

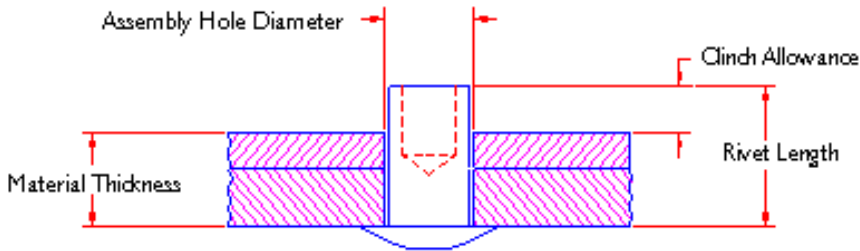
Rivet Lengths

All rivet lengths, except countersunk head rivets, are measured from the underside of the head to the end of the shank. In applications involving countersunk head rivets, overall length is measured from the top of the head to the end of the shank. Length under the head must also be specified.

Example

If a semi-tubular rivet of 1/8" diameter has been selected, the length should be established as follows:

Combined Material Thickness	.125"
Clinch Allowance	<u>+.062"</u>
Rivet Length	.187" = 3/16" Long



As a guide in determining proper rivet length, Chicago Rivet engineers have compiled a chart of Standard Clinch Allowances for the most popular rivet diameters. The term "clinch allowance" applies to the part of the rivet extending beyond the material thickness of the assembly. (See illustration above.) To determine rivet length, add combined material thickness and clinch allowance, then use the next highest applicable increment. Rivets with body diameters from .060" to .098" are available in 1/64" length increments; 1/8" and larger diameters in 1/32" length increments.

CAUTION: While long usage proves it generally satisfactory, this chart should be used as a guide only. Before recording the rivet length permanently, rivet and test a sample assembly. Certain assembly materials and various other conditions can cause a deviation from the established standard clinch allowances.

Chart of Standard Clinch Allowances

Rivet Shank Diameter		.060"	.065"	.088"	.098"	1/8"	9/64"	5/32"	3/16"	7/32"	1/4"	5/16"	3/8"
Clinch Allowance	Semi-Tubular	.032"	.032"	.045"	.055"	.062"	.093"	.093"	.110"	.140"	.156"	.187"	7/32"
	Split and Deep Hole			.062"	.078"	.093"	.125"	.125"	.156"	.175"	.187"	.210"	
Diameter of Hole in Assembly		.067"	.070"	.093"	.104"	.128"	.152"	.165"	.196"	15/64"	17/64"	21/64"	25/64"
Drill Number		51	50	42	37	30	24	19	9	15/64"	17/64"	21/64"	25/64"