

POP[®]

HR Rivets

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

Key Benefits:

- Excellent Mandrel Retention
- Excellent Rattle Resistance
- Consistent and Stable Clamp Force
- Increased Secondary Side Expansion
- Meets QS9001; RoHS Compliant 2006

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





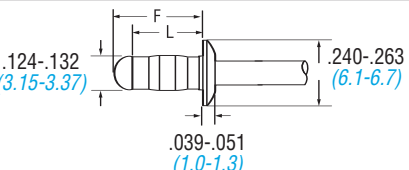
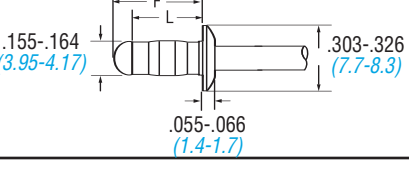
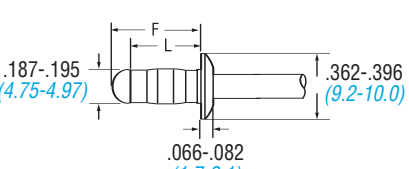
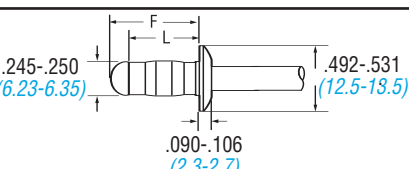
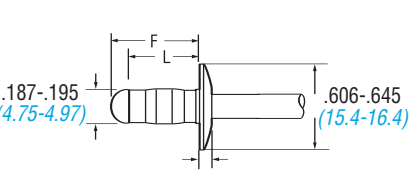
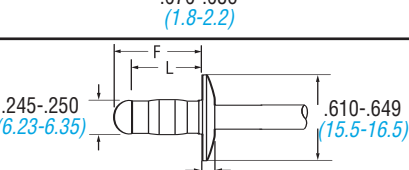


Automotive Seat Assembly



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**Emhart[®]
Teknologies**
POP[®]

Nominal Rivet Diameter	(L) Nominal Rivet Body Length	(F) Nominal Blind Side Protrusion	 Grip Range	Rivet Part Number	 Hole Size	—	 Shear Strength	 Tensile Strength
	In. (mm)	In. (mm)	In. (mm)		In. (mm)		Lbs. (N)	Lbs. (N)
HR Type Steel Body/Steel Mandrel – Domed Head – Finish: Zinc/Protective Coating								
1/8 (3.2)	.315 (8.0)	.440 (11.2)	.063-.125 (1.6-3.2)	SD 42 HR	.133-.141 (3.4-3.6)		325 (1450)	382 (1700)
	.378 (9.6)	.503 (12.8)	.125-.187 (3.2-4.8)	SD 43 HR				
	.440 (11.2)	.566 (14.4)	.187-.250 (4.8-6.4)	SD 44 HR				
5/32 (4.0)	.354 (9.0)	.492 (12.5)	.063-.125 (1.6-3.2)	SD 52 HR	.165-.173 (4.2-4.4)		449 (2000)	584 (2600)
	.417 (10.6)	.555 (14.1)	.125-.187 (3.2-4.8)	SD 53 HR				
	.480 (12.2)	.618 (15.7)	.187-.250 (4.8-6.04)	SD 54 HR				
3/16 (4.8)	.362 (9.2)	.531 (13.5)	.063-.125 (1.6-3.2)	SD 62 HR	.196-.212 (5.0-5.4)		696 (3100)	764 (3400)
	.425 (10.8)	.594 (15.1)	.125-.187 (3.2-4.8)	SD 63 HR				
	.488 (12.4)	.657 (16.7)	.187-.250 (4.8-6.4)	SD 64 HR				
	.551 (14.0)	.720 (18.3)	.250-.312 (6.4-8.0)	SD 65 HR				
1/4 (6.4)	.444 (11.3)	.444 (11.3)	.047-.187 (1.2-4.8)	SD 83 HR	.259-.275 (6.6-7.0)		876 (3900)	1202 (5350)
	.570 (14.5)	.755 (19.2)	.187-.312 (4.8-8.0)	SD 85 HR				
HR Type Steel Body/Steel Mandrel – Large Flange – Finish: Zinc/Protective Coating								
3/16 (4.8)	.362 (9.2)	.531 (13.5)	.063-.125 (1.6-3.2)	SD 62 HR LF	.196-.212 (5.0-5.4)		696 (3100)	764 (3400)
	.425 (10.8)	.594 (15.1)	.125-.187 (3.2-4.8)	SD 63 HR LF				
	.488 (12.4)	.657 (16.7)	.187-.250 (4.8-6.4)	SD 64 HR LF				
	.551 (14.0)	.720 (18.3)	.250-.312 (6.4-8.0)	SD 65 HR LF				
1/4 (6.4)	.444 (11.3)	.444 (11.3)	.047-.187 (1.2-4.8)	SD 83 HR LF	.259-.275 (6.6-7.0)		876 (3900)	1202 (5350)
	.570 (14.5)	.755 (19.2)	.187-.312 (4.8-8.0)	SD 85 HR LF				



