M 5 Hole Ø: 7.1 mm	**7 x 11.5**	0.25 - 3.0	**643** 0104	A 500
	7 x 13.5	2.5 - 4.5	**643** 0112	"
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**643** 0201	A 250
	9 x 18.0	3.0 - 5.5	**643** 0228	"
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**643** 0309	A 100
	11 x 20.0	3.0 - 6.0	**643** 0317	"

Material surcharge will be added at a daily rate

Small head

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	0.25 - 3.0	**643** 0503	A 500
M 5 Hole Ø: 7.1 mm	**7 x 12.5**	0.25 - 3.0	**643** 0600	A 500
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.5	**643** 0708	A 250
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.5	**643** 0805	A 100

Material surcharge will be added at a daily rate

Countersunk

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 12.0**	1.5 - 3.0	**643** 2018	A 500
	6 x 13.0	2.5 - 4.0	**643** 2026	"
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	1.5 - 4.0	**643** 2107	A 500
	7 x 15.5	3.5 - 6.0	**643** 2115	"
M 6 Hole Ø: 9.1 mm	**9 x 17.0**	1.5 - 4.5	**643** 2204	A 250
	9 x 18.5	4.0 - 6.0	**643** 2212	"
M 8 Hole Ø: 11.1 mm	**11 x 18.5**	1.5 - 4.5	**643** 2301	A 100
	11 x 20.0	4.0 - 6.0	**643** 2328	"

Material surcharge will be added at a daily rate

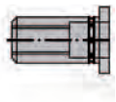
Material	All materials		Steel-hexagonal	
Size mm	Head diameter (mm) Dome/countersunk	Small head	Head diameter (mm) Dome/countersunk	Small head
M 4	**9**	**7.1**	**9**	**7.4**
M 5	**10**	**8.1**	**10**	**8.4**
M 6	**12**	**10.1**	**13**	**10.4**
M 8	**14**	**12.1**	**15.8**	**12.4**
M 10	**15**	**./.**	**./.**	**./.**

The maximum tightening torque and the thread breaking force and shear strengths for all blind rivet nuts can be found on pages 102 and 103.

PolyGrip® blind rivet nuts with large grip range

Aluminium

Standard
(Dome head)

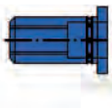



Material: AlMg 2.5

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	0.25 - 5.0	**655** 0171	A 500
M 6 Hole Ø: 9.1 mm	**9 x 18.0**	0.25 - 6.0	**655** 0277	A 250
M 8 Hole Ø: 11.1 mm	**11 x 20.0**	0.5 - 6.5	**655** 0366	A 100

Steel

Standard
(Dome head)

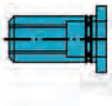



Material: Steel
Surface: Zinc-plated

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	0.25 - 5.0	**656** 0213	A 500
M 6 Hole Ø: 9.1 mm	**9 x 18.0**	0.25 - 6.0	**656** 0338	A 250
M 8 Hole Ø: 11.1 mm	**11 x 20.0**	0.5 - 6.5	**656** 0426	A 100

Stainless steel

Standard
(Dome head)

Material: Stainless steel A2 1.4567, polished

	Rivet body D_1 x L mm	Grip range mm	Part no.	Quantity per box
M 5 Hole Ø: 7.1 mm	**7 x 13.5**	0.25 - 5.0	**657** 0113	A 500
M 6 Hole Ø: 9.1 mm	**9 x 18.0**	0.5 - 6.0	**657** 0227	A 250
M 8 Hole Ø: 11.1 mm	**11 x 20.0**	0.5 - 6.5	**657** 0366	A 100

The maximum tightening torque and the thread breaking force and shear strengths for all blind rivet nuts can be found on pages 102 and 103.

Steel blind rivet stud nuts



As a combination of blind rivet nut and screw, blind rivet nut studs offer an alternative or replacement for welding studs.

The following applications are particularly suitable for the use of GESIPA® blind rivet nut studs:

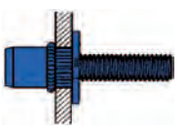
- Accessibility from one side only
- Thin carrier materials (sheet metal, plastics, etc...)
- Necessary pre-centering
- On application materials where thermal effects are possible (e.g. welding)
- Surface coatings must not be damaged
- Production of electrically conductive connections
- Fast replacement of weld studs (repairs)

GESIPA® blind rivet nut studs can be set without any problem with the GESIPA® blind rivet nut setting tools FireBird®, GBM 95 and FireFox® using corresponding adapters (see tool description) for blind rivet nut studs.

Further dimensions, special surface treatments or materials are available on request.

