



TOP SCREW METAL CORP.

Bolt Rivet Nut



The Bolt Rivet Nut features a round serrated body that installs in the same fashion as a Blind Rivet Nut. The Bolt Rivet Nut is an ideal alternative to weld stud and clinch stud.

The Bolt Rivet Nut fastener makes fastening easy as they:

Install without warping the workpiece

Install into material as thin as 0.20 or 0.5mm.

Install after finish to eliminate thread masking.

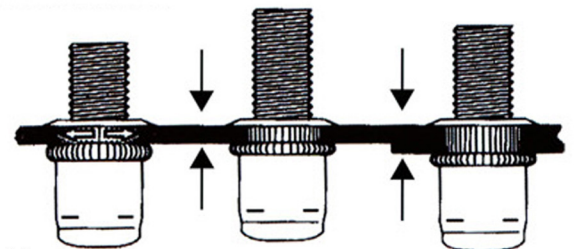
Install into a wide range of material type or thickness.

Install without producing harmful dust, gas or electromagnetic fields.

Install with hand help pneumatic tools at any location on the assembly.

Install into galvanised or pre-painted material without damaging surface.

Install blind eliminating the need to access the backside of the workpiece.



As The Bolt Rivet Nut is installed, the knurled body expands 360° filling the hole.

This feature provides exceptional torque strength and vibration resistance.

The installation tool then continues to install the stud forming a backside flange even in variable thickness material without adjustment.

The Bolt Rivet Nut fastener is available in M5 to M8 thread sizes in steel with Zinc/Yellow finish.

It is ideal for applications on vertical surfaces where the mating component can be 'hung' on the Bolt Rivet Nut before final assembly is made with mating nut.

Hexagonal head are also available.

Superior corrosion resistance is provided by our standard Zinc/Yellow dichromate finish.

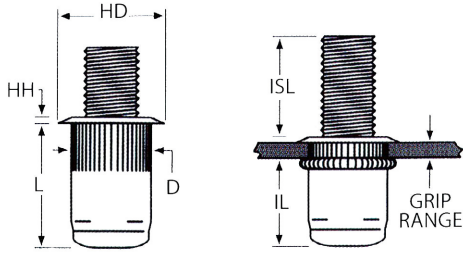
Available in steel 1010, 1008 shell - steel 10B21 threaded stud.

Bolt Rivet Nuts

ISL (INSTALLED STUD LENGTH) DIMENSION IS BASED ON MAX. GRIP INSTALLATION.
TO CALCULATE THE ACTUAL ISL IN A SPECIFIC GRIP, USE THE FOLLOWING FORMULA:

MAX. GRIP - ACTUAL GRIP =
GRIP DIFFERENCE

ISL + GRIP DIFFERENCE =
ACTUAL ISL



PART NUMBER	THREAD SIZE	THREAD CALL OUT	GRIP RANGE	GRIP CALL OUT	STUD LENGTHS MIN.			HOLE SIZE +.006 -.000	HD ±.010 ±.025*	HH ±.003	L ±.020	D MAX.	IL MAX.	TOOL RPM	DYNAMIC AIR PRESSURE SETTINGS PSI
					ISL	ISL	ISL								
					CALL OUT	CALL OUT	CALL OUT								
TSBS 632-B	6-32 UNC	632	.020-.080	80	.500	.625	.750	17/64 (.2656)	.390	.030	.485	.265	.360	3000	70 - 80
TSBS 632-BL	6-32 UNC	632	.080-.130	130	.450	.575	.700	17/64 (.2656)	.390	.030	.535	.265	.360	3000	70 - 80
TSBS 832-B	8-32 UNC	832	.020-.080	80	.500	.625	.750	17/64 (.2656)	.390	.030	.485	.265	.360	3000	75 - 90
TSBS 832-BL	8-32 UNC	832	.080-.130	130	.450	.575	.700	17/64 (.2656)	.390	.030	.535	.265	.360	3000	75 - 90
TSBS 1024-B	10-24 UNC	1024	.020-.130	130	.500	.625	.750	19/64 (.2969)	.415	.030	.545	.296	.380	1500	60 - 80
TSBS 1024-BL	10-24 UNC	1024	.130-.225	225	.405	.530	.655	19/64 (.2969)	.415	.030	.655	.296	.380	1500	60 - 80
TSBS 1032-B	10-32 UNF	1032	.020-.130	130	.500	.625	.750	19/64 (.2969)	.415	.030	.545	.296	.380	1500	60 - 80
TSBS 1032-BL	10-32 UNF	1032	.130-.225	225	.405	.530	.655	19/64 (.2969)	.415	.030	.655	.296	.380	1500	60 - 80
TSBS 420-B	1/4-20 UNC	420	.027-.165	165	.625	.8125	1.000	25/64 (.3906)	.500	.030	.670	.390	.465	900	70 - 90
TSBS 420-BL	1/4-20 UNC	420	.165-.260	260	.530	.7175	.905	25/64 (.3906)	.500	.030	.770	.390	.465	900	70 - 90
TSBS 518-B	5/16-18 UNC	518	.027-.150	150	.625	.875	1.125	17/32 (.5312)	.685*	.035	.810	.530	.555	600	80 - 110
TSBS 518-BL	5/16-18 UNC	518	.150-.312	312	.463	.713	.963	17/32 (.5312)	.685*	.035	.925	.530	.510	600	80 - 110
TSBS 616-B	3/8-16 UNC	616	.027-.150	150	.750	1.000	1.250	17/32 (.5312)	.685*	.035	.810	.530	.555	600	80 - 110
TSBS 616-BL	3/8-16 UNC	616	.150-.312	312	.588	.838	1.088	17/32 (.5312)	.685*	.035	.925	.530	.510	600	80 - 110

