

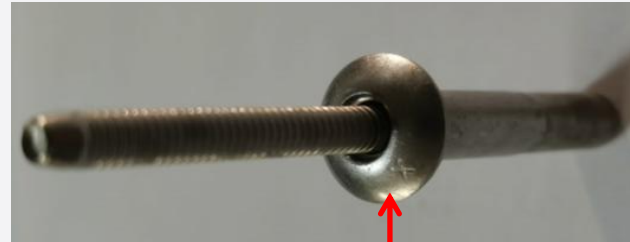
RIVMATE for Monolock vs STANLEY for Monobolt

Rivmate BBM6.4X20



VS

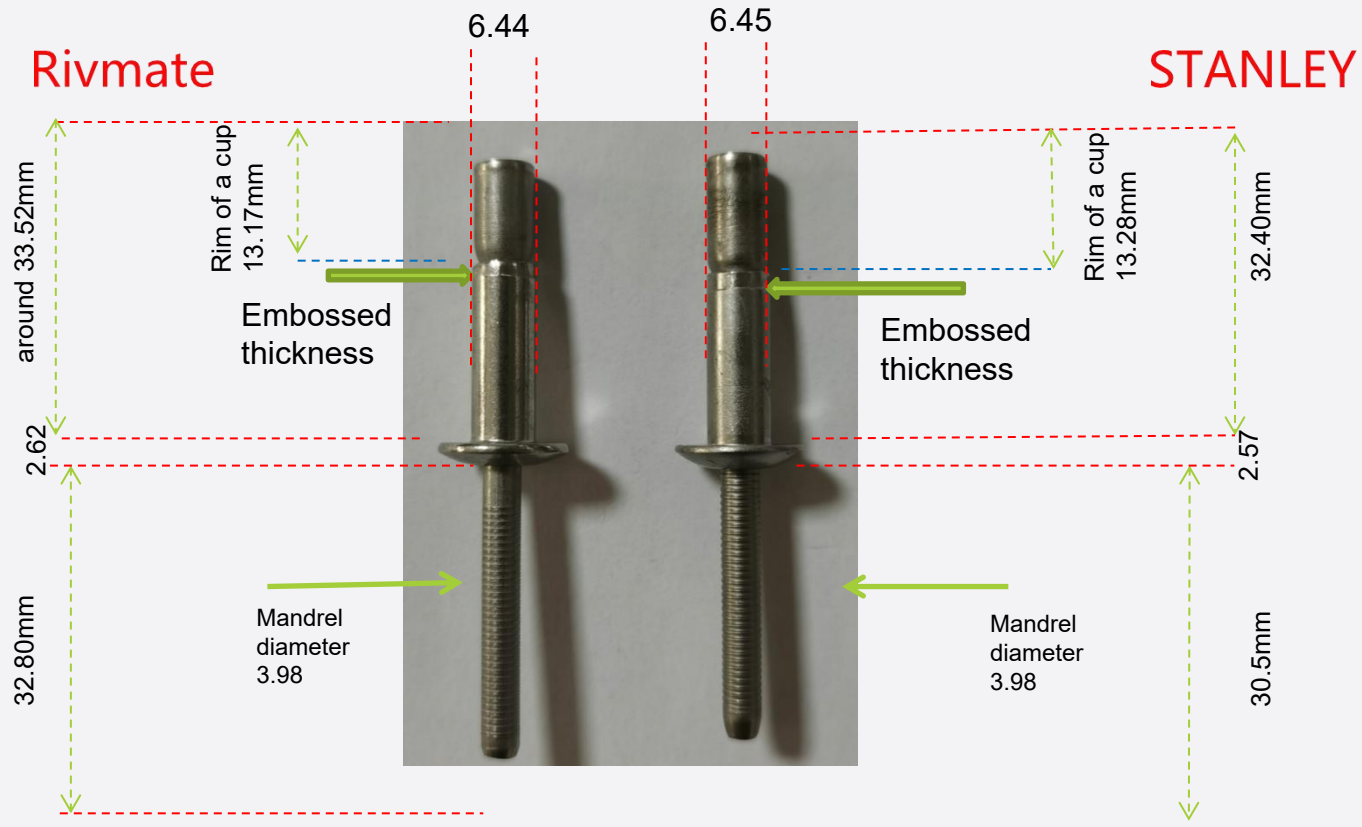
STANLEY(02771-00824)



