



FASTEKS® Speed rivets

Economically and efficiently connecting

The center of excellence for high-performance fastening technology

KVT-Fastening is an expert for high-quality fastening applications and offers engineering solutions based on the wide product portfolio of the leading manufacturers in the market.



Mechanical engineering | Automotive | Electrical engineering | Energy | Precision engineering | Fluid power | Transportation | Off-shore and Marine | Medical equipment
Aviation and aerospace | Construction industry | Watch manufacturing industry

www.kvt-fastening.com



High-performance solutions from KVT-Fastening are found wherever absolutely safe and secure connections are essential. These small but extremely resilient components play key roles where it matters most – whether in the electronics and energy sector, the automotive and transportation industries, aviation and aerospace, engineering and construction, precision engineering, or medical equipment.

KVT-Fastening does not just supply standard products and individual components, but also provides close and active customer support in the search for ideal solutions, particularly when specific requirements must be fulfilled. This portfolio is complemented by a range of innovative tools and

machines as well as, if needed, the integration into automated serial production workflows.

Ever since 1927, KVT-Fastening has stood for experience, solution-driven know-how, unique expertise in development and consultancy as well as the ultimate in reliability. Since December 2012, KVT-Fastening is a member of the Bossard Group. Bossard is a leading provider of intelligent solutions for industrial fastening technology. The range includes global sales, technical consulting (engineering) and logistics of fastening technology components and bolts. Customers benefit from the extension of competencies in industrial fastening technology and from an optimally enhanced product or service portfolio.



Optimal fastening, increased lifespan

In all branches of industry, more and more small and mid-sized series must be produced efficiently. With the FASTEKS® speed rivet system, we offer the perfect solution. This system allows an extremely precise and economical installation with relatively low investment costs.

The **Fixriv**, with its large secondary expansion, provides a high clamping force and, along with the hole filling, ensures a good shear performance as well as excellent vibration resistance.

The **Fixsho** is particularly well-suited for fastening soft and brittle materials.

The **Fixscrew** is used for fastening components that must be removable.

Advantages

- Secure installation of rivet types
- High product safety
- Quick reloading of the magazined speed rivets
- No mandrel rest to fall off
- High rivet performance

More about FASTEKS®

www.kvt-fastening.de/en/products/brands/fasteks



Content

Speed rivets Fixriv

Domed head and countersunk head

Material aluminum 6 – 7

Material zinc-plated steel 8 – 9

Material brass 10 – 11

Material stainless steel 12 – 13

Speed rivets Fixsho

Domed head

Material aluminum 14

Material zinc-plated steel 15

Material brass 16

Material stainless steel 17

Speed rivets Fixscrew

Domed head

Material zinc-plated steel 18

Mandrel and spring 19

Nose pieces and return stop 20

Tools 21

Installation 22

Technical performances, installation recommendations as well as unspecified tolerances regarding the dimensions of the parts have to be requested individual for each application before starting the series production.

All dimensions are specified in mm.

Speed rivets

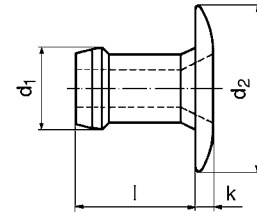
Domed head


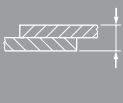


Type Fixriv

Material

Aluminum

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_{2 max.}$	Rivets per pot	 N	 N	Order description
2.4 (2.35 max.)	2.36 – 2.44	1.14 – 2.42	3.98	0.89	4.30	64	266	444	ADF-0304
		2.15 – 3.43	5.00			52			ADF-0306
		3.17 – 4.45	6.02			44			ADF-0308
3.2 (3.14 max.)	3.26 – 3.34	0.64 – 1.91	3.86	0.99	6.60	59	756	1.312	ADF-0403
		1.14 – 2.42	4.37			58			ADF-0404
		1.65 – 2.87	4.87			50			ADF-0405
		2.15 – 3.43	5.39			48			ADF-0406
		3.17 – 4.45	6.41			42			ADF-0408
		4.19 – 5.47	7.42			37			ADF-0410
		5.20 – 6.48	8.44			33			ADF-0412
		6.22 – 7.50	9.45			29			ADF-0414
		4.0 (3.88 max.)	3.97 – 4.04			1.57 – 2.93			4.91
2.66 – 3.94	5.92			44	ADF-0507				
3.68 – 4.96	6.94			39	ADF-0509				
4.69 – 5.97	7.95			34	ADF-0511				
5.71 – 6.99	8.97			31	ADF-0513				
6.73 – 8.00	9.98			26	ADF-0515				
4.8 (4.77 max.)	4.85 – 4.93	1.65 – 3.30	5.39	1.17	9.80	46	1.512	2.240	ADF-0606
		2.03 – 3.94	6.10			42			ADF-0607
		3.68 – 5.21	7.37			35			ADF-0609
		4.95 – 6.48	8.64			31			ADF-0611
		6.22 – 7.75	9.91			27			ADF-0613
		7.49 – 9.02	11.18			24			ADF-0615
		8.76 – 10.29	12.45			22			ADF-0617
10.03 – 11.56	13.46	20	ADF-0619						

