

Plated Steel Body
Plated Steel Mandrel



Steel Q-Lok™ Rivets

AFS Part No.	D Rivet Dia. Nom. Inch (mm)	Drill No. & Hole Size (mm)	H Head Dia. Nom. Inch (mm)	E Head Height Max. Inch (mm)	L Rivet Length Max. Inch (mm)	Grip Range		Typical Ultimate Strength (Lbs.) (newtons)	
						Inch	(mm)	Shear	Tensile
SB4-2QL	1/8"(.125)	#30(.129-.133)	.250	.045	.300 7.6	.062-.125	1.6-3.2	500	400
SB4-4QL	3.2	3.3(3.28-3.38)	6.40	1.20	.425 10.8	.126-.250	3.3-6.4	2220	1780
SB5-2QL	5/32*(.156)	#20(.160-.164)	.312	.055	.325 8.3	.062-.125	1.6-3.2	700	550
SB5-4QL	4.0	4.1(4.06-4.16)	7.9	1.40	.450 11.4	.126-.250	3.3-6.4	3110	2440
SB6-2QL	3/16*(.187)	#11(.192-.196)	.375	.065	.350 8.9	.062-.125	1.6-3.2	1050	825
SB6-4QL	4.8	4.9(4.88-4.98)	9.5	1.65	.475 12.0	.126-.250	3.3-6.4	4670	3670
SB6-6QL					.600 15.2	.251-.375	6.5-9.5		
SB6-8QL					.725 18.4	.376-.500	9.6-12.7		

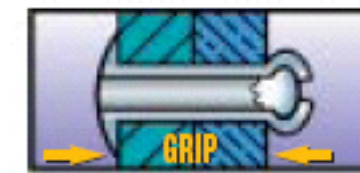
Design Information

Rivet Code Definitions

Example: ABL6-6A	A — First Letter	Rivet material (A - Aluminum, S - Steel, C - Copper, SS - Stainless Steel)
	B — Second Letter	Style of Head (B - Buttonhead, C - Countersunk)
	L — Third Letter (if any)	Large Flange Head
	6 — First Number	Body Diameter in 32nd's
	6 — Second Number	Maximum Grip Length in 16th's
	A — Final Letter (S).....	A - Aluminum Mandrel, S - Stainless Steel Mandrel, B - Brass Mandrel, C - Copper Plated Steel Mandrel, CLD - Closed-End, MG - Multi-Grip, QL - Q-Lok, KL - Klik-Lok. No letter indicates steel mandrel.

Design Information

- The shear and tensile strength of the rivet selected and the number of rivets used in the application should equal or exceed the joint strength requirements. Typical ultimate shear and tensile strengths are listed by diameter and alloy on pages 5 through 16 of this catalog. Testing is recommended before final selection and use in product.
- The rivet body material should be compatible with the materials to be joined to resist galvanic corrosion which may result in reduction of joint strength. If dissimilar materials are widely separated on the galvanic chart, it is advisable to separate them with a dielectric material such as paint or other coating. AFS can paint colors to match, as well as anodize or plate to your specifications.
- After determination of strengths required by diameter and alloy, the total thickness of materials to be joined must be considered. The grip range for each rivet is listed on pages 5 through 16. Select the rivet grip range which includes the total thickness of materials to be joined. Please note that the rivet barrel length (Column L) is not the grip range.
- Recommended hole sizes listed for each rivet diameter on pages 5 through 16 should be followed closely. An undersize hole will not allow insertion of the rivet body; an oversize hole will reduce shear and tensile strengths, and may cause improper rivet setting, all of which promote joint failure.
- The various head styles (illustrated page 3) are offered to accommodate different assembly needs. The most popular Klik-Fast rivet is the buttonhead, whose lower-profile head is twice the diameter of the rivet body. This provides adequate bearing surface for nearly all applications. The large flange Klik-Fast rivet provides greater bearing surface for fastening soft or brittle facing materials. The countersunk Klik-Fast rivet is available for applications where a flush appearance is required. And the closed-end is ideal for electric or electronics applications.
- Besides the sizes, alloys and head styles listed, AFS manufactures a wide range of special rivets to accommodate a variety of customer needs for strength, head style and grip range. You are invited to send your applications questions or problems to Stoughton Operations for evaluation, testing and recommendations.
 - Samples are available upon request.
 - Special packaging needs are quickly and easily met.



Design Information

To install

- Insert rivet mandrel in rivet setting tool.
- Using tool as a guide, insert rivet into prepared hole.
- Or insert rivet into prepared hole and then engage the mandrel with rivet-setting tool. Squeeze trigger or handles to set rivet. Mandrel ejects after rivet is set.

Features, benefits & applications