Material ID



Comparation---Appearance and Size

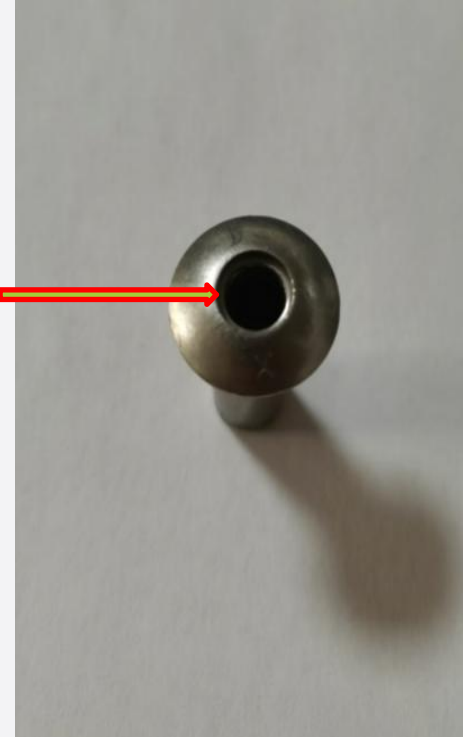


Rivmate



The locking step of Rivmate is a shallow one, while the locking step of Stanley is clear.

STANLEY



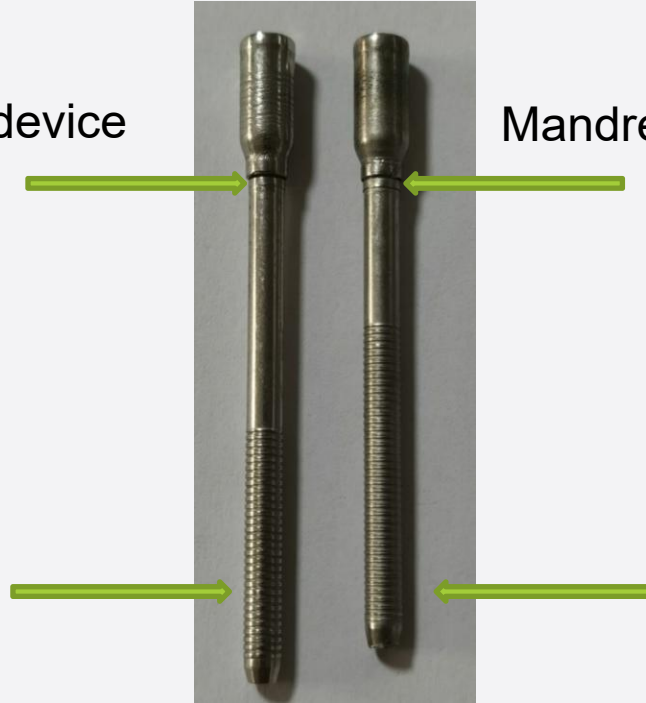
Comparison---Mandrel structure

Rivmate

STANLEY

Mandrel locking device

Mandrel locking device



The design concepts of Rivmate and STANLEY are basically the same, but there are slight differences in the craftsmanship.



Rivmate **Riveting Thickness Test: 10.0mm** STANLEY

The interlocking effect of the step part of the mandrel and the rivet shell hole can meet the requirements