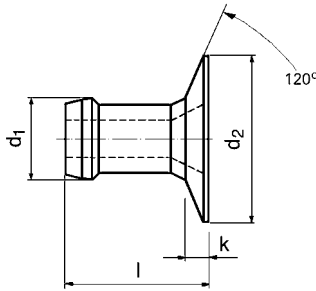
Speed rivets

Countersunk head

Type Fixriv

Material
Aluminum

Additional types on request



d ₁ nom.			l _{max.}	k _{max.}	d ₂ max.	Rivets per pot	N	N	Order description
3.2 (3.17 max.)	3.26 – 3.34	1.45 – 1.70	4.19	0.74	5.50	72	756	1.312	ACF-0404
		1.27 – 2.29	4.32	0.69		72			ACF-0405
		1.52 – 2.79	4.77	0.76		64			ACF-0406
		2.54 – 3.81	5.79			52			ACF-0407
		3.56 – 4.83	6.81			44			ACF-0408
		4.57 – 5.84	7.82			38			ACF-0410
		5.59 – 6.86	8.84			33			ACF-0411
4.0 (3.90 max.)	3.97 – 4.04	1.57 – 2.93	5.18	1.02	6.50	59	1.134	1.734	ACF-0505
		2.15 – 3.43	5.69			54			ACF-0506
		2.66 – 3.94	6.19			49			ACF-0507
		3.68 – 4.96	7.21			42			ACF-0509
		4.69 – 5.97	8.22			36			ACF-0511
		5.71 – 5.99	9.24			32			ACF-0513

Speed rivets

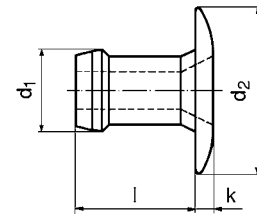
Domed head

Type Fixriv

Material

Zinc-plated steel

Additional types on request



d_1 nom.		$l_{max.}$	$k_{max.}$	$d_{2 max.}$	Rivets per pot			Order description
						N	N	
2.4 (2.35 max.)	2.36 – 2.44	1.14 – 2.42	3.98	0.89	64	355	533	SDF-0304
		2.15 – 3.43	5.00		52			SDF-0306
		3.17 – 4.45	6.02		44			SDF-0308
3.2 (3.14 max.)	3.26 – 3.34	0.64 – 1.91	3.86	0.99	59	1.134	1.832	SDF-0403
		1.14 – 2.42	4.37		58			SDF-0404
		1.65 – 2.87	4.87		50			SDF-0405
		2.15 – 3.43	5.39		48			SDF-0406
		3.17 – 4.45	6.41		42			SDF-0408
		4.19 – 5.47	7.42		37			SDF-0410
		5.20 – 6.48	8.44		33			SDF-0412
		6.22 – 7.50	9.45		29			SDF-0414
		4.0 (3.88 max.)	3.97 – 4.04		1.57 – 2.93			4.91
2.66 – 3.94	5.92			44	SDF-0507			
3.68 – 4.96	6.94			39	SDF-0509			
4.69 – 5.97	7.95			34	SDF-0511			
5.71 – 6.99	8.97			31	SDF-0513			
6.73 – 8.00	9.98			26	SDF-0515			
4.8 (4.77 max.)	4.85 – 4.93	1.65 – 3.30	5.39	1.17	46	2.246	3.714	SDF-0606
		2.03 – 3.94	6.10		42			SDF-0607
		3.68 – 5.21	7.37		35			SDF-0609
		4.95 – 6.48	8.64		31			SDF-0611
		6.22 – 7.75	9.91		27			SDF-0613
		7.49 – 9.02	11.18		24			SDF-0615
		8.76 – 10.29	12.45		22			SDF-0617
10.03 – 11.56	13.46	20	SDF-0619					

Speed rivets

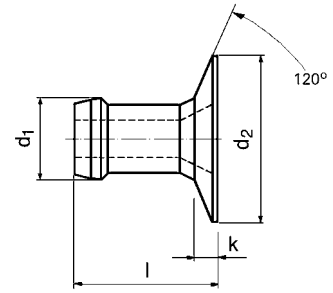
Countersunk head



Type Fixriv

Material

Zinc-plated steel

Additional types on request



d ₁ nom.			l _{max.}	k _{max.}	d ₂ max.	Rivets per pot			Order description
							N	N	
3.2 (3.17 max.)	3.26 – 3.34	1.45 – 1.70	4.19	0.74	5.50	72	947	1.646	SCF-0404
		1.27 – 2.29	4.32	0.69		72			SCF-0405
		1.52 – 2.79	4.77	0.76		64			SCF-0406
		2.54 – 3.81	5.79			52			SCF-0407
		3.56 – 4.83	6.81			44			SCF-0408
		4.57 – 5.84	7.82			38			SCF-0410
		5.59 – 6.86	8.84			33			SCF-0411
4.0 (3.90 max.)	3.97 – 4.04	1.57 – 2.93	5.18	1.02	6.50	59	1.645	2.802	SCF-0505
		2.15 – 3.43	5.69			54			SCF-0506
		2.66 – 3.94	6.19			49			SCF-0507
		3.68 – 4.96	7.21			42			SCF-0509
		4.69 – 5.97	8.22			36			SCF-0511
		5.71 – 5.99	9.24			32			SCF-0513

