Effective 1 st July 2020

CATALOGUE 2020/21

Blind rivets, blind rivet nuts and riveting tools

A member of SFS

GESIPA®

Follow us on

www.gesipa.com
youtube.com/gesipa-videos

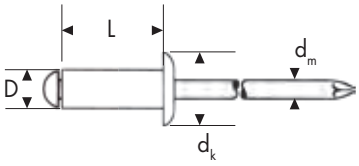
Overview

Please find the detailed table of contents on page 6.

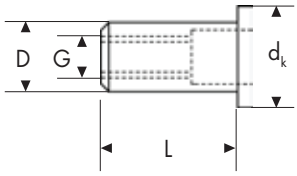
CATALOGUE GUIDE

BLIND RIVET/BLIND RIVET NUT DIMENSIONS
acronyms

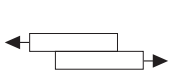
NEW



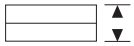
D = Rivet body Ø
L = Rivet body length
d_k = Setting head Ø
d_m = Mandrel Ø



D = Rivet nut body Ø
L = Rivet nut body length
d_k = Setting head Ø
G = Thread dimension


Shear strength


Tensile strength


Grip range

Hole Ø = d_h

PART NUMBERS
Our part numbers are marked by **No.**

No.145 0810

NEW

COLOR LEGEND of blind rivet materials

- Alu
- Steel
- Stainless steel A2
- Stainless steel A4
- Copper
- Plastic
- Monel®
  (Nickel-copper alloy))

PAGE REFERENCE
This symbol refers to the page number.

20

CE MARKING
The EU Construction Products Regulation (CPR) No. 305/2011 came into effect in June 2013. The approved products in our catalogue are marked with the CE symbol. The relevant approval documents can be found in the download area at **www.gesipa.com**.

In accordance with ETA approval **ETA-13/0255**

CE

AVAILABILITY
This product is made to order. Contact our Customer Service for detailed information on availability.

SYMBOLS FOR BATTERY AND CHARGER

NEW

- 14 V — Battery 14.4 V/1.3 Ah
- 14 V — Charger 14.4 V Li-Ion
- 18 V — Slide-on battery 18 V/2.1 Ah
- 18 V — Charger 18 V Li-Ion
- 18 V 18 V — 2 batteries in scope of delivery
- Tool is delivered in a carton
- Tool is delivered in a plastic case

QR-CODES / VIDEOS
Scan the QR codes to receive more information or watch videos about products

VIDEO — Video

Product information

Don't you have a QR Code scanner? Then simply use the Google Play Install App Store for free:

JETZT BEI Google Play — Laden im App Store

More dimensions and Types available on request.
We reserve the right to make changes for the entire catalogue. We do not accept liability for errors or misprints.

The applicable terms and conditions of guarantee shall apply and can be viewed under following link: https://en.gesipa.de/service/manufacturers-warranty/

GESIPA®S NEW PRODUCTS

OUR NEWS AT A GLANCE!

NEW

S. 152

INTERFACE 4.0

The new communication interface between GESIPA® tools and production

S. 196

BLIND RIVET NUTS

Light Weight > S. 196
High Strength > S. 198
Torque resistant > S. 199
G-Sealed® > S. 200

S. 226

FIREBIRD® PRO S GOLD EDITION

The blind rivet nut setting tool with stroke adjustment

CONTENTS

20 PROGRAM BLIND RIVET TECHNOLOGY

178 PROGRAM BLIND RIVET NUT TECHNOLOGY

251 POINT OF SALE / DO IT YOURSELF

GESIPA® – AT A GLANCE

A member of SFS

GESIPA®

1955 year of foundation. High standards, the reliability of GESIPA® fasteners, innovative, high-quality setting tools and process-oriented consulting services have made GESIPA® a valuable and valued partner for trade and industry. Family-owned until the end of 2008, GESIPA® is now a member of the international SFS Group.

PRODUCTION SITES AROUND THE WORLD

ALWAYS AT YOUR SIDE WITH BRANCHES AND AGENCIES ON ALL CONTINENTS

GESIPA BLINDNIETTECHNIK GMBH

5

GESIPA BUSINESS UNITS

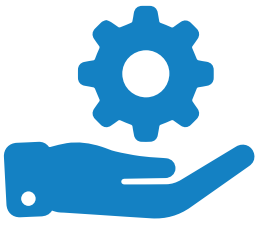
Application-optimised and cost-effective joining solutions

- **Distribution and Retail** (R-DR)
- **Equipment Manufacturer** (R-EM)
- **Industrial Applications** (R-IA)
- **Automotive Riveting** (R-AR)
- **Solid Riveting** (R-SR)

GESIPA® riveting technology focuses on **five** customer segments. The top priority is the direct relationship with the customer and his specific requirements with the aim of designing application-optimised and cost-effective joining solutions.

All German GESIPA® production locations operate a quality management system certified to DIN EN ISO 9001 and ISO TS 16949.

CUSTOMER PROXIMITY and **FLEXIBILITY** are certainly given top priority at GESIPA®. The creativity and openness to innovation of all our employees contribute to lasting customer satisfaction and partnership-based cooperation.



GESIPA®-SERVICE
Take advantage of GESIPA® Services – a multitude of services from a single source for a simple and straightforward process.

SUSTAINABILITY IS IMPORTANT TO US!
Ergonomics and economical energy consumption are priorities for us in our setting tools.

MADE IN GERMANY
Tools and fasteners that are Made in Germany. At our three German locations, we manufacture top-quality blind rivets and setting tools for international demand.

IN THE BEST HANDS AT GESIPA®!
Highly skilled staff, top-level production machines and manufacturing quality controls guarantee fulfilment of our customers' most stringent demands.

GESIPA®-SERVICE*

GESIPA® – Comprehensive range of services from under one roof

WORLDWIDE SERVICE
The people at GESIPA® are committed and passionate about providing high-quality, innovative products every day, worldwide. GESIPA® isat your side on every continent through our own sites or our trade partners.

INITIAL SAMPLE INSPECTION (PPAP, VDA 2)
Initial sample inspection verifies that, prior to the start of series production, the customer requirements agreed upon in the specification as well as other requirements (e.g. legislation, standards) in terms of the product and process are met. The same also applies to the annual re-qualification

NEW GESIPA®-REPAIR SERVICE

Further Information to our optimized Repairservice here:

REPAIR SERVICE
GESIPA® processing tools are manufactured to the highest quality standards. However, should repairs ever become necessary our technicians will provide fast and reliable assistance.

FIRMWARE UPDATE
Firmware updates are available on request to keep your processing systems up-to-date, making sure they operate reliably safely and efficiently at all times.

FACTORY CALIBRATION
Process-monitored riveting tools are calibrated based on applicable test standards as part of the GESIPA calibration service. The calibration standard used is verified by routine test equipment monitoring. We can also carry out the calibration procedure directly on your premises.

COMMISSIONING
Following the installation of a machine, comprehensive customer service is provided by our resourceful service team. The service team carries out both the commissioning as well as the maintenance of the machine.

**These services vary specific to country and are based on the service programmes available at the Walldorf/Germany site.

MAINTENANCE & SERVICING AGREEMENTS
Regular servicing and maintenance are required to ensure processes and production runs smoothly. Servicing and maintenance are the foundation for guaranteeing high availability of your production facilities where downtimes are minimised, thus keeping costs down. These procedures also increase operational safety thereby protecting your personnel.

TECHNICAL TALKS
Whether in our Demonstration Center, on your premises or at conferences: when it comes to selecting the venue and time we are really flexible. Talks aimed at specific target groups

TRAINING
We hold training courses for our customers' staff at our training centres or, if required, on site. The innovative training programme includes training courses on equipment, GAV systems as well as foundation andadvanced courses.

ONLINE-SERVICE
More Infos here:

ONLINE-SERVICE
GESIPA® uses the Oxomi platform to maintain close ties with our customers. At the POS and across our network, we provide our customers with the latest marketing materials such as brochures, operating instructions, product videos, etc. online and offline via our homepage or mobile app. In addition, most of our products can now also be ordered directly from our authorised trade partners via the **BUY NOW button** on our homepage. Delivery times and prices of the trading partner are displayed with one click.

REPLACEMENT EQUIPMENT HIRE
(GESIPA® SPECIAL MODELS)
To ensure your production process keeps running smoothly we stock a range of equipment for hire. You can make use of this equipment in maintenance and repair phases. Or when your own equipment pool is unable to deal with peaks in orders. We are here to help!

BLIND RIVET TECHNOLOGY

» trust
» move
» know
» understand
» create

GESIPA®-BLIND RIVETS

GESIPA® BLIND RIVETS PROVIDE A LASTING AND SAFE JOINT FOR DIVERSE AND SENSITIVE MATERIALS.

GESIPA® BLIND RIVETS – EFFICIENT TECHNOLOGY

Life without blind rivet technology from GESIPA® can no longer be imagined in modern industry production where fastening technology is required due to its efficiency and versatility. It combines the advantagesof overcoming restricted component accessibility, permanently safe connection of different, and specialised materials, and even documentation of the setting process if required.

Technically speaking, the blind rivet consists of two parts: the rivet body and the mandrel. During screw-connecting, clinching and punch riveting etc. the application must always be accessible on both sides but the special thing about blind riveting is that the application only needs to be accessed from one side.

GESIPA® BLIND RIVETS – CONNECTIONS THAT LAST

During the setting process, the mandrel is pulled by the jaws of the setting tool and forms the rivet body to the predefined fixed position in the application. The mandrel then breaks off at the intended point (the target breakage point) and can be recycled. The filling cut (this is the remaining rest of mandrel in the rivet body) can provide an additional securing function depending on the application.

GESIPA® BLIND RIVETS – FOR EVERY APPLICATION

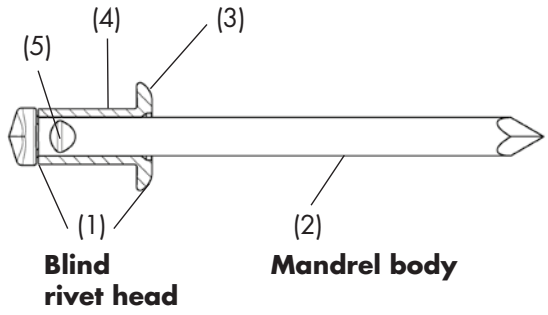
Blind rivets are available in a variety of designs, materials, forms, lengths and even colours. Depending on the task which the blind rivet should fulfil, GESIPA® can choose between a standard model available from stock or a blind rivet specially designed for the application

GESIPA® BLIND RIVETS – A RULE OF THUMB

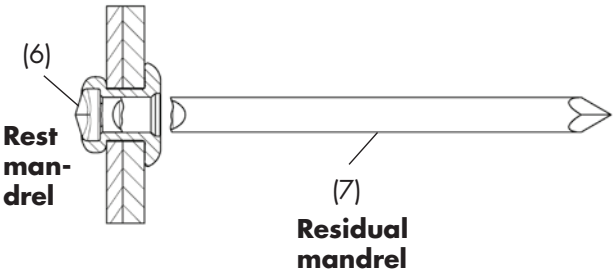
Material thickness + rivet diameter = rivet body length

TECHNICAL DATA on GESIPA® blind rivets

BLIND RIVET BEFORE SETTING PROCESS



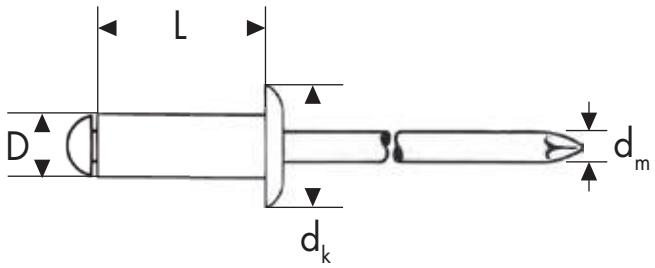
BLIND RIVET AFTER SETTING PROCESS

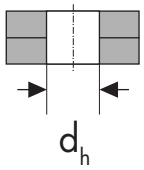


GESIPA®-BLINDNIETE – BEGRIFFLICHKEITEN

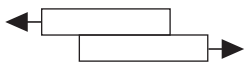
- The blind rivet consists of two parts: the **blind rivet head** (1) and the **mandrel body** (2).
- The rivet body consists of the **setting head** (3) and the **shaft** (4).
- The setting head is found on the processing side and is variable in diameter and shape. There are **dome**, **countersunk** and **large flange** versions. The rivet body is available in different lengths depending on the material thickness to be riveted.
- The rivet mandrel is used to deform the rivet body. It contains the **predetermined breaking point** (5) This is where the rivet mandrel breaks after the rivet has deformed.
- The **rest mandrel** (6) is the remaining part of the rivet mandrel in the rivet body. The **residual mandrel** (7) is the part of the rivet mandrel that is disposed of from the set rivet via the blind rivet setting tool.

BLIND RIVET– DIMENSIONS /SYMBOLS

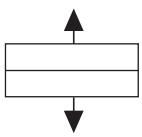




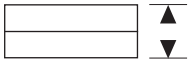
D = Rivet body Ø
L = Rivet body length
d_k = Setting head Ø
d_m = Mandrel Ø
d_h = Hole Ø



Shear strength



Tensile strength



Grip range

hole Ø = d_h

For the hole Ø is generally a tolerance of +0.1 / 0 to note!

IN THE BEST HANDS AT GESIPA®

Special challenges in industry demand special solutions with regard to efficiency, function and innovation. GESIPA® has decades of experience in consultancy and development of blind rivets for specific applications. Requirements such as surface treatments, appropriate shear strength and/or tensile strength and setting process reliability are defined by Technical Sales according to the project, and guarantee millions of consistent quality fastenings.

QUALITY

From the traceability and documentation of the raw materials to the checking of dimensions and tolerances during production, GESIPA® attaches the greatest value to quality. But GESIPA® also goes one decisive step further. For blind rivets for specific applications, thorough functional tests are carried out and documented step-by-step.

FUNCTIONAL TEST /SETTING CURVE

For every production batch of blind rivets for specific applications, the setting curve is measured on a sophisticated test bench. The measured results of shaft deformation, insertion characteristics, mandrel shear load and tensile force are compared with the target values in order to ensure that the blind rivet forms as intended in the application and produces a secure fastening.

FUNCTION TESTS/MANDREL PUSH-OUT FORCE (1)

The remaining part of the mandrel enclosed in the set rivet is pushed out. The measured force can be used to determine whether the remaining part of the mandrel is properly locked and will not cause any rattling noises or even fall out. The batch is only released if both these values are within tolerance.

MONITORED PROCESS – RELIABLE CONNECTION (2)

Safety relevant processes in the industrial use of blind rivets make 100% reliability of riveting operations essential. The process-controlled GESIPA® tools enable economic application solutions, from the basic system to systems with barcode scanners and process computers.

ONE FASTENER FOR SEVERAL APPLICATIONS

The versatility of GESIPA® fasteners often means that several application cases which previously required different fasteners can be served by a single specially designed blind rivet. This saves costs and simplifies handling.

COST ADVANTAGES AT A GLANCE

- Reduction of downstream quality costs due to GESIPA® setting process monitoring
- Reduction of wearing parts costs due to identical parts strategy and modular design of the tools
- Reduction of logistics costs due to multi-functionality of the fasteners and corresponding reduction of parts diversity.

