

## Minimum Ultimate Tensile Strength

| Nominal Rivet Diameter | Nominal Diameter   |                                    | Oversize Diameter  |                                    |
|------------------------|--|------------------------------------|--|------------------------------------|
|                        | Alum/Steel   | Monel/A286                         | Alum/Steel   | Monel/A286                         |
|                        | HR3212-NAS9302B<br>HR3213-NAS9301B<br>HR3222-NAS9302E (1)<br>HR3223-NAS9301E (1) | HR3522-NAS9308M<br>HR3523-NAS9307M | HR3242-NAS9305B<br>HR3243-NAS9304B<br>HR3252-NAS9305E (1)<br>HR3253-NAS9304E (1) | HR3552-NAS9311M<br>HR3553-NAS9310M |
| 1/8 (-4)               | 285  | 400                                | 345  | 490                                |
| 5/32 (-5)              | 445  | 635                                | 530  | 740                                |
| 3/16 (-6)              | 635  | 890                                | 710  | 1000                               |

(1) Indicates fasteners have A-286 CRES spindles.

## Minimum Single Shear Strength

| Minimum Rivet Single Shear in Pounds (2) |  |  |  |  |                                     |                    |                                      |                    |
|--|--|--|--|--|-------------------------------------|--------------------|--------------------------------------|--------------------|
| Nom. Rivet Dia.                          | Nominal Diameter Aluminum Blind Rivets   |  | Oversize Diameter Aluminum Blind Rivets  |  | Nominal Diameter Monel Blind Rivets |                    | Oversize Diameter Monel Blind Rivets |                    |
|  | Flush Head                               | Protruding Head                          | Flush Head                               | Protruding Head                          | Flush Head                          | Protruding Head    | Flush Head                           | Protruding Head    |
|  | HR3212<br>HR3222<br>NAS9302B<br>NAS9302E | HR3213<br>HR3223<br>NAS9301B<br>NAS9301E | HR3242<br>HR3252<br>NAS9305B<br>NAS9305E | HR3243<br>HR3253<br>NAS9304B<br>NAS9304E | HR3522<br>NAS9308M                  | HR3523<br>NAS9307M | HR3552<br>NAS9311M                   | HR3553<br>NAS9310M |
| 1/8                                      | 664                                      | 664                                      | 814                                      | 814                                      | 995                                 | 995                | 1220                                 | 1220               |
| 5/32                                     | 1030                                     | 1030                                     | 1245                                     | 1245                                     | 1545                                | 1545               | 1865                                 | 1865               |
| 3/16                                     | 1480                                     | 1480                                     | 1685                                     | 1685                                     | 2215                                | 2215               | 2525                                 | 2525               |

(2) Shear values for shorter rivets are lower commensurate with sheet bearing strength.

## Sheet Take-up Capability

The HuckMAX® blind rivet system has gap closing capabilities detailed in the table below.

| Nominal Rivet Diameter | Sheet Gap | Force resisting Gap Closure |               |
|------------------------|-----------|-----------------------------|---------------|
|                        |           | Nominal Dia.                | Oversize Dia. |
| 1/8 (-4)               | .010"     | 15 lbs.                     | 20 lbs.       |
| 5/32 (-5)              | .015"     | 30 lbs.                     | 35 lbs.       |
| 3/16 (-6)              | .020"     | 50 lbs.                     | 60 lbs.       |

## Thin Sheet Pull-Through

The HuckMAX® system exceeds the M7885 thin sheet requirements shown in the table below.

| Nominal Rivet Diameter | Sheet Thickness | Thin 2024-T3 Sheet Pull-Through Strength |               |
|------------------------|-----------------|--|---------------|
|                        |                 | Nominal Dia.                             | Oversize Dia. |
| 1/8 (-4)               | .025"           | 160 lbs.                                 | 180 lbs.      |
| 5/32 (-5)              | .032"           | 220 lbs.                                 | 260 lbs.      |
| 3/16 (-6)              | .040"           | 315 lbs.                                 | 375 lbs.      |

## Spindle Retention

| All Blind Rivet Styles, Nominal and Oversize Diameters |                 |              |
|--|-----------------|--------------|
| Nominal Rivet Diameter                                 | Aluminum Rivets | Monel Rivets |
| 1/8 (-4)   | 125             | 150          |
| 5/32 (-5)  | 200             | 250          |
| 3/16 (-6)  | 290             | 450          |