Speed rivets

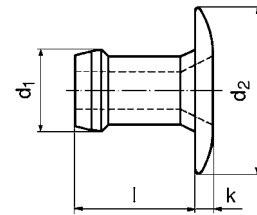
Domed head


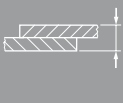


Type Fixriv

Material

Brass

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_{2 max.}$	Rivets per pot			Order description
							N	N	
2.4 (2.35 max.)	2.36 – 2.44	1.14 – 2.42	3.98	0.89	4.30	64	453	889	BDF-0304
		2.15 – 3.43	5.00			52			BDF-0306
		3.17 – 4.45	6.02			44			BDF-0308
3.2 (3.14 max.)	3.26 – 3.34	0.64 – 1.91	3.86	0.99	6.60	59	1.112	1.912	BDF-0403
		1.14 – 2.42	4.37			58			BDF-0404
		1.65 – 2.87	4.87			50			BDF-0405
		2.15 – 3.43	5.39			48			BDF-0406
		3.17 – 4.45	6.41			42			BDF-0408
		4.19 – 5.47	7.42			37			BDF-0410
		5.20 – 6.48	8.44			33			BDF-0412
		6.22 – 7.50	9.45			29			BDF-0414
		4.0 (3.88 max.)	3.97 – 4.04			1.57 – 2.93			4.91
2.66 – 3.94	5.92			44	BDF-0507				
3.68 – 4.96	6.94			39	BDF-0509				
4.69 – 5.97	7.95			34	BDF-0511				
5.71 – 6.99	8.97			31	BDF-0513				
6.73 – 8.00	9.98			26	BDF-0515				
4.8 (4.77 max.)	4.85 – 4.93	1.65 – 3.30	5.39	1.17	9.80	46	2.312	3.602	BDF-0606
		2.03 – 3.94	6.10			42			BDF-0607
		3.68 – 5.21	7.37			35			BDF-0609
		4.95 – 6.48	8.64			31			BDF-0611
		6.22 – 7.75	9.91			27			BDF-0613
		7.49 – 9.02	11.18			24			BDF-0615
		8.76 – 10.29	12.45			22			BDF-0617
10.03 – 11.56	13.46	20	BDF-0619						

Speed rivets

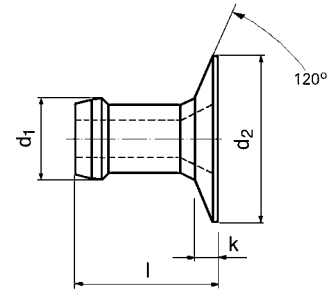
Countersunk head


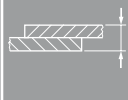

Type Fixriv

Material

Brass

Additional types on request



d ₁ nom.			l _{max.}	k _{max.}	d ₂ max.	Rivets per pot			Order description
3.2 (3.17 max.)	3.26 – 3.34	1.45 – 1.70	4.19	0.74	5.50	72	N/A	N/A	BCF-0404
		1.27 – 2.29	4.32	0.69		72			BCF-0405
		1.52 – 2.79	4.77	0.76		64			BCF-0406
		2.54 – 3.81	5.79			52			BCF-0407
		3.56 – 4.83	6.81			44			BCF-0408
		4.57 – 5.84	7.82			38			BCF-0410
		5.59 – 6.86	8.84			33			BCF-0411
4.0 (3.90 max.)	3.97 – 4.04	1.57 – 2.93	5.18	1.02	6.50	59	N/A	N/A	BCF-0505
		2.15 – 3.43	5.69			54			BCF-0506
		2.66 – 3.94	6.19			49			BCF-0507
		3.68 – 4.96	7.21			42			BCF-0509
		4.69 – 5.97	8.22			36			BCF-0511
		5.71 – 5.99	9.24			32			BCF-0513

Speed rivets

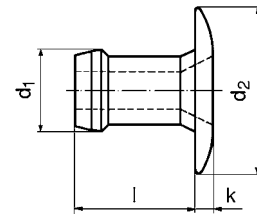
Domed head


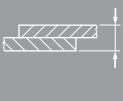


Type Fixriv

Material

Stainless steel

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_2_{max.}$	Rivets per pot	 N	 N	Order description
2.4 (2.35 max.)		1.14 – 2.42	3.98	0.89	4.30	64	N/A	N/A	FDf-0304
		2.15 – 3.43	5.00			52			FDf-0306
		3.17 – 4.45	6.02			44			FDf-0308
3.2 (3.14 max.)		0.64 – 1.91	3.86	0.99	6.60	59	1.300	2.000	FDf-0403
		1.14 – 2.42	4.37			58			FDf-0404
		1.65 – 2.87	4.87			50			FDf-0405
		2.15 – 3.43	5.39			48			FDf-0406
		3.17 – 4.45	6.41			42			FDf-0408
		4.19 – 5.47	7.42			37			FDf-0410
		5.20 – 6.48	8.44			33			FDf-0412
		6.22 – 7.50	9.45			29			FDf-0414
		4.0 (3.88 max.)				1.57 – 2.93			4.91
2.66 – 3.94	5.92			44	FDf-0507				
3.68 – 4.96	6.94			39	FDf-0509				
4.69 – 5.97	7.95			34	FDf-0511				
5.71 – 6.99	8.97			31	FDf-0513				
6.73 – 8.00	9.98			26	FDf-0515				
4.8 (4.77 max.)		1.65 – 3.30	5.39	1.17	9.80	46	3.558	5.114	FDf-0606
		2.03 – 3.94	6.10			42			FDf-0607
		3.68 – 5.21	7.37			35			FDf-0609
		4.95 – 6.48	8.64			31			FDf-0611
		6.22 – 7.75	9.91			27			FDf-0613
		7.49 – 9.02	11.18			24			FDf-0615
		8.76 – 10.29	12.45			22			FDf-0617
		10.03 – 11.56	13.46			20			FDf-0619

