

# POP<sup>®</sup>



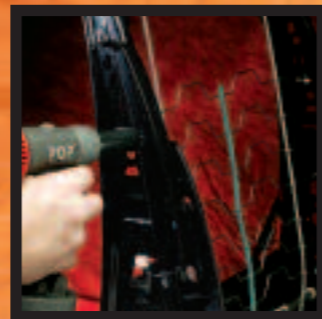
## HR Rivets

High Retention Rivets for Metal and Plastic-to-Metal Applications

**Key Benefits:**

- Superior Clamp Force
- Excellent Mandrel Retention
- Increased Blind Side Expansion
- Rattle Resistant
- RoHS Compliant

Unique rib design accomodates larger primary holes in plastic and thin sheet metal without causing deformation or stress fractures.



Automotive Seat Assembly



Increased Blind Side Expansion



# HR Rivets

High Retention Rivets for Metal and Plastic-to-Metal Applications

Nominal Rivet Diameter	(L) Nominal Rivet Body Length	(F) Max Blind Side Protrusion	Grip Range	Rivet Part Number	Hole Size	Shear Strength	Tensile Strength
mm	mm	mm	mm		mm	n	n
<b>HR Type Steel Body/Steel Mandrel – Domed Head – Finish: Zinc/Protective Coating</b>							
3.2	8.0	11.2	1.6-3.2	SD 42 HR	3.4-3.6	3.15-3.37	6.1-6.7
	9.6	12.8	3.2-4.8	SD 43 HR			
	11.2	14.4	4.8-6.4	SD 44 HR			
4.0	9.0	12.5	1.6-3.2	SD 52 HR	4.2-4.4	3.95-4.17	7.7-8.3
	10.6	14.1	3.2-4.8	SD 53 HR			
	12.2	15.7	4.8-6.4	SD 54 HR			
4.8	9.2	13.5	1.6-3.2	SD 62 HR	5.0-5.4	4.75-4.97	9.2-10.0
	10.8	15.1	3.2-4.8	SD 63 HR			
	12.4	16.7	4.8-6.4	SD 64 HR			
	14.0	18.3	6.4-8.0	SD 65 HR			
6.4	11.3	16.0	1.2-4.8	SD 83 HR	6.6-7.0	6.35-6.57	12.5-13.5
	14.5	19.2	4.8-8.0	SD 85 HR			
<b>HR Type Steel Body/Steel Mandrel – Large Flange – Finish: Zinc/Protective Coating</b>							
4.8	9.2	13.5	1.6-3.2	SD 62 HR LF	5.0-5.4	4.75-4.97	15.4-16.4
	10.8	15.1	3.2-4.8	SD 63 HR LF			
	12.4	16.7	4.8-6.4	SD 64 HR LF			
	14.0	18.3	6.4-8.0	SD 65 HR LF			
6.4	11.3	16.0	1.2-4.8	SD 83 HR LF	6.6-7.0	6.35-6.57	15.5-16.5
	14.5	19.2	4.8-8.0	SD 85 HR LF			