Standard
(Dome head)

Material: Steel, zinc-plated



	Rivet body D_1 x L mm	Grip range mm	Thread protrusion min. mm	Part no.	Quantity per box
M 4 Hole Ø: 6.1 mm	**6 x 11.0**	0.25 - 3.0	10.0	**638** 1010	A 200
M 5 Hole Ø: 7.1 mm	**7 x 11.5**	0.25 - 3.0	11.5	**638** 1018	A 150
M 6 Hole Ø: 9.1 mm	**9 x 15.5**	0.25 - 3.0	13	**638** 1027	A 150
M 8 Hole Ø: 11.1 mm	**11 x 17.0**	0.25 - 3.0	15.5	**638** 1035	A 100

Size mm	Shear strength N	(kp)	Tensile strength N	(kp)	Max. torque Nm
M 4	**5,160**	(525)	**6,030**	(614)	**3.0**
M 5	**7,200**	(733)	**10,800**	(1,100)	**6.0**
M 6	**10,800**	(1,100)	**17,800**	(1,812)	**13.0**
M 8	**18,400**	(1,873)	**27,800**	(2,830)	**26.0**

The values were determined using a screw of the strength class 8.8.

Blind rivet nuts –

What rivets what?

Units	Energy	Blind rivet nuts						
		M3	M4	M5	M6	M8	M10	M12
GBM 10	H				A			
GBM 20	H				A			
GBM 30	H						A	
FireFly	H				A			
FireBird®	B				A S E	A S	A	
GBM 95	P							
FireFox®	P						A S E	A S

H: Hand tool
B: Battery powered tool
P: Hydro-pneumatic tool

A: Alu
S: Steel
E: Stainless steel

– setting tools

Blind rivet hand tool

GBM 10

GBM 10 – M5 Part no. 720 0013
GBM 10 – M4 Part no. 720 0056
GBM 10 – M6 Part no. 720 0064

Working range

M3* to M6 alu blind rivet nuts and up to M5 steel, brass and stainless steel

Technical data

Weight:	600 g
Total length:	260 mm
Stroke:	7 mm

Accessories

Standard:
Threaded mandrel and nosepiece M5
(also with optional M4 or M6)
Maintenance instructions with spare parts list
Stroke table

Threaded mandrels and nosepieces

Nosepiece	Part no.
Threaded mandrel M4	**720** 2407
Threaded mandrel M5	**720** 2504
Threaded mandrel M6	**720** 2601
Nosepiece M4	**720** 2415
Nosepiece M5	**720** 2512
Nosepiece M6	**720** 2628

*Threaded mandrel and nosepiece M3 also available as special accessories

Features

- Simple lift setting via a knurled nut for safe and complete setting of the blind rivet nuts
- Threaded mandrel protection via spring ring for fast tool-free replacement of the threaded mandrel
- With opening spring for simple handling
- Body casing in high-quality die cast aluminium
- Body head made of forged chrome-vanadium steel
- Ergonomic handles

MADE IN GERMANY

Blind rivet nut box

GBM 10 with mandrel and nosepiece M 5
including threaded mandrels and nosepieces M 4 and M 6, different blind rivet nut dimensions M 4 to M 6 made of alu for joint thicknesses of 0.25 to 3 mm.

The 4 blind rivet nut sizes:

Alu M4 x 6 x 11.0
Alu M5 x 7 x 11.5
Alu M5 x 7 x 13.5
Alu M6 x 9 x 15.5

Part no. 753 0013

Blind rivet hand tool

GBM 20

GBM 20 – M5 Part no. 721 0019

GBM 20 – M4 Part no. 721 0027
GBM 20 – M6 Part no. 721 0035

Working range

M3* to M6 alu blind rivet nuts and up to M5 steel, brass and stainless steel

Technical data

Weight:	900 g
Total length:	360 mm
Stroke:	7 mm

Accessories

Standard:
Threaded mandrel and nosepiece M5 (also with optional M4 or M6)
Maintenance instructions with spare parts list
Stroke table

Threaded mandrels and nosepieces

Nosepiece	Part no.
Threaded mandrel M4	**721** 2402
Threaded mandrel M5	**721** 2496
Threaded mandrel M6	**721** 2607
Nosepiece M4	**721** 2410
Nosepiece M5	**721** 2518
Nosepiece M6	**721** 2615

*Threaded mandrel and nosepiece M3 also available as special accessories

Features

- With opening spring for simple handling
- Large lever action for working with a minimum of effort
- Fast tool-free replacement of the threaded mandrel
- Quick drill configuration for fast and simple winding on/of the threaded mandrel
- Casing in steel
- Lever made of forged steel
- Plastic-coated handles

Blind rivet hand tool

GBM 30

GBM 30 – M6 Part no. 722 0014

GBM 30 – M5 Part no. 722 0022
GBM 30 – M8 Part no. 722 0030
GBM 30 – M10 Part no. 722 0049