Abb. 1

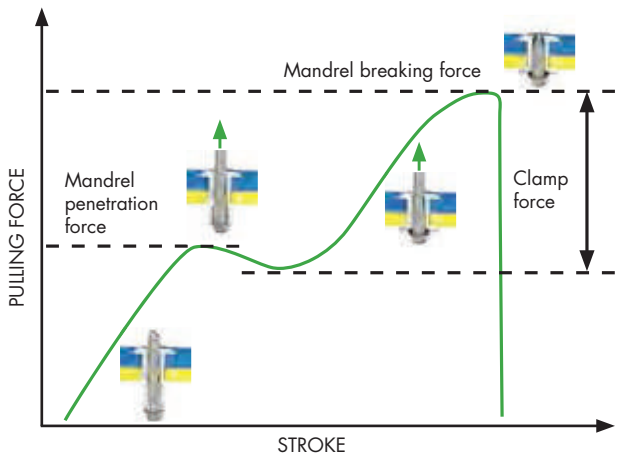
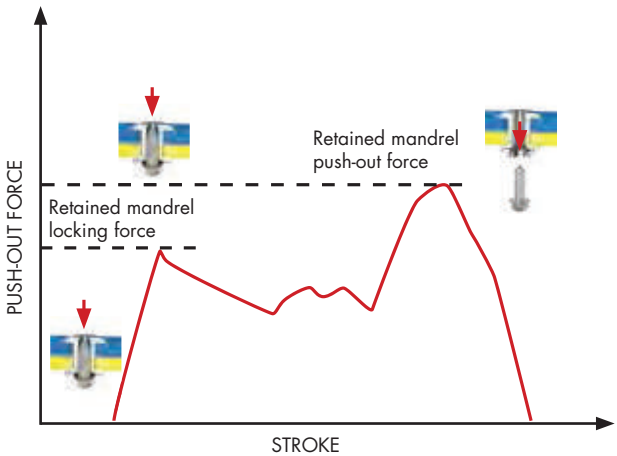


Abb. 2



CORROSION PROTECTION AND WATERTIGHTNESS

Our fasteners provide corrosion protection and watertightness to various extents depending on the material chosen. The features of the individual fasteners are shown in the following tables:

Category	Water tightness	Corrosion resistance
STANDARD BLIND RIVETS		
Alu/Steel		••
Alu/Stainless steel		•••
Alu/Alu		•••
Steel/Steel		•
Copper/Steel		••
Copper/Bronze		•••
Stainless steel/Stainless steel		••••
Stinox		••
POLYGRIP® BLIND RIVETS		
Alu/Steel	✱⚹	••
Alu/Stainless steel	✱⚹	•••
Steel/Steel		•
Stainless steel/Stainless steel		••••
SolarGrip® with (SolarSeal-coating)	✱⚹	••••
CAP® BLIND RIVETS		
Alu/Steel	⚹	••
Alu/Stainless steel	⚹	•••
Stainless steel/Stainless steel	⚹	••••
Copper/Steel	⚹	••
Copper/Stainless steel	⚹	•••
SPECIAL BLIND RIVETS		
Painted blind rivets alu/stainless steel		•••
Grooved blind rivets alu/steel		••
Blind rivets thread Steel/Steel		•
Plastic blind rivets (Polyamide)		••••
Peel blind rivets alu/steel		••
Profile clinching rivets alu/steel		••

Category	Water tightness	Corrosion resistance
HIGH STRENGTH STRUCTURE BLIND RIVETS		
G-Bulb steel/steel		•
G-Bulb Stainless steel/ stainless steel		•••
MEGA GRIP® alu/ alu	✱⚹	••
MEGA GRIP® steel/steel	✱⚹	•
Folding Type blind rivets		
BULB-TITE® blind rivets alu/alu	✱	••
TRI-FOLD® blind rivets alu/alu		••
STANDARD AND POLYGRIP® BLIND RIVET NUTS		
Alu		•••
Steel		•
Stainless steel		••••
Monel®		••••
BLIND RIVET NUT STUDS		
Steel		•

⚹ Fastener is watertight
✱ Joint is wateright when a washer is used
✱⚹ Splash-proof

• low
•• middle
••• high
•••• very high

Further sizes, special surface treatments or materials are available upon request.

THE APPLICATION-SPECIFIC GESIPA® FASTENING ...

The basic features of the standard blind rivet are defined by various DIN EN ISO standards. These features primarily involve the geometric dimensions and mechanical properties. Other fastener properties, such as the choice of material and surface coating, are defined very generally by the standards and are left up to the manufacturer. These specifications about the blind rivet features seriously limit the tolerances of the connection parameters and the feasible requirements. Blind rivets that comply with DIN EN ISO standards are always designed for fixed parts

CUSTOMER REQUIREMENT	GESIPA® SOLUTION
Adaption to rubber, wood, plastic and other materials	Definition of max. / min. tightening value or clamping force
Watertightness	Material + stamping + coating
Accessibility problem	Extended nosepiece in combination with a rivet mandrel extension
Corrosion resistance	Through organic and inorganic surfaces e.g. Zn, ZnNi, Delta Seal, stainless steel A2 and A4 or Monel® Organic Topcoat
No noise	Monitored rest mandrel locking
Tolerance compensation	Borehole diameter larger than DIN
High device and system availability	Device and fastener matched to each other, GESIPA®-general system

GESIPA®-FEM SIMULATION

EFFICIENT AND CUSTOMER-ORIENTED DEVELOPMENT USING FEM SIMULATION

The Finite Element Method (FEM) works by breaking down a component into a finite number of defined geometric elements. Boundary conditions, such as the application of force and displacement, can be defined for these elements, and the structure's reaction can be calculated by applying physical laws.

The result is the virtual simulation of deformation processes in the production process or the process of setting a joining element.

BENEFITS

- Simulation integrated into the concept phase
- Efficient, fast and customer-oriented development
- Shorter development times
- Reduction of development costs
- Targeted tool design and optimisation
- Avoidance of errors during the production process
- Savings in quality costs

BLIND RIVET RANGE

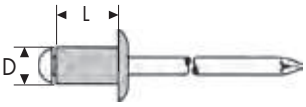
- » multifunctional
- » resistant
- » application-specific

OVERVIEW of the GESIPA® blind rivet product range

BLIND RIVETS ***ALU/STEEL***

Standard Dome head

Aluminium alloy Steel, zinc-plated



D	D x L mm	mm	No.	
2.4 2.5 mm	**2.4 x 4**	0.5 - 2.0	**145 4019**	A 1,000
	2.4 x 6	1.5 - 3.5	**143 3464**	A 1,000
	2.4 x 8	4.0 - 6.0	**145 4020**	A 1,000
3 3.1 mm	**3 x 4**	0.5 - 1.5	**143 3466**	A 500
	3 x 5	1.5 - 2.5	**143 3467**	A 500
	3 x 6	2.5 - 3.5	**143 3468**	A 500
	3 x 7	3.5 - 4.5	**143 3469**	A 500
	3 x 8	4.5 - 5.0	**143 3470**	A 500
	3 x 10	5.0 - 7.0	**143 3471**	A 500
	3 x 12	7.0 - 9.0	**143 3472**	A 500
	3 x 14	9.0 - 11.0	**145 4022**	A 500
	3 x 16	11.0 - 13.0	**145 4023**	A 500
	3 x 18	13.0 - 15.0	**145 4024**	A 250
	3 x 20	15.0 - 17.0	**145 4025**	A 250
	3 x 25	17.0 - 22.0	**143 3473**	A 250
	3 x 30	22.0 - 26.0	**145 4026**	A 250
3.2 3.3 mm	**3.2 x 4**	0.5 - 1.5	**143 3475**	A 500
	3.2 x 6	1,5 - 3,5	**143 3476**	A 500
	3.2 x 8	3.5 - 5.0	**143 3477**	A 500
	3.2 x 10	5.0 - 7.0	**143 3478**	A 500
	3.2 x 12	7.0 - 9.0	**143 3479**	A 500
	3.2 x 14	9.0 - 11.0	**143 3465**	A 500
	3.2 x 16	11.0 - 13.0	**143 3480**	B 500
	3.2 x 18	13.0 - 15.0	**143 3483**	B 500
	3.2 x 20	15.0 - 17.0	**143 3481**	B 500
	3.2 x 25	17.0 - 22.0	**143 3482**	B 500
4 4.1 mm	**4 x 5**	0.5 - 1.5	**143 3484**	A 500
	4 x 6	1.5 - 3.0	**143 3485**	A 500
	4 x 7	3.0 - 4.0	**145 4028**	A 500
	4 x 8	4.0 - 5.0	**143 3486**	A 500
	4 x 10	5.0 - 6.5	**143 3487**	A 500
	4 x 12	6.5 - 8.5	**143 3488**	B 500
	4 x 14	8.5 - 10.5	**145 4029**	B 500
	4 x 16	10.5 - 12.5	**145 4030**	B 500
	4 x 18	12.5 - 14.5	**145 4031**	B 500
	4 x 20	14.5 - 16.5	**145 4032**	B 500
	4 x 25	16.5 - 21.5	**145 4033**	B 500
	4 x 30	21.5 - 26.0	**145 4034**	B 250
	4 x 35	26.0 - 30.0	**145 4035**	B 250
	4 x 40	30.0 - 35.0	**145 4036**	B 250

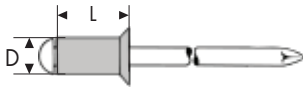
D	D x L mm	mm	No.	
4.8 4.9 mm	**4.8 x 6**	2.0 - 2.5	**143 3493**	B 500
	4.8 x 8	2.5 - 4.5	**143 3494**	B 500
	4.8 x 10	4.5 - 6.0	**143 3495**	B 500
	4.8 x 12	6.0 - 8.0	**143 3496**	B 500
	4.8 x 14	8.0 - 10.0	**145 4043**	B 500
	4.8 x 16	10.0 - 12.0	**143 3497**	B 500
	4.8 x 18	12.0 - 14.0	**145 4044**	B 500
	4.8 x 20	14.0 - 15.0	**145 4045**	B 250
	4.8 x 25	15.0 - 20.0	**143 3498**	B 250
	4.8 x 30	20.0 - 25.0	**143 3499**	A 100
5 CE 5.1 mm	**5 x 6**	2.0 - 2.5	**143 3500**	B 500
	5 x 8	2.5 - 4.5	**143 3501**	B 500
	5 x 10	4.5 - 6.0	**143 3502**	B 500
	5 x 12	6.0 - 8.0	**143 3503**	B 500
	5 x 14	8.0 - 10.0	**145 4048**	B 500
	5 x 16	10.0 - 12.0	**143 3504**	B 500
	5 x 18	12.0 - 14.0	**145 4049**	B 500
	5 x 20	14.0 - 15.0	**145 4050**	B 250
	5 x 25	15.0 - 20.0	**143 3505**	B 250
	5 x 30	20.0 - 25.0	**145 4051**	A 100
	5 x 35	25.0 - 30.0	**145 4052**	A 100
	5 x 40	30.0 - 35.0	**145 4053**	A 100
	5 x 45	35.0 - 40.0	**145 4054**	B 100
	5 x 50	40.0 - 45.0	**145 4055**	B 100
	5 x 55	45.0 - 48.0	**145 4056**	B 100
	5 x 60	48.0 - 52.0	**145 4057**	B 100
	5 x 65	52.0 - 57.0	**145 4058**	B 100
	5 x 70	57.0 - 62.0	**145 4059**	B 100
	5 x 80	62.0 - 72.0	**143 3506**	B 100
6 6.1 mm	**6 x 8**	2.0 - 3.0	**145 4060**	B 250
	6 x 10	3.0 - 5.0	**145 4061**	B 250
	6 x 12	5.0 - 7.0	**145 4062**	B 250
	6 x 16	7.0 - 11.0	**143 3507**	B 250
	6 x 18	11.0 - 13.0	**145 4064**	B 250
	6 x 20	13.0 - 15.0	**145 4065**	B 250
	6 x 25	15.0 - 20.0	**145 4066**	B 200
	6 x 30	20.0 - 24.0	**145 4067**	B 200
	6 x 35	24.0 - 29.0	**145 4068**	B 100
	6 x 40	29.0 - 34.0	**145 4069**	B 100
	6 x 50	34.0 - 44.0	**143 3508**	B 100

BLIND RIVETS ***ALU/STEEL***

D	D x L mm	mm	No.	
6.4 6.5 mm	**6.4 x 12**	2.0 - 6.0	**145 4070**	B 250
	6.4 x 16	6.0 - 10.0	**145 4072**	"
	6.4 x 20	10.0 - 14.0	**145 4073**	B 200
	6.4 x 25	14.0 - 18.0	**145 4074**	"
	6.4 x 30	18.0 - 23.0	**145 4075**	B 100

Countersunk (120°)

Aluminium alloy Steel, zinc-plated



D	D x L mm	mm	No.	
3 3.1 mm	**3 x 6**	1.5 - 3.5	**145 4078**	A 500
	3 x 8	3.5 - 5.0	**143 3509**	"
	3 x 10	5.0 - 7.0	**143 3510**	"
	3 x 12	7.0 - 9.0	**145 4079**	"
	3 x 16	9.0 - 13.0	**145 4080**	"
4 4.1 mm	**4 x 6**	1.5 - 3.0	**145 4081**	A 500
	4 x 8	3.0 - 5.0	**143 3512**	"
	4 x 10	5.0 - 6.5	**145 4082**	"
	4 x 12	6.5 - 8.5	**143 3513**	B 500
	4 x 16	10.5 - 12.5	**143 3514**	"
	4 x 20	14.5 - 16.5	**145 4083**	"

D	D x L mm	mm	No.	
5 5.1 mm	**5 x 8**	2.0 - 4.5	**143 3515**	B 500
	5 x 10	4.5 - 6.0	**143 3516**	"
	5 x 12	6.0 - 8.0	**145 4085**	"
	5x 16	8.0 - 12.0	**145 4086**	"
	5 x 18	12.0 - 14.0	**145 4084**	"
	5 x 20	14.0 - 15.0	**145 4087**	B 250
	5 x 25	15.0 - 20.0	**143 3517**	"
	5 x 30	20.0 - 25.0	**145 4088**	A 100
	5 x 35	25.0 - 30.0	**145 4089**	"

22

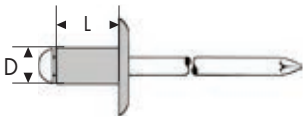
The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 22.**

BLIND RIVETS ***ALU/STEEL***

Large flange

Aluminium alloy

Steel, zinc-plated



D	D x L mm	mm	No.	
3.2 - K 9.5 3,3 mm	**3.2 x 8**	3.5 - 5.0	**145 4091**	"
	3.2 x 10	5.0 - 7.0	**145 4092**	"
	3.2 x 12	7.0 - 9.0	**145 4093**	"
	3.2 x 16	9.0 - 13.0	**145 4094**	B 500
4 - K 12 4.1 mm	**4 x 6**	1.5 - 3.0	**145 4095**	B 500
	4 x 8	3.0 - 5.0	**143 3518**	"
	4 x 10	5.0 - 6.5	**145 4096**	"
	4 x 12	6.5 - 8.5	**145 4097**	"
	4 x 16	8.5 - 12.5	**145 4098**	"
	4 x 20	12.5 - 16.5	**145 4099**	B 250
4.8 - K 16 4.9 mm	**4.8 x 8**	2.5 - 4.5	**145 4106**	B 250
	4.8 x 10	4.5 - 6.0	**145 4107**	"
	4.8 x 12	6.0 - 8.0	**143 3519**	"
	4.8 x 16	8.0 - 12.0	**145 4109**	"
	4.8 x 20	12.0 - 15.0	**145 4111**	"
	4.8 x 25	15.0 - 20.0	**143 3520**	"