Speed rivets

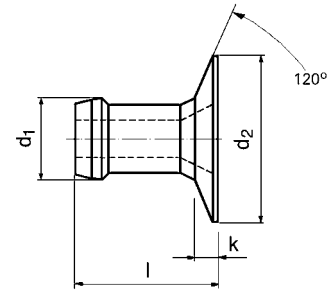
Countersunk head


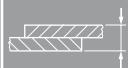



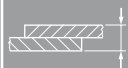

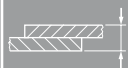
Type Fixriv

Material

Stainless steel

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_{2 max.}$	Rivets per pot			Order description	
3.2 (3.17 max.)			1.45 – 1.70	4.19	0.74	5.50	72	N/A	N/A	FCF-0404
			1.27 – 2.29	4.32	0.69		72			FCF-0405
			1.52 – 2.79	4.77	0.76		64			FCF-0406
			2.54 – 3.81	5.79			52			FCF-0407
			3.56 – 4.83	6.81			44			FCF-0408
			4.57 – 5.84	7.82			38			FCF-0410
			5.59 – 6.86	8.84			33			FCF-0411
4.0 (3.90 max.)			1.57 – 2.93	5.18	1.02	6.50	59	N/A	N/A	FCF-0505
			2.15 – 3.43	5.69			54			FCF-0506
			2.66 – 3.94	6.19			49			FCF-0507
			3.68 – 4.96	7.21			42			FCF-0509
			4.69 – 5.97	8.22			36			FCF-0511
			5.71 – 5.99	9.24			32			FCF-0513

Speed rivets

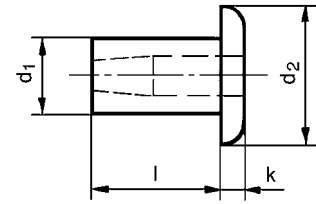
Domed head


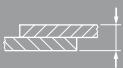


Type Fixsho

Material

Aluminum

Additional types on request



d_1 nom.			l max.	k max.	d_2 max.	Rivets per pot			Order description
2.4 (2.48 max.)	2.49 – 2.55	0.00 – 1.57	3.17	1.0	4.3	73	N/A	N/A	ADFS-0304
		1.57 – 3.17	4.75			52			ADFS-0306
		3.17 – 4.75	6.35			41			ADFS-0308
3.2 (3.27 max.)	3.28 – 3.34	0.00 – 1.57	3.17	1.2	5.5	71	623	1000	ADFS-0404
		1.57 – 3.17	4.75			51			ADFS-0406
		3.17 – 4.75	6.35			39			ADFS-0408
		4.75 – 6.35	7.92			32			ADFS-0410
		6.35 – 7.92	9.52			27			ADFS-0412
4.0 (4.06 max.)	4.09 – 4.16	1.57 – 3.17	4.75	1.5	6.5	47	979	1624	ADFS-0506
		3.17 – 4.75	6.35			38			ADFS-0508
		4.75 – 6.35	7.92			31			ADFS-0510
		6.35 – 7.92	9.52			27			ADFS-0512
		7.92 – 9.52	11.1			23			ADFS-0514
		9.52 – 11.10	12.7			21			ADFS-0516
4.8 (4.82 max.)	4.85 – 4.93	0.00 – 1.57	3.96	1.8	8.9	50	1423	2291	ADFS-0605
		1.57 – 3.17	5.56			38			ADFS-0607
		3.17 – 4.75	7.17			33			ADFS-0609
		4.75 – 6.35	8.74			28			ADFS-0611
		6.35 – 7.92	10.31			24			ADFS-0613
		7.92 – 9.52	11.91			21			ADFS-0615
		9.52 – 11.10	13.49			19			ADFS-0617
11.10 – 12.70	15.09	17	ADFS-0619						

Speed rivets

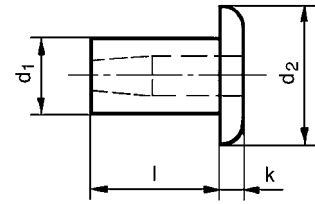
Domed head


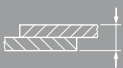


Type Fixsho

Material

Zinc-plated steel

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_2_{max.}$	Rivets per pot			Order description
2.4 (2.48 max.)	2.49 – 2.55	0.00 – 1.57	3.17	1.0	4.3	73	N/A	N/A	SDFS-0304
		1.57 – 3.17	4.75			52			SDFS-0306
		3.17 – 4.75	6.35			41			SDFS-0308
3.2 (3.27 max.)	3.28 – 3.34	0.00 – 1.57	3.17	1.2	5.5	71	1148	1660	SDFS-0404
		1.57 – 3.17	4.75			51			SDFS-0406
		3.17 – 4.75	6.35			39			SDFS-0408
		4.75 – 6.35	7.92			32			SDFS-0410
		6.35 – 7.92	9.52			27			SDFS-0412
4.0 (4.06 max.)	4.09 – 4.16	1.57 – 3.17	4.75	1.5	6.5	47	1926	2891	SDFS-0506
		3.17 – 4.75	6.35			38			SDFS-0508
		4.75 – 6.35	7.92			31			SDFS-0510
		6.35 – 7.92	9.52			27			SDFS-0512
		7.92 – 9.52	11.1			23			SDFS-0514
		9.52 – 11.10	12.7			21			SDFS-0516
4.8 (4.82 max.)	4.85 – 4.93	0.00 – 1.57	3.96	1.8	8.9	50	2615	3790	SDFS-0605
		1.57 – 3.17	5.56			38			SDFS-0607
		3.17 – 4.75	7.17			33			SDFS-0609
		4.75 – 6.35	8.74			28			SDFS-0611
		6.35 – 7.92	10.31			24			SDFS-0613
		7.92 – 9.52	11.91			21			SDFS-0615
		9.52 – 11.10	13.49			19			SDFS-0617
11.10 – 12.70	15.09	17	SDFS-0619						