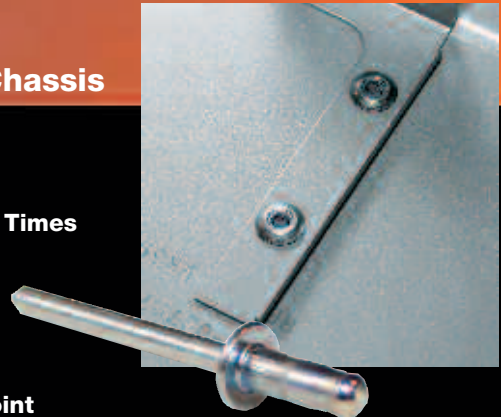
Application: Electronic Chassis





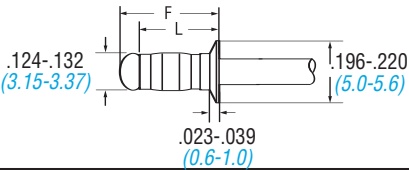
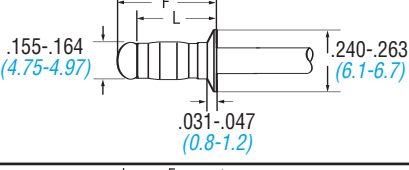
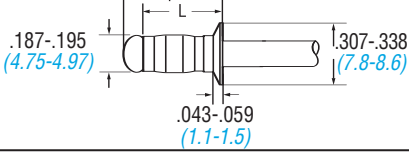
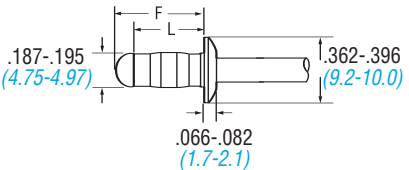
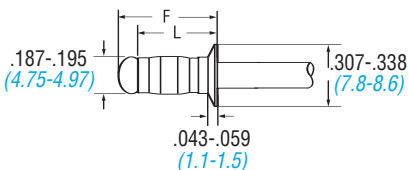
Previous Fastening Method:

- Welded Joint
- Inconsistent Results
- Higher Labor Cost and Set-up Times

Emhart Solution:

- SD 63 HR
- Reduction of Labor Time
- Overall Cost Savings
- Elimination of Consumables
- Anti-Rattle and High Clamp Joint



Nominal Rivet Diameter	(L) Nominal Rivet Body Length	(F) Nominal Blind Side Protrusion	 Grip Range	Rivet Part Number	 Hole Size		 Shear Strength	 Tensile Strength	
	In. (mm)	In. (mm)	In. (mm)		In. (mm)		Lbs. (N)	Lbs. (N)	
HR Type Steel Body/Steel Mandrel – 120° Countersunk – Finish: Zinc/Protective Coating									
1/8 (3.2)	.315 (8.0)	.440 (11.2)	.078-.125 (2.0-3.2)	SK 42 HR	.133-.138 (3.4-3.5)		213 (950)	269 (1200)	
	.378 (9.6)	.503 (12.8)	.125-.187 (3.2-4.8)	SK 43 HR					
	.440 (11.2)	.566 (14.4)	.187-.250 (4.8-6.4)	SK 44 HR					
5/32 (4.0)	.354 (9.0)	.492 (12.5)	.078-.125 (2.0-3.2)	SK 52 HR	.165-.169 (4.2-4.4)		292 (1300)	449 (2000)	
	.417 (10.6)	.555 (14.1)	.125-.187 (3.2-4.8)	SK 54 HR					
	.480 (12.2)	.618 (15.7)	.187-.250 (4.8-6.4)	SK 56 HR					
3/16 (4.8)	.425 (10.8)	.555 (15.1)	.093-.187 (2.4-4.8)	SK 63 HR	.196-.205 (5.0-5.2)		696 (3100)	764 (3400)	
	.488 (12.4)	.657 (16.7)	.187-.250 (4.8-6.4)	SK 64 HR					
HR Type Stainless Steel Body/Stainless Steel Mandrel – Domed Head– Finish: Plain/Plain									
3/16 (4.8)	.362 (9.2)	.545 (13.9)	.063-.125 (1.6-3.2)	SSD 62 SSHR	.196-.212 (5.0-5.4)		1056 (4700)	1124 (5000)	
	.425 (10.8)	.610 (15.5)	.125-.187 (3.2-4.8)	SSD 63 SSHR					
	.488 (12.8)	.673 (17.1)	.187-.250 (4.8-6.4)	SSD 64 SSHR					
HR Type Stainless Steel Body/Stainless Steel Mandrel – 120° Countersunk – Finish: Plain/Plain									
3/16 (4.8)	.425 (10.8)	.555 (15.1)	.094-.187 (2.4-4.8)	SSK 63 SSHR	.196-.205 (5.0-5.2)		831 (3700)	1124 (5000)	
	.488 (12.4)	.657 (16.7)	.187-.250 (4.8-6.4)	SSK 64 SSHR					



Application: Racking Systems

Previous Fastening Method:

- Bolt, Washer and Nut
- Higher Inventory Costs
- Extra Labor and Assembly Cost

Emhart Solution:

- SD 83 HR
- Significant Fastener Cost Savings
- Higher Strength Joint
- Quicker Assembly



POP® Rivet Tool Nosepiece, Jaws & Jaw Pusher Selection Guide



	Set-Up	Nominal Rivet Diameter			
		1/8" (3.2 mm)	5/16" (4.0 mm)	3/16" (4.8 mm)	1/4" (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® Manual Tools					
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	

(†) DP249-008: Optional part available separately for 8 size, 1/4" HR rivets.

- Standard parts supplied with rivet tool.
- Standard parts supplied with rivet tool; set-up may be required.
- Optional parts available separately.

POP® Tool Selection Guide by Diameter

Tool Series	Rivet Diameter			
	1/8" (3.2 mm)	5/32" (4.0 mm)	3/16" (4.8 mm)	1/4" (6.4 mm)
ProSet™ 2101	✓✓✓			
510A	✓✓	✓		
5250A	✓	✓✓		
ProSet™ 2100	✓✓	✓✓✓		
540	✓	✓✓	✓✓✓	
5400/5400LS	✓	✓	✓✓	✓✓✓

Recommendation: ✓ Good ✓✓ Better ✓✓✓ Best

AMERICAS

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