D	D x L mm	mm	No.	
5 - K 11 5.1 mm CE	**5 x 8**	2.5 - 4.5	**143 3521**	B 500
	5 x 10	4.5 - 6.0	**145 4116**	"
	5 x 12	6.0 - 8.0	**143 3522**	"
	5 x 14	8.0 - 10.0	**145 4115**	"
	5 x 16	10.0 - 12.0	**145 4117**	"
	5 x 18	12.0 - 14.0	**145 4113**	B 250
	5 x 20	14.0 - 15.0	**145 4118**	"
	5 x 25	15.0 - 20.0	**145 4119**	"
	5 x 30	20.0 - 25.0	**145 4120**	B 100
5 - K 14 5.1 mm CE	**5 x 8**	2.5 - 4.5	**143 3523**	B 250
	5 x 10	4.5 - 6.0	**145 4121**	"
	5 x 12	6.0 - 8.0	**143 3524**	"
	5 x 14	8.0 - 10.0	**145 4122**	"
	5 x 16	10.0 - 12.0	**145 4123**	"
	5 x 18	12.0 - 14.0	**145 4124**	"
	5 x 20	14.0 - 15.0	**145 4125**	"
	5 x 25	15.0 - 20.0	**145 4126**	"
	5 x 30	20.0 - 25.0	**145 4127**	B 100

SHEAR AND TENSILE STRENGTH ALU/STEEL standard, counter sunk and large flange

STANDARD

D mm	N	N	d_m mm	max. d_k mm
2.4	**350**	**450**	1.45	5.0
3	**700**	**900**	1.8	6.5
3.2	**720**	**950**	1.95	6.5
4 x 5-25	**1,400**	**2,000**	2.1	8.0
4 x 30-40 ■	**850**	**1,000**	2.1	8.0
4.8	**1,800**	**2,700**	2.7	9.5
5 x 6 - 35	**2,000**	**2,800**	2.7	9.5
5 x 40 - 80	**1,400**	**2,000**	2.7	9.5
6	**3,100**	**3,800**	3.2	12.0
6.4	**3,400**	**4,600**	3.65	13.0
COUNTER SUNK AND LARGE FLANGE				
3	**700**	**900**	1.8	6.0
4	**1,400**	**2,000**	2.1	7.5
5	**2,000**	**2,800**	2.7	9.0
3.2 K 9.5 nur Alu/Stahl	**720**	**950**	1.95	9.5
4 K 12 nur Alu/Stahl	**1,400**	**2,000**	2.1	12.0
4.8 K 16 nur Alu/Stahl	**1,800**	**2,700**	2.7	16.0
5 K 11	**2,000**	**2,800**	2.7	11.0
5 K 14	**2,000**	**2,800**	2.7	14.0

■ **Rivet body: AlMgSi**

Test procedure according to DIN EN ISO 14589

BLIND RIVETS ***ALU/STAINLESS***

Standard Dome head

Aluminium alloy Stainless steel A2

D	D x L mm	mm	No.	
3	**3 x 4**	0.5 - 1.5	**145 5036**	A 500
3.1 mm	**3 x 6**	1.5 - 3.5	**143 3581**	"
	3 x 8	3.5 - 5.0	**143 3582**	"
	3 x 10	5.0 - 7.0	**145 5037**	"
	3 x 12	7.0 - 9.0	**145 5038**	"
	3 x 16	9.0 - 13.0	**145 5039**	"
3.2	**3.2 x 4**	0.5 - 1.5	**145 5048***	A 500
3.3 mm	**3.2 x 6**	1.5 - 3.5	**145 5049**	"
	3.2 x 8	3.5 - 5.0	**145 5044**	"
	3.2 x 10	5.0 - 7.0	**145 5045**	"
	3.2 x 12	7.0 - 9.0	**145 5046**	"
	3.2 x 14	9.0 - 11.0	**144 6433**	"
	3.2 x 16	11.0 - 13.0	**145 5050**	B 500
4	**4 x 6**	1.5 - 3.0	**143 3589**	A 500
4.1 mm	**4 x 8**	3.0 - 5.0	**143 3590**	"
	4 x 10	5.0 - 6.5	**143 3591**	"
CE	**4 x 12**	6.5 - 8.5	**143 3592**	B 500
	4 x 14	8.5 - 10.5	**143 3588**	"
	4 x 16	10.5 - 12.5	**143 3594**	"
	4 x 18	12.5 - 14.5	**143 3593**	"
	4 x 20	14.5 - 16.5	**143 3595**	"
	4 x 25	16.5 - 21.5	**143 3596**	"

D	D x L mm	mm	No.	
4.8	**4.8 x 8**	2.5 - 4.5	**145 5040**	"
4.9 mm	**4.8 x 10**	4.5 - 6.0	**145 5041**	"
	4.8 x 12	6.0 - 8.0	**145 5042**	"
CE	**4.8 x 14**	8.0 - 10.0	**145 5043**	"
	4.8 x 16	10.0 - 12.0	**143 3584**	"
5	**5 x 8**	2.5 - 4.5	**143 3597**	B 500
5.1 mm	**5 x 10**	4.5 - 6.0	**143 3598**	"
	5 x 12	6.0 - 8.0	**143 3599**	"
CE	**5 x 14**	8.0 - 10.0	**143 3600**	"
	5 x 16	10.0 - 12.0	**145 5053**	"
	5 x 18	12.0 - 14.0	**145 5054**	"
	5 x 20	14.0 - 15.0	**143 3601**	B 250
	5 x 25	15.0 - 20.0	**145 5055**	"
	5 x 30	20.0 - 25.0	**145 5056**	A 100
	5 x 35	25.0 - 30.0	**145 5057**	"
	5 x 40	30.0 - 35.0	**143 3602**	"

*Clearance – only while stocks last!

Material surcharge will be added at a daily rate.

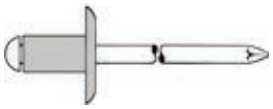
24

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on page **24.**

BLIND RIVETS ***ALU/STAINLESS***

Large flange

Aluminium alloy Stainless steel A2



D	D x L mm	mm	No.	
5 - K 11	**5 x 8**	2.5 - 4.5	**143 3605**	B 500
	5 x 10	4.5 - 6.0	**143 3606**	"
	5 x 12	6.0 - 8.0	**143 3607**	"
5.1 mm	**5 x 14**	8.0 - 10.0	**143 3603**	"
CE	**5 x 16**	10.0 - 12.0	**143 3608**	"

D	D x L mm	mm	No.	
5 - K 14	**5 x 8**	2.5 - 4.5	**143 3612**	B 250
	5 x 10	4.5 - 6.0	**143 3613**	"
	5 x 12	6.0 - 8.0	**143 3614**	"
5.1 mm	**5 x 14**	8.0 - 10.0	**143 3619**	"
CE	**5 x 16**	10.0 - 12.0	**143 3615**	"
	5 x 18	12.0 - 14.0	**143 3620**	"
	5 x 20	14.0 - 15.0	**143 3616**	"
	5 x 25	15.0 - 20.0	**143 3617**	"
	5 x 30	20.0 - 25.0	**143 3618**	B 100

Material surcharge will be added at a daily rate.

SHEAR AND TENSILE STRENGTH ALU/STAINLESS Standard and large flange

D mm	N	N	d_m mm	max. d_k mm
3	**700**	**900**	1.8	6.5
3.2	**720**	**950**	1.95	6.5
4	**1,400**	**2,000**	2.1	8.0
4.8	**1,800**	**2,700**	2.7	9.5
5	**2,000**	**2,800**	2.7	9.5
5 K 11	**2,000**	**2,800**	2.7	11.0
5 K 14	**2,000**	**2,800**	2.7	14.0

Test procedure according to DIN EN ISO 14589

BLIND RIVETS ***ALU/ALU***

Standard Dome head

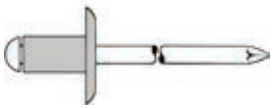
Aluminium alloy Aluminium alloy

D	D x L mm	mm	No.	
3.2	**3.2 x 6.1**	0.8 - 3.2	**143 3751**	A 500
3.3 mm	**3.2 x 7.6**	3.2 - 4.8	**143 3752**	"
	3.2 x 9.2	4.8 - 6.4	**145 5510**	"
4	**4 x 6.6**	1.5 - 3.2	**145 5513**	B 500
4.1 mm	**4 x 9.8**	3.2 - 6.4	**143 3753**	"
	4 x 12.9	6.4 - 9.5	**143 3754***	"
	4 x 16.1	9.5 - 12.7	**145 5514***	"

D	D x L mm	mm	No.	
4.8	**4.8 x 7.2**	1.5 - 3.2	**143 3755***	B 500
4.9 mm	**4.8 x 10.3**	3.2 - 6.4	**143 3756**	"
	4.8 x 13.5	6.4 - 9.5	**145 5515**	"
	4.8 x 16.7	9.5 - 12.7	**145 5516***	"
6.4	**6.4 x 12.0**	1.5 - 6.4	**143 3757**	B 250
6.5 mm	**6.4 x 14.9**	6.4 - 9.5	**143 3758**	"
	6.4 x 18.1	9.5 - 12.7	**143 3759**	A 100
	6.4 x 24.4	12.7 - 19.0	**143 3760**	"

Large flange

Aluminium alloy Aluminium alloy



D	D x L mm	mm	No.	
3.2 - K 9.5	**3.2 x 9.2**	3.2 - 6.4	**145 5520***	"
3.3 mm	**3.2 x 12.3**	6.4 - 9.5	**145 5521***	B 500

D	D x L mm	mm	No.	
4.8 - K 16	**4.8 x 10.3**	1.5 - 6.4	**145 5522**	B 250
4.9 mm	**4.8 x 13.5**	6.4 - 9.5	**145 5523**	"
	4.8 x 19.9	12.7 - 15.9	**145 5525***	"
	4.8 x 23.0	15.9 - 19.0	**145 5526***	"

*Clearance – only while stocks last!

SHEAR AND TENSILE STRENGTH ALU/ALU Standard and large flange

D mm	N	N	d_m mm	max. d_k mm
3.2	**600**	**850**	2.05	6.5
4	**800**	**1,020**	2.45	8.0
4.8	**1,150**	**1,420**	3.0	9.5
6.4	**2,040**	**2,490**	3.85	12.9
3.2 K 9.5	**530**	**660**	1.95	9.5
4.8 K 16	**1,150**	**1,420**	2.9	16.0

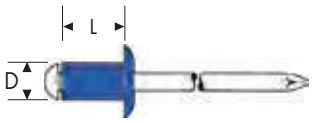
Test procedure according to DIN EN ISO 14589

BLIND RIVETS ***STEEL/STEEL***

Standard Dome head

Steel, zinc-plated

Steel, zinc-plated



D	D x L mm	mm	No.	
3	**3 x 5**	0.5 - 2.0	**145 4595**	A 500
3.1 mm	**3 x 6**	2.0 - 3.0	**143 3551**	"
	3 x 8	3.0 - 5.0	**143 3552**	"
	3 x 10	5.0 - 6.5	**145 4596**	"
	3 x 12	6.5 - 8.5	**145 4597**	"
	3 x 16	8.5 - 12.5	**145 4598**	B 500
3.2	**3.2 x 6**	0.5 - 3.0	**145 4602**	A 500
3.3 mm	**3.2 x 8**	3.0 - 5.0	**143 3553**	"
	3.2 x 10	5.0 - 6.5	**143 3554**	"
	3.2 x 12	6.5 - 8.5	**145 4603**	"
	3.2 x 16	8.5 - 12.5	**145 4604**	B 500
	3.2 x 18	12.5 - 14.5	**145 4601**	"
	3.2 x 20	14.5 - 16.5	**145 4605**	"
4	**4 x 6**	0.5 - 2.5	**145 4606**	A 500
4.1 mm	**4 x 8**	2.5 - 4.5	**143 3555**	"
	4 x 10	4.5 - 6.5	**143 3556**	B 500
	4 x 12	6.5 - 8.5	**143 3557**	"
	4 x 16	8.5 - 12.0	**145 4607**	"
	4 x 18	12.0 - 14.0	**145 4609**	"
	4 x 20	14.0 - 16.0	**145 4608**	"
	4 x 25	16.0 - 21.0	**145 4610**	"
4.8	**4.8 x 8**	2.0 - 4.0	**143 3558**	B 500
4.9 mm	**4.8 x 10**	4.0 - 6.0	**143 3559**	"
	4.8 x 12	6.0 - 8.0	**143 3560**	"
	4.8 x 16	8.0 - 11.0	**143 3561**	"
	4.8 x 20	11.0 - 15.0	**143 3562**	B 250
	4.8 x 25	15.0 - 20.0	**145 4612**	"

D	D x L mm	mm	No.	
5	**5 x 8**	2.0 - 4.0	**145 4613**	B 500
5.1 mm	**5 x 10**	4.0 - 6.0	**145 4614**	"
	5 x 12	6.0 - 8.0	**145 4615**	"
	5 x 16	9.5 - 11.0	**145 4617**	"
	5 x 20	11.0 - 15.0	**145 4619**	B 250
	5 x 25	15.0 - 20.0	**145 4620**	"
	5 x 30	20.0 - 25.0	**145 4621**	A 100
	5 x 35	25.0 - 30.0	**145 4622**	"
	5 x 40	30.0 - 34.0	**145 4623**	B 100
	5 x 45	34.0 - 39.0	**145 4624**	B 100
	5 x 50	39.0 - 44.0	**145 4625**	B 100
6	**6 x 10**	2.5 - 4.5	**145 4626**	B 250
6.1 mm	**6 x 12**	4.5 - 6.5	**145 4627**	"
	6 x 14	6.5 - 8.5	**145 4628**	"
	6 x 16	8.5 - 10.5	**145 4629**	"
	6 x 20	10.5 - 14.5	**145 4630**	"
	6 x 25	14.5 - 19.5	**145 4631**	"
6.4	**6.4 x 8**	1.0 - 3.0	**143 3563**	B 250
6.5 mm	**6.4 x 12**	3.0 - 6.0	**143 3564**	"
	6.4 x 16	6.0 - 9.0	**143 3565**	"
	6.4 x 20	9.0 - 13.0	**143 3566**	"
	6.4 x 25	13.0 - 17.0	**143 3567**	"

BLIND RIVETS ***STEEL/STEEL***

Countersunk (120°)

