



Huck® structural blind fasteners

Extremely resilient, high reliable, absolutely secure

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.



HUCK® structural blind fasteners – unshakable, even under extreme stress

HUCK® structural blind fasteners as well as specially designed rivet solutions are primarily used in the fields of transport, rail vehicles, bus and truck production, semitrailers, containers and frame construction – fields that place great demands on components and materials.

Challenge

The problem is the joining of two components made of the same or different materials, such as steel and plastic, with different strengths and material thicknesses. Above all, the joints must be able to withstand vibrations over a long period of time.

Solution

HUCK® structural blind fasteners live up to these most demanding requirements thanks to their enormous shear strength and great tensile strength. Even large components can be permanently joined without deformation.







Vorteile

- Highly resistant to vibrations
- Ideally designed, nondetachable blind rivet joints
- Deformation-free joints without surface damage
- Virtually corrosion-free
- Range of tools for quick and easy installation








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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.

Overview of structural blind fasteners

Heavy-duty rivet series	Head shape	Use	Features of use	Fasteners sleeve material	Fasteners mandrel material
Magna-Lok®	Domed head		Structural blind fastener with wide grip range and good hole filling. The mandrel is automatically locked to prevent detachment. The break point is flush-fit to the rivet body. Magna-Lok® seals the joint against splash water.	Aluminum	Aluminum
				Steel	Steel
				Stainless steel	Stainless steel
Magna-Lok®	Countersunk head		Structural blind fastener with wide grip range and good hole filling. The mandrel is automatically locked to prevent detachment. The break point is flush-fit to the rivet body. Magna-Lok® seals the joint against splash water.	Aluminum	Aluminum
				Steel	Steel
				Stainless steel	Stainless steel
Huck-Lok™	Domed head		The great vibration resistance of the Huck-Lok™ is achieved by a double-mandrel lock. The special bulge style prevents pulling through in combination with the locking mechanism on the blind side. Wide grip range and high shear strength.	Steel	Steel
Magna-Bulb®	Domed head		Large contact surfaces paired with high clamping force are well suited for use in sheet-metal and plastic applications. The form-fit locked rivet mandrel provides security even under heavy component vibrations.	Steel	Steel
Auto-Bulb®	Domed head		Auto-Bulb® offers optimum appearance and no danger of injury on the blind side. The projecting height of the bulge can be ideally adapted due to overlapping clamping ranges. High clamping force and a large blind side footprint offer optimum fatigue strength.	Steel	Steel
BOM®	Collar head		The structural blind fastener for the most demanding requirements in terms of clamping force and shear strength. The joint is sealed to prevent liquid from entering. The rivet mandrel breaks flush. BOM® provides the strength advantages of HUCK® lockbolt systems but is also made for blind installation from one side.	Steel	Steel

	Grip range [mm]	Fasteners diameters							Seite
		4.8	6.4	7.9	9.5	12.7	15.9	19.4	
Standard lengths (included in catalog)	1.6 – 11.1	2.0 – 15.9			3.0 – 14.2				8
Standard lengths (included in catalog)	1.6 – 11.1	2.0 – 15.9			3.0 – 14.2				9
Standard lengths (included in catalog)	1.6 – 11.1	2.0 – 15.9							10
Standard lengths (included in catalog)	3.2 – 12.7	4.0 – 18.4							11
Standard lengths (included in catalog)	3.2 – 12.7	4.0 – 18.4							12
Standard lengths (included in catalog)	3.2 – 12.7	4.0 – 18.4							13
Standard lengths (included in catalog)		2.0 – 22.2							14
Standard lengths (included in catalog)	2.2 – 8.8	8.8 – 33.8							15
Available upon request			3.8 – 15.2						
Standard lengths (included in catalog)	2.2 – 9.8	2.2 – 9.8							16
Available upon request	9.8 – 18.8	9.8 – 20.8							
Standard lengths (included in catalog)		4.0 – 10.3	4.8 – 17.5	4.8 – 20.6					17
Available upon request	2.4 – 19.8	10.3 – 23.0	20.7 – 27.0	20.7 – 33.3	6.4 – 41.3	6.4 – 38.1	6.4 – 31.7		