PART NUMBER	THREAD SIZE	THREAD CALL OUT	GRIP RANGE	GRIP CALL OUT	STUD LENGTHS MIN.			HOLE SIZE +.015 -.000	HD ±0.25 ±0.64*	HH ±0.08	L ±0.50	D MAX.	IL MAX.	TOOL RPM	DYNAMIC AIR PRESSURE SETTINGS BARS
					ISL	ISL	ISL								
					CALL OUT	CALL OUT	CALL OUT								
TSBS 470-B	M4x0,7 ISO	470	0,50-2,00	2.0	12,0	15,0	20,0	6,75	9,91	0,76	12,32	6,73	9,15	3000	4.8 - 5.5
TSBS 470-BL	M4x0,7 ISO	470	2,00-3,30	3.3	10,7	13,7	18,7	6,75	9,91	0,76	13,59	6,73	9,15	3000	4.8 - 5.5
TSBS 580-B	M5x0,8 ISO	580	0,50-3,30	3.3	12,0	15,0	20,0	7,60	10,54	0,76	13,84	7,52	9,65	1500	4.1 - 5.5
TSBS 580-BL	M5x0,8 ISO	580	3,30-5,70	5.7	9,6	12,6	17,6	7,60	10,54	0,76	16,64	7,52	9,65	1500	4.1 - 5.5
TSBS 610-B	M6x1,0 ISO	610	0,70-4,20	4.2	15,0	20,0	25,0	10,00	12,70	0,76	17,02	9,91	11,81	900	5.5 - 6.2
TSBS 610-BL	M6x1,0 ISO	610	4,20-6,60	6.6	12,6	17,6	22,6	10,00	12,70	0,76	19,56	9,91	11,81	900	5.5 - 6.2
TSBS 8125-B	M8x1,25 ISO	8125	0,70-3,8	3.8	16,0	22,0	28,0	13,50	17,40*	0,89	20,57	13,46	14,10	600	5.5 - 7.5
TSBS 8125-BL	M8x1,25 ISO	8125	3,8-7,90	7.9	11,9	17,9	23,9	13,50	17,40*	0,89	23,50	13,46	12,96	600	5.5 - 7.5
TSBS 1015-B	M10x1,5 ISO	1015	0,70-3,8	3.8	20,0	25,0	30,0	13,50	17,40*	0,89	20,57	13,46	14,10	600	5.5 - 7.5
TSBS 1015-BL	M10x1,5 ISO	1015	3,8-7,90	7.9	15,9	20,9	25,9	13,50	17,40*	0,89	23,50	13,46	12,96	600	5.5 - 7.5

NOTE 1: Grip range can be affected by parent material density and actual hole size.
We suggest trial installations to determine optimum grip.

NOTE 2: Additional UNF fine threads, grip lengths and materials are available.
Contact Imperial Rivets & Fasteners for details.

Thread Specification:
Unified - 2A/21 per ASME B1.1
Metric - 6g/21 per ASME B1.21M