Speed rivets

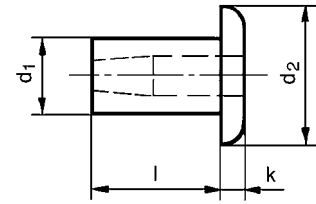
Domed head


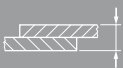


Type Fixsho

Material

Brass

Additional types on request



d_1 nom.			l max.	k max.	d_2 max.	Rivets per pot			Order description
2.4 (2.48 max.)	2.49 – 2.55	0.00 – 1.57	3.17	1.0	4.3	73	N/A	N/A	BDFS-0304
		1.57 – 3.17	4.75			52			BDFS-0306
		3.17 – 4.75	6.35			41			BDFS-0308
3.2 (3.27 max.)	3.28 – 3.34	0.00 – 1.57	3.17	1.2	5.5	71	1.290	N/A	BDFS-0404
		1.57 – 3.17	4.75			51			BDFS-0406
		3.17 – 4.75	6.35			39			BDFS-0408
		4.75 – 6.35	7.92			32			BDFS-0410
		6.35 – 7.92	9.52			27			BDFS-0412
4.0 (4.06 max.)	4.09 – 4.16	1.57 – 3.17	4.75	1.5	6.5	47	1.134	N/A	BDFS-0506
		3.17 – 4.75	6.35			38			BDFS-0508
		4.75 – 6.35	7.92			31			BDFS-0510
		6.35 – 7.92	9.52			27			BDFS-0512
		7.92 – 9.52	11.1			23			BDFS-0514
		9.52 – 11.10	12.7			21			BDFS-0516
4.8 (4.82 max.)	4.85 – 4.93	0.00 – 1.57	3.96	1.8	8.9	50	1.387	N/A	BDFS-0605
		1.57 – 3.17	5.56			38			BDFS-0607
		3.17 – 4.75	7.17			33			BDFS-0609
		4.75 – 6.35	8.74			28			BDFS-0611
		6.35 – 7.92	10.31			24			BDFS-0613
		7.92 – 9.52	11.91			21			BDFS-0615
		9.52 – 11.10	13.49			19			BDFS-0617
		11.10 – 12.70	15.09			17			BDFS-0619

Speed rivets

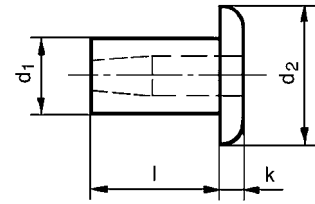
Domed head

Type Fixsho

Material

Stainless steel

Additional types on request



d_1 nom.			$l_{max.}$	$k_{max.}$	$d_2_{max.}$	Rivets per pot	N	N	Order description
2.4 (2.48 max.)	2.49 – 2.55	0.00 – 1.57	3.17	1.0	4.3	73	N/A	N/A	FDFS-0304
		1.57 – 3.17	4.75			52			FDFS-0306
		3.17 – 4.75	6.35			41			FDFS-0308
3.2 (3.27 max.)	3.28 – 3.34	0.00 – 1.57	3.17	1.2	5.5	71	N/A	N/A	FDFS-0404
		1.57 – 3.17	4.75			51			FDFS-0406
		3.17 – 4.75	6.35			39			FDFS-0408
		4.75 – 6.35	7.92			32			FDFS-0410
		6.35 – 7.92	9.52			27			FDFS-0412
4.0 (4.06 max.)	4.09 – 4.16	1.57 – 3.17	4.75	1.5	6.5	47	N/A	N/A	FDFS-0506
		3.17 – 4.75	6.35			38			FDFS-0508
		4.75 – 6.35	7.92			31			FDFS-0510
		6.35 – 7.92	9.52			27			FDFS-0512
		7.92 – 9.52	11.1			23			FDFS-0514
		9.52 – 11.10	12.7			21			FDFS-0516
4.8 (4.82 max.)	4.85 – 4.93	0.00 – 1.57	3.96	1.8	8.9	50	N/A	N/A	FDFS-0605
		1.57 – 3.17	5.56			38			FDFS-0607
		3.17 – 4.75	7.17			33			FDFS-0609
		4.75 – 6.35	8.74			28			FDFS-0611
		6.35 – 7.92	10.31			24			FDFS-0613
		7.92 – 9.52	11.91			21			FDFS-0615
		9.52 – 11.10	13.49			19			FDFS-0617
11.10 – 12.70	15.09	17	FDFS-0619						

