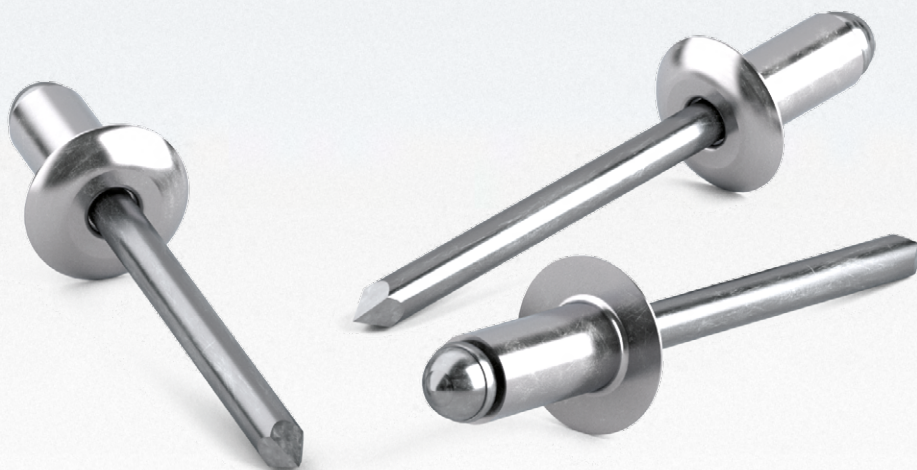


Fastening Technology / Blind Rivets

TIFAS[®] Blind Rivets



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TIFAS® blind rivets



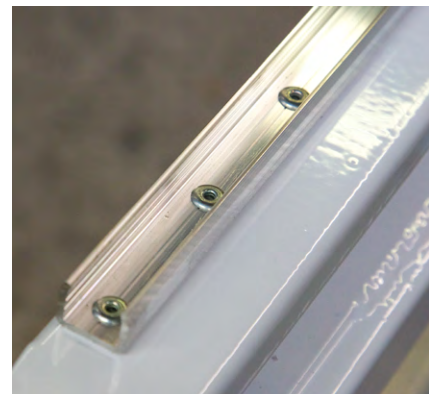
Benefits of blind rivet installation

More and more users are recognising and applying the positive benefits of working with blind rivets: for example, in electrical, medical and mechanical engineering, household appliances, power engineering, the toy and furniture industries, or even in the automotive sector and equipment manufacturing. Unlike welded joints, rivets can be quickly installed on one side and with little heat.

Even on hollow profiles and pipes, the joints are guaranteed to fit perfectly and maintain their dimensional accuracy.

TIFAS® blind rivets are especially suitable for thin-walled components and for effective installation from one side.

TIFAS® blind rivets are highly versatile and can fasten profiles, pipes, tanks and much more besides. Standard blind rivets come in a wide selection of material combinations, head shapes and grip lengths. Low in cost, standard blind rivets are quickly installed and fasten tightly and securely. The stainless steel version is also very corrosion resistant. Also available in A4 stainless steel.



Installation steps

1. Place the blind rivet with mandrel into the installation tool and insert into the drilled hole.
2. On triggering the installation tool, the jaws take hold of the mandrel and pull. At the same time, the mandrel head swages the end of the shank on the sleeve. The rivet is installed when the mandrel head is at the same height as the surface layer of the component.
3. A surge of force is applied at this point, causing the mandrel to snap off when it reaches its set breaking point.

Coloured plastic caps

Plastic caps in an array of RAL colours can be supplied for the TIFAS® blind rivet line. TIFAS® blind rivets can also be supplied painted in the desired RAL colour.

General building control approval

Some dimensions are available with general building control approval No. Z-14.1-4.

Bespoke versions

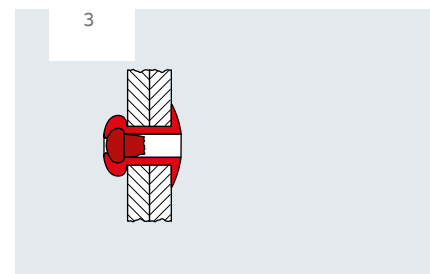
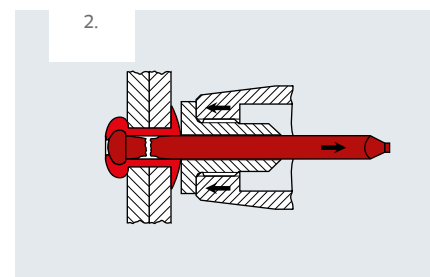
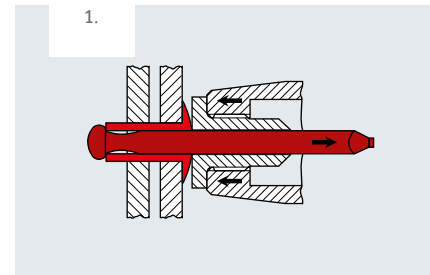
TIFAS® blind rivets can be modified depending on the customer's requirements. In these cases, the geometric parameters will be changed and, depending on the version, also the surface finish.

Benefits at a glance

- Universal use
- Fastens various materials such as metals and plastics
- Quick and secure installation
- Permanent secure fixing
- Heatless installation means component will not warp.
- Eliminates extensive refinishing
- Ideal for lightweight constructions.

Sample applications:

- General industry
- Automotive industry
- Construction industry
- Bodywork and vehicle manufacture