Nominal Rivet Diameter	(L) Nominal Rivet Body Length	(F) Max Blind Side Protrusion	Grip Range	Rivet Part Number	Hole Size	Shear Strength	Tensile Strength
mm	mm	mm	mm		mm	n	n
<b>HR Type Steel Body/Steel Mandrel – 120° Countersunk – Finish: Zinc/Protective Coating</b>							
3.2	8.0	11.2	2.0-3.2	SK 42 HR	3.4-3.5	3.15-3.37	5.0-5.6
	9.6	12.8	3.2-4.8	SK 43 HR			
	11.2	14.4	4.8-6.4	SK 44 HR			
4.0	9.0	12.5	2.0-3.2	SK 52 HR	4.2-4.3	3.95-4.17	6.1-6.7
	10.6	14.1	3.2-4.8	SK 53 HR			
	12.2	15.7	4.8-6.4	SK 54 HR			
4.8	10.8	15.1	2.4-4.8	SK 63 HR	5.0-5.2	4.75-4.97	7.8-8.6
	12.4	16.7	4.8-6.4	SK 64 HR			
<b>HR Type Stainless Steel Body/Stainless Steel Mandrel – Domed Head – Finish: Plain/Plain</b>							
3.2	8.0	11.2	1.6-3.2	SSD 42 SSHR	3.4-3.6	3.15-3.37	6.1-6.7
	9.6	12.8	3.2-4.8	SSD 43 SSHR			
	11.2	14.4	4.8-6.4	SSD 44 SSHR			
4.0	9.0	12.5	1.6-3.2	SSD 52 SSHR	4.2-4.4	3.95-4.17	7.7-8.3
	10.6	14.1	3.2-4.8	SSD 53 SSHR			
	12.2	15.7	4.8-6.4	SSD 54 SSHR			
4.8	9.2	13.9	1.6-3.2	SSD 62 SSHR	5.0-5.4	4.75-4.97	9.2-10.0
	10.8	15.5	3.2-4.8	SSD 63 SSHR			
	12.4	17.1	4.8-6.4	SSD 64 SSHR			
<b>HR Type Stainless Steel Body/Stainless Steel Mandrel – 120° Countersunk – Finish: Plain/Plain</b>							
3.2	8.0	11.2	2.0-3.2	SSK 42 SSHR	3.4-3.5	3.15-3.37	5.0-5.6
	9.6	12.8	3.2-4.8	SSK 43 SSHR			
	11.2	14.4	4.8-6.4	SSK 44 SSHR			
4.0	9.0	12.5	2.0-3.2	SSK 52 SSHR	4.2-4.3	3.95-4.17	6.1-6.7
	10.6	14.1	3.2-4.8	SSK 53 SSHR			
	12.2	15.7	4.8-6.4	SSK 54 SSHR			
	12.2	15.7	4.8-6.4	SSK 54 SSHR			
4.8	10.8	15.1	2.4-4.8	SSK 63 SSHR	5.0-5.2	4.75-4.97	7.8-8.6
	12.4	16.7	4.8-6.4	SSK 64 SSHR			

POP® Rivet - Power Tool Nosepiece, Jaw & Jaw Pusher Selection Guide

	Set-Up	Nominal Rivet Diameter			
		3.2 mm	4.0 mm	4.8 mm	6.4 mm
510A	Nosepiece	PRN4HR	PRN5HR		
	Jaws Jaw Pusher	PRG402-8A PRG520-33	PRG402-8A PRG520-33		
ProSet™ 2101	Nosepiece	PRN4HR			
	Jaws Jaw Pusher	PRG402-8A PRT5200-4			
5250A	Nosepiece	PRN4HR	PRN5HR		
	Jaws Jaw Pusher	PRG540-46 PRG520-33	PRG540-46 PRG520-33		
ProSet™ 2100	Nosepiece	PRN4HR	PRN5HR		
	Jaws Jaw Pusher	13300 PRT5200-34	13300 PRT5200-34		
540	Nosepiece	PRN4HR	PRN5HR	PRN6HR	
	Jaws Jaw Pusher	PRG540-46 PRG14	PRG540-46 PRG14	PRG540-44 PRG740-7A	
5400/5400LS	Nosepiece	PRN4HR	PRN5HR	PRN6HR	PRN8HR
	Jaws Jaw Pusher	PRG540-46 PRT5500-06	PRG540-46 PRT5500-06	PRG540-44 PRT5500-8	PRG540-44 DP249-008

POP® Rivet - Manual Tool Nosepiece, Jaw & Jaw Pusher Selection Guide

PowerLink 30®	Nosepiece	PRN4HR	PRN5HR		
	Jaws Jaw Pusher	PL30-010 PL30-009	PL30-010 PL30-009		
PowerLink Plus™	Nosepiece	PRN4HR	PRN5HR	PRN6HR	
	Jaws Jaw Pusher	PLP-04 PLP-06	PLP-04 PLP-06	PLP-04 PLP-06	
PowerLink Leverlite™	Nosepiece	PRN4HR	PRN5HR	PRN6HR	
	Jaws Jaw Pusher	LLP-05 LLP-04	LLP-05 LLP-04	LLP-05 LLP-04	

- Parts supplied fitted to rivet tool.
- Parts supplied with rivet tool, fitting required.
- Parts supplied separately, fitting required.

POP® Rivet - Power Tool Selection Guide by Diameter

Tool Series	Rivet Diameter			
	3.2 mm	4.0 mm	4.8 mm	6.4 mm
ProSet™ 2101	✓✓✓			
510A	✓✓	✓		
5250A	✓	✓✓		
ProSet™ 2100	✓✓	✓✓✓		
540	✓	✓✓	✓✓✓	
5400/5400LS	✓	✓	✓✓	✓✓✓

Recommendation: ✓ Good    ✓✓ Better    ✓✓✓ Best

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