Steel, zinc-plated — Steel, zinc-plated

D	D x L mm	mm	No.	
3	**3 x 6**	1.0 - 3.0	**145 4633**	A 500
3.1 mm	**3 x 8**	3.0 - 5.0	**145 4634**	"
	3 x 10	5.0 - 6.5	**145 4635**	"
	3 x 12	6.5 - 8.5	**145 4636**	"
4	**4 x 6**	1.5 - 2.5	**145 4637**	A 500
4.1 mm	**4 x 8**	2.5 - 4.5	**145 4638**	"
	4 x 10	4.5 - 6.5	**145 4639**	B 500
	4 x 12	6.5 - 8.5	**145 4640**	"
	4 x 16	8.5 - 12.0	**145 4641**	"

D	D x L mm	mm	No.	
5	**5 x 8**	2.0 - 4.0	**145 4644**	B 500
5.1 mm	**5 x 10**	4.0 - 6.0	**145 4645**	"
	5 x 12	6.0 - 8.0	**145 4646**	"
	5 x 16	9.5 - 11.0	**145 4647**	"
	5 x 20	11.0 - 15.0	**145 4648**	B 250
	5 x 25	15.0 - 20.0	**145 4649**	"

SHEAR AND TENSILE STRENGTH STEEL/STEEL Standard and countersunk

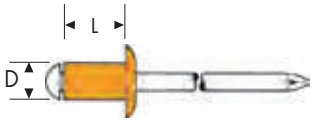
D mm	N	N	d_m mm	max. d_k mm
STANDARD				
3	**1,000**	**1,300**	1.95	6.5
3.2	**1,200**	**1,500**	2.0	6.5
4	**2,000**	**2,500**	2.5	8.0
4.8	**2,900**	**4,000**	3.0	9.5
5	**3,100**	**4,400**	3.0	9.5
6	**4,400**	**6,000**	3.65	12.0
6.4	**4,900**	**6,800**	3.85	13.0
COUNTERSUNK				
3	**1,000**	**1,300**	1.95	6.0
4	**2,000**	**2,500**	2.5	7.5
5	**3,100**	**4,400**	3.0	9.0

Test procedure according to DIN EN ISO

BLIND RIVETS ***COPPER/STEEL***

Standard Dome head

Copper — Steel, zinc-plated



D	D x L mm	mm	No.	
3 3.1 mm	**3 x 4**	0.5 - 1.5	**145 5279**	A 500
	3 x 6	1.5 - 3.0	**143 3655**	"
	3 x 8	3.0 - 5.0	**143 3656**	"
	3 x 10	5.0 - 7.0	**143 3657**	"
	3 x 12	7.0 - 9.0	**145 5280***	"

D	D x L mm	mm	No.	
4 4.1 mm	**4 x 6**	0.5 - 3.5	**143 3658**	A 500
	4 x 8	3.5 - 4.5	**145 5281**	"
	4 x 10	4.5 - 6.5	**145 5282**	"

*Clearance – only while stocks last!

BLIND RIVETS ***COPPER/STEEL***

Standard Dome head

Copper — Bronze

D	D x L mm	mm	No.	
3 3.1 mm	**3 x 4**	0.5 - 1.5	**145 5289**	A 500
	3 x 6	1.5 - 3.0	**145 5290**	"
	3 x 8	3.0 - 5.0	**143 3661**	"
	3 x 10	5.0 - 7.0	**145 5291**	"

D	D x L mm	mm	No.	
4 4.1 mm	**4 x 6**	0.5 - 3.5	**145 5293**	A 500
	4 x 8	3.5 - 4.5	**145 5294**	"
	4 x 10	4.5 - 6.5	**145 5295**	"

SHEAR AND TENSILE STRENGTH COPPER/STEEL and **COPPER/BRONZE**

D mm	N	N	d_m mm	max. d_k mm
3	**800**	**1,000**	1.8	6.5
4	**1,500**	**2,200**	2.1	8.0

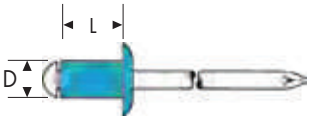
Test procedure according to DIN EN ISO 14589

BLIND RIVETS ***A2 STAINLESS STEEL***

Standard Dome head

Stainless steel A2 — Nr. 1.4567

Stainless steel A2



D	D x L mm	mm	No.	
3 3.1 mm	**3 x 6**	1.0 - 3.0	**143 3621**	A 500
	3 x 8	3.0 - 5.0	**143 3622**	"
	3 x 10	5.0 - 6.5	**145 5157**	"
	3 x 12	6.5 - 8.5	**145 5158**	"
	3 x 14	8.5 - 10.5	**145 5159**	"
	3 x 16	10.5 - 12.5	**145 5160**	"
3.2 3.3 mm	**3.2 x 6**	1.0 - 3.0	**143 3623**	A 500
	3.2 x 8	3.0 - 5.0	**143 3624**	"
	3.2 x 10	5.0 - 6.5	**143 3625**	"
	3.2 x 12	6.5 - 8.5	**143 3626**	"
	3.2 x 16	8.5 - 12.5	**145 5161**	"
4 4.1 mm CE	**4 x 6**	1.0 - 2.5	**143 3627**	A 500
	4 x 8	2.5 - 4.5	**143 3628**	"
	4 x 10	4.5 - 6.5	**143 3629**	B 500
	4 x 12	6.5 - 8.5	**143 3630**	"
	4 x 14	8.5 - 10.5	**143 3633**	"
	4 x 16	10.5 - 12.0	**143 3631**	"
	4 x 20	12.0 - 16.0	**143 3632**	"
	4 x 25	16.0 - 21.0	**145 5163**	"

D	D x L mm	mm	No.	
4.8 4.9 mm CE	**4.8 x 6**	1.5 - 3.0	**145 5164**	B 500
	4.8 x 8	2.0 - 4.0	**143 3634**	"
	4.8 x 10	4.0 - 6.0	**143 3635**	"
	4.8 x 12	6.0 - 8.0	**143 3636**	"
	4.8 x 14	8.0 - 9.5	**145 5165**	"
	4.8 x 16	9.5 - 11.0	**143 3637**	"
	4.8 x 20	11.0 - 15.0	**143 3638**	B 250
	4.8 x 25	15.0 - 20.0	**145 5166**	B 250
	4.8 x 30	20.0 - 25.0	**143 3639**	A 100
5 5.1 mm	**5 x 8**	2.0 - 4.0	**145 5168**	B 500
	5 x 10	4.0 - 6.0	**145 5169**	"
	5 x 12	6.0 - 8.0	**145 5170**	"
	5 x 14	8.0 - 9.5	**145 5171**	"
	5 x 16	9.5 - 11.0	**145 5172**	"
	5 x 20	11.0 - 15.0	**143 3646**	B 250
	5 x 25	15.0 - 20.0	**143 3647**	"
	5 x 30	20.0 - 25.0	**143 3648**	A 100
	5 x 35	25.0 - 30.0	**145 5173**	"
	5 x 40	30.0 - 34.0	**143 3649**	"

Material surcharge will be added at a daily rate.

Countersunk (120°)

Stainless steel A2 — Nr. 1.4567

Stainless steel A2

D	D x L mm	mm	No.	
3 3.1 mm	**3 x 6**	1.5 - 3.0	**145 5174**	A 500
	3 x 8	3.0 - 5.0	**143 3650**	"
	3 x 10	5.0 - 6.5	**145 5175**	"
3.2 3.3 mm	**3.2 x 6**	1.5 - 3.0	**145 5177**	A 500
	3.2 x 8	3.0 - 5.0	**145 5178**	"
	3.2 x 10	5.0 - 6.5	**145 5179**	"

D	D x L mm	mm	No.	
4 4.1 mm	**4 x 8**	1.5 - 4.5	**145 5181**	A 500
	4 x 10	4.5 - 6.5	**143 3651**	B 500
	4 x 12	6.5 - 8.5	**143 3652**	"
4.8 4.9 mm	**4.8 x 10**	4.0 - 6.0	**145 5183**	"
	4.8 x 12	6.0 - 8.0	**145 5184**	"
5 5.1 mm	**5 x 8**	2.0 - 4.0	**145 5185**	B 500
	5 x 10	4.0 - 6.0	**145 5186**	"
	5 x 12	6.5 - 8.5	**143 3653**	"

Material surcharge will be added at a daily rate.

30

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 30.**

BLIND RIVETS ***A2 STAINLESS STEEL***

Large flange

Stainless steel A2
— Nr. 1.4567

Stainless steel A2

D	D x L mm	mm	No.	
4.8 - K 15	**4.8 x 14**	8.0 - 9.5	**143 3640**	B 250
	4.8 x 16	9.5 - 11.0	**143 3641**	"
4.9 mm	**4.8 x 20**	11.0 - 15.0	**143 3642**	"
	4.8 x 25	15.0 - 20.0	**143 3643**	B 200
CE	**4.8 x 30**	20.0 - 25.0	**143 3644**	B 100

Material surcharge will be added at a daily rate.

SHEAR AND TENSILE STRENGTH A2 STAINLESS STEEL Standard, countersunk and large flange

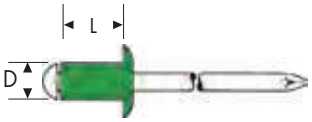
D mm	N	N	d_m mm	max. d_k mm
STANDARD / COUNTERSUNK				
3	**1,600**	**2,000**	2.0	6.5
3.2	**1,900**	**2,500**	2.0	6.5
4	**2,700**	**3,600**	2.6	8.0
4 x 20 - 25 ■	**3,800**	**4,500**	2.6	8.0
4.8	**4,000**	**5,000**	3.2	9.5
5	**4,700**	**5,900**	3.2	9.5
5 x 40 ■	**5,900**	**7,200**	3.2	9.5
LARGE FLANGE				
4.8	**4,000**	**5,000**	3.2	15.0

■ Hollow rivet stainless steel A2 tube, material no. 1.4301 Test procedure according to DIN EN ISO 14589

BLIND RIVETS ***A4 STAINLESS STEEL***

Standard Dome head

Stainless steel A4 — Nr. 1.4578 | Stainless steel A4



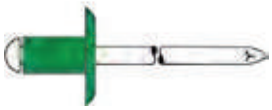
D	D x L mm	mm	No.	
3 3.1 mm	**3 x 6**	1.0 - 3.0	**145 5530**	A 500
	3 x 8	3.0 - 5.0	**145 5531**	"
	3 x 10	5.0 - 6.5	**145 5532**	"
	3 x 12	6.5 - 8.5	**145 5533**	"
3.2 3.3 mm	**3.2 x 6**	1.0 - 3.0	**143 3761**	A 500
	3.2 x 8	3.0 - 5.0	**143 3762**	"
	3.2 x 10	5.0 - 6.5	**143 3763**	"
4 4.1 mm CE	**4 x 6**	1.0 - 2.5	**145 5534**	A 500
	4 x 8	2.5 - 4.5	**143 3764**	"
	4 x 10	4.5 - 6.5	**143 3765**	B 500
	4 x 12	6.5 - 8.5	**143 3766**	"
	4 x 14	8.5 - 10.5	**145 5536**	"
	4 x 16	10.5 - 12.0	**143 3767**	"

D	D x L mm	mm	No.	
4.8 4.9 mm CE	**4.8 x 8**	3.0 - 4.5	**143 3769**	"
	4.8 x 10	4.5 - 6.0	**143 3770**	"
	4.8 x 12	6.0 - 7.5	**143 3777**	"
	4.8 x 16	9.5 - 11.0	**143 3772**	"
	4.8 x 20	11.0 - 15.0	**143 3773**	B 250
5 5.1 mm	**5 x 8**	2.0 - 4.0	**145 5537**	B 500
	5 x 10	4.0 - 6.0	**143 3778**	"
	5 x 12	6.0 - 8.0	**143 3779**	"
	5 x 16	8.0 - 11.0	**143 3781**	"
	5 x 20	11.0 - 15.0	**145 5538**	B 250
	5 x 25	15.0 - 20.0	**143 3782**	"
	5 x 30	20.0 - 25.0	**143 3783**	A 100
	5 x 35	25.0 - 30.0	**143 3784**	"

Material surcharge will be added at a daily rate.

Large flange

Stainless steel A4 — Nr. 1.4578 | Stainless steel A4



D	D x L mm	mm	No.	
4.8 - K 15 4.9 mm CE	**4.8 x 14**	8.0 - 9.5	**143 3785**	B 250
	4.8 x 16	9.5 - 11.0	**143 3786**	"
	4.8 x 20	11.0 - 15.0	**143 3787**	"
	4.8 x 25	15.0 - 20.0	**143 3788**	B 200
	4.8 x 30	20.0 - 25.0	**143 3789**	B 100
	4.8 x 35	25.0 - 30.0	**143 3790**	"

Material surcharge will be added at a daily rate.

SHEAR AND TENSILE STRENGTH A4 STAINLESS STEEL Standard and large flange

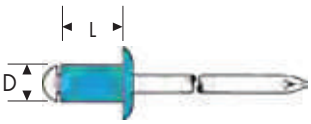
D mm	Art	N	N	d_m mm	max. d_k mm
3	Standard	**1,600**	**2,000**	2.0	6.5
3.2	Standard	**1,900**	**2,500**	2.0	6.5
4	Standard	**2,700**	**3,600**	2.6	8.0
4.8	Standard	**4,000**	**5,000**	3.2	9.5
4.8	Large flange	**4,000**	**5,000**	3.2	15.0
5	Standard	**4,700**	**5,900**	3.2	9.5

BLIND RIVETS ***STINOX***

Standard Dome head

Stainless steel A2 — Nr. 1.4567

Steel, zinc-plated



D	D x L mm	mm	No.	
3 3.1 mm	**3 x 6**	1.0 - 3.0	**145 5297**	A 500
	3 x 8	3.0 - 5.0	**145 5298**	"
4 4.1 mm	**4 x 8**	2.5 - 4.5	**145 5304**	"
	4 x 10	4.5 - 6.5	**145 5305**	B 500
	4 x 12	6.5 - 8.5	**145 5306**	"
	4 x 16	8.5 - 12.0	**145 5307**	"
5 5.1 mm	**5 x 8**	2.0 - 4.0	**145 5311**	B 500
	5 x 10	4.0 - 6.0	**145 5312**	"

Material surcharge will be added at a daily rate.