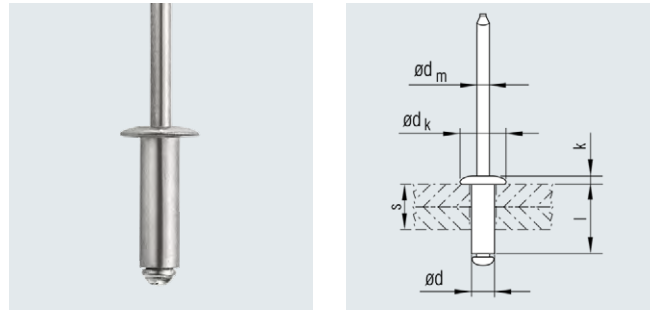


TIFAS® blind rivets

Truss head

Material

 Sleeve:	 Mandrel:
Aluminum AlMg 3.5	Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l ± 0.5 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk ± 0.3 [mm]	Height k ± 0.2 [mm]		Shear [N]	Tensile [N]	
2.4	2.5	0.5-2.5	5.0	4.5	1.0	1.4	360	480	424 100 900
		2.0-3.5	6.0	4.5	1.0	1.4	360	480	424 101 900
		3.5-6.5	9.0	4.5	1.0	1.4	360	480	424 103 900
3.0	3.1	0.5-2.0	5.0	5.8	1.3	1.7	660	920	424 110 900
		1.5-3.0	6.0	5.8	1.3	1.7	660	920	424 111 900
		3.0-5.0	8.0	5.8	1.3	1.7	660	920	424 112 900
		5.0-7.0	10.0	5.8	1.3	1.7	660	920	424 113 900
		7.0-9.0	12.0	5.8	1.3	1.7	660	920	424 114 900
3.2	3.3-3.4	1.5-2.5	6.0	6.3	1.3	1.8	830	1000	424 121 900
		2.5-4.5	8.0	6.3	1.3	1.8	830	1000	424 122 900
		4.5-6.5	10.0	6.3	1.3	1.8	830	1000	424 123 900
		6.5-8.5	12.0	6.3	1.3	1.8	830	1000	424 124 900
		8.5-10.5	14.0	6.3	1.3	1.8	830	1000	424 125 900
		10.5-12.5	16.0	6.3	1.3	1.8	830	1000	424 126 900
		12.5-14.5	18.0	6.3	1.3	1.8	830	1000	424 127 900
4.0	4.1-4.2	1.0-2.5	6.0	8.0	1.7	2.3	1200	1800	424 130 900
		2.5-3.5	7.0	8.0	1.7	2.3	1200	1800	424 149 900
		3.0-4.5	8.0	8.0	1.7	2.3	1200	1800	424 131 913
		5.0-6.5	10.0	8.0	1.7	2.3	1200	1800	424 132 900
		7.0-8.5	12.0	8.0	1.7	2.3	1200	1800	424 133 900
		8.0-10.0	14.0	8.0	1.7	2.3	1200	1800	424 134 900
		10.0-11.0	16.0	8.0	1.7	2.3	1200	1800	424 135 900
		11.0-13.0	18.0	8.0	1.7	2.3	1200	1800	424 136 900
		13.0-15.0	20.0	8.0	1.7	2.3	1200	1800	424 137 900
		18.0-20.0	25.0	8.0	1.7	2.3	1200	1800	424 138 900
4.8	4.9-5.0	1.0-2.5	7.0	9.5	2.0	2.6	1900	2500	424 141 900
		3.0-4.5	9.0	9.5	2.0	2.6	1900	2500	424 142 900
		4.0-6.0	10.0	9.5	2.0	2.6	1900	2500	424 143 900
		6.0-8.0	12.0	9.5	2.0	2.6	1900	2500	424 140 900
		8.0-10.0	14.0	9.5	2.0	2.6	1900	2500	424 144 900
		9.0-11.0	16.0	9.5	2.0	2.6	1900	2500	424 145 900
		11.0-13.0	18.0	9.5	2.0	2.6	1900	2500	424 146 900
		14.0-15.0	20.0	9.5	2.0	2.6	1900	2500	424 147 900
		15.0-16.0	22.0	9.5	2.0	2.6	1900	2500	424 148 900
		21.0-24.0	30.0	9.5	2.0	2.6	1900	2500	424 152 900
		24.0-30.0	35.0	9.5	2.0	2.6	1900	2500	424 153 900

Continued on next page

Cont'd

Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l ± 0.5 [mm]	Blind rivet head $\varnothing$ dk ± 0.3 [mm]	Height k ± 0.2 [mm]	Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
							Shear	Tensile	
							[N]	[N]	
4.8	4.9-5.0	30.0-34.0	40.0	9.5	2.0	2.6	1900	2500	424 154 900
		34.0-40.0	45.0	9.5	2.0	2.6	1900	2500	424 557 900
5.0	5.1-5.2	0.5-1.5	6.0	9.6	2.1	2.6	1900	2500	424 160 900
		2.0-3.5	8.0	9.6	2.1	2.6	1900	2500	424 161 900
		3.5-6.0	10.0	9.6	2.1	2.6	1900	2500	424 162 900
		6.0-8.0	12.0	9.6	2.1	2.6	1900	2500	424 163 900
		8.0-10.0	14.0	9.6	2.1	2.6	1900	2500	424 164 900
		9.0-11.0	16.0	9.6	2.1	2.6	1900	2500	424 165 900
		10.0-14.0	18.0	9.6	2.1	2.6	1900	2500	424 166 001
		14.0-15.0	20.0	9.6	2.1	2.6	1900	2500	424 167 900
6.0	6.1-6.2	1.0-2.0	8.0	12.0	2.5	3	3000	4100	424 181 901
		2.0-4.0	10.0	12.0	2.5	3	3000	4100	424 182 900
		3.0-6.0	12.0	12.0	2.5	3	3000	4100	424 183 900
		6.0-10.0	16.0	12.0	2.5	3	3000	4100	424 184 900
		9.0-12.0	18.0	12.0	2.5	3	3000	4100	424 185 900
		12.0-16.0	22.0	12.0	2.5	3	3000	4100	424 187 900
		16.0-21.0	27.0	12.0	2.5	3	3000	4100	424 188 003
		21.0-26.0	32.0	12.0	2.5	3	3000	4100	424 190 900
6.4	6.5-6.5	3.0-5.0	12.0	13.0	2.7	3.5	3200	5100	424 193 900
		3.0-6.0	13.0	13.0	2.7	3.5	3200	5100	424 194 000
		6.9-9.0	16.0	13.0	2.7	3.5	3200	5100	424 195 900
		9.0-12.0	19.0	13.0	2.7	3.5	3200	5100	424 196 900
		12.0-18.0	25.0	13.0	2.7	3.5	3200	5100	424 198 900

* Strengths at break relate to rivet failure.

Other designs available on request.