Comparison-The Riveting Effect for 9.5mm Grip Range

Rivmate

Blind Side Appearance:
Riveting Thickness: 10.0mm

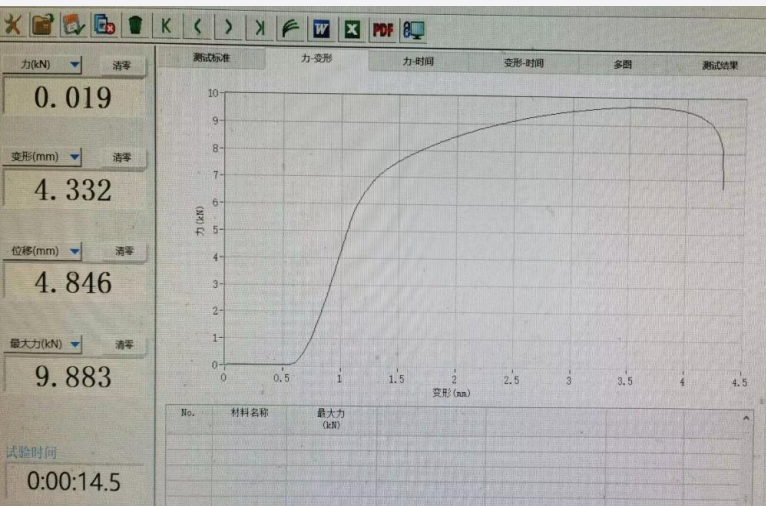
STANLEY



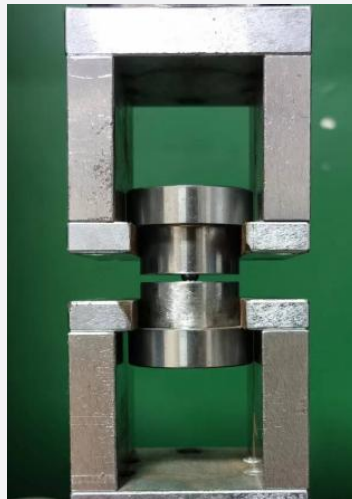
Comparison-Mechanical performance: Tensile strength testing

Rivmate

Tensile Strength: 9883N

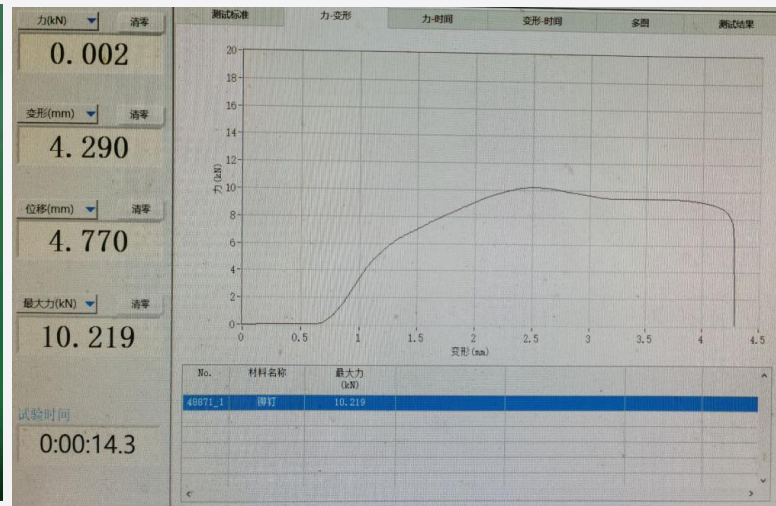


Same Testing Environment:
Rivet thickness 8.0mm, fixture
hole diameter 6.8mm, using the
same tensile testing machine