Speed rivets

Domed head

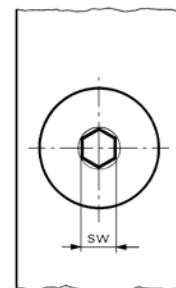
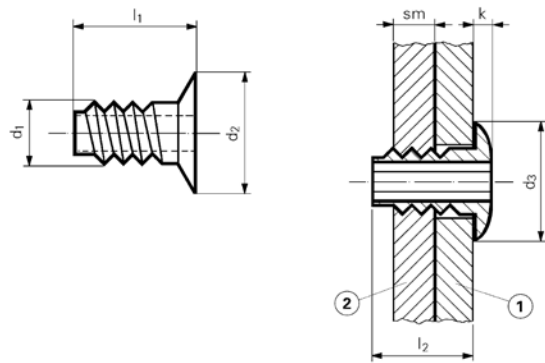
Type Fixscrew

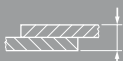


Material

Zinc-plated steel


Can be used in materials with a hardness up to 105 Hv5.

Additional types on request



d ₁ nom.	①	②		sm	l ₁	d ₂	l ₂	d ₃	k	Rivets per pot	sw			Order description
3.0 (2.8 max.)	3.07 – 3.15	2.82 – 2.89	2.85	1.62	5.2	5.7	4.0	6.1	1.4	62	1/16" 1.6	899	800	SDFR-3006
			3.85		6.1		5.0			52				SDFR-3007
			4.83		7.1		6.0			43				SDFR-3009
			5.82		8.1		7.0			38				SDFR-3010
			6.81		9.1		8.0			34				SDFR-3011
			7.80		10.1		9.0			30				SDFR-3012
			10.72		13.1		11.9			23				SDFR-3016
3.5 (3.1 max.)	3.50 – 3.58	3.10 – 3.17	2.85	1.62	5.2	5.8	4.0	6.1	1.4	62	5/64" 2.0	1.000	1.000	SDFR-3506
			3.85		6.1		5.0			52				SDFR-3507
			4.83		7.1		6.1			43				SDFR-3509
			5.82		8.1		7.0			38				SDFR-3510
			6.81		9.1		8.0			34				SDFR-3511
			7.80		10.1		9.0			30				SDFR-3512
			11.76		14.1		12.9			21				SDFR-3517
4.0 (3.6 max.)	4.19	3.61 – 3.68	2.85	1.62	5.2	6.0	4.0	6.4	1.4	62	2.5	1.299	1.201	SDFR-4006
			3.85		6.1		5.0			52				SDFR-4007
			4.83		7.1		6.0			43				SDFR-4009
			5.82		8.1		7.0			38				SDFR-4010
			6.81		9.1		8.0			34				SDFR-4011
			7.80		10.1		9.0			30				SDFR-4012
			9.78		12.1		11.0			25				SDFR-4015

Mandrel and spring

Product	d ₁ nom.		Mandrel type	Color identifier	Dimensions		Order description mandrel	Order description sprint
					Ø Head	Length		
Fixriv Aluminum, zinc-plated steel, brass	2.4	2.36 – 2.44	Standard mandrel, standard length	green	1.83	483	ZRTM-093-S	ZSTS-093
		2.46 – 2.54	Mandrel oversize 1, standard length	yellow	1.93		ZRTM-093-1	
		2.56 – 2.64	Mandrel oversize 2, standard length	blue	2.01		ZRTM-093-2	
	3.2	3.26 – 3.34	Standard mandrel, standard length	green	2.34	483	ZRTM-125-S	ZRTS-125
		3.39 – 3.47	Mandrel oversize 1, standard length	yellow	2.46		ZRTM-125-1	
		3.51 – 3.59	Mandrel oversize 2, standard length	blue	2.59		ZRTM-125-2	
	4.0	3.97 – 4.04	Standard mandrel, standard length	green	2.79	483	ZRTM-156-S	ZRTS-156
		4.10 – 4.17	Mandrel oversize 1, standard length	yellow	2.92		ZRTM-156-1	
		4.22 – 4.29	Mandrel oversize 2, standard length	blue	3.05		ZRTM-156-2	
	4.8	4.85 – 4.93	Standard mandrel, standard length	green	3.58	483	ZRTM-187-S	ZRTS-187
		4.98 – 5.06	Mandrel oversize 1, standard length	yellow	3.71		ZRTM-187-1	
		5.10 – 5.18	Mandrel oversize 2, standard length	blue	3.84		ZRTM-187-2	
5.15 – 5.23		Dornkopf Übermaß 3, Standard Länge	red	3.85	ZRTM-187-3			
Fixriv Stainless steel	All sizes	The correct Fixriv mandrel for your application in stainless steel has to be evaluated by tests.						
Fixsho Aluminum, zinc-plated steel, brass, stainless steel	2.4	2.49 – 2.55	Standard mandrel, standard length	green	1.84	483	ZSTM-093-S	ZRTS-093
		2.53 – 2.59	Mandrel oversize 1, standard length	yellow	1.88		ZSTM-093-1	
		2.58 – 3.04	Mandrel oversize 2, standard length	blue	1.93		ZSTM-093-2	
	3.2	3.28 – 3.34	Standard mandrel, standard length	green	2.24	483	ZSTM-125-S	ZRTS-125
		3.38 – 3.44	Mandrel oversize 1, standard length	yellow	2.34		ZSTM-125-1	
		3.53 – 3.59	Mandrel oversize 2, standard length	blue	2.49		ZSTM-125-2	
	4.0	4.03 – 3.69	Dornkopf Übermaß 3, Standard Länge	red	2.59	483	ZSTM-125-3	ZRTS-156
		4.09 – 4.16	Standard mandrel, standard length	green	2.72		ZSTM-156-S	
		4.29 – 4.36	Mandrel oversize 1, standard length	yellow	2.92		ZSTM-156-1	
	4.8	4.47 – 4.54	Mandrel oversize 2, standard length	blue	3.10	483	ZSTM-156-2	ZRTS-187
		4.72 – 4.79	Dornkopf Übermaß 3, Standard Länge	red	3.35		ZSTM-156-3	
		4.85 – 4.93	Standard mandrel, standard length	green	3.35		ZSTM-187-S	
4.8	5.20 – 5.28	Mandrel oversize 1, standard length	yellow	3.71	483	ZSTM-187-1	ZRTS-187	
	5.45 – 5.53	Mandrel oversize 2, standard length	blue	3.96		ZSTM-187-2		
	5.45 – 5.53	Mandrel oversize 2, standard length	blue	3.96		ZSTM-187-2		
Fixscrew zinc-plated steel	3.0	See information on page 18	Standard mandrel, standard length	green	1.65	483	ZWTM-300-S	ZRTS-300
	3.5		Standard mandrel, standard length	yellow	2.10	483	ZWTM-350-S	ZRTS-350
	4.0		Standard mandrel, standard length	blue	2.62	483	ZWTM-400-S	ZRTS-400