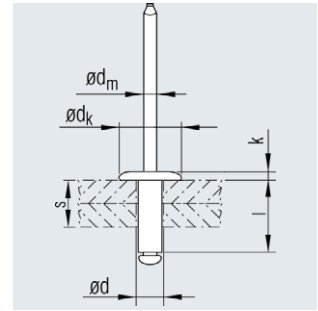
TIFAS® blind rivets

Large truss head

Material

 Sleeve:
Aluminum
AlMg 2.5/3.5

 Mandrel:
Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0-0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k ±0.5 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
4.0	4.1-4.2	5.0-6.0	10.0	12.0	1.5	2.3	1200	1800	426 132 902
		10.0-11.0	16.0	12.0	1.5	2.3	1200	1800	426 136 900
4.8	4.9-5.0	4.0-5.0	10.0	14.0	1.7	2.6	1900	2500	426152 900
		5.0-7.0	12.0	14.0	1.7	2.6	1900	2500	426 153 900
		7.0-9.0	14.0	14.0	1.7	2.6	1900	2500	426 154 900
		9.0-11.0	16.0	14.0	1.7	2.6	1900	2500	426 155 901
		11.0-13.0	18.0	14.0	1.7	2.6	1900	2500	426 156 900
		11.0-13.0	18.0	16.0	1.7	2.6	1900	2500	426 146 902
		13.0-15.0	20.0	14.0	1.7	2.6	1900	2500	426 157 900
5.0	5.1-5.2	1.0-3.5	8.0	14.0	1.7	2.6	1900	2500	426 400 000 ¹
		3.5-5.0	10.0	14.0	1.7	2.6	1900	2500	426 401 000 ¹
		5.0-6.5	12.0	14.0	1.7	2.6	1900	2500	426 402 000 ¹
		6.5-8.0	14.0	14.0	1.7	2.6	1900	2500	426 403 000 ¹
		8.0-9.5	16.0	14.0	1.7	2.6	1900	2500	426 404 000 ¹
		9.5-11.0	18.0	14.0	1.7	2.6	1900	2500	426 405 000 ¹

* Strengths at break relate to rivet failure.

¹ Please note: With general building control approval No. Z-14.1-4

Other versions available on request.

TIFAS® blind rivets

Countersunk 120°

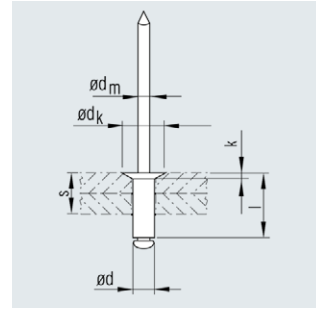
Material



Sleeve:
Aluminum AlMg 3.5



Mandrel:
Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0-0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k ±0.5 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.0	3.1	0.5-3.5	6,5	5.8	1.3	1.7	660	920	425 111 900
4.0	4.1-4.2	1.0-2.5	6.0	8.0	1.7	2.3	1200	1800	425 130 900
		2.5-3.5	7.0	8.0	1.7	2.3	1200	1800	425 149 900
		3.0-4.5	8.0	8.0	1.7	2.3	1200	1800	425 131 900
		5.0-6.5	10.0	8.0	1.7	2.3	1200	1800	425 132 900
		7.0-8.5	12.0	8.0	1.7	2.3	1200	1800	425 133 000
4.8	4.9-5.0	1.0-2.5	7.0	9.5	2.0	2.6	1900	2500	425 140 900
		3.0-4.5	9.0	9.5	2.0	2.6	1900	2500	425 141 900
		4.0-6.0	10.0	9.5	2.0	2.6	1900	2500	425 142 900

* Strengths at break relate to rivet failure.

Other designs available on request.

TIFAS® blind rivets

Truss head

Material



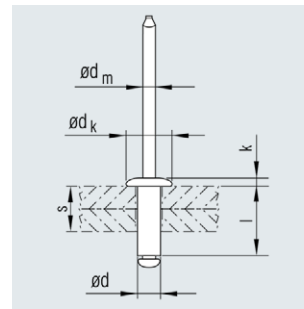
Sleeve:

Aluminum AlMg 3.5



Mandrel:

Stainless steel



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 1.0 - 0.2$ [mm]	Blind rivet head		Mandrel $\varnothing$ d_m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ $d_k \pm 0.5$ [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.0	3.1	0.5-2.0	5.0	6.0	1.0	1.7	660	920	424 210 000
		1.5-3.0	6.0	6.0	1.0	1.7	660	920	424 211 000
		3.0-5.0	8.0	6.0	1.0	1.7	660	920	424 212 000
		5.0-7.0	10.0	6.0	1.0	1.7	660	920	424 213 000
		7.0-9.0	12.0	6.0	1.0	1.7	660	920	424 214 000
3.2	3.3-3.4	1.0-2.5	6.0	6.5	1.0	1.8	830	1000	424 221 000
		2.5-4.5	8.0	6.5	1.0	1.8	830	1000	424 222 000
		4.5-6.5	10.0	6.5	1.0	1.8	830	1000	424 223 000
		6.5-8.5	12.0	6.5	1.0	1.8	830	1000	424 224 000
4.0	4.1-4.2	2.5-3.5	7.0	8.0	1.2	2.2	1200	1800	424 230 000
		3.0-4.5	8.0	8.0	1.2	2.2	1200	1800	424 231 000
		5.0-6.5	10.0	8.0	1.2	2.2	1200	1800	424 232 000
		7.0-8.5	12.0	8.0	1.2	2.2	1200	1800	424 233 000
4.8	4.9-5.0	2.0-3.5	8.0	9.5	1.6	2.6	1900	2500	424 241 000
		4.0-6.0	10.0	9.5	1.6	2.6	1900	2500	424 242 000
		6.0-8.0	12.0	9.5	1.6	2.6	1900	2500	424 243 000
		8.0-10.0	14.0	9.5	1.6	2.6	1900	2500	424 244 000
		14.0-15.0	20.0	9.5	1.6	2.6	1900	2500	424 247 000
		15.0-16.0	25.0	9.5	1.6	2.6	1900	2500	424 248 000
5.0	5.1-5.3	2.0-3.5	8.0	9.5	1.6	2.6	1900	2500	424 261 000
		3.5-6.0	10.0	9.5	1.6	2.6	1900	2500	424 262 000
		6.0-8.0	12.0	9.5	1.6	2.6	1900	2500	424 263 000
		8.0-10.0	14.0	9.5	1.6	2.6	1900	2500	424 264 000

* Strengths at break relate to rivet failure.