STANLEY

Tensile strength: 10219N



Comparison-Mechanical performance: Shear Strength Testing

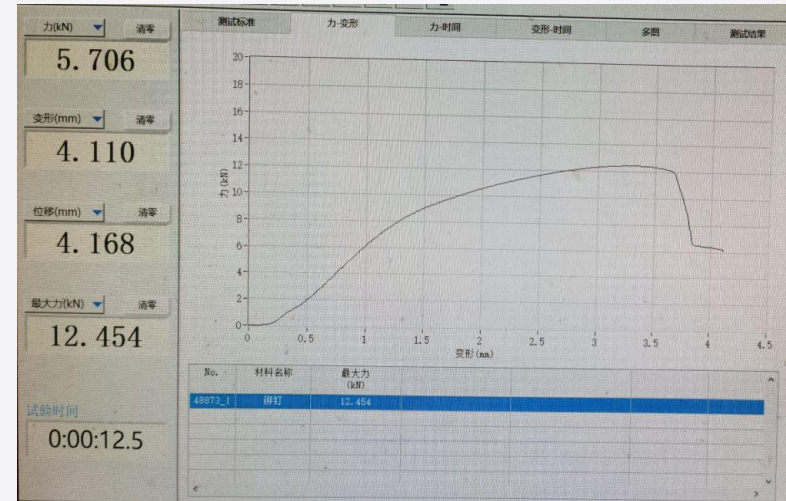
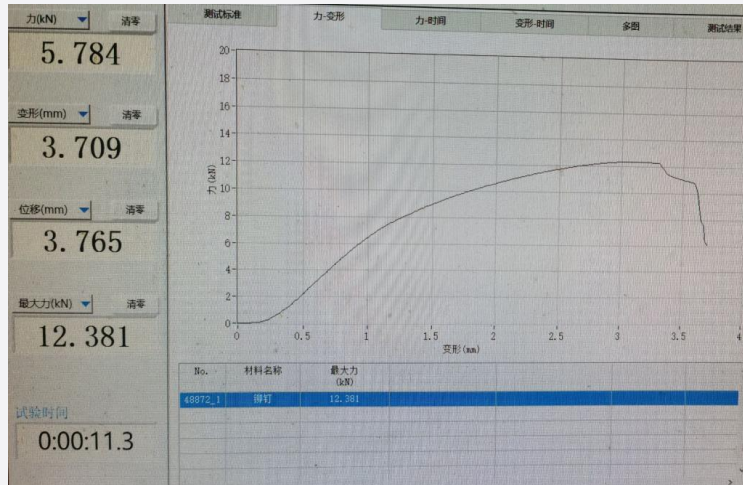
Rivmate

Shear strength:12,381N

Same testing environment: Rivet thickness 8.0mm, fixture hole diameter 6.8mm, using the same tensile testing machine