Working range

M3* to M10 alu and steel blind rivet nuts and up to M8 brass and stainless steel

Technical data

Weight:	1,8 kg
Total length:	470 mm
Stroke:	7 mm

Accessories

Standard:
Threaded mandrel and nosepiece M6 (also with optional M5, M8 or M10)
Maintenance instructions with spare parts list
Stroke table

Features

- Quick drill configuration for fast and simple drilling in and out of the threaded mandrel
- Favourable transmission ration for low force application even when seting larger blind rivet nuts
- Simple lift setting via a lift scale for safe and complete setting of the blind rivet nuts
- Fast tool-free replacement of the threaded mandrel
- Casing and cross bearing made of forged steel
- Lever arms made of galvanised steel tubes
- Plastic-coated handles

Threaded mandrels and nosepieces

Nosepiece	Part no.
Threaded mandrel M5	**722** 2505
Threaded mandrel M6	**722** 2602
Threaded mandrel M8	**722** 2807
Threaded mandrel M10	**722** 2904
Nosepiece M5	**722** 2513
Nosepiece M6	**722** 2610
Nosepiece M8	**722** 2815
Nosepiece M10	**722** 2912

*Threaded mandrel and nosepiece M3 and M4 also available as special accessories

FireFly

Power and intelligence for setting blind rivet nuts

FireFly – Smart handling

- The well-proven principle of operation of the GESIPA® hand riveting tool Flipper spares up to 40% of the hand force for setting blind rivet nuts.
- A special lever design as well as the ratchet mechanism provide a reduction of hand force
- Exchange of nosepiece and threaded mandrel
- The stroke is 9 millimeter long for setting of new generation multigrip blind rivet nuts like new the GESIPA® PolyGrip® blind rivet nuts
- Tool-free setting of stroke and threaded mandrel lengths allows simple setting of blind rivets of different lengths.

FireFly – Working range

M3* to M6 alu blind rivet nuts and up to M3 to M5 steel

FireFly – the technical data

Total stroke: 9 mm
Single action stroke: 1.8 mm
Weight: 750 g

Refill mini packs for blind rivet nuts:

M4 x 6 x 13.0
€ 12.80 / Pack
Part no. 641 4200

M5 x 7 x 13.5
€ 14.30 / Pack
Part no. 641 4210

FireFly – The comprehensive one

Equipped with M5 nosepiece and threaded mandrel, in plastic carrying case with 2 Alu M4 and M5 blind rivet nut mini packs, as well as M4 nosepiece and threaded mandrel, operating instructions and stroke adjustment list
Part no. 752 0001

Retrofit set for blind rivet stud nuts

	Part no.	BRN thread protrusion min.	max.*
M4	**702** 1027	8	22
M5	**702** 1028	9	22
M6	**702** 1029	10	22

Threaded mandrels and nosepieces

Article	Part no.
Threaded mandrel 6-32 UNC	**702** 2001
Threaded mandrel 8-32 UNC	**702** 2002
Threaded mandrel 10-24 UNC	**702** 2003
Threaded mandrel 10-32 UNC	**702** 2004
Threaded mandrel 1/4" - 20 UNC	**702** 2005
Nosepiece insert 6 - 32 UNC	**702** 2006
Nosepiece insert 8 - 32 UNC	**702** 2007
Nosepiece insert 10 - 24 UNC	**702** 2008
Nosepiece insert 1/4" - 20 UNC	**702** 2009

Article	Part no.
Threaded mandrel M3	**702** 1015
Threaded mandrel M4	**702** 1014
Threaded mandrel M5	**702** 1013
Threaded mandrel M6	**702** 1026
Nosepiece insert M3	**702** 1008
Nosepiece insert M4	**702** 1007
Nosepiece insert M5	**702** 1006
Nosepiece insert M6	**702** 1010

The nosepiece insert 10 - 24 UNC can be used for threaded mandrels 10 - 24 UNC and 10-32 UNF

Article	Part no.
FireFly M5 in cardboard box	**752** 0002
FireFly M3 in cardboard box	**752** 0003
FireFly M4 in cardboard box	**752** 0004
FireFly M6 in cardboard box	**752** 0006
FireFly 6 - 32 UNC in cardboard box	**752** 0007
FireFly 8 - 32 in cardboard box	**752** 0008
FireFly 10 - 24 UNC in cardboard box	**752** 0009
FireFly 10 - 32 UNF in cardboard box	**752** 0010
FireFly 1/4" - 20 UNC in cardboard box	**752** 0011

Equipped with a nosepiece and threaded mandrel and operating instructions

* A corresponding extended nosepiece must be used for thread protrusions > 22 mm.