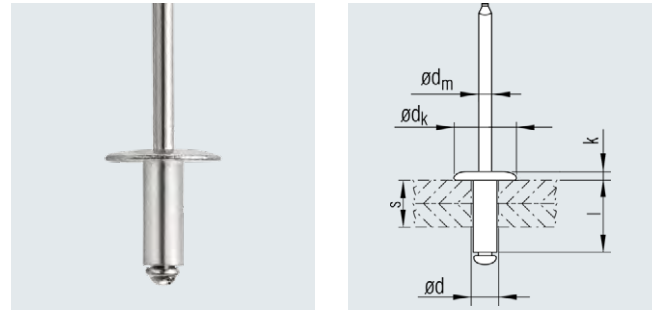
Other designs available on request.

TIFAS® blind rivets

Large truss head

Material

	
Sleeve:	Mandrel:
Aluminum AlMg 2.5	Stainless steel



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k ±0.5 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
4.8	4.9 - 5.0	4.0 - 5.0	10.0	14.0	1.7	2.6	2100	2800	426 243 900
		15.0 - 19.0	25.0	14.0	1.7	2.6	2100	2800	426 250 000
		19.0 - 26.0	32.0	16.0	1.7	2.6	2100	2800	426 249 000
5.0	5.1 - 5.2	1.0 - 3.5	8.0	14.0	1.7	2.6	1900	2500	426 300 000 ¹
		3.5 - 5.0	10.0	14.0	1.7	2.6	1900	2500	426 301 000 ¹
		5.0 - 7.0	12.0	14.0	1.7	2.6	1900	2500	426 302 000 ¹
		7.0 - 9.0	14.0	14.0	1.7	2.6	1900	2500	426 303 000 ¹
		9.0 - 11.0	16.0	14.0	1.7	2.6	1900	2500	426 304 000 ¹
		11.0 - 13.0	18.0	14.0	1.7	2.6	1900	2500	426 305 000 ¹
		13.0 - 15.0	20.0	14.0	1.7	2.6	1900	2500	426 306 000 ¹

* Strengths at break relate to rivet failure.

¹ Please note: With general building control approval No. Z-14.1-4

Other versions available on request.

TIFAS® blind rivets

Truss head

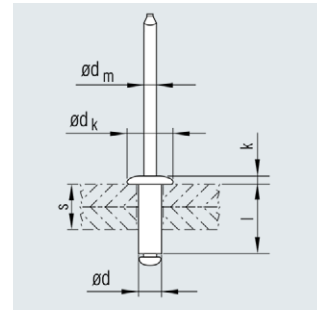
Material



Sleeve:
Steel, galvanised
passivated



Mandrel:
Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head $\varnothing$ dk +0.6/-1.2 [mm]	Height k max. [mm]	Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
							Shear	Tensile	
							[N]	[N]	
3.0	3.1	1.5 - 3.0	6.0	6.0	1.0	1.9	1000	1300	424 010 900
		3.0 - 5.0	8.0	6.0	1.0	1.9	1000	1300	424 011 900
		7.0 - 9.0	12.0	6.0	1.0	1.9	1000	1300	424 013 900
3.2	3.3	1.0 - 2.5	6.0	6.5	1.0	1.9	1100	1400	424 020 900
		2.5 - 4.5	8.0	6.5	1.0	1.9	1100	1400	424 021 900
		4.5 - 6.5	10.0	6.5	1.0	1.9	1100	1400	424 022 900
4.0	4.1	1.0 - 2.5	6.0	8.0	1.2	2.3	1700	2400	424 030 900
		2.0 - 3.5	7.0	8.0	1.2	2.3	1700	2400	424 029 900
		3.0 - 4.5	8.0	8.0	1.2	2.3	1700	2400	424 031 900
		5.0 - 6.5	10.0	8.0	1.2	2.3	1700	2400	424 032 900
		7.0 - 8.5	12.0	8.0	1.2	2.3	1700	2400	424 033 900
		8.0 - 10.0	14.0	8.0	1.2	2.3	1700	2400	424 034 900
		10.0 - 11.0	16.0	8.0	1.2	2.3	1700	2400	424 035 900
4.8	4.9 - 5.0	0.5 - 1.5	6.0	9.5	1.5	2.9	3000	4200	424 050 900
		2.0 - 3.5	8.0	9.5	1.5	2.9	3000	4200	424 051 900
		4.0 - 6.0	10.0	9.5	1.5	2.9	3000	4200	424 049 900
		6.0 - 8.0	12.0	9.5	1.5	2.9	3000	4200	424 053 900
		8.0 - 10.0	14.0	9.5	1.5	2.9	3000	4200	424 054 900
		9.0 - 11.0	16.0	9.5	1.5	2.9	3000	4200	424 055 900
		16.0 - 19.0	25.0	9.5	1.5	2.9	3000	4200	424 057 900
		19.0 - 24.0	30.0	9.5	1.5	2.9	3000	4200	424 058 900
5.0	5.1 - 5.2	0.5 - 2.0	6.0	9.7	1.6	2.9	3300	4700	424 060 900
		2.0 - 3.5	8.0	9.7	1.6	2.9	3300	4700	424 061 900
		3.5 - 6.0	10.0	9.7	1.6	2.9	3300	4700	424 062 900
		6.0 - 8.0	12.0	9.7	1.6	2.9	3300	4700	424 063 900
		8.0 - 10.0	14.0	9.7	1.6	2.9	3300	4700	424 064 900
		15.0 - 20.0	25.0	9.7	1.6	2.9	3300	4700	424 069 902
6.0	6.1 - 6.2	2.0 - 4.0	10.0	12.0	1.8	3.5	4000	5200	424 082 901
		3.0 - 6.0	12.0	12.0	1.8	3.5	4000	5200	424 083 900
		6.0 - 9.0	15.0	12.0	1.8	3.5	4000	5200	424 084 900
		9.0 - 12.0	18.0	12.0	1.8	3.5	4000	5200	424 086 900
6.4	6.5 - 6.6	2.0 - 4.0	10.0	13.0	2.3	3.9	4400	5100	424 091 907
		3.0 - 5.0	12.0	13.0	2.3	3.9	4400	5100	424 092 900
		7.0 - 9.0	17.0	13.0	2.3	3.9	4400	5100	424 094 902

* Strengths at break relate to rivet failure.

Other designs available on request.