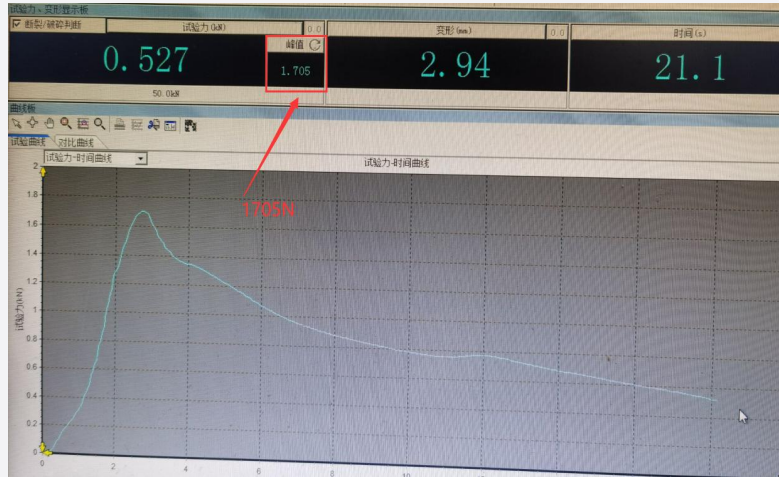
STANLEY

Shear strength:12,454 N

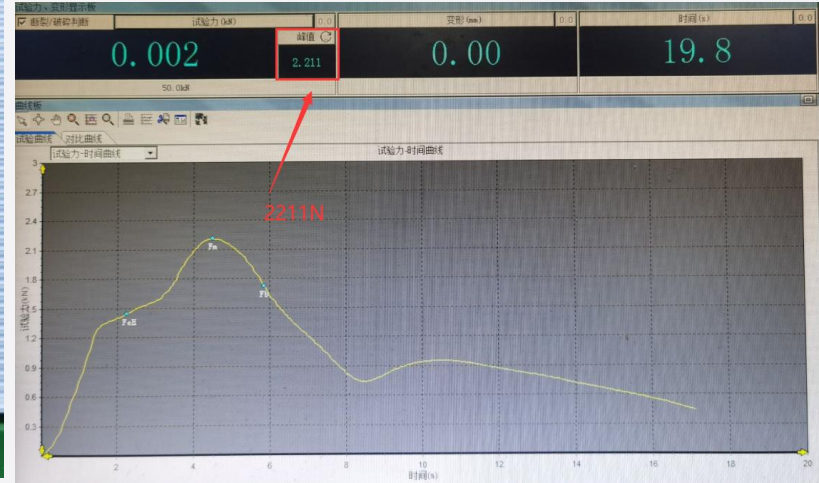


Comparison-Mechanical performance: Mandrel Retention Force

Rivmate



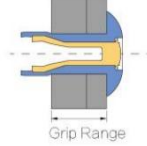
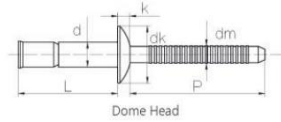
STANLEY



Rivmate & Stanley Drawing Comparing

Rivmate

BBM

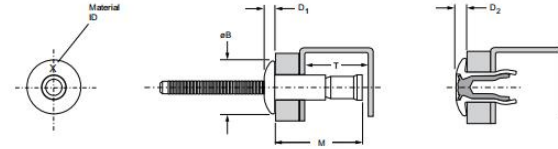


Units: mm

No.	Part Number	Size	AVD Art. Code	d	k (Max)	L (Max)	dk (Max)	P (Min)	dm (Max)	Hole Dia	Grip Range	Tensile ref.	Shear ref.	Breaking Load (Max)	Retention load (Min)
1	BBM48100	4.8×10	BBM-0613	4.8	2.2	18.2	10.1	27.0	3.1	4.9-5.1	1.6-6.5	5100N	5400N	7000N	445N
2	BBM48140	4.8×14	BBM-0617			24.4					1.6-11.0				
3	BBM64140	6.4×14	BBM-0817	6.4	3.0	26.7	13.4	27.0	4.1	6.7-7.0	2.1-9.5	9000N	11000N	12000N	1112N
4	BBM64190	6.4×19	BBM-0824			36.5					2.1-16.0				
5	BBM98210	9.8×21	BBM-1228	9.8	4.0	36.2	20.0	32.0	6.15	10.0-10.4	3.0-16.0	19400N	26080N	20000N	2400N

STANLEY

*: AISI 304



ø					M	øB	D ₁	T	D ₂			Part No/ref
nom.	min.	max.	min.	max.	max.	max.	max.	min.	max.	kN ¹⁾	kN ¹⁾	
4.8 (3/16")	1.63	6.86	4.9	5.1	18.2	10.1	2.1	10.5	1.9	6.44	5.11	02711-00613 ²⁾
	1.63	11.10			24.5			13.5				02711-00617 ²⁾
6.4 (1/4")	2.03	9.53	6.6	7.0	23.7	13.4	2.9	12.2	2.7	11.78	10.45	02711-00817 ²⁾
	2.03	15.87			33.0			16.4				02711-00824 ²⁾
10.0 (3/8")	3.04	15.87	9.95	10.4	36.2	20.3	4.1	22.3	4.0	26.08	19.40	02711-01228



Comparison-Conculsion

Compared with STANLEY, Rivmate rivet are basically similar in size and structure, and the mandrel thread rolling process is slightly different, but both can meet the riveting requirements.

Rivmate rivets and STANLEY rivets can meet the requirements of mandrel locking effect after riveting.

Mechanical properties: When the hole diameter is 6.8mm and the riveting thickness is 8.0mm, the tensile strength of Rivmate rivet is slightly lower than that of STANLEY rivet; the Rivmate drawing parameter is the minimum value of 9000N, and the measured average value is about 9800N, and the Stanley drawing parameter is the reference value of 10450N, and the measured average value is about 10200N.

The shear force of the two is basically close; when the hole is 6.8mm and the riveting thickness is 10.0mm, the mandrel retention force of Rivmate products is slightly lower than that of STANLEY products (the standard parameter is 1112N).





**Thank you for viewing this comparison
report, hope this report can bring
“value” to your company!**

**Suzhou Rivmate Import
& Export Co., Ltd**