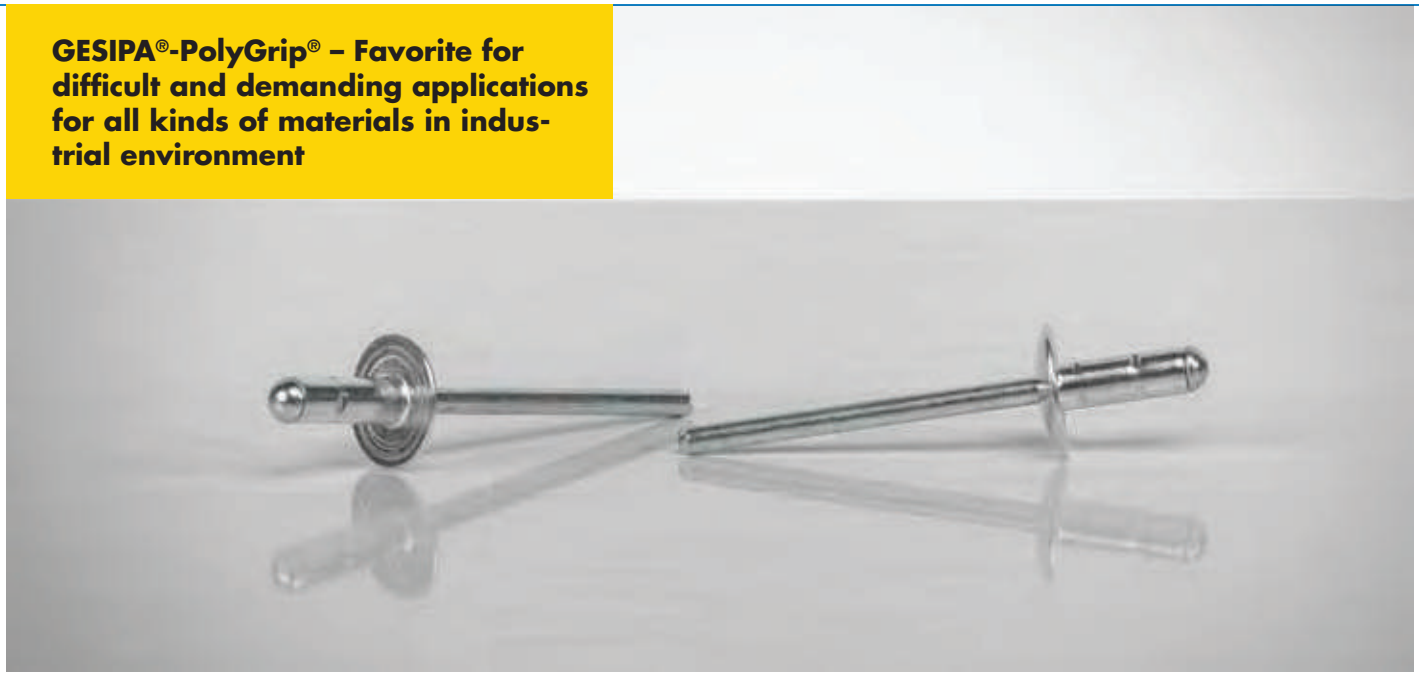
SHEAR AND TENSILE STRENGTH Standard

D mm	N	N	d_m mm	max. d_k mm
3	**1,600**	**2,000**	2.0	6.5
4	**2,700**	**3,600**	2.6	8.0
5	**4,700**	**5,900**	3.2	9.5

Test procedure according to DIN EN ISO 14589

POLYGRIP® – A MOST VERSATILE SMALL FELLOW

GESIPA®-PolyGrip® – Favorite for difficult and demanding applications for all kinds of materials in industrial environment

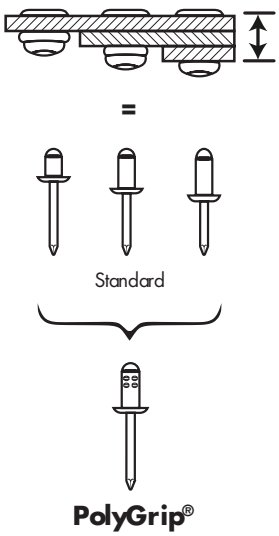


The GESIPA® PolyGrip® range of blind rivets, originally meant to be only a multigrip rivet has meanwhile shown other multiple talents. This makes it a favourite choice for difficult and demanding applications in industrial environment. Whether in aluminium, steel or stainless steel, outdoor or indoor, with hard or soft application materials, critical hole diameters and tolerances, when nothing seems to work properly, GESIPA® PolyGrip® will usually save the day.

MAIN FEATURES

- **Large grip range:**
  One single PolyGrip® blind rivet can replace up to five different sizes of standard DIN blind rivets

  Your benefits:
  > Type simplification
  > Limited type variety for reduced stocks
  > Lower risk of confusion therefore fewer mistakes in production

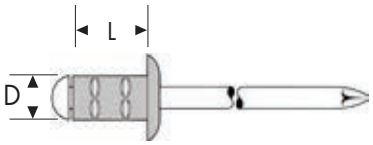


- **Outstanding hole filling capability**: The rivet body expands radially during the setting process and compensates hole tolerances, centering deviations and differences in diameter, thus always building up a playfree and tight joint.

- **Safe rest mandrel locking:** PolyGrip® blind rivets neither generate rattling noises due to free moving rest mandrels nor do they allow the risk of loss of the rest mandrel.

- **Splash waterproof** are the PolyGrip® blind rivets under certain conditions too. Hole filling and rest mandrel locking make of them a real alternative to closed end rivets when it is essential to prevent water flowing through the whole joint and not only through the rivet body.

- **A large closing head**: for a high tensile and unbuttoning resistance.



Alu/steel
Standard

(Dome head)

Aluminium alloy

Steel, zinc-plated

D	D x L mm	mm	No.	
3.2	**3.2 x 8**	0.5 - 5.0	**143 3822**	B 1,000
3.3 mm	**3.2 x 9.5**	1.5 - 6.5	**143 3823**	"
	3.2 x 11	3.0 - 8.0	**143 3824**	"
4.0	**4 x 10**	0.5 - 6.5	**143 3826**	B 500
4.1 mm	**4 x 13**	3.5 - 9.5	**143 3827**	"
	4 x 17	7.0 - 13.0	**143 3828**	"
4.8	**4.8 x 10**	0.5 - 6.5	**143 3831**	B 500
4.9 mm	**4.8 x 15**	4.5 - 11.0	**143 3832**	"
	4.8 x 17	6.5 - 13.0	**143 3833**	"
CE	**4.8 x 25**	11.0 - 19.5	**143 3838**	B 250
	4.8 x 30	16.0 - 24.0	**143 3839**	"
6.4	**6.4 x 15**	1.5 - 9.0	**143 3841**	B 250
6.5 mm	**6.4 x 20**	6.0 - 14.0	**143 3842**	"
	6.4 x 25	10.0 - 18.0	**143 3843**	"

Alu/steel
Countersunk (120°)

Aluminium alloy

Steel, zinc-plated

D	D x L mm	mm	No.	
3.2	**3.2 x 6**	1.0 - 3.0	**145 0404**	B 1,000
3.3 mm	**3.2 x 10**	4.0 - 7.0	**145 0405**	"
4.0	**4 x 6**	1.5 - 3.5	**145 0406**	B 500
4.1 mm	**4 x 12**	3.5 - 8.5	**144 6470**	"
4.8	**4.8 x 10**	2.0 - 5.0	**145 0407**	B 500
4.9 mm	**4.8 x 15**	5.0 - 11.0	**144 6471**	"

Alu/steel
Large flange

Aluminium alloy

Steel, zinc-plated

D	D x L mm	mm	No.	
3.2 - K 9.5	**3.2 x 8**	0.5 - 5.0	**143 3825**	B 1,000
3.3 mm	**3.2 x 9.5**	1.5 - 6.5	**145 5675**	"
	3.2 x 11	3.0 - 8.0	**145 5676**	"
4.0 - K 12	**4 x 10**	0.5 - 6.5	**143 3829**	B 500
4.1 mm	**4 x 13**	3.5 - 9.5	**143 3830**	"
	4 x 17	7.0 - 13.0	**143 3837**	"
4.8 - K 16	**4.8 x 10**	0.5 - 6.5	**143 3834**	B 250
4.9 mm	**4.8 x 15**	4.5 - 11.0	**143 3835**	"
	4.8 x 17	6.5 - 13.0	**143 3836**	"
CE	**4.8 x 25**	11.0 - 19.5	**143 3840**	B 100
	4.8 x 30	16.0 - 24.0	**145 5677**	"

Alu/stainless
Standard

(Dome head)

Aluminium alloy

Stainless steel A2

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 8**	0.5 - 5.0	**143 3883**	B 1,000
	3.2 x 9,5	1.5 - 6.5	**143 3884**	"
	3.2 x 11	3.0 - 8.0	**143 3885**	"
4.0 CE 4.1 mm	**4 x 10**	0.5 - 6.5	**143 3887**	B 500
	4 x 13	3.5 - 9.5	**143 3888**	"
	4 x 17	7.0 - 13.0	**143 3889**	"
4.8 CE 4.9 mm	**4.8 x 10**	0.5 - 6.5	**143 3892**	B 500
	4.8 x 15	4.5 - 11.0	**143 3893**	"
	4.8 x 17	6.5 - 13.0	**143 3894**	"
	4.8 x 25	11.0 - 19.5	**143 3895**	B 250
	4.8 x 30	16.0 - 24.0	**143 3896**	"
6.4 6.5 mm	**6.4 x 15**	1.5 - 9.0	**143 3902**	B 250
	6.4 x 20	6.0 - 14.0	**143 3903**	"
	6.4 x 25	10.0 - 18.0	**143 3904**	"

Material surcharge will be added at a daily rate.

Alu/stainless
Large flange

Aluminium alloy

Stainless steel A2

D	D x L mm	mm	No.	
3.2 - K 9.5 CE 3.3 mm	**3.2 x 8**	0.5 - 5.0	**145 6032**	B 1,000
	3.2 x 9.5	1.5 - 6.5	**143 3886**	"
4.0 - K 12 CE 4.1 mm	**4 x 10**	0.5 - 6.5	**143 3890**	B 500
	4 x 13	3.5 - 9.5	**143 3891**	"
	4 x 17	7.0 - 13.0	**145 6034**	"
4.8 - K 16 4.9 mm	**4.8 x 10**	0.5 - 6.5	**143 3897**	B 250
	4.8 x 15	4.5 - 11.0	**143 3898**	"
	4.8 x 17	6.5 - 13.0	**143 3899**	"
	4.8 x 25	11.0 - 19.5	**143 3900**	B 100
	4.8 x 30	16.0 - 24.0	**143 3901**	"

Material surcharge will be added at a daily rate.

Under certain conditions all GESIPA® PolyGrip® blind rivets are splash waterproof.

38

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 38**.

Steel/steel
Standard

(Dome head)

Steel, zinc-plated

SSteel, zinc-plated

D	D x L mm	mm	No.	
3.2	**3.2 x 8**	1.0 - 5.0	**143 3866**	B 1,000
3.3 mm	**3.2 x 9.5**	2.0 - 6.5	**143 3867**	"
	3.2 x 11	3.0 - 8.0	**143 3868**	"
4.0	**4 x 10**	1.5 - 6.5	**143 3869**	B 500
4.1 mm	**4 x 13**	4.5 - 9.0	**143 3870**	"
	4 x 17	8.5 - 13.0	**143 3871**	"
4.8	**4.8 x 10**	1.5 - 6.5	**143 3873**	B 500
4.9 mm	**4.8 x 15**	6.0 - 11.0	**143 3874**	B 250
	4.8 x 17	8.5 - 13.0	**143 3875**	"
6.4	**6.4 x 15**	2.0 - 8.0	**143 3877**	B 250
6.5 mm	**6.4 x 20**	5.0 - 13.0	**143 3878**	"
	6.4 x 25	10.0 - 18.0	**143 3879**	B 200

Steel/steel
Countersunk (120°)

Steel, zinc-plated

Steel, zinc-plated

D	D x L mm	mm	No.	
3.2	**3.2 x 6**	1.0 - 3.0	**145 0435**	B 1,000
3.3 mm	**3.2 x 10**	3.0 - 7.0	**145 0436**	"
4.0	**4 x 6**	1.5 - 3.5	**145 0437**	B 500
4.1 mm	**4 x 12**	3.5 - 8.5	**144 6482**	"
4.8	**4.8 x 10**	2.0 - 6.0	**144 6483**	B 500
4.9 mm	**4.8 x 15**	5.5 - 11.0	**144 6484**	"

Steel/steel
Large flange

Steel, zinc-plated

Steel, zinc-plated

D	D x L mm	mm	No.	
3.2 - K 9.5	**3.2 x 8**	1.0 - 5.0	**145 5972**	B 1,000
3.3 mm	**3.2 x 9.5**	2.0 - 6.5	**145 5973**	"
	3.2 x 11	3.0 - 8.0	**145 5974**	"
4.0 - K 12	**4 x 10**	1.5 - 6.5	**143 3872**	B 500
4.1 mm	**4 x 13**	4.5 - 9.0	**145 5975**	"
	4 x 17	8.5 - 13.0	**145 5976**	"
4.8 - K 16	**4.8 x 10**	1.5 - 6.5	**143 3876**	B 250
4.9 mm	**4.8 x 15**	6.0 - 11.0	**145 5977**	"
	4.8 x 17	8.5 - 13.0	**145 5978**	"

A2 Stainless steel
Standard

Dome head


Stainless steel A2 - no. 1.4567

Stainless steel A2

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 8**	1.0 - 5.0	**143 3909**	B 1,000
	3.2 x 9.5	2.0 - 6.0	**145 6288**	"
	3.2 x 11	3.0 - 8.0	**143 3910**	"
4.0 4.1 mm	**4 x 10**	1.0 - 6.5	**143 3911**	B 500
	4 x 13	3.0 - 8.0	**143 3912**	"
	4 x 17	7.0 - 11.0	**143 3913**	"
4.8 CE 4.9 mm	**4.8 x 10**	1.0 - 6.5	**143 3914**	B 500
	4.8 x 15	5.0 - 10.0	**143 3915**	"
	4.8 x 17	8.0 - 12.0	**143 3916**	"
6.4 6.5 mm	**6.4 x 13**	2.0 - 6.5	**143 3918**	B 250
	6.4 x 15	3.5 - 8.5	**143 3917**	"
	6.4 x 20	7.0 - 12.5	**143 3919**	B 200

Material surcharge will be added at a daily rate.

A4 Stainless steel
Standard

Dome head


Stainless steel A4 - no. 1.4578

Stainless steel A4

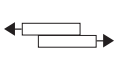
D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 11**	3.0 - 8.0	**143 3921**	B 1,000
4.0 4.1 mm	**4 x 10**	1.0 - 6.5	**143 3922**	B 500
4.8 4.9 mm	**4.8 x 10**	1.0 - 6.5	**143 3923**	"
	4.8 x 15	5.0 - 10.0	**143 3924**	"

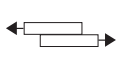
Material surcharge will be added at a daily rate.

38

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 38**.