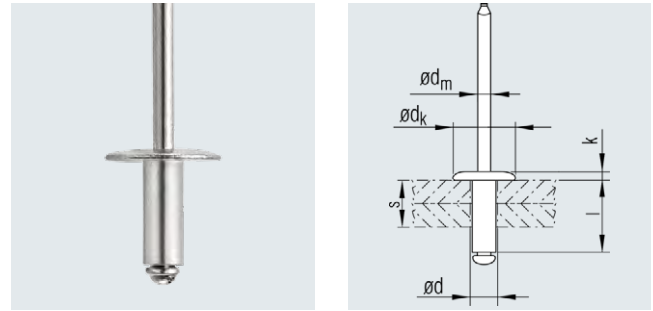
TIFAS® blind rivets

Large truss head

Material

Sleeve:
Steel, galvanised,
passivated

Mandrel:
Steel, galvanised,



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k +0.6/-1.2 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.2	3.3	3.0 - 6.5	10.0	9.5	1.4	1.8	1100	1400	426 022 900
4.0	4.1	3.0 - 4.5	8.0	12.0	1.6	2.3	1700	2400	426 032 900
		3.0 - 4.5	8.0	14.0	1.6	2.3	1700	2400	426 033 900
		8.0 - 10.0	14.0	12.0	1.6	2.3	1700	2400	426 034 900
4.8	4.9 - 5.0	1.0 - 6.0	11.0	14.0	1.8	2.9	3000	4200	426 053 901
		9.5 - 12.0	17.5	14.0	1.8	2.9	3000	4200	426 056 001

* Strengths at break relate to rivet failure.

Other designs available on request.

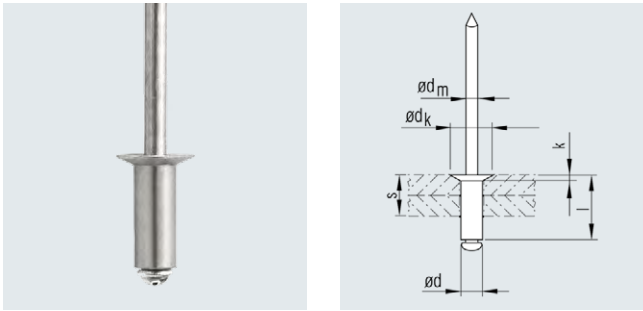
TIFAS® blind rivets

Countersunk 120°

Material

Sleeve:
Steel, galvanised,
passivated

Mandrel:
Steel, galvanised,



Nominal Ø d [mm]	Bore Ø [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel Ø d _m nom. [mm]	Nominal strength at break		Article No.
				Ø d _k +1.1/-0.7 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
4.0	4.1	1.0 - 2.0	6.0	7.5	1.7	2.3	1900	2700	425 030 901
		2.0 - 4.0	8.0	7.5	1.7	2.3	1900	2700	425 061 900
		4.0 - 6.0	10.0	7.5	1.7	2.3	1900	2700	425 032 900
		6.0 - 8.0	12.0	7.5	1.7	2.3	1900	2700	425 033 900
4.8	4.9 - 5.0	5.0 - 7.0	12.0	9.0	2.0	2.9	3000	4200	425 043 900
		9.0 - 11.0	16.0	9.0	2.0	2.9	3000	4200	425 045 901
		11.0 - 13.0	18.0	9.0	2.0	2.9	3000	4200	425 046 900
6.4	6.5 - 6.6	3.0 - 6.0	12.0	12.5	2.1	3.9	4400	6300	425 092 901
		15.0 - 20.0	27.0	12.5	2.1	3.9	4400	6300	425 098 900

* Strengths at break relate to rivet failure.

Other designs available on request.

TIFAS® blind rivets

Truss head

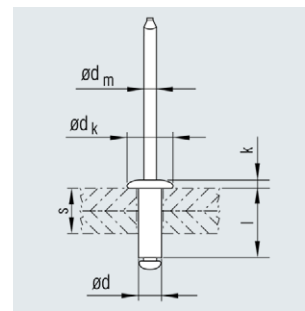
Material



Sleeve:
Nickel/copper,
70/30 alloy, galvanised



Mandrel:
Steel, galvanised



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 1.0 - 0.2$ [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k ± 0.3 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
2.8	2.9 - 3.0	0.5 - 1.8	5.0	4.9	0.65	1.8	950	1000	424 400 000
		1.8 - 2.3	5.5	4.9	0.65	1.8	950	1000	424 401 000
3.2	3.3 - 3.4	0.5 - 1.8	5.0	6.0	0.85	1.9	1100	1200	424 410 000
		1.8 - 3.1	6.2	6.0	0.85	1.9	1100	1200	424 411 000
		3.1 - 4.3	7.5	6.0	0.85	1.9	1100	1200	424 412 000
		4.3 - 5.8	9.0	6.0	0.85	1.9	1100	1200	424 413 000
		5.8 - 7.1	10.3	6.0	0.85	1.9	1100	1200	424 414 000
4.0	4.1 - 4.2	1.3 - 2.5	6.2	6.8	1.20	2.3	2200	3000	424 420 000
		2.5 - 4.1	7.8	6.8	1.20	2.3	2200	3000	424 421 000
		4.1 - 5.8	9.5	6.8	1.20	2.3	2200	3000	424 423 000
		5.8 - 6.6	10.3	6.8	1.20	2.3	2200	3000	424 424 000
		6.6 - 7.9	11.5	6.8	1.20	2.3	2200	3000	424 425 000
4.8	4.9 - 5.0	2.3 - 3.8	7.7	6.8	1.30	2.9	3300	3750	424 430 000
		3.8 - 5.1	9.3	8.1	1.30	2.9	3300	3750	424 431 000
		5.1 - 5.8	10.0	8.1	1.30	2.9	3300	3750	424 432 000
		5.8 - 8.6	12.8	8.1	1.30	2.9	3300	3750	424 433 000
		8.6 - 12.5	16.5	8.1	1.30	2.9	3300	3750	424 434 000
		12.5 - 15.0	19.0	8.1	1.30	2.9	3300	3750	424 435 000
6.4	6.5 - 6.6	4.0 - 7.6	12.8	10.8	1.60	3.9	5400	6750	424 440 000
		8.4 - 13.5	18.0	10.8	1.60	3.9	5400	6750	424 441 000

* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in TIFAS® blind rivets is equivalent to Monel®.