Structural blind fasteners

Domed head



Type Magna-Lok®

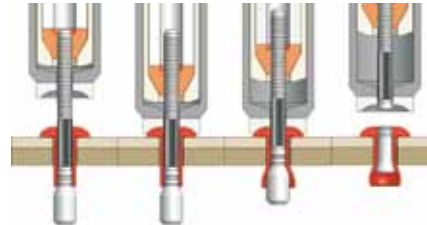
Material

Body: Aluminum (AlMg5)

Mandrel: Aluminum (AlZn5, 5MgCu)

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation			
									Setting tool	Pulling head		
4.8	1.6 – 6.9	MGLP-B6-4	10.54	17.15	4.9 – 5.1		2.16 MAX	9.78 MAX	2.220	2.670	2025L/2480L ¹⁾ LH-224/ --- 202V	99-3303L 99-3303 99-3303
	5.5 – 11.1	MGLP-B6-7	14.53	20.96								
	1.6 – 11.1	MGLP-B6-E	14.53	24.13								
6.4	2.0 – 9.5	MGLP-B8-6	14.22	24.64	6.6 – 6.9		2.97 MAX	13.34 MAX	3.960	5.780	2025L/2480L ¹⁾ LH-224/ --- 202V	99-3305L 99-3305 99-3305
	8.9 – 15.9	MGLP-B8-10	20.57	30.99								
	2.0 – 15.9	MGLP-B8-E	20.57	35.69								
9.5	3.0 – 14.2	MGLP-B12-12	21.34	41.91	9.9 – 10.3		4.45 MAX	19.99 MAX	8.450	13.120	255/2580 ¹⁾	99-3329

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Domed head



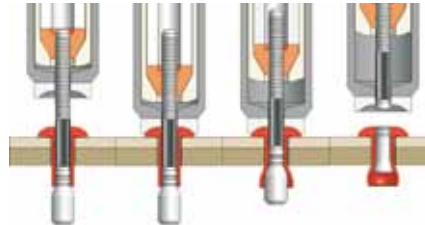
Type Magna-Lok®

Material

Body: Steel
Mandrel: Steel
Surface: Zinc-plated with clear chromate

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø	Order description	Body length D max.	Rivet length E max.	Installation	Setting tool	Pulling head
4.8	1.6 – 6.9 MGLP-R6-4	10.54	17.15	4.9 – 5.1		4.450 5.780 2025L/2480L ¹⁾ LH-224/ --- 202V 99-3303L 99-3303 99-3303
	5.5 – 11.1 MGLP-R6-7	14.53	20.96			
	1.6 – 11.1 MGLP-R6-E	14.53	24.13			
6.4	2.0 – 9.5 MGLP-R8-6	14.22	24.64	6.6 – 6.9		8.230 11.120 2025L/2480L ¹⁾ LH-224/ --- 202V 99-3305L 99-3305 99-3305
	8.9 – 15.9 MGLP-R8-10	20.57	30.99			
	2.0 – 15.9 MGLP-R8-E	20.57	35.69			
9.5	3.0 – 14.2 MGLP-R12-12	21.34	41.91	9.9 – 10.3		17.790 26.690 255/2580 ¹⁾ 99-3329

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Domed head



Type Magna-Lok®

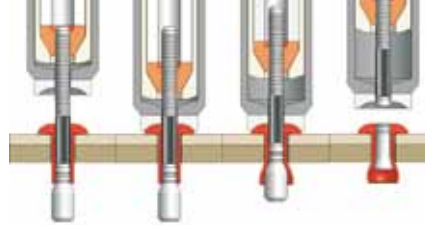
Material

Body: Stainless steel 1.4310 (AISI 302)

Mandrel: Stainless steel 1.4303 (AISI 305)

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation			
									Setting tool	Pulling head		
4.8	1.6 – 6.9	MGLP-U6-4	10.54	17.15	4.9 – 5.1		D	2,16 MAX	4.220	5.780	Pneu./Hydr.	99-3303L 99-3303 99-3303
	5.5 – 11.1	MGLP-U6-7	14.53	20.96								
6.4	2.0 – 9.5	MGLP-U8-6	14.22	24.64	6.6 – 6.9		D	2,97 MAX	8.000	10.450	Pneu./Hydr.	99-3305L 99-3305 99-3305
	8.9 – 15.9	MGLP-U8-10	20.57	30.99								