FireFly in cardboard box

NEW

FireBird®

FireBird® – High performance

14.4 Volt rechargeable energy for flexible, cable-free use on building sites and industrial production systems

FireBird® – Safety first

- Drill-on of the blind rivet nut with reduced torque and automatic switch-off
- Triggering the setting process clearly separated from the drill-on action
- Automatic drill-out function after the end of the setting process
- Drill-off with high torque
- Sturdy, compact and shockproof tool housing

FireBird® – Ergonomics

- Fatigue-free working through well balanced weight re-partition and ergonomic grip
- Easy stroke adjustment

FireBird® with battery 14.4 V / 1.3 Ah,
and charger **in carrying case**
Part no. 726 0032

FireBird® with two batteries 14.4 V / 1.3 Ah,
and charger **in carrying case**
Part no. 726 0030

FireBird® – with Li-Ion energy

- Battery with 1.3 Ah (standard) or power battery with 2.6 Ah as special accessory
- No memory-effect
- High energy yield due to high voltage
- Low weight allows for extremely easy and fast operation
- Extremely low self discharge
- New battery shape allow the tool to be stored standing on its battery

FireBird® – The fast one

- Simple and safe drilling of the blind rivet nuts
- Constant setting speed
- Automatic switchover from setting to drilling
- Fast and simple change system for threaded mandrels

FireBird® – The versatile one

M10 alu blind rivet nuts and up to M8 steel and up to M6 stainless steel

Battery powered blind rivet nut setting tool with 14.4 Volt Li-Ion battery

Working range

Up to M10 alu, up to M8 steel and up to M6 stainless steel

Accessories

Threaded mandrel and nosepiece M6 (in work position)
1 hexagonal wrench
Threaded mandrel and nosepiece M4 and M5 (in magazine)
Double open ended wrench SW 24/27

Technical data

Weight:	2.1 kg with battery
Traction power:	13,000 N
Drive:	DC motor
Stroke:	7 mm

Power per battery charge/threaded mandrels and nosepieces

Blind rivet nuts Inner thread	Material	approx. pc per charging process	Part no.	
			Threaded mandrel	Nosepiece
M3	Alu	**480**	**726** 2019*	**726** 2086*
M3	Steel/stainless steel	**440**		
M4	Alu	**420**	**726** 2027	**726** 2094
M4	Steel/stainless steel	**380**		
M5	Alu	**380**	**726** 2035	**726** 2108
M5	Steel/stainless steel	**320**		
M6	Alu	**320**	**726** 2043	**726** 2116
M6	Steel/stainless steel	**240**		
M8	Alu	**270**	**726** 2051*	**726** 2124*
M8	Steel	**140**		
M10	Alu	**240**	**726** 2078*	**726** 2132*

* Available as special accessory

Conversion kit for blind rivet stud nuts

	Part no.	BRN thread protrusion min.	BRN thread protrusion max.*
M4	**726** 3015	8	22
M5	**726** 3023	9	22
M6	**726** 3031	10	22
M8	**726** 3058	12	22

* A corresponding extended nosepiece must be used for thread protrusions > 22 mm.

Charger 14.4 V Li-Ion

Part no. 725 1134

Technical data

Input voltage:	230 V / 50 Hz
Output voltage:	14.4 V DC
Recharging time:	50 to 100 minutes (battery depending)
Weight:	0.6 g

Battery 14.4 V/1.3 Ah (Li-Ion)

Part no. 725 1045
Weight: 0.35 g

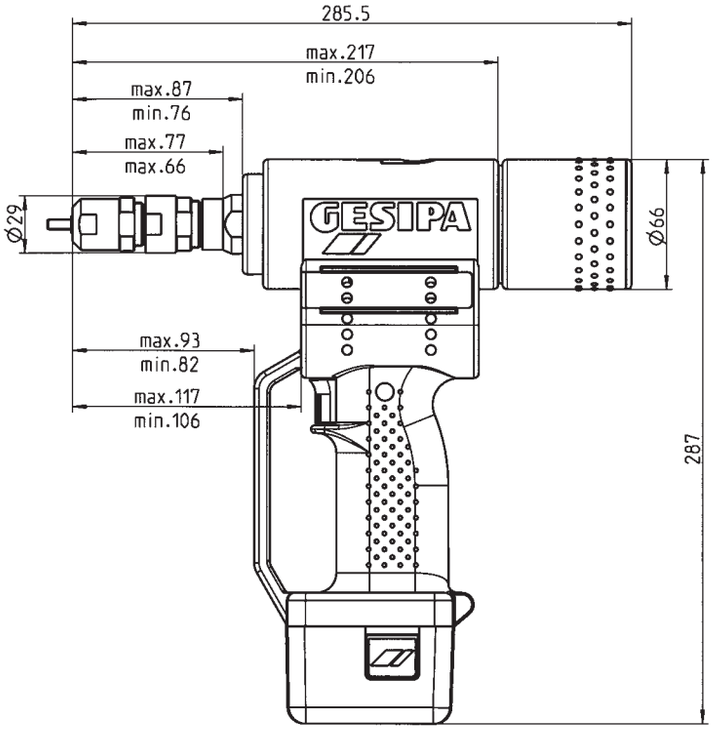
Power battery 14.4 V/2.6 Ah (Li-Ion)