TIFAS® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

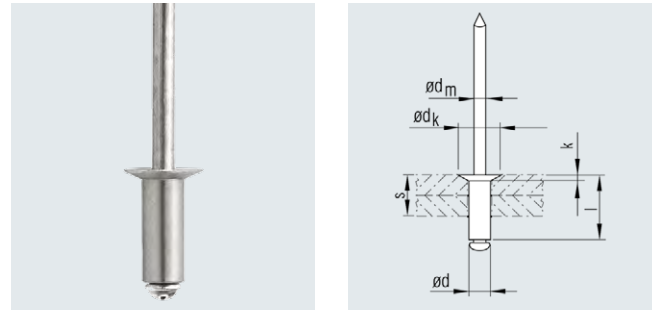
Other designs available on request.

TIFAS® blind rivets

Countersunk 120°

Material

	
Sleeve:	Mandrel:
Nickel/copper, 70/30 alloy, galvanised	Steel, galvanised



Nominal ø d [mm]	Bore ø [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel ø dm nom. [mm]	Nominal strength at break		Article No.
				ø dk ±0.3 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
2.8	2.9 - 3.0	2.3 - 2.8	6.0	5.0	1.0	1.8	950	1000	424 451 000
3.2	3.3 - 3.4	0.8 - 2.5	5.8	6.0	1.0	1.9	1100	1200	424 460 000
		2.5 - 3.8	7.0	6.0	1.0	1.9	1100	1200	424 461 000
		3.8 - 5.1	8.5	6.0	1.0	1.9	1100	1200	424 462 000
		5.1 - 6.6	10.0	6.0	1.0	1.9	1100	1200	424 463 000
		6.6 - 7.9	11.2	6.0	1.0	1.9	1100	1200	424 464 000
4.0	4.1 - 4.2	2.0 - 3.3	7.2	6.9	1.1	2.3	2200	3000	424 470 000
		3.3 - 4.8	8.7	6.9	1.1	2.3	2200	3000	424 471 000
		4.8 - 6.6	10.5	6.9	1.1	2.3	2200	3000	424 472 000
		6.6 - 7.4	11.3	6.9	1.1	2.3	2200	3000	424 473 000
4.8	4.9 - 5.0	3.1 - 4.6	9.0	8.3	1.3	2.9	3300	3750	424 480 000
		4.6 - 5.8	10.5	8.3	1.3	2.9	3300	3750	424 481 000
		5.8 - 6.6	11.0	8.3	1.3	2.9	3300	3750	424 482 000
		6.6 - 9.4	14.0	8.3	1.3	2.9	3300	3750	424 483 000
		9.4 - 13.2	18.0	8.3	1.3	2.9	3300	3750	424 484 000
		13.2 - 15.8	20.5	8.3	1.3	2.9	3300	3750	424 485 000
6.4	6.6 - 6.7	4.6 - 8.4	14.5	11.0	1.8	3.9	5400	6750	424 490 000
		8.4 - 13.5	19.4	11.0	1.8	3.9	5400	6750	424 491 000

* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in TIFAS® blind rivets is equivalent to Monel®.

TIFAS® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

Other designs available on request.

TIFAS® blind rivets

Truss head

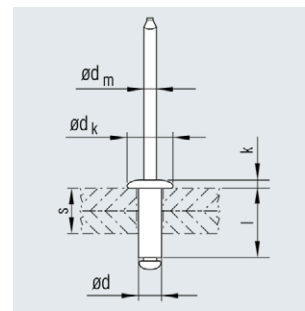
Material



Sleeve:
Nickel/copper,
70/30 alloy, galvanised



Mandrel:
Stainless steel 1.4303



Nominal Ø d [mm]	Bore Ø [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel Ø d _m max. [mm]	Nominal strength at break		Article No.
				Ø d _k ±0.3 [mm]	Height k ±0.2 [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	0.5 - 3.1	5.0	6.0	0.85	1.9	1100	1200	424 500 000
		1.8 - 3.1	6.2	6.0	0.85	1.9	1100	1200	424 501 000
		3.1 - 4.3	7.5	6.0	0.85	1.9	1100	1200	424 502 000
		4.3 - 5.8	9.0	6.0	0.85	1.9	1100	1200	424 503 000
		5.8 - 7.1	10.3	6.0	0.85	1.9	1100	1200	424 504 000
4.0	4.1 - 4.2	1.3 - 2.5	6.2	6.7	1.20	2.3	2200	3000	424 510 000
		2.5 - 4.1	7.8	6.7	1.20	2.3	2200	3000	424 511 000
		4.1 - 5.9	9.5	6.7	1.20	2.3	2200	3000	424 512 000
		5.8 - 6.6	10.3	6.7	1.20	2.3	2200	3000	424 513 000
		6.6 - 7.9	11.5	6.7	1.20	2.3	2200	3000	424 514 000
4.8	4.9 - 5.0	2.3 - 3.8	7.7	8.1	1.30	2.9	3300	3750	424 520 000
		5.8 - 6.6	11.0	8.1	1.30	2.9	3300	3750	424 521 000
		5.1 - 5.8	10.0	8.1	1.30	2.9	3300	3750	424 522 000
		5.8 - 8.6	12.8	8.1	1.30	2.9	3300	3750	424 523 000
		8.6 - 12.5	16.5	8.1	1.30	2.9	3300	3750	424 524 000
		12.5 - 15.0	19.0	8.1	1.30	2.9	3300	3750	424 525 000
		15.0 - 17.5	21.7	8.1	1.30	2.9	3300	3750	424 526 000

* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in TIFAS® blind rivets is equivalent to Monel®.

TIFAS® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

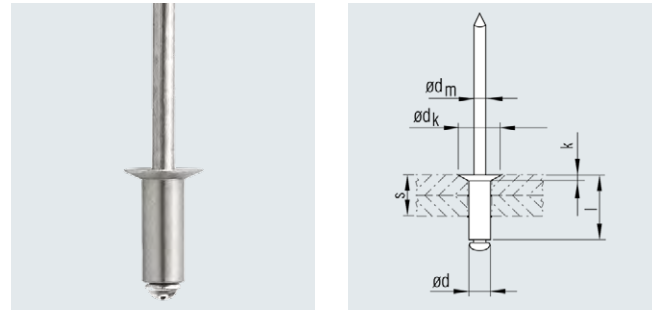
Other designs available on request.