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Countersunk head, 100°



Type Magna-Lok®

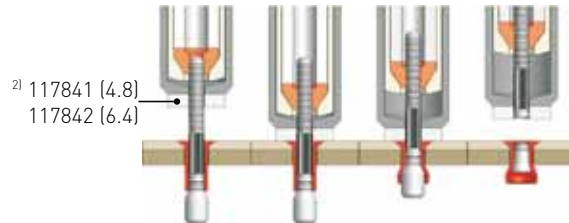
Material

Body: Aluminum (AlMg5)

Mandrel: Aluminum (AlZn5,5MgCu)

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation	
									Setting tool	Pulling head
4.8	3.2 – 8.4	MGL100-B6-6	12.34	19.35	4.9 – 5.1		2.220	2.670	Pneu./Hydr.	99-3303L ²¹ 99-3303 ²¹ 99-3303
	7.8 – 12.7	MGL100-B6-9	16.59	23.60						
6.4	4.0 – 12.1	MGL100-B8-8	16.76	26.90	6.6 – 6.9		3.960	5.780	Pneu./Hydr.	99-3305L ²¹ 99-3305 ²¹ 99-3305
	10.5 – 18.4	MGL100-B8-12	23.11	33.25						

¹¹ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

²¹ The respective mouthpiece, 117841 (4.8) or 117842 (6.4), must be used to set countersunk head fasteners. They are supplied with the respective pulling head as standard.

Structural blind fasteners

Countersunk head, 100°



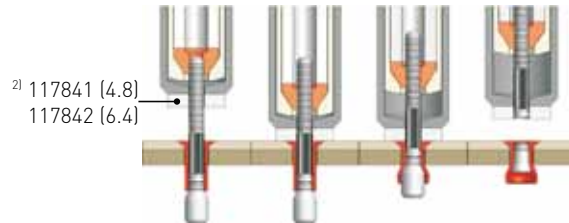
Type Magna-Lok®

Material

Body: Steel
Mandrel: Steel
Surface: Zinc-plated with clear chromate

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation	
									Setting tool	Pulling head
4.8	3.2 – 8.4	MGL100-R6-6	12.34	19.35	4.9 – 5.1		[N]	[N]	Pneu./Hydr.	
	7.8 – 12.7	MGL100-R6-9	16.59	23.60						
6.4	4.0 – 12.1	MGL100-R8-8	16.76	26.90	6.6 – 6.9		[N]	[N]	Pneu./Hydr.	
	10.5 – 18.4	MGL100-R8-12	23.11	33.25						

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

²⁾ The respective mouthpiece, 117841 (4.8) or 117842 (6.4), must be used to set countersunk head fasteners. They are supplied with the respective pulling head as standard.

Structural blind fasteners

Countersunk head, 100°



Type Magna-Lok®

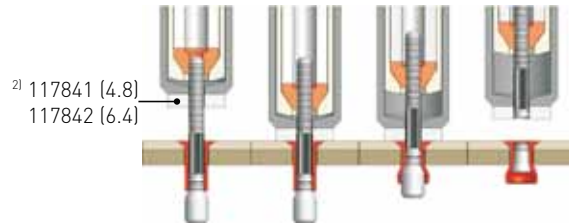
Material

Body: Stainless steel 1.4310 (AISI 302)

Mandrel: Stainless steel 1.4303 (AISI 305)

Tools see pages 18 – 21

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø	Order description	Body length D max.	Rivet length E max.	Installation	Setting tool	Pulling head		
							[N]	[N]
4.8	3.2 – 8.4	MGL100-U6-6	12.34	19.35	4.220	5.780	2025L/2480L ¹⁾ LH-224/ --- 202V	99-3303L ²⁾ 99-3303 ²⁾ 99-3303
	7.8 – 12.7	MGL100-U6-9	16.59	23.60				
6.4	4.0 – 12.1	MGL100-U8-8	16.76	26.90	8.000	10.450	2025L/2480L ¹⁾ LH-224/ --- 202V	99-3305L ²⁾ 99-3305 ²⁾ 99-3305
	10.5 – 18.4	MGL100-U8-12	23.11	33.25				

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

²⁾ The respective mouthpiece, 117841 (4.8) or 117842 (6.4), must be used to set countersunk head fasteners. They are supplied with the respective pulling head as standard.