SHEAR AND TENSILE STRENGTH POLYGRIP®

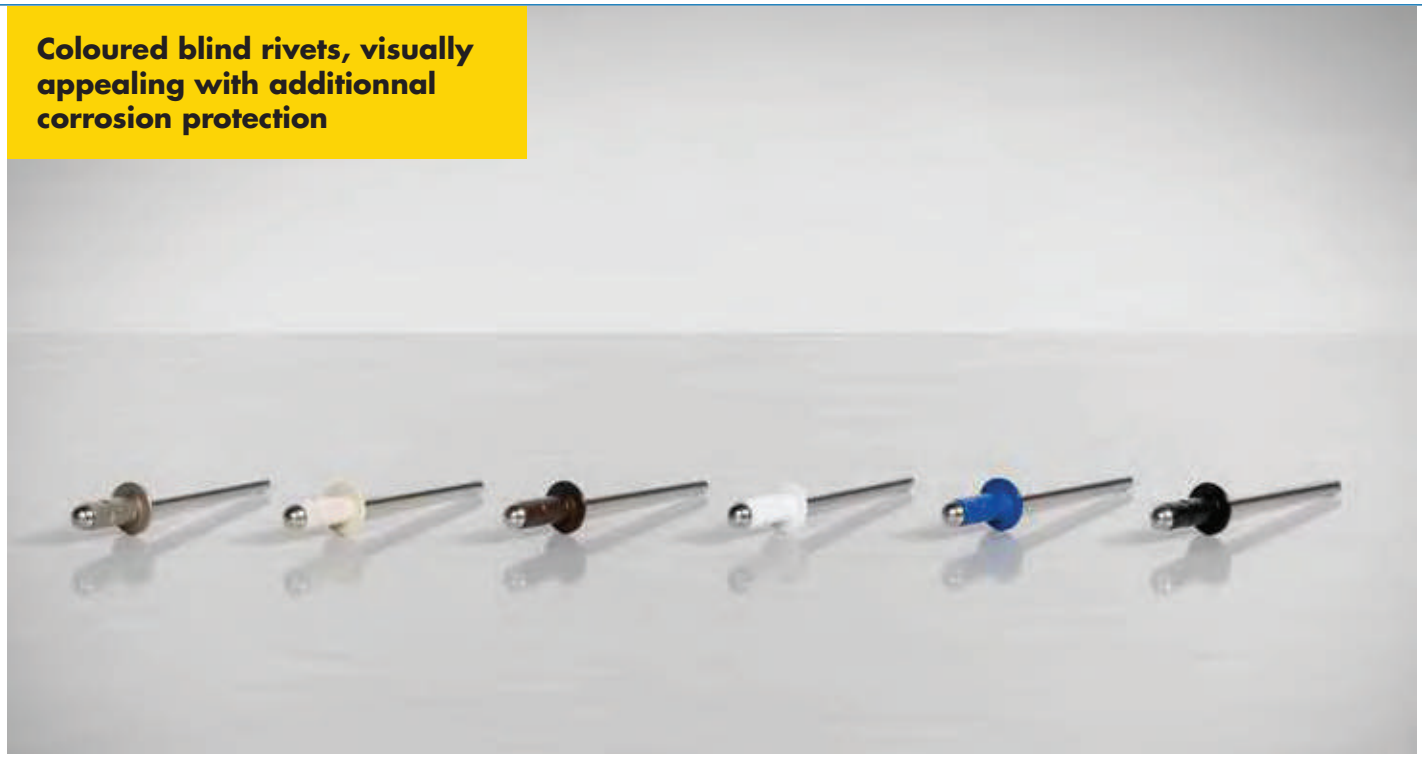
D mm	N 	N 	d_m mm	max. d_k Standard mm	max. d_k Großkopf mm
ALU/STEEL AND **ALU/STAINLESS STEEL**					
3.2	**720**	**1,050**	1.8	6.5	9,5
4.0	**1,060**	**1,680**	2.3	8.0	12.0
4.8	**1,500**	**2,300**	2.7	9.5	16.0
6.4	**2,800**	**4,000**	3.65	13.0	-
STEEL/STEEL					
3.2	**1,200**	**1,600**	2.1	6.5	9.5
4.0	**1,650**	**2,400**	2.6	8.0	12.0
4.8	**2,400**	**3,200**	3.2	9.5	16.0
6.4	**4,000**	**6,100**	4.25	13.0	-

D mm	N 	N 	d_m mm	max. d_k Standard mm
STAINLESS STEEL A2				
3.2	**1,450**	**2,300**	2.2	6.5
4.0	**2,650**	**3,600**	2.7	8.0
4.8	**4,000**	**5,000**	3.2	9.5
6.4	**7,800**	**8,800**	4.25	13.0
STAINLESS STEEL A4				
3.2	**1,450**	**2,300**	2.2	6.5
4.0	**2,650**	**3,600**	2.7	8.0
4.8	**4,000**	**5,000**	3.2	9.5

Test procedure according to DIN EN ISO 14589

COLOURED BLIND RIVETS

Coloured blind rivets, visually appealing with additionnal corrosion protection



GESIPA® blind rivets are also available in colour to match the application. To guarantee the best possible durability the hollow rivets are painted using a two-component epoxy resin paint in a stow enamelling process.

In addition to the visual benefits, the painted blind rivet also has added protection against corrosion. Aluminium blind rivets are best suited for this procedure. In the longterm they achieve the desired visual effect when joining coloured parts.

GESIPA® blind rivets are available in the standard RAL colours. On request, steel blind rivets are also available in RAL colours or even special colours. Another method for colouring blind rivets and for protecting them against corrosion is to anodize them.

GESIPA® blind rivets are anodized in a direct current sulphuric acid process. The term Eloxal is used to describe the electrolytic oxidation of aluminium. Eloxal itself is actually colourless. Applying a second coat using metal salts creates the desired light-fast colour. The Eloxal method is more complex but is the most durable process for coloured blind rivets.

The range of coloured blind rivets includes 15 RAL colours in ten different dimensions each. The blind rivets are produced in a wet varnish drum process. The colours are similar to the RAL colours.

38

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 38**.

COLOURED BLIND RIVETS Polygrip® in Alu/Stainless

Aluminium alloy

stainless steal A2

x = No longer in stock

D mm	D x L mm	mm	RAL 1015 Light ivory No.	RAL 3000 Flame red No.	RAL 5010 Gentian blue No.	RAL 7011 Iron grey No.	RAL 7016 Anthracit grey No.	
3.2	**3.2 x 8**	0.5 - 5.0	x	x	x	x	**145 0448**	B 1000
3.3 mm	**3.2 x 9.5**	1.5 - 6.5	x	x	x	x	**145 0449**	B 1000
	3.2 x 11	3.0 - 8.0	x	x	x	x	**144 6510**	B 1000
4 CE	**4 x 10**	0.5 - 6.5	**145 6036**	**145 6049**	**145 6057**	**145 6066**	**145 6159**	B 500
4.1 mm	**4 x 13**	3.5 - 9.5	**145 6037**	**145 6050**	**144 6496**	**145 6067**	**144 6511**	B 500
	4 x 17	7.0 - 13.0	x	x	x	x	**145 6160**	B 500
4.8 CE	**4.8 x 10**	0.5 - 6.5	**145 6039**	**145 6051**	**145 6059**	**145 6068**	**145 0450**	B 500
4.9 mm	**4.8 x 15**	4.5 - 11.0	**145 6040**	**145 6052**	**145 6060**	**145 6069**	**145 6161**	B 500
	4.8 x 17	6.5 - 13.0	**144 6487**	**145 6053**	**145 6061**	**145 0447**	**145 6162**	B 500
	4.8 x 25	11.0 - 19.5	**145 6041**	**145 6054**	**145 6062**	**145 6070**	**144 6512**	B 250

D mm	D x L mm	mm	RAL 7022 Umbra grey No.	RAL 7024 Graphite grey No.	RAL 8014 Sepia brown No.	RAL 9002 Grey white No.	RAL 9003 Signal white No.	
3.2	**3.2 x 8**	0.5 - 5.0	x	x	**145 6088**	**145 6096**	**145 6106**	B 1000
3.3 mm	**3.2 x 9.5**	1.5 - 6.5	x	x	**145 6089**	x	**144 6503**	B 1000
	3.2 x 11	3.0 - 8.0	x	x	**144 6501**	x	**145 6107**	B 1000
4 CE	**4 x 10**	0.5 - 6.5	**145 6074**	**145 6082**	**145 6090**	**145 6099**	**145 6108**	B 500
4.1 mm	**4 x 13**	3.5 - 9.5	**145 6075**	**145 6083**	**145 6091**	**145 6100**	**145 6109**	B 500
	4 x 17	7.0 - 13.0	x	x	**145 6092**	**145 6101**	**145 6110**	B 500
4.8 CE	**4.8 x 10**	0.5 - 6.5	x	**145 6085**	**145 6093**	**145 6102**	**145 6111**	B 500
4.9 mm								

D mm	D x L mm	mm	RAL 9005 Jet black No.	RAL 9006 White aluminium No.	RAL 9007 Grey aluminium No.	RAL 9010 Pure white No.	RAL 9011 Graphite black No.	
3.2	**3.2 x 8**	0.5 - 5.0	**145 6114**	x	**145 6131**	**145 6140**	**145 6150**	B 1000
3.3 mm	**3.2 x 9.5**	1.5 - 6.5	**145 6115**	x	**145 6132**	**145 6141**	**145 6151**	B 1000
	3.2 x 11	3.0 - 8.0	**145 6116**	**144 6505**	**145 6133**	**145 6142**	**145 6152**	B 1000
4 CE	**4 x 10**	0.5 - 6.5	**145 6117**	**145 6126**	**145 6134**	**145 6143**	**145 6153**	B 500
4.1 mm	**4 x 13**	3.5 - 9.5	**145 6118**	**144 6506**	**145 6135**	**145 6144**	**145 6154**	B 500
	4 x 17	7.0 - 13.0	**145 6119**	**145 6127**	**144 6508**	**145 6145**	**145 6155**	B 500
4.8 CE	**4.8 x 10**	0.5 - 6.5	**145 6120**	**145 6128**	**145 6136**	**145 6146**	**145 6156**	B 500
4.9 mm	**4.8 x 15**	4.5 - 11.0	**145 6121**	**145 6129**	**145 6137**	**145 6147**	**145 6157**	B 500
	4.8 x 17	6.5 - 13.0	**145 6122**	**145 6130**	**145 6138**	**145 6148**	**144 6509**	B 500
	4.8 x 25	11.0 - 19.5	**145 6123**	x	**145 6139**	**145 6149**	x	B 250

The material surcharge will be added at a daily rate.

SOLARGRIP® – THE SPECIAL RIVET

SolarGrip® – the special rivet for flexible use in solar panel installation

IBC SOLAR AG, one of the world's leading global photovoltaic systems integrators, is investing in its cooperation with GESIPA®. GESIPA® has developed a blind rivet for the efficient IBC TopFix 200 assembly system that adequately meets the technical requirements, and has produced it in Germany.

THE ADVANTAGES ARE CLEAR: Fast and precise work, as well as tightness against splashing water at the riveting points, result in a durable and safe connection. We recommend using PowerBird® Solar or AccuBird® for quick and easy assembly. IBC Solar and GESIPA®, good connections are unbeatable.

WHAT OUR CLIENT IBC SOLAR SAYS ABOUT SOLARGRIP®:
„By offering our IBC TopFix 200 assembly system, we provide our customers with an assembly system for pitched roofs that is approved by the building inspectorate and ensures the highest level of flexibility and quality. IBC TopFix 200 is universally usable on any pitched roof and provides solutions for many different Types of roofs. Specially-designed prefabricated module clamps are used for assembly on trapezoidal sheet metal roofs, which helps to save up to 20% of installation time compared to conventional assembly systems.

GESIPA® SolarGrip® rivets ensure quick, easy and safe assembly on the metal sheet. The rivet customised to our system and quality requirements guarantees water tightness, a long service life and the highest economic efficiency, and has proved itself in practice millions of times.

Many of our trade partners use **SolarGrip®** for convenient assembly of the substructure. The same also goes for the Haude family in Upper Franconia, Germany (see image). In 2015, the Haude family built their house in accordance with the latest energy efficiency principles, with the aim of avoiding primary energy from fossil fuels altogether. At the heart of the energy concept is a 9.7 kWp PV roof system. "To fix the assembly system to the trapezoidal sheet roof, we used pre-assembled clamps with SolarGrip® rivets – an impressive solution from our partner GESIPA®."

Sonnenstrom mit System IBC SOLAR

SOLARGRIP® – THE SPECIAL RIVET

Millions of connections exposed to storms, rain, snow and sunlight on a daily basis are testament to the reliability of GESIPA® SolarGrip® blind rivets

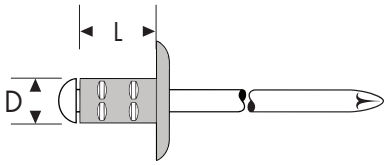
Speak to us, we will be happy to advise you!

SolarGrip® – The solar fastener
- ETA-Approval applied for ETA-13/0255
- Matching grip range for many solar applications
- deal for working on trapezoid panel roofs
- SolarSeal coating for 4.8 mm rivets
- Riveting of sponge rubber or EPDM washers possible
- Function documentation available on request at
- extra cost

SolarGrip® – The basic characteristics
- Large grip range coverage with a single blind rivet
- Wide closing head
- Outstanding hole filling capability
- Compact closing head
- For use with all GESIPA® setting tools

The perfect processing tool, the **PowerBird®-Solar**, can be found on **page 96**.

SOLARGRIP® PROGRAM



D	D x L mm	MATERIAL	mm	N	N	No.	
4.8 - K 11.4 CE 5.1- 5.2 mm	4.8 x 12.0	Rivet body: Alu AlMg 2.5 (Colour: black) Mandrel: Stainless steel A2 — Nr. 1.4541	3.0 - 5.0	**2,300**	**1,500**	**143 3905**	P 500
	4.8 x 15.0	Rivet body: Alu AlMg 2.5 (blank) Mandrel: Stainless steel, zinc-plated	5.0 - 8.0	**2,300**	**1,500**	**143 3906**	"
6.4 - K 11.4 CE 6.5 - 6.9 mm	6.4 x 14.0	Rivet body: Alu AlMg 2.5 (blank) Mandrel: Steel, zinc-plated	3.0 - 8.0	**4,000**	**2,800**	**145 5678**	P 250

Material surcharge will be added at a daily rate

CE: ETA certification 13/0255 Corresponding approval documents on **www.gesipa.com**
All sizes on request – also available in bulk packs

CAP® – CLOSED END BLIND RIVETS

GESIPA® CAP® – naturally air and watertight

THE STRUCTURE

For technical reasons, the rivet mandrel of the GESIPA® CAP ® blind rivet must be fixed in the rivet body. However this means that the rivet body can only deform slightly during the setting process. As a result, the cap blind rivet only has marginal hole filling capability. However this is necessary to be able to compensate large borehole tolerances.

TIGHT CONNECTIONS WITH CARE

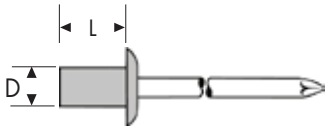
The above-mentioned technical situations make careful preparation of the application imperative. The hole diameter should be as tight as possible to ensure a flawless function in the application for a long period.

If the GESIPA® CAP® blind rivet is processed carefully, it forms the basis for a reliably „tight" connection.