TIFAS® blind rivets

Countersunk 120°

Material

	
Sleeve:	Mandrel:
Nickel/copper, 70/30 alloy, galvanised	Stainless steel 1.4303



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k ±0.3 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.2	3.3 - 3.4	0.8 - 2.5	5.8	6.0	1.0	1.9	1100	1200	424 530 000
		2.5 - 3.8	7.0	6.0	1.0	1.9	1100	1200	424 531 000
		3.8 - 5.1	8.5	6.0	1.0	1.9	1100	1200	424 532 000
		5.1 - 6.6	10.0	6.0	1.0	1.9	1100	1200	424 533 000
		6.6 - 7.9	11.2	6.0	1.0	1.9	1100	1200	424 534 000
4.0	4.1 - 4.2	2.0 - 3.3	7.2	6.9	1.1	2.3	2200	3000	424 540 000
		3.3 - 4.8	8.7	6.9	1.1	2.3	2200	3000	424 541 000
		4.8 - 6.6	10.5	6.9	1.1	2.3	2200	3000	424 542 000
		6.6 - 7.4	11.2	6.9	1.1	2.3	2200	3000	424 543 000

* Strengths at break relate to rivet failure.

The 70/30 nickel/copper alloy used in TIFAS® blind rivets is equivalent to Monel®.

TIFAS® standard open sleeves made of 70/30 nickel/copper alloy are additionally galvanised to further enhance the products' resistance.

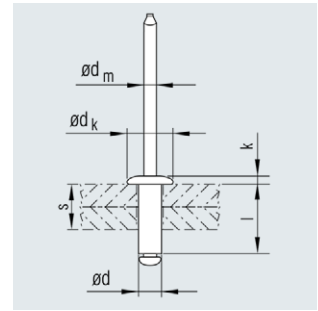
Other designs available on request.

TIFAS® blind rivets

Truss head with grooved mandrel

Material

Sleeve: Stainless steel 1.4303
Mandrel: Stainless steel A2



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head $\varnothing$ dk +0.5/-1.0 [mm]	Height k max. [mm]	Mandrel $\varnothing$ dm nom. [mm]	Nominal strength at break		Article No.
							Shear	Tensile	
3.0	3.1 - 3.2	1.0 - 3.0	6.0	6.5	1.0	2.0	1800	2200	427 110 907
		3.0 - 5.0	8.0	6.5	1.0	2.0	1800	2200	427 111 907
		5.0 - 6.5	10.0	6.5	1.0	2.0	1800	2200	427 112 907
		6.5 - 8.5	12.0	6.5	1.0	2.0	1800	2200	427 113 907
		9.0 - 12.0	15.0	6.5	1.0	2.0	1800	2200	427 114 907
3.2	3.3 - 3.4	1.5 - 3.0	6.0	6.5	1.0	2.0	1900	2500	427 121 907
		3.0 - 5.0	8.0	6.5	1.0	2.0	1900	2500	427 122 907
		5.0 - 6.5	10.0	6.5	1.0	2.0	1900	2500	427 123 907
		6.5 - 8.5	12.0	6.5	1.0	2.0	1900	2500	427 124 907
		8.5 - 10.5	14.0	6.5	1.0	2.0	1900	2500	427 125 907
		10.5 - 12.5	16.0	6.5	1.0	2.0	1900	2500	427 126 907
4.0	4.1 - 4.2	1.0 - 2.5	6.0	8.0	1.3	2.5	2700	3500	427 129 907
		2.5 - 4.5	8.0	8.0	1.3	2.5	2700	3500	427 131 907
		4.5 - 6.5	10.0	8.0	1.3	2.5	2700	3500	427 132 907
		6.5 - 8.5	12.0	8.0	1.3	2.5	2700	3500	427 133 907
		8.5 - 10.0	14.0	8.0	1.3	2.5	2700	3500	427 134 907
		10.0 - 12.0	16.0	8.0	1.3	2.5	2700	3500	427 136 907
		12.0 - 14.0	18.0	8.0	1.3	2.5	2700	3500	427 137 907
		14.0 - 16.0	20.0	8.0	1.3	2.5	2700	3500	427 138 907
4.8	4.9 - 5.0	2.5 - 4.0	8.0	9.5	1.4	2.9	4000	5000	427 139 907
		4.0 - 6.0	10.0	9.5	1.4	2.9	4000	5000	427 140 907
		6.0 - 8.0	12.0	9.5	1.4	2.9	4000	5000	427 141 907
		8.0 - 9.5	14.0	9.5	1.4	2.9	4000	5000	427 192 907
		9.5 - 11.0	16.0	9.5	1.4	2.9	4000	5000	427 143 907
		11.0 - 13.0	18.0	9.5	1.4	2.9	4000	5000	427 194 907
		13.0 - 15.0	20.0	9.5	1.4	2.9	4000	5000	427 145 907
		15.0 - 17.0	22.0	9.5	1.4	2.9	4000	5000	427 195 907
		17.0 - 20.0	25.0	9.5	1.4	2.9	4000	5000	427 146 907
		20.0 - 25.0	30.0	9.5	1.4	2.9	4000	5000	427 148 907
5.0	5.1 - 5.2	2.5 - 4.0	8.0	9.5	1.4	2.9	4700	5800	427 149 907
		4.0 - 6.0	10.0	9.5	1.4	2.9	4700	5800	427 150 907
		6.0 - 8.0	12.0	9.5	1.4	2.9	4700	5800	427 151 907
		8.0 - 9.5	14.0	9.5	1.4	2.9	4700	5800	427 196 907
		9.5 - 11.0	16.0	9.5	1.4	2.9	4700	5800	427 152 907

Continued on next page

Cont'd

Nominal Ø d [mm]	Bore Ø [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head Ø dk +0.5/-1.0 [mm]	Height k max. [mm]	Mandrel Ø dm nom. [mm]	Nominal strength at break		Article No.
							Shear [N]	Tensile [N]	
6.4	6.5 - 6.6	4.0 - 6.0	12.0	13.0	2.2	2.9	7500	9300	427 153 907
		6.0 - 9.0	15.0	13.0	2.2	2.9	7500	9300	427 154 907
		9.0 - 12.0	18.0	13.0	2.2	2.9	7500	9300	427 155 907
		12.0 - 14.0	20.0	13.0	2.2	2.9	7500	9300	427 156 907
		14.0 - 19.0	25.0	13.0	2.2	2.9	7500	9300	427 157 907

* Strengths at break relate to rivet failure.