Structural blind fasteners

Domed head



Type Huck-Lok™

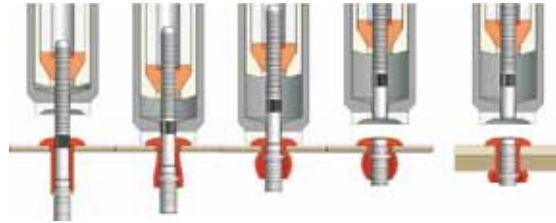
Material

Body: Steel
Mandrel: Steel
Surface: Zinc-plated with clear chromate

Tools see pages 18 – 21

Grip range 22.2 to 28.6 mm and 25.4 to 31.8 mm are available upon request

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation		
									Setting tool	Pulling head	
								[N]	[N]	Pneu./Hydr.	
6.4	2.0 – 9.5	HKLP-R8-6	14.2	28.3	6.6 – 7.0			8.450	15.570	2025L/2480L ¹⁾ LH-224/ --- 202V	99-3305L 99-3305 99-3305
	4.8 – 11.1	HKLP-R8-7	15.8	29.9							
	9.5 – 15.9	HKLP-R8-10	20.6	34.7							
	12.7 – 19.1	HKLP-R8-12	23.7	37.9							
	15.9 – 22.2	HKLP-R8-14	26.9	41.1							

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Domed head



Type Magna-Bulb®

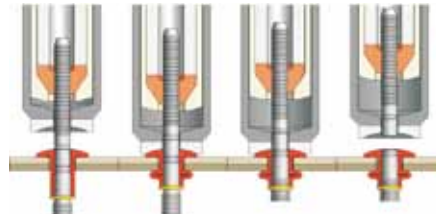
Material

Body: Steel
Mandrel: Steel
Surface: Zinc-plated with clear chromate

Tools see pages 18 – 21

Other rivet diameters 7.9 mm (3.8 to 6.4 mm) and other grip ranges of the below-mentioned types are available upon request

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø	Order description	Body length D max.	Rivet length E max.	Installation	Setting tool	Pulling head
4.8 Upon request!	2.2 – 3.8 MBP-R6-M3	9.91	17.1	4.9 – 5.1	[N]	[N]
	3.2 – 4.8 MBP-R6-M4	10.90	17.7			
	4.2 – 5.8 MBP-R6-M5	11.89	18.6			
	5.2 – 6.8 MBP-R6-M6	12.90	19.7			
	7.2 – 8.8 MBP-R6-M8	14.91	21.7			
6.4	1.5 – 3.5 MBP-R8-M2	11.48	19.3	6.6 – 6.9	[N]	[N]
	2.8 – 4.8 MBP-R8-M3	12.75	21.9			
	3.8 – 5.8 MBP-R8-M4	13.77	23.9			
	5.8 – 7.8 MBP-R8-M6	15.77	23.9			
	7.8 – 9.8 MBP-R8-M8	17.78	25.9			
	8.8 – 10.8 MBP-R8-M9	18.77	26.9			
	10.8 – 12.8 MBP-R8-M11	20.78	28.9			
	12.8 – 14.8 MBP-R8-M13	22.78	30.9			