Part no. 725 1049
Available as special accessory
Weight: 0.5 g

Akku
RECYCLING

Charger 12 V NiCd

Part no. 725 1035



FireFox®

Most blind rivet nut setting devices are lift-controlled, the others are setting force-controlled
The FireFox® from GESIPA® represents a new generation of blind rivet nut setting device which allows the user to define which control type he would like: simply, quickly and safely.

FireFox® — The new one

Setting blind rivet nuts with traction force adjustment
This means that the tool will stop pulling the blind rivet nut when a pre-adjusted traction force threshold is reached. No re-adjustment is needed when setting blind rivet nuts into different material thicknesses or when using blind rivet nuts with different shaft lengths. Traction force control prevents damage of the material which cannot be overstressed by a too high setting pressure and preserves the integrity of the blind rivet nut thread. As a bonus, it also extends the life duration of the threaded mandrels. The desired traction force threshold can be very simply adjusted with an allen wrench once the stroke adjustment has been set to the maximum.

FireFox® — The reliable one

Setting blind rivet nuts with constant stroke adjustment
This means that the tool will pull the blind rivet nut with its maximum force and stop immediately when the pre-adjusted stroke has been covered, nut for nut, safely and reliably. The stroke adjustment is easily and clearly performed using a millimetre scale on the tool adjustment thumb wheel, without the need for any tool, after having adjusted the pulling force to its maximum. The millimetre adjustment scale exactly reflects the effective stroke of the threaded mandrel, so that maladjustment is nearly impossible. Moreover it is safely locked to prevent any drift. The protruding length of the threaded mandrel can be adjusted manually according to the shaft length of the blind rivet nut.

FireFox® — The versatile one

Sets blind rivet nuts from M3 to M12, also those with extended grip range
The wide range of suitable thread sizes provides the FireFox® with a large variety of possible operation. The choice between stroke and traction force control also makes it suitable for industrial applications where several material thicknesses need to be covered, which would normally require the use of several tools. Moreover, its outstanding 10mm stroke is ideally suited to the new generation of large grip range blind rivet nuts, like the GESIPA® PolyGrip® products.

FireFox® — The simple one

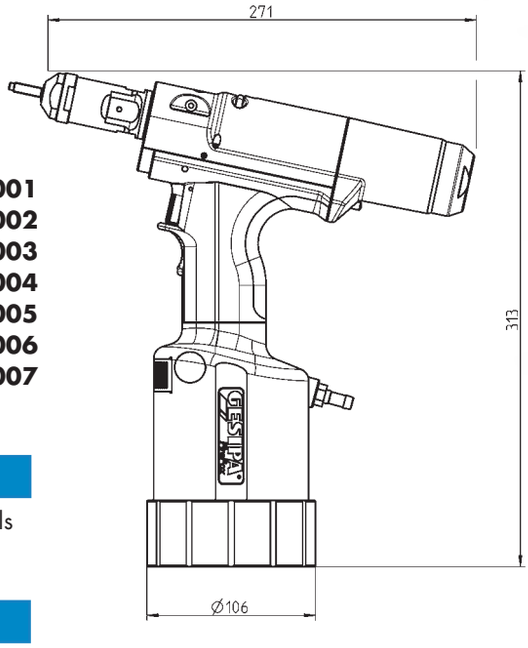
Easy operation through automatic drill-on function
The drill-on process will automatically start when a blind rivet nut is lightly pressed onto the mandrel tip. This avoids the cumbersome double action on twin triggers. Thereafter introduce the blind rivet nut into its setting hole, press the trigger and keep it pressed until the setting cycle is completely finished, nut drilled off and tool free. It couldn't be easier!

FireFox® — The fast one

Extremely fast working cycle
Great care has been taken to shorten every sequence of the setting cycle to its absolute minimum: Pulling sequence and subsequent automatic drill-off take place at breathtaking speed and require only a single action on the trigger.