Alu/steel Standard

Aluminium alloy

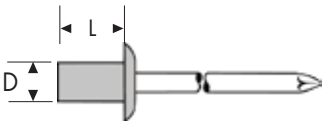
Steel, phosphate coated



D	D x L mm	mm	No.	
3.2	**3.2 x 6.5**	0.5 - 2.0	**143 3423**	A 500
3.3 mm	**3.2 x 8.0**	2.0 - 3.5	**143 3424**	"
	3.2 x 9.5	3.5 - 5.0	**143 3425**	"
	3.2 x 10.5	5.0 - 6.5	**145 3876**	"
	3.2 x 12.5	6.5 - 8.0	**145 3877**	"
4	**4 x 8.0**	0.5 - 3.5	**143 3431**	B 500
4.1 mm	**4 x 9.5**	3.5 - 5.0	**143 3432**	"
	4 x 11.0	5.0 - 6.5	**143 3433**	"
	4 x 12.5	6.5 - 8.0	**143 3434**	"
	4 x 15.0	8.0 - 11.0	**145 3878**	"

D	D x L mm	mm	No.	
4.8	**4.8 x 8.0**	1.0 - 3.5	**143 3426**	B 500
4.9 mm	**4.8 x 9.5**	3.5 - 5.0	**143 3427**	"
CE	**4.8 x 11.0**	5.0 - 6.5	**143 3428**	"
	4.8 x 12.5	6.5 - 8.0	**143 3429**	"
	4.8 x 14.0	8.0 - 9.5	**143 3430**	"
	4.8 x 16.0	9.5 - 11.0	**145 3879**	"
	4.8 x 18.0	11.0 - 13.0	**143 3435**	"
	4.8 x 21.0	13.0 - 16.0	**143 3436**	B 250

Alu/stainless steel Standard



Aluminium alloy

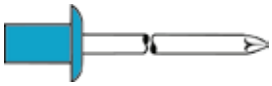
Stainless steel

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 6.5**	0.5 - 2.0	**143 3437**	A 500
	3.2 x 8.0	2.0 - 3.5	**143 3438**	"
	3.2 x 9.5	3.5 - 5.0	**143 3439**	"
	3.2 x 10.5	5.0 - 6.5	**143 3440**	"
	3.2 x 12.5	6.5 - 8.0	**145 3890**	"
4 4.1 mm	**4 x 8.0**	0.5 - 3.5	**143 3441**	B 500
	4 x 9.5	3.5 - 5.0	**145 3891**	"
	4 x 11.0	5.0 - 6.5	**145 3892**	"
	4 x 12.5	6.5 - 8.0	**143 3442**	"

D	D x L mm	mm	No.	
4.8 4.9 mm CE	**4.8 x 8.0**	1.0 - 3.5	**143 3443**	B 500
	4.8 x 9.5	3.5 - 5.0	**143 3444**	"
	4.8 x 11.0	5.0 - 6.5	**143 3445**	"
	4.8 x 12.5	6.5 - 8.0	**143 3446**	"
	4.8 x 14.0	8.0 - 9.5	**143 3447**	"
	4.8 x 16.0	9.5 - 11.0	**143 3448**	"
	4.8 x 18.0	11.0 - 13.0	**143 3449**	"
	4.8 x 21.0	13.0 - 16.0	**143 3450**	B 250

Material surcharge will be added at a daily rate

A2 stainless steel Standard



Stainless Steel A2 — no. 1.4301

Stainless Steel A1

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 6.0**	0.8 - 2.0	**145 3899**	A 500
	3.2 x 8.0	2.0 - 4.0	**143 3452**	"
	3.2 x 10.0	4.0 - 6.0	**145 3900**	"
	3.2 x 12.0	6.0 - 8.0	**143 3453**	"
4 4.1 mm	**4 x 6.0**	0.8 - 1.5	**145 3901**	A 500
	4 x 8.0	1.5 - 3.5	**143 3454**	"
	4 x 10.0	3.5 - 5.5	**145 3902**	B 500
	4 x 12.0	5.5 - 7.5	**143 3455**	"
	4 x 16.0	7.5 - 11.5	**145 3903**	"

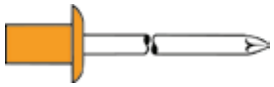
D	D x L mm	mm	No.	
4.8 4.9 mm	**4.8 x 8.0**	0.8 - 3.0	**143 3456**	B 500
	4.8 x 10.0	3.0 - 5.0	**143 3457**	"
	4.8 x 12.0	5.0 - 7.0	**143 3458**	"
	4.8 x 16.0	7.0 - 11.0	**143 3459**	"
	4.8 x 20.0	11.0 - 15.0	**143 3460**	B 250

Material surcharge will be added at a daily rate
You have to expect limited jaw life.

45

The information on shear and tensile strength, rivet pin diameters and the maximum setting head diameters can be found on **page 45**

Copper/steel Standard



Copper alloy

Steel, lightly oiled

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 6.0**	0.5 - 1.5	**145 3904**	A 500
	3.2 x 7.5	1.5 - 3.0	**145 3905**	"
	3.2 x 9.0	3.0 - 4.5	**145 3906**	"
4 4.1 mm	**4 x 9.5**	1.0 - 4.5	**145 3908**	A 500

Copper/stainless Standard

Copper alloy

Stainless steel

D	D x L mm	mm	No.	
3.2 3.3 mm	**3.2 x 6.0**	0.5 - 1.5	**145 3913**	A 500
	3.2 x 7.5	1.5 - 3.0	**145 3914**	"
	3.2 x 9.0	3.0 - 4.5	**145 3915**	"
4 4.1 mm	**4 x 9.5**	1.5 - 4.5	**145 0152**	B 500
	4 x 11	4.5 - 6.0	**145 0153**	"
	4 x 12.5	6.0 - 7.5	**145 0154**	"
	4 x 15	7.5 - 10.5	**145 0155**	"

Material surcharge will be added at a daily rate

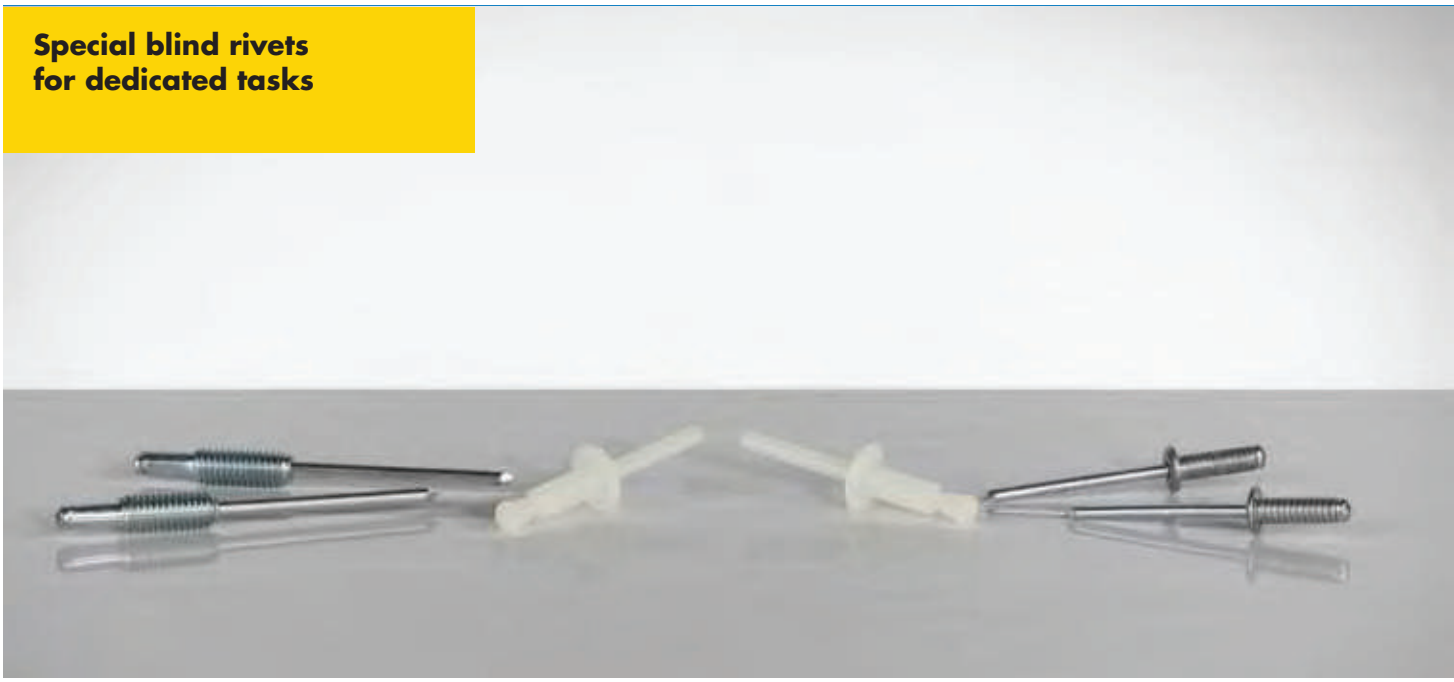
SHEAR AND TENSILE STRENGTH CAP®-BLIND RIVETS

D mm	N	N	d_m mm	max. d_k Standard mm
CAP® ALU/STEEL AND **ALU/STAINLESS STEEL**				
3.2	**1,100**	**1,250**	1.7	6.5
4.0	**1,600**	**2,200**	2.18	8.5
4.8	**2,230**	**3,100**	2.63	10.0
CAP®-A2 STAINLESS STEEL				
3.2	**2,000**	**2,200**	1.9	6.5
4.0	**3,120**	**3,560**	2.3	8.5
4.8	**4,000**	**4,400**	2.9	10.0
CAP®-COPPER/STEEL AND **COPPER/STAINLESS STEEL**				
3.2	**980**	**1,340**	1.7	6.0
4.0	**1,350**	**2,000**	2.18	8.5

Test procedure according to DIN EN ISO 14589

SPECIAL BLIND RIVETS

Special blind rivets for dedicated tasks



There are numerous applications that require the use of special blind rivets. For this reason GESIPA® has come up with some variations to meet these requirements.

Grooved blind rivets are suitable for riveting pocket holes in soft materials. They are used in the furniture industry, for interior construction, in the wood and plastics processing industry, in car body construction and lots more. Important: Before processing grooved blind rivets, the borehole diameter must be determined in trials and the minimim borehole depth must be observed.

Peel blind rivets are required if soft or porous parts such as wood, hard-fi bre, fi breglass or plasterboards need to be joined together. In the setting process, the rivet mandrel falls out of the rivet body, and on the closing head side the rivet mandrel splits the rivet shaft into four parts. These then grip into the material. Typical application fields are the assembly of plastic and wooden elements,caravan constructions and the attachment of interior panels.

The blind rivet connection itself is a permanent connection. However to attach further detachable parts, GESIPA® has the **threaded blind rivet** in its range. The threaded blind rivet has a stud bolt with an M5 or M6 outer thread to which other parts can be attached using an additional nut. The GESIPA® blind rivet stud range is listed on page 204 for parts that need greater clamping forces.

The **GESIPA®-clamp profi le blind rivet** are excellently suited to comply with defi ned clearances when mounting parts or to set stoppers in rails. Accordingly, this special rivet is also used in the white goods and furniture industry.

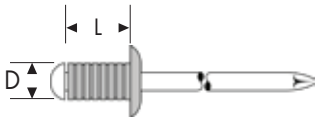
Plastic rivets are free from corrosion, do not conduct electricity and do not damage varnished surfaces. They can be processed quickly and easily using GESIPA® manual blind rivet tools and automated riveting tools. The plastic blind rivets can be found in many trade sectors and their versatility makes them an interesting choice for a wide range of application possibilities.

SPECIAL BLIND RIVETS

Grooved alu/steel Standard (Dome head)

Aluminium alloy

Steel, zinc-plated



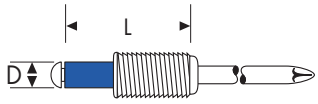
D	D x L mm	max. thickness of material to be fixed mm	No.	
3.2	**3.2 x 10**	6	**145 4100**	A 500
3.4 mm	**3.2 x 16**	12	**145 4101**	"
4	**4 x 8**	4	**145 4103**	A 500
	4 x 12	8	**145 4104**	B 500
4.3 mm	**4 x 16**	12	**145 4105**	"

D	D x L mm	max. thickness of material to be fixed mm	No.	
4.8	**4.8 x 10**	6	**145 4108**	B 500
5.1 mm	**4.8 x 14**	10	**145 4110**	B 250
	4.8 x 18	13	**145 4102**	"

Threaded steel/steel

Steel, zinc-plated

Steel, zinc-plated



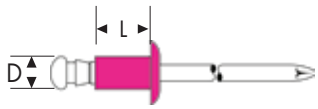
Thread 3.1 mm G x l mm	D x L mm	mm	No.	
M 5 x 10	**3 x 6**	0.5 - 3.0	**145 5326**	A 250
M 5 x 15	**3 x 9**	3.0 - 6.0	**145 5327**	"

Thread 4.1 mm G x l mm	D x L mm	mm	No.	
M 6 x 10	**4 x 5**	1.0 - 2.0	**145 5328**	A 250
M 6 x 15	**4 x 8**	2.0 - 5.0	**145 5329**	"

Plastic Standard (Dome head)

Polyamid, PA 6.6

Polyamid, PA 6.6



D	D x L mm	mm	No.	
4	**4 x 8**	0.5 - 5.0	**145 5337**	B 500
4.1 mm	**4 x 12**	5.0 - 9.0	**145 5338**	"
5	**5 x 8**	0.5 - 5.0	**145 5339**	B 500
5.1 mm	**5 x 12**	5.0 - 9.0	**145 5340**	"

D	D x L mm	mm	No.	
6	**6 x 8**	0.5 - 5.0	**145 5341**	B 250
6.1 mm	**6 x 12**	5.0 - 9.0	**145 5342**	"

CHART SHEAR AND TENSILE STRENGTH

D mm	N	N	d_m mm
Grooved alu/steel			
3.2	**720**	**950**	1.95
4	**1,400**	**2,000**	2.1
4.8	**1,800**	**2,700**	2.7

D mm	N	d_m mm
Threaded steel/steel		
3	**1,100**	1.95
4	**2,000**	2.5

D mm	N	d_m mm
Plastic		
4	**180**	2.5
5	**300**	3.0
6	**440**	3.5

Test procedure according to DIN EN ISO 14589

SPECIAL BLIND RIVETS

Peel alu/steel Standard

Rivet body: Aluminium alloy
Mandrel: Steel, zinc-plated

D	D x L mm	mm	No.	
3.2	**3.2 x 10**	2.5 - 5.0	**145 5496**	A 500
3.6 mm	**3.2 x 12**	4.5 - 7.0	**143 3748**	"
	3.2 x 16	6.5 - 11.0	**145 5497**	"
4	**4 x 8**	1.0 - 3.0	**145 5490**	A 500
4.4 mm	**4 x 10**	2.5 - 5.0	**145 5494**	B 500
	4 x 12	4.5 - 6.5	**145 5491**	"
	4 x 14	6.0 - 8.0	**145 5492**	"
	4 x 16	7.5 - 10.0	**143 3740**	"
	4 x 18	9.0 - 12.0	**143 3741**	"
	4 x 20	11.5 - 14.0	**145 5493**	"

D	D x L mm	mm	No.	
4.8	**4.8 x 10**	2.5 - 5.0	**143 3747**	B 500
5.2 mm	**4.8 x 12**	4.5 - 7.0	**143 3742**	"
	4.8 x 14	6.5 - 9.0	**143 3743**	B 250
	4.8 x 16	8.5 - 10.0	**143 3744**	"
	4.8 x 18	9.5 - 12.0	**143 3746**	"
	4.8 x 20	11.5 - 14.0	**143 3745**	"
	4.8 x 25	13.5 - 19.0	**143 3749**	"

SHEAR STRENGTH

D mm	N	d_m mm	max. d_k mm
3.2	**700**	1.95	6.5
4	**1,200**	2.1	8.0
4.8	**1,700**	2.7	9.5

Test procedure according to DIN EN ISO 14589

Profile clinching rivets alu/steel

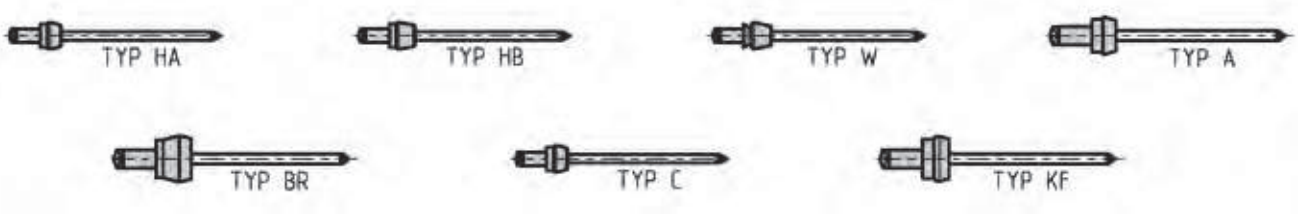
Rivet body: Aluminium alloy
Mandrel: Steel, zinc-plated

Profile Typ 3.1 mm	D x L mm	mm	No.	
HA	**3 x 5**	1.0 - 2.5	**145 3916**	A 500
HB	**3 x 5**	1.0 - 2.5	**145 3918**	A 500
HB	**3 x 7**	2.5 - 4.5	**145 3919**	"
W	**3 x 5**	1.0 - 2.5	**145 3920**	A 500
A	**4 x 7**	1.0 - 4.0	**145 3921**	B 500
BR	**4 x 7**	1.0 - 4.0	**145 3922**	"
C	**4 x 7**	1.0 - 4.0	**145 3923**	"

SHEAR STRENGTH

D mm	N	d_m mm
3	**450**	1.8
4	**850**	2.1

Test procedure according to DIN EN ISO 14589



G-BULB BLIND RIVETS

G-Bulb – high strength blind rivets – in carbon steel and stainless steel

G-BULB BLIND RIVET

GESIPA® has developed a new range of high strength structural blind rivets called G-Bulb with diameters of 4.8 and 6.4 mm in steel and A2 stainless steel, to fit grip ranges from 1.5 up to 15.5 mm.