Note: For a standard long nose piece or a curved nose piece, a long mandrel (508 mm) and a long spring are required. For the long size, please add „L” to the part number.



Fixriv mandrel



Fixsho mandrel



Special Fixsho mandrel for tight, short reach installations (please add „SR” to the part number)



Fixscrew mandrel



Spring

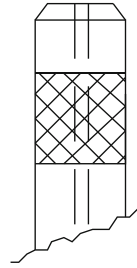


Detailed view of Fixscrew mandrel

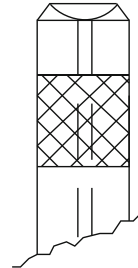
Nose pieces and return stop

The nose piece is an important element of the speed rivet system and must be suitable for the application. Long and curved nose pieces are used in hard to reach or limited access areas, e.g. deep-seated sections or areas close to edge. In addition to the nose pieces illustrated, customized nose pieces to fit your application can be designed.

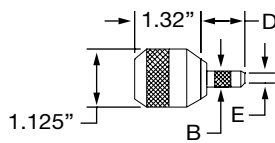
By default, the nose pieces are delivered with a flat end. With the concave end profile higher clamp forces can be achieved for the Fixriv. Contact us for consultation.



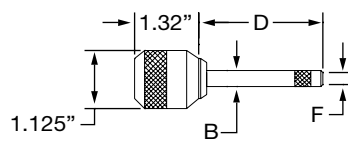
End profile, flat



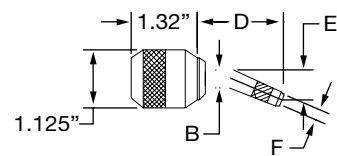
End profile, concave



Standard nose piece



Standard nose piece, long



Nose piece, curved

Nose pieces

d _i nom.	Type	End profile	Dimensions			Order description
			B	D	E	
2.4	Standard	flat	9.14	33.02	4.06	Z-7150-3003
	Standard, long	flat	10.41	58.42	4.06	Z-7150-4003
	curved	flat	10.41	57.91	4.06	Z-7150-5003
3.2	Standard	flat	10.41	29.97	5.08	Z-7150-3004
	Standard, long	flat	10.41	55.37	5.08	Z-7150-4004
	curved	flat	10.41	56.39	5.08	Z-7150-5004
4.0	Standard	flat	22.19	33.02	6.10	Z-7150-3005
	Standard, long	flat	22.19	58.42	6.10	Z-7150-4005
	curved	flat	22.19	56.64	6.10	Z-7150-5005
4.8	Standard	flat	14.22	29.97	8.38	Z-7150-3006
	Standard, long	flat	14.22	58.42	8.38	Z-7150-4006
	curved	flat	14.22	56.13	8.38	Z-7150-5006

Consumable tooling parts

Article	Order description
Return stop	ZRTM-IC

Tools

These hand tools for speed rivets offer a great set speed with up to one rivet per second and a high clamp force. All listed machines fit to Fixriv, Fixsho and Fixscrew as well as to all equivalent types of speed rivets with diameters ranging from 2.4 mm to 4.8 mm.

- The **RK-753** standard hand tool separates the pistol from the weight of the tool body, therefore, the operator carries only 1kg (2.2 lb). The hydropneumatic intensifier is located in a separating housing at ground level.
- The **RK-753-P** pantograph is based on the RK-753 standard hand tool and ensures a vertical application of the speed rivets due to its exact guidance.
- The **RK-753-I** hand tool integrates the intensifier in the pistol. It is suitable for spatial flexible applications. We can offer this tool on request.
- The **HTS-500** is designed to hang vertically. The option to install the intensifier above the pistol allows for a very flexible work place layout.
- The **ETS 20 arrangement system** ensures orderly, direct access to mandrels, mandrel springs and nose pieces. It can be assembled to all workplaces.

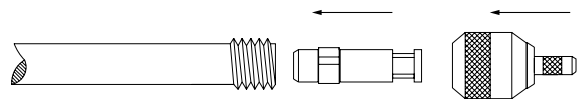


We are pleased to assist you in selecting the appropriate device for your application.