The ultimate hydro-pneumatic blind rivet nut setting tool

With its FireFox® GESIPA® is setting new standards in the field of blind rivet nut setting. The tool can be controlled either through a stroke adjustment or through pulling force limitation. Especially the latter provides a safe anchorage of the blind rivet nut in its hole, while preserving both application materials and inner thread with high process safety.



FireFox® – M6 Part no. 772 0001
FireFox® – M3 Part no. 772 0002
FireFox® – M4 Part no. 772 0003
FireFox® – M5 Part no. 772 0004
FireFox® – M8 Part no. 772 0005
FireFox® – M10 Part no. 772 0006
FireFox® – M12 Part no. 772 0007

Working range

M3 to M10 blind rivet nuts all materials and M12 in aluminium and steel

Technical data

Weight: 2.4 g
Adjustable stroke, max: 10mm
Adjustable traction force, max: 18.5 KN at 5 bar
Operating air pressure: 5-7 bar
Air hose connection: 6 mm Ø (1/4")
Air consumption: approx. 2 to 4 ltr. per cycle (depending on nut size)

Scope of delivery

- 2 double open ended wrenches SW 24/27
- 1 hexagon screwdriver SW 4
- 1 oil refill can with hydraulic oil 100 ml
- 1 oil refill can
- Operating instructions with spare parts list

Equipment

Threaded mandrel and nosepiece choice from M3 to M12

Accessories

- Adapter for use with hexagon socket cylinder screws DIN EN ISO 4762 as threaded mandrel from M4 to M8
- Adapter for setting blind rivet studs, M4 to M8
- Nosepieces and threaded mandrels in imperial or US dimensions
- Complete threaded mandrel and nosepiece sets

Threaded mandrel

Description	Part no.
Threaded mandrel M3	**772** 1046
Threaded mandrel M4	**772** 1047
Threaded mandrel M5	**772** 1048
Threaded mandrel M6	**772** 1049
Threaded mandrel M8	**772** 1050
Threaded mandrel M10	**772** 1051
Threaded mandrel M12	**772** 1052

Description	Part no.
Threaded mandrel 6-32 UNC	**772** 1101
Threaded mandrel 8-32 UNC	**772** 1102
Threaded mandrel 10-24 UNC	**772** 1103
Threaded mandrel 10-32 UNC	**772** 1104
Threaded mandrel 1/4"-20 UNC	**772** 1105
Threaded mandrel 5/16"-18 UNC	**772** 1106
Threaded mandrel 3/8"-16 UNC	**772** 1107

Nosepieces

Description	Part no.
Nosepiece M3	**772** 1053
Nosepiece M4	**772** 1054
Nosepiece M5	**772** 1055
Nosepiece M6	**772** 1056
Nosepiece M8	**772** 1057
Nosepiece M10	**772** 1058
Nosepiece M12	**772** 1059

Description	Part no.
Nosepiece 6-32 UNC	**772** 1108
Nosepiece 8-32 UNC	**772** 1109
Nosepiece 10-32 UNF	**772** 1110
Nosepiece 1/4"-20 UNC	**772** 1111
Nosepiece 5/16"-18 UNC	**772** 1112
Nosepiece 3/8"-16 UNC	**772** 1113

FireFox® accessories

FireFox® protective cover

An additional protective cover over the head ensures that the stroke length setting is not unintentionally changed.

Part no. 772 1194

Conversion kit for blind rivet stud nuts

	Part no.	BRN thread protrusion min.	max.*
M4	**772** 1138	8	22
M5	**772** 1139	9	22
M6	**772** 1140	10	22
M8	**772** 1141	12	22

* A correspondingly extended nosepiece must be used for thread protrusions > 22 mm.

FireFox® special accessories

Ready to hand and neatly stored
Complete metric threaded mandrel and nosepiece set M3 to M12

Metric dimensions

Part no. 772 1115

UNC/UNF dimensions

Part no. 772 1142

Conversion kit for Hexagon socket screws

Conversion kit for DIN screws	Part no.
M4 x min. 20	**772** 1117
M5 x min. 25	**772** 1132
M6 x min. 30	**772** 1136
M8 x min. 30	**772** 1137

Conversion kit for setting nuts

Conversion kit for setting nuts	Part no.
M6	**772** 1308
M8	**772** 1309
M10	**772** 1310
M12	**772** 1311