¹¹ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Domed head



Type Auto-Bulb®

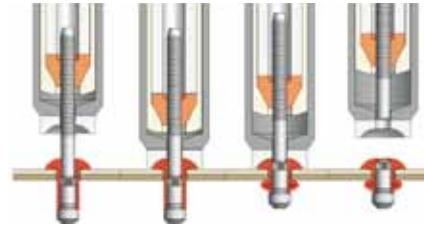
Material

Body: Steel
Mandrel: Steel
Surface: Zinc-plated with clear chromate

Tools see pages 18 – 21

Further grip ranges upon request

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Rivet length D max.		[N]		Installation		
							Setting tool	Pulling head	
					[N]	[N]	Pneu./Hydr.		
4.8 Upon request!	2.2 – 3.8	ABP-R6-M3	12.95	4.9 – 5.1		3.780	5.340	2025L/2480L1) LH-224/ --- 202V	99-3303L 99-3303 99-3303
	3.2 – 4.8	ABP-R6-M4	13.97						
	4.2 – 5.8	ABP-R6-M5	14.96						
	5.2 – 6.8	ABP-R6-M6	15.98						
	6.2 – 7.8	ABP-R6-M7	16.97						
	7.2 – 8.8	ABP-R6-M8	17.98						
	8.2 – 9.8	ABP-R8-M9	18.97						
6.4	2.8 – 4.8	ABP-R8-M3	17.09	6.7 – 6.9		7.120	11.570	2025L/2480L1) LH-224/ --- 202V	99-3305L 99-3305 99-3305
	3.8 – 5.8	ABP-R8-M4	18.11						
	4.8 – 6.8	ABP-R8-M5	19.10						
	5.8 – 7.8	ABP-R8-M6	20.12						
	6.8 – 8.8	ABP-R8-M7	21.11						
	7.8 – 9.8	ABP-R8-M8	22.12						

¹¹ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Structural blind fasteners

Collar head



Type BOM®

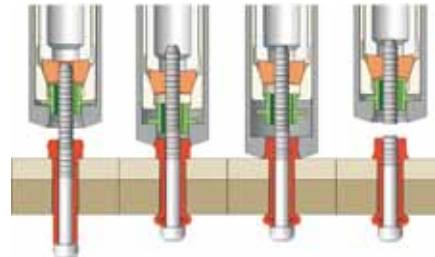
Material

Body: Steel, Zinc-plated, with wax film
Mandrel: Steel, black, oiled

Tools see pages 18 – 21

Further diameters (4.8 mm, 12.7 mm, 15.9 mm, 19.1 mm) and grip ranges upon request

Installation



3-D Daten: <http://kvt.partcommunity.com>

NOM fasteners Ø		Order description	Body length D max.	Rivet length E max.					Installation	
									Setting tool	Pulling head
							[N]	[N]	Pneu./Hydr.	
6.4	4.0 – 5.6	BOM-R8-3	13.28	17.32	7.0 – 7.4		14.460	22.690	255/2580 ¹⁾	99-830-1
	5.6 – 7.2	BOM-R8-4	14.86	18.92						
	7.2 – 8.8	BOM-R8-5	16.46	20.50						
	8.8 – 10.3	BOM-R8-6	18.03	22.10						
7.9	4.8 – 7.9	BOM-R10-4	17.65	22.23	8.8 – 9.4		23.130	35.810	----/2580 ¹⁾	99-769
	7.9 – 11.1	BOM-R10-6	20.83	25.40						
	11.1 – 14.3	BOM-R10-8	24.00	28.58						
	14.3 – 17.5	BOM-R10-10	27.18	31.75						
9.5	4.8 – 7.9	BOM-R12-4	19.46	24.61	10.5 – 11.0		32.250	49.380	----/2580 ¹⁾	99-1272
	7.9 – 11.1	BOM-R12-6	22.63	27.79						
	11.1 – 14.3	BOM-R12-8	25.81	30.96						
	14.3 – 17.5	BOM-R12-10	28.98	34.14						
	17.5 – 20.6	BOM-R12-12	32.16	37.31						

¹⁾ This tool can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Tools Structural blind fasteners

Overwiev



	NOM fasteners Ø	Pneumatic tools				Hydraulic tools	
		202V	LH-224	255	2025 L/LB	2480 L	2581
		Pulling head	Pulling head	Pulling head	Pulling head	Pulling head	Pulling head
Magna-Lok®	4.8	99-3303	99-3303		99-3303 L	99-3303 L	
	6.4	99-3305	99-3305		99-3305 L	99-3305 L	
	9.5			99-3318			99-3329
Huck-Lok™	6.4	99-3305	99-3305		99-3305 L	99-3305 L	
Magna-Bulb®	4.8	99-3303	99-3303		99-3303 L	99-3303 L	
	6.4	99-3305	99-3305		99-3305 L	99-3305 L	
	7.9			99-3307			99-3307
Auto-Bulb®	4.8	99-3303	99-3303		99-3303 L	99-3303 L	
	6.4	99-3305	99-3305		99-3305 L	99-3305 L	
BOM®	6.4			99-830-1			99-830-1
	7.9						99-769
	9.5						99-1272