Installation

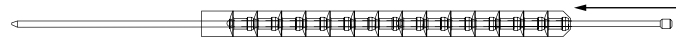
Step 1

Install the return stop into the tool and screw the nose piece on it.



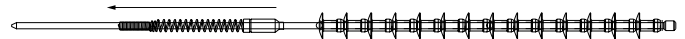
Step 2

Insert the mandrel opposite to the setting direction in the hole of the podded rivets; the head of the mandrel rests against body of the first rivet. Tear off and dispose of the podding paper.



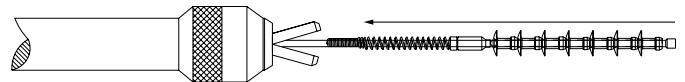
Step 3

Insert the spring onto the mandrel in the proper direction; the body of the spring touches the last rivet.



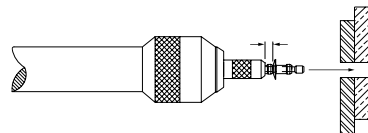
Step 4

Split the nose jaws open and insert the mandrel assembly (mandrel, spring and rivets). Insert assembly inside the nose piece until the last rivet remains outside of the nose piece.



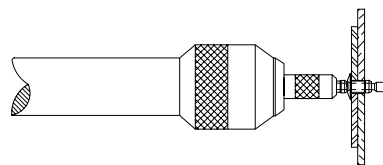
Step 5

Make sure the head of the first rivet is about 2 mm away from the end profile of the nose piece.



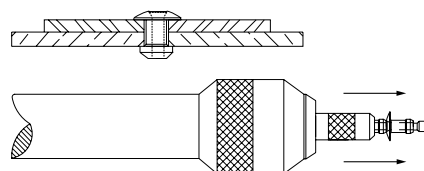
Step 6

Using the handle of the tool, insert the rivet and mandrel through the hole of your work piece until the head is sitting flush on the bearing surface. Pull the trigger to actuate the tools cycle and clinch the rivet.



Step 7

After proper assembly, the next rivet will automatically feed through the nose piece to advance the next rivet.



KVT-Fastening – Fastening technology



Blind rivet nuts



Blind rivet technology



Thread inserts



Self-clinching fasteners



Stud welding systems¹⁾



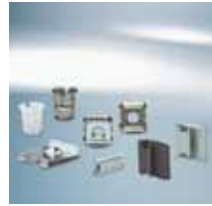
Lock nuts



Bonding fasteners



Access solutions



Quick fastening elements and clips



Quick release pins and spring plungers



Adhesives and sealants¹⁾



Construction fasteners²⁾



Special processes²⁾



Plugs



Pressure intensifiers³⁾



Installation technology



Quick connectors⁴⁾

Fastening, sealing and flow control solutions for complex applications

The extensive KVT-Fastening portfolio offers optimal solutions for your most challenging applications. The products included in this catalog represent only a selection from our entire product portfolio. Upon request, we will be pleased to provide additional information or an individual consultation to you.

Intelligent logistic systems

Bossard SmartBin and SmartLabel are intelligent logistics systems which monitor stock with total reliability and ensure stock replenishment automatically. An online system transmits the data to our server, and this – if necessary – triggers an order. These systems ensure quick and easy availability of C-parts while production is running.



Logistic systems

Competent analysis for efficient solutions

KVT-Fastening's highly qualified experts analyze the given task at hand. Based on this sound understanding of the project, they then develop ideal solutions that are economical, efficient, and safe.



Solutioneering

For more information about our range of products and order at our E-shop, please visit www.kvt-fastening.com

¹⁾ Not available in Germany. ²⁾ Only available in Switzerland. ³⁾ Not available in Switzerland. ⁴⁾ Not available in Austria.

KVT-Fastening
Branch of Bossard Ltd
Dietikon/Zürich | Switzerland
Tel: +41 44 743 33 33
info-CH@kvt-fastening.com
www.kvt-fastening.ch

KVT-Fastening GmbH
Illerrieden | Germany
Tel: +49 7306 782-0
info-DE@kvt-fastening.com
www.kvt-fastening.de

KVT-Fastening GmbH
Linz/Pichling | Austria
Tel: +43 732 25 77 00
info-AT@kvt-fastening.com
www.kvt-fastening.at

KVT-Fastening Sp. z o.o.
Radom | Poland
Tel: +48 58 762 17 80
info-PL@kvt-fastening.com
www.kvt-fastening.pl

KVT-Fastening S.R.L.
București | Romania
Tel: +40 37 1381155
info-RO@kvt-fastening.com
www.kvt-fastening.ro

KVT-Fastening spol. s.r.o.
Bratislava | Slovakia
Tel: +421 9 11102510
info-SK@kvt-fastening.com
www.kvt-fastening.sk

KVT-Tehnika pritrjevanja d.o.o.
Ljubljana | Slovenia
Tel: +386 1 2808019
info-SI@kvt-fastening.com
www.kvt-fastening.si

KVT-Fastening s.r.o.
Brno | Czech Republic
Tel: +420 547 125200201
info-CZ@kvt-fastening.com
www.kvt-fastening.cz

KVT-Fastening Kft.
Budapest | Hungary
Tel: +36 1 769 0925
info-HU@kvt-fastening.com
www.kvt-fastening.hu



www.kvt-fastening.com