FireFox® C

Advice and delivery time on request

Available from end of 2012

FireFox® C — the variant with a setting process monitoring function

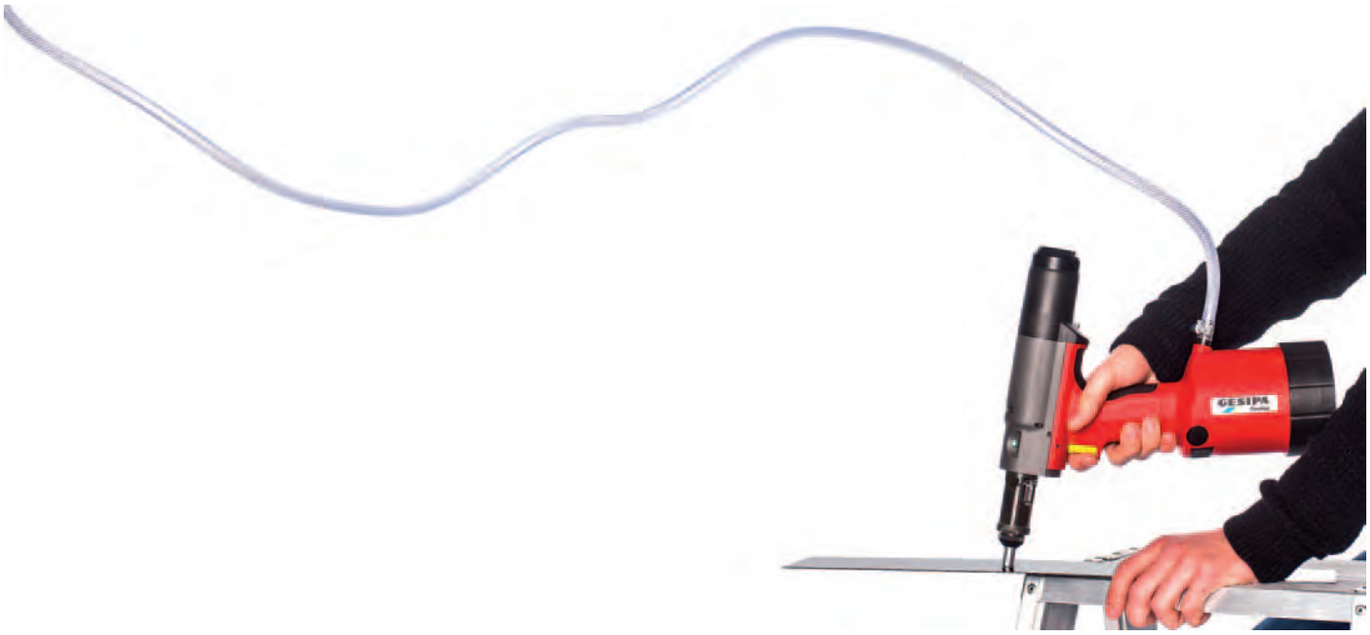
The basis for this device is the proven ***Taurus C***. Here the setting process is analysed via integrated electronics using travel and force sensors. The user can define an OK window using a special software. The result of the seeting process monitoring is shown on the device via a coloured LED; the values can also be recorded and processed via data lines.

FireFox® C — application

In the series production of safety parts or also for automatic setting processes, the FireFox® C allows the results to be checked and documented.

FireFox® C — the benefits

- High process security
- Documentation of each separate setting process
- Less scrap because errors can be recognised immediately



GBM 95 Hydro-pneumatic blind rivet nut setting tool

Working range

Blind rivet nuts from M3 to M10 all materials

Technical data

Weight:	2.3 g
Operating air pressure:	6 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption: approx.	8 ltr. per rivet process
Traction power:	15,700 N (1.600 kp)
Stroke:	7 mm

Accessories

1 wrench MSU
1 hexagon screwdriver SW 4
1 hexagon ball-end driver SW 2.5
1 assembly rod
1 pin spanner Ø 42
1 oil refill can with hydraulic oil

Equipment

Standard:
Threaded mandrel and nosepiece M6
(also with optional M3, M4, M5, M8 or M10)
Operating instructions with spare parts list
Stroke table

GBM 95 – M6 Part no. 727 0143

GBM 95 – M3 Part no. 727 0208
GBM 95 – M4 Part no. 727 0194
GBM 95 – M5 Part no. 727 0186
GBM 95 – M8 Part no. 727 0178
GBM 95 – M10 Part no. 727 0151

MADE IN GERMANY

Features

- Patented, rational drilling in and out system for threaded mandrels – time saving
- The compressed air used for the setting process is then used to automatically wind off the threaded mandrel – efficiently
- Simple lift setting – safe and complete setting of the blind rivet nuts
- Setting process: Hydraulic in an axial lift action – no twisting or turning of the blind rivet nuts and no damage to the surface
- Easy one-hand operation – rational and fatigue-proof
- Pneumatic locking of threaded mandrel – fast change without tools
- Hydraulic head; aluminium with wear-proof cylinder surface
- Pneumatic cylinder: aluminium with impact-resistance plastic sheath