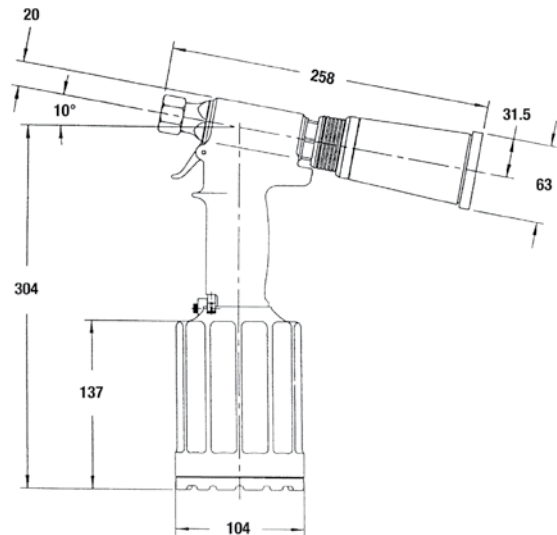
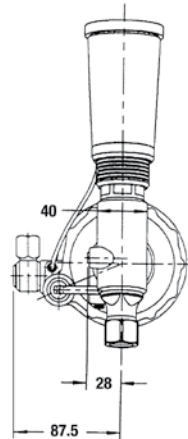
The hydraulic tools can only be operated in combination with the HK32-002 Powerig® and the HS-10-MCE hose set.

Tools Structural blind fasteners

202V

Pneumatic with vacuum system

Weight: 2.3 kg
 Air pressure: 5.5 to 6.9 bar
 Tensile force: 17.3 kN (at 6.2 bar)
 Max. power stroke: 18.9 mm
 Air consumption: 244 l/min at
 30 cycles/min



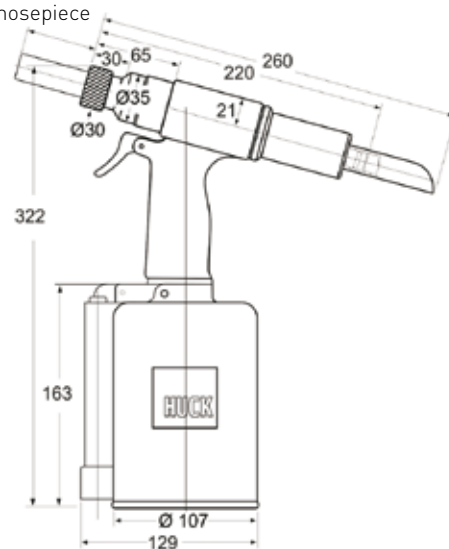
LH-224

Pneumatic

Weight: 2,8 kg
 Air pressure: 6,2 to 6,9 bar
 Tensile force: 19 kN (at 6,2 bar)
 Max. power stroke: 21 mm

The tool is also available with a mandrel collection container under the designation "LH-244 B" (without picture).

depending on
nosepiece

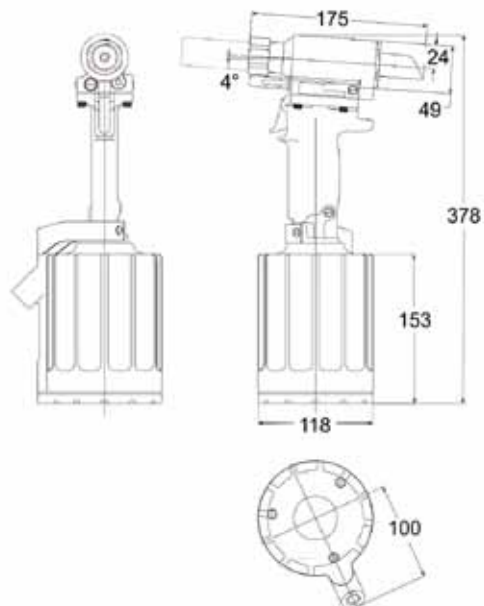


Tools Structural blind fasteners

255

Pneumatic

Weight: 4 kg
Air pressure: 6.2 to 6.9 bar
Tensile force: 34.5 kN (at 6.2 bar)
Max. power stroke: 15.9 mm

