



Chicago Rivet & Machine Co.

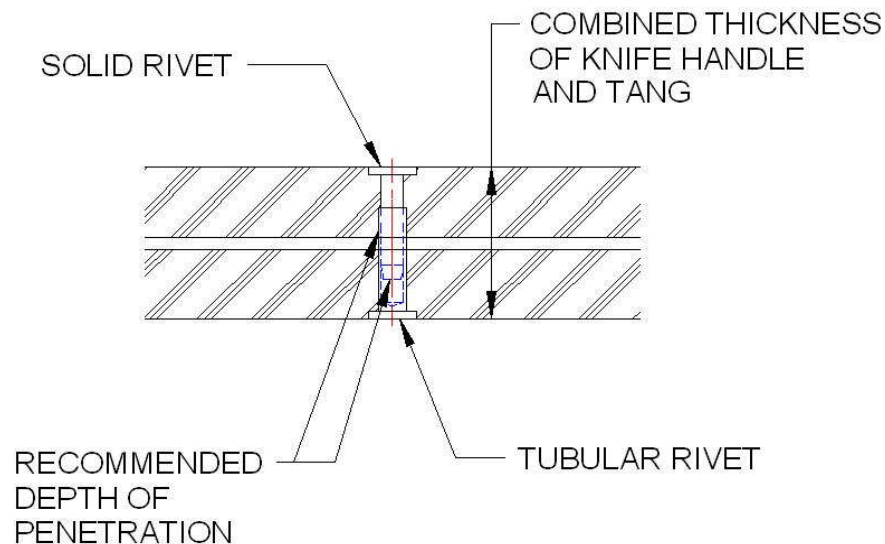
P.O. Box 3061
901 Frontenac Road
Naperville, IL 60566-7061
Ph. (630) 357-8500
Fax (630) 983-9314
www.chicagorivet.com

Compression or Cutlery Rivets

A compression rivet is a combination of a solid rivet with a chamfered shank and a deep-drilled rivet. In application, both are swedged together and designed to fit accurately into counterbored holes of knife handles or similar applications. Satisfactory riveting requires the following:

1. The rivets must be made to close tolerances so that shank and head are almost perfectly concentric. Fastening must be accomplished by uniform swelling of the tubular shank to lock securely in the tang of the knife or appliance.
2. Both sections of the rivet must be of correct length so that the rivet heads are flush with the outside surface of the handle.

Safe Rule to Follow in Compression Rivet Length Selection



Each unit when swedged together should equal at least 3/4 of the combined thickness of both sides of the knife handle, including the tang. This permits approximately 1/4 of the shank length of the solid rivet and 1/4 of the shank length of the tubular section to extend through the opposite side of the tang.

Example:

A compression rivet with .050" head thickness has been selected on a handle and tang having a combined thickness of 1.000". The rivet recommended, measured under the head, should be 11/16", provided the rivet heads are to be flush in the handle. The result is arrived at as follows:

Combined thickness of knife handle and tang	1.000"
Total rivet head thickness	<u>-.100"</u>
Length between bottom of rivet heads	.900"

Applying the formula:

$$3/4 \text{ of } .900" = .675"$$

The nearest increment length of compression rivet is .687" or 11/16".



Compression Rivet Standards												
Body Diameter	.083"		.105"		3/32"		1/8"		1/8"		5/32"	
Style	Solid	Tubular	Solid	Tubular	Solid	Tubular	Solid	Tubular	Solid	Tubular	Solid	Tubular
Head Diameter	3/16" x .036		7/32" x .036		1/4" x .044		9/32" x .044		5/16" x .044		11/32" x .044	
Steel	R-4518	R-4519	R-4500	R-4501	R-4504	R-4505	R-4520	R-4521	R-4506	R-4507	R-4510	R-4511
Brass	R-4550	R-4551	R-4530	R-4531	R-4532	R-4533	R-4534	R-4535	R-4536	R-4537	R-4538	R-4539
18% Nickel Silver	R-4618	R-4619	R-4620	R-4621	R-4622	R-4623	R-4624	R-4625	R-4626	R-4627	R-4628	R-4629

CHICAGO RIVET & MACHINE CO.												
Body Diameter	1/8"		5/32"		9/64"		3/16"		9/64"		3/16"	
Style	Solid	Tubular	Solid	Tubular	Solid	Tubular	Solid	Tubular	Solid	Tubular		
Head Diameter	3/8" x .044		5/16" x .050		11/32" x .050		3/8" x .050		7/16" x .050			
Steel	R-4512	R-4513	R-4514	R-4515	R-4522	R-4523	R-4524	R-4525	R-4516	R-4517		
Brass	R-4540	R-4541	R-4542	R-4543	R-4544	R-4545	R-4546	R-4547	R-4548	R-4549		
18% Nickel Silver	R-4630	R-4631	R-4632	R-4633	R-4634	R-4635	R-4636	R-4637				

NOTE: Subject to change without notice