Other designs available on request.

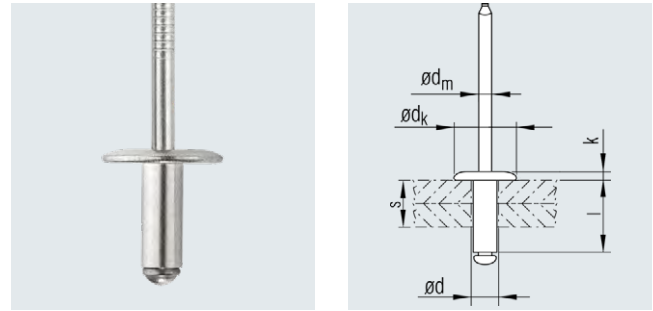
TIFAS® blind rivets

Large truss head with grooved mandrel

Material

Sleeve:
Stainless steel
A2 1.4303

Mandrel:
Stainless steel A2



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve $l \pm 1.0 - 0.2$ [mm]	Blind rivet head		Mandrel $\varnothing$ d_m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ $d_k \pm 0.5 / -1.0$ [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
4.8	4.9	1.5 - 3.0	8.0	14.0	2.1	2.9	4200	5300	427 162 001
		3.0 - 5.0	10.0	14.0	2.1	2.9	4200	5300	427 163 906

* Strengths at break relate to rivet failure.

Other designs available on request.

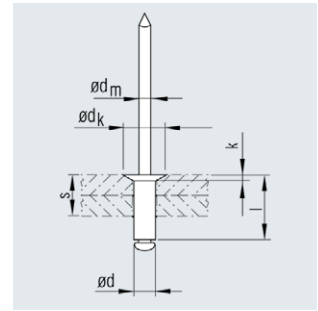
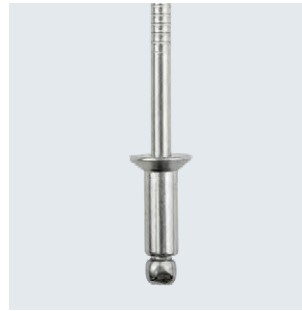
TIFAS® blind rivets

Countersunk 120° with grooved mandrel

Material

Sleeve:
Stainless steel
A2 (1.4301)

Mandrel:
Stainless steel A2



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ dk ±0.5 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.2	3.3	1.5 - 2.5	6	6	1	2	1800	2500	427 170 001
		2.5 - 4.5	8	6	1	2	1800	2500	427 171 001
		4.5 - 6.5	10	6	1	2	1800	2500	427 172 001
		6.5 - 8.5	12	6	1	2	1800	2500	427 173 001
4.0	4.1	0.5 - 2.0	6	7.5	1.2	2.5	3100	3800	427 174 001
		2.0 - 4.0	8	7.5	1.2	2.5	3100	3800	427 175 001
		4.0 - 6.0	10	7.5	1.2	2.5	3100	3800	427 176 001
		6.0 - 8.0	12	7.5	1.2	2.5	3100	3800	427 177 001
4.8	4.9	1.5 - 3.0	8	9	1.2	2.9	4500	6000	427 178 001
		3.0 - 5.0	10	9	1.2	2.9	4500	6000	427 179 001
		5.0 - 7.0	12	9	1.2	2.9	4500	6000	427 180 001
		8.0 - 10.0	15	9	1.2	2.9	4500	6000	427 181 001
		11.0 - 13.0	18	9	1.2	2.9	4500	6000	427 182 001
		14.0 - 16.0	21	9	1.2	2.9	4500	6000	427 183 001
		18.0 - 20.0	25	9	1.2	2.9	4500	6000	427 184 001

* Strengths at break relate to rivet failure.

Other designs available on request.

TIFAS® blind rivets

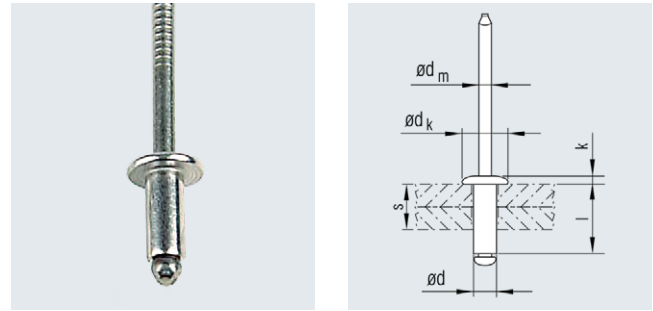
Truss head with grooved mandrel

Material

Sleeve: Stainless steel A4
Mandrel: Stainless steel A4



Extra-high corrosion resistance



Nominal $\varnothing$ d [mm]	Bore $\varnothing$ [mm]	Grip range s [mm]	Blind sleeve l +1.0 -0.2 [mm]	Blind rivet head		Mandrel $\varnothing$ d _m nom. [mm]	Nominal strength at break		Article No.
				$\varnothing$ d _k +0.5/-1.0 [mm]	Height k max. [mm]		Shear [N]	Tensile [N]	
3.0	3.1	1.5 - 2.5	6.0	6.5	1.0	1.9	1600	2000	427 011 000
3.2	3.3	1.5 - 2.5	6.0	6.5	1.0	2.0	1800	2500	427 021 000
		2.5 - 4.5	8.0	6.5	1.0	2.0	1800	2500	427 022 000
4.0	4.1	0.5 - 2.0	6.0	8.0	1.3	2.5	3100	3800	427 220 001
		2.0 - 4.0	8.0	8.0	1.3	2.5	3100	3800	427 221 001
		4.0 - 6.0	10.0	8.0	1.3	2.5	3100	3800	427 222 001
4.8	4.9	1.5 - 3.0	8.0	9.5	1.4	2.9	4500	6000	427 042 000
		5.0 - 7.0	12.0	9.5	1.4	2.9	4500	6000	427 232 001
		7.0 - 9.0	14.0	9.5	1.4	2.9	4500	6000	427 233 001
		11.0 - 13.0	18.0	9.5	1.4	2.9	4500	6000	427 235 001

* Strengths at break relate to rivet failure.

Other designs available on request.

About us

Titgemeyer Group is a leading fastening technology and transport technology group of companies with 15 sites across Europe. Steeped in tradition, the company develops, manufactures and sells more than 30,000 fastening elements, tools and vehicle components – in series and to customer specification.

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