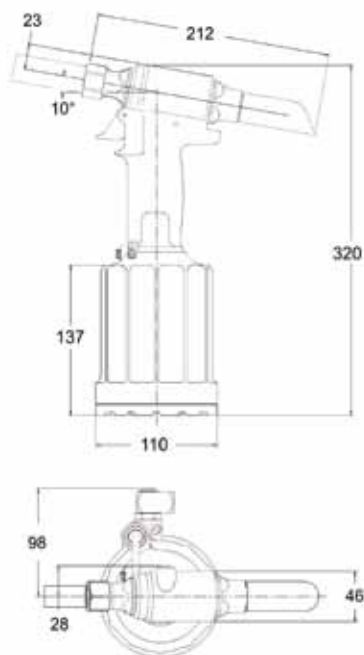


2025 L

Pneumatic

Weight: 2.6 kg
Air pressure: 6.2 to 7.6 bar
Tensile force: 19 kN (at 6.2 bar)
Max. power stroke: 17 mm
Air consumption: 1.3 l/stroke

The tool can also be supplied with a mandrel collection container under the designation "LH-244 B" (without picture).

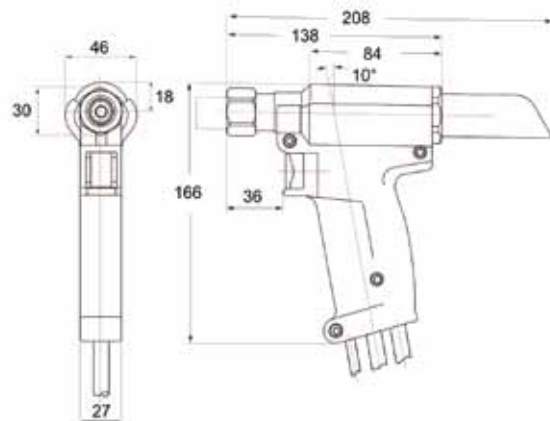


Tools Structural blind fasteners

2480L

Hydraulic

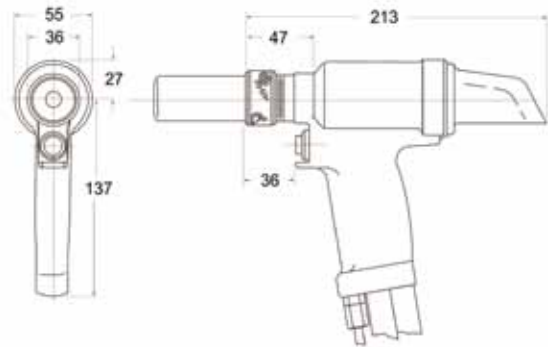
Weight: 1.0 kg
 Tensile force: 25.4 kN (bei 580 bar)
 Max. power stroke: 20.6 mm
 Power stroke: 580 bar
 Return stroke: 220 bar



2581

Hydraulic

Weight: 2,49 kg
 Tensile force: 47.6 kN (at 510 bar)
 Max. power stroke: 24 mm
 Power stroke: 510 bar
 Return stroke: 220 bar



HK32-002 Powerig®

Hydraulic-aggregate

Max. force pressure: 600 bar
 Max. return stroke: 300 bar
 Dimensions: 540 x 470 x 565 mm (LxWxH)
 Connection: 50 Hz, 3 x 220V, 3 x 400V
 Motor: 2.2 kW



KVT-Fastening – Fastening technology



Blind rivet nuts



Blind rivet technology



Thread inserts



Self-clinching fasteners



Stud welding systems¹⁾



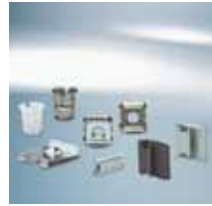
Lock nuts



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.

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