Threaded mandrels

Article	Part no.
Threaded mandrel M3	**727** 9108
Threaded mandrel M4	**727** 9116
Threaded mandrel M5	**727** 9124
Threaded mandrel M6	**727** 9132
Threaded mandrel M8	**727** 9140
Threaded mandrel M10	**727** 9159

Nosepieces

Article	Part no.
Nosepiece M3	**727** 9167
Nosepiece M4	**727** 9175
Nosepiece M5	**727** 9183
Nosepiece M6	**727** 9191
Nosepiece M8	**727** 9205
Nosepiece M10	**727** 9213

Conversion kit for blind rivet stud nuts

	Part no.	BRN thread protrusion min.	max.*
M4	**727** 1409	8	22
M5	**727** 1417	9	22
M6	**727** 1425	10	22
M8	**727** 1433	12	22
M10	**727** 1441	14	22

* A correspondingly extended nosepiece must be used for thread protrusions > 22 mm.

Do-it-yourself-program

Hand riveter NTS

Art. no. 703 0029

For easy operation, slim design of tool body for setting rivets in narrow places, self opening spring for automatic mandrel ejection.

Nietboy

Art. no. 755 0014

The handyman's riveting kit including **NTS** hand riveter and a selection of 100 rivets, washers and a drill.

Blind rivet assortment

Art. no. 639 1109

Contents:
100 **blind rivets in alu/steel:**
4 mm Ø x 6, x 8, x 12

Service pack

Art. no. 639 2016

Contents:
50 pcs. of **washers** 3,1 and 4,1 mm Ø and one of **drills** 3,1 and 4,1 mm Ø.

PolyGrip® alu/steel large flange K16

Rivet body- Ø mm	length mm	Grip range mm	Art. no.	Pcs per pack
4,8	10	0,5-6,5	**670** 4130	25
4,8	17	6,5-13	**670** 4140	25

Mini pack blind rivets

26 of the most popular blind rivet sizes in **alu/steel, steel/steel** and **copper/bronze** in attractive boxes.

Mini pack rivets are supplied in a **cardboard box with 10 boxes** each.*

Alu/steel

Rivet body- Ø mm	length mm	Grip range mm	Art. no.	Pcs per pack
3	6	1-3	**630** 4206	100
3	8	3-6	**630** 4214	100
3	12	6-9	**630** 4222	100
4	6	1-3	**630** 4230	100
4	8	3-6	**630** 4249	100
4	12	6-9	**630** 4257	100
5	6	1-3	**630** 4265	50
5	10	3-6	**630** 4273	50
5	12	6-9	**630** 4281	50

Steel/steel

Rivet body- Ø mm	length mm	Grip range mm	Art. no.	Pcs per pack
3	6	1-3	**631** 3108	100
3	10	3-6	**631** 3116	100
3	12	6-9	**631** 3124	100
4	6	1-3	**631** 3132	100
4	10	3-6	**631** 3140	100
4	12	6-9	**631** 3159	100

Copper/bronze

Rivet body- Ø mm	length mm	Grip range mm	Art. no.	Pcs per pack
4	6	1-3	**635** 3010	50
4	10	3-6	**635** 3029	50
4	12	6-9	**635** 3037	50

PolyGrip® alu/steel

Rivet body- Ø mm	length mm	Grip range mm	Art. no.	Pcs per pack
3,2	8	0,5-5	**670** 4073	100
3,2	11	3-8	**670** 4080	100
4	10	0,5-6,5	**670** 4090	100
4	17	7-13	**670** 4100	50
4,8	10	0,5-6,5	**670** 4110	50
4,8	17	6,5-13	**670** 4120	50

*** only available in full cardboard boxes**

Blind rivet nut tool GBM 5

Easy stroke adjustment, quick exchange of mandrel.

Art. no. 723 0028

Working range:
From M4 to M6 alu and up to M5 steel and stainless steel

Mini pack blind rivet nuts

GBM mini pack blind rivet nuts in **alu** on blister card.

Description	Grip range mm	Art. no.	Pcs per pack
M4	0,25 - 3,0	**639** 4000	20
M4	2,5 - 4,5	**639** 4019	20
M5	0,25 - 3,0	**639** 4027	15
M5	2,5 - 5,0	**639** 4035	15
M6	0,25 -3,5	**639** 4043	8
M6	3,0 - 5,5	**639** 4051	7

Blind rivet nut assortment

Art. no. 639 4094

Contents:
One threaded mandrel M4 and M5 each for GBM and 16 blind rivet nuts M4 and M5 short and medium.

GESIPA® fasteners—Innovation for the customers...

We specialize in blind riveting systems.

We have many years of experience in manufacturing as well as distribution worldwide.

This allows us to offer you the complete solution to your fastening problem.

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