The G-Bulb rivet features a wide grip range, together with high shear and tensile strengths generated by the rivet function, the formation of a large closing head and the mechanical lock of the rest mandrel in the rivet body.

In combination with the patented function crimping on the rivet body, the G-Bulb provides tight and sealed joints in a large variation of hole sizes.

The G-Bulb rivet generates a large closing head which transfers high strain and clamping load to the application. With a mandrel breakload of max.16 kN, the G-Bulb rivets can be installed with standard tooling.

G-BULB – HIGH STRENGTH BLIND RIVETS

THE SETTING PROCESS

MAIN FEATURES

- Excellent hole filling capability
- High clamping force
- Excellent tensile strength through large closing head
- Excellent shear strength through mandrel locking
- Processing with standard setting tools
- Process control compatible with the TAURUS® C
- RoHS compliant

MATERIALS

Rivet body: Steel, zinc plated CrVI-free,
or stainless steel
A2 no. 1.4567, Mandrel: Steel, zinc plated
CrVI-free, or stainless steel A2 no. 1.4541

Other surface treatments on request

Steel/steel Dome head

Steel, zinc-plated

Steel, zinc-plated

D	D x L mm	mm	No.	
4.8 CE	**4.8 x 10**	1.5 - 3.5	**143 3925**	B 500
	4.8 x 13	3.5 - 6.0	**143 3926**	"
5.0 - 5.2 mm	**4.8 x 15**	6.0 - 8.0	**143 3927**	"
6.4 CE	**6.4 x 13**	2.0 - 4.5	**143 3928**	B 250
	6.4 x 17	4.5 - 7.0	**143 3929**	"
6.7 - 6.9 mm	**6.4 x 20**	7.0 - 10.5	**143 3930**	B 200
	6.4 x 23	10.5 - 13.0	**143 3931**	B 150
	6.4 x 25	13.0 - 15.5	**143 3932**	"

Further dimensions and surface treatments on request

A2 stainless steel Standard Dome head

Stainless steel A2 — no. 1.4567

Stainless steel A2

D	D x L mm	mm	No.	
4.8 CE	**4.8 x 10**	1.5 - 3.5	**145 6426**	B 500
	4.8 x 13	3.5 - 5.5	**145 6427**	"
5.0 - 5.2 mm	**4.8 x 15**	5.5 - 7.5	**143 3936**	"
6.4 CE	**6.4 x 13**	2.0 - 4.0	**143 3937**	B 250
	6.4 x 15	4.0 - 6.0	**143 3938**	"
6.7 - 6.9 mm	**6.4 x 17**	6.0 - 8.0	**143 3939**	"
	6.4 x 20	8.0 - 10.5	**143 3940**	B 200
	6.4 x 23	10.5 - 12.5	**143 3941**	B 150
	6.4 x 25	12.5 - 14.5	**143 3942**	B 150

Material surcharge will be added at a daily rate

Further dimensions and surface treatments on request

SHEAR AND TENSILE STRENGTH G-BULB

D mm	N	N	d_m mm	max. d_k mm
STEEL/STEEL				
4.8 x 10	**3,600**	**3,500**	3.2	9.5
4.8 x 13	**4,000**	**3,500**	3.2	9.5
4.8 x 15	**5,600**	**3,500**	3.2	9.5
6.4 x 13	**8,500**	**8,000**	4.25	13.0
6.4 x 17	**10,000**	**8,000**	4.25	13.0
6.4 x 20	**11,000**	**8,000**	4.25	13.0
6.4 x 23	**11,000**	**8,000**	4.25	13.0
6.4 x 25	**11,000**	**8,000**	4.25	13.0
A2 STAINLESS STEEL				
4.8 x 10	**4,400**	**5,400**	3.2	9.5
4.8 x 13	**4,550**	**5,400**	3.2	9.5
4.8 x 15	**4,700**	**5,400**	3.2	9.5
6.4 x 13	**8,000**	**8,800**	4.25	13.0
6.4 x 15	**10,000**	**8,800**	4.25	13.0
6.4 x 17	**10,000**	**8,800**	4.25	13.0
6.4 x 20	**11,000**	**8,800**	4.25	13.0
6.4 x 23	**11,000**	**8,800**	4.25	13.0
6.4 x 25	**11,000**	**8,800**	4.25	13.0

Test procedure according to DIN EN ISO 14589

POLYBULB® BLIND RIVETS

Large disc-shaped bulb formation – perfect for sensitive applications with both soft and brittle materials.

DISC-SHAPED CLOSING HEAD

This practical closing head shape evenly distributes the contact pressure over the component, making it the perfect joining element for riveting both soft and brittle components such as plastics and composite materials. The PolyBulb® blind rivet leaves an aesthetic setting appearance.

LARGE GRIP RANGE

A PolyBulb® blind rivet replaces up to 3 conventional blind rivets, thus reducing parts diversity. Combining several dimensions saves handling and storage costs while additionally reducing the risk of mix-up at the workplace and subsequent quality problems.

CONTROLLED HOLE FILLING

With hole filling capabilities adapted to requirements, the PolyBulb® blind rivet provided an optimum joint.

ADVANTAGES

- Large grip range
- Disc-shaped closing head with large closing head Ø
- Aesthetic setting appearance, only one distinct closing head
- High tensile strength and detachment force (especially with plastic joining material)
- Controlled hole filling
- Excellent grip properties
- Locked mandrel
- Non-rattling
- Process control capabilities

POLYBULB® BLIND RIVETS

Alu/steel Dome head

Aluminium alloy
Steel, zinc-plated

D	D x L mm	mm	No.	
4.8	**4.8 x 11**	1.5 - 6.0 *	**145 0473**	B 250
4.9 mm - 5.1 mm	**4.8 x 16**	6.0 - 10.0 *	**145 0474**	B 250

*Reference value that changes depending on the hole diameter and the material to be riveted.

Alu/stainless steel Dome head

Aluminium alloy
A2 stainless steel

D	D x L mm	mm	No.	
4.8	**4.8 x 11**	1.5 - 4.5*	**161 9573**	B 250
4.9 mm - 5.1 mm	**4.8 x 16**	6.0 - 9.0 *	**161 9574**	B 250

*Reference value that changes depending on the hole diameter and the material to be riveted.

Steel/steel Dome head

Steel, zinc-plated
Steel, zinc-plated

D	D x L mm	mm	No.	
4.8	**4.8 x 11**	1.5 - 6.0 *	**146 4926**	B 250
4.9 mm - 5.2 mm	**4.8 x 16**	6.0 - 10.0 *	**146 4925**	B 250

*Reference value that changes depending on the hole diameter and the material to be riveted.

SHEAR AND TENSILE STRENGTH

D mm	N	N	d_m mm	max. d_k mm
ALU/STEEL				
4.8 x 11	**1,200**	**1,900**	3.0	10.0
4.8 x 16				
ALU/STAINLESS STEEL				
4.8 x 11	**1,200**	**1,900**	3.0	10.0
4.8 x 16				
STEEL/STEEL				
4.8 x 11	**2,700**	**3,800**	3.0	10.0
4.8 x 16		**3,300**		

MEGA GRIP® BLIND RIVETS

GESIPA®-MEGA GRIP® – High strength blind rivets with large grip range and optimal cost effectiveness

MEGA GRIP® BLIND RIVETS – PERFECT EFFICIENCY

The GESIPA® MEGA GRIP® is a high strength structure blind rivet with a very large grip range. The variable grip range allows efficient use and, owing to the merging of up to five blind rivet lengths into one MEGA GRIP® dimension, reduces the handling costs.

THE SETTING PROCESS

During the setting process, the hollow mandrel head presses the rivet body with great force against the rivet hole. The radial deformation here ensures that an aboveaverage, large clamping area is covered. The stable position of the rivet mandrel throughout the entire setting process guarantees compliance with the high shear force through double locking. The excellent hole filling capability also protect ideally against splash-water.

STANDARD OR SPECIAL PRODUCTION?

The GESIPA® MEGA GRIP® is available in a flat Round head or recessed head form and comes in the material combinations alu/alu or steel/steel as standard. Supplied in large or small packages, the MEGA GRIP® is always available in the quantity required. We can supply special dimensions on request.

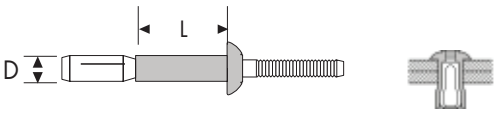
THE ADVANTAGES

- Perfectly splash proof
- Efficient use with large grip range coverage
- High shear strength due to double rest mandrel locking
- Outstanding hole filling capability
- Flush removal on the setting head without sharp edges.

Please note that to achieve the best possible values from the GESIPA®-MEGA GRIP®, use of special tools/nosepieces is required.

MEGA GRIP® blind rivets are available in small packs, too! Marked with the abbreviation KV.

MEGA GRIP® BLIND RIVETS



Alu/alu

Dome head

Aluminium alloy

Aluminium alloy

D	D x L mm	mm	TYP	No. GV		No. KV	
4.8	**4.8 x 10.0**	1.6 - 6.4	RV6900-6-4	**143 3805**	5,000	**143 3808**	B500
4.9 - 5.2 mm	**4.8 x 14.0**	1.6 - 11.1	RV6900-6-7	**145 5654**	3,000	**143 3809**	B250
6.4	**6.4 x 14.1**	2.0 - 9.5	RV6900-8-6	**143 3806**	2,000	**143 3810**	B200
6.6 - 6.9 mm	**6.4 x 19.1**	2.0 - 15.9	RV6900-8-10XG	**143 3807**	1,500	**143 3811**	B100

Steel/steel

Dome head

Steel, zinc-plated

Steel, zinc-plated

D	D x L mm	mm	TYP	No. GV		No. KV	
4.8	**4.8 x 10.0**	1.6 - 6.4	RV6977-6-4	**143 3812**	5,000	**143 3816**	B500
4.9 - 5.2 mm	**4.8 x 14.0**	1.6 - 11.1	RV6977-6-7	**145 5657**	3,000	**143 3817**	B250
6.4	**6.4 x 14.1**	2.0 - 9.5	RV6977-8-6	**143 3813**	1,500	**145 5663**	B200
6.6 - 6.9 mm	**6.4 x 19.1**	2.0 - 15.9	RV6977-8-10XG	**143 3814**	1,500	**143 3818**	B100

Steel/steel

Countersunk

Steel, zinc-plated

Steel, zinc-plated

D	D x L mm	mm	TYP	No. GV		No. KV	
4.8	**4.8 x 10.0**	2.6 - 6.4	RV6177-6-5	**145 5658**	2,500	**145 5660**	B250
4.9- 5.2 mm	**4.8 x 14.0**	5.5 - 11.1	RV6177-6-8	**145 5659**	2,500	**145 5661**	B250
6.4	**6.4 x 15.8**	3.0 - 11.1	RV6177-8-7	**143 3815**	1,500	**145 5662**	B200
6.6 - 6.9 mm							

SHEAR AND TENSILE STRENGTH MEGA GRIP®

D mm	N	N	d_m mm	max. d_k mm
ALU/ALU				
4.8	**3,280**	**2,350**	2.95	9.5
6.4	**5,730**	**3,840**	3.9	12.7
STEEL/STEEL				
4.8	**6,850**	**4,500**	2.95	9.5
6.4	**12,455**	**8,200**	3.9	12.7

Test procedure according to DIN EN ISO 14589

BULB-TITE® BLIND RIVETS

Strong in demanding applications requiring perfect clamp force and weatherproofness

Originally designed for the construction industry, the GESIPA®-BULB-TITE® rivets have proven their worth in many other application fields thanks to their multi-functional properties. The majority of the BULB-TITE® program has been approved by the „Deutsches Institut für Bautechnik" in Berlin thereby guaranteeing extra security when used in steel constructions or on facades.

POWERFUL WHEREVER USED

Thanks to the shear zone overlap of the BULB-TITE®-rivet mandrel in the application, permanent and very high shear forces can be achieved.

WEATHER RESISTANCE

The use of a special nosepiece when processing the BULB-TITE®-rivet locks the mandrel into the sealing part on the setting head side to prevent dirt and/or damp penetrating the application. The sealing washer, which is available as an optional accesory, offers added protection against wet and damp below the closing head.

EXCELLENT CLAMPING FORCE

The three large pressure plates distribute the clamping forces evenly across a large area of the surface so that even soft, thin, supple or brittle materials can be riveted safely without destroying or damaging the surface.

COMPLEX APPLICATIONS

BULB-TITE®- rivets also guarantee a safe function where other rivets have already given up. The three plates of the closing head adapt and form to fit even curved application surfaces so that safe riveting is possible even on pipes, beads and other unusually formed applications.

APPLICATION AREAS

Fassades, shipbuilding, containers, truck and passenger busses production, trailers, trapezoidal sheet metal roof

THE ADVANTAGES

- Large grip range
- Vibration-proof
- Use on straight and curved application parts
- Waterproof with neoprene sealing washer
- Large distirbution of the grip force over a large surface

Please note that to achieve the best possible values from the GESIPA®-BULB-TITE®, use of special tools/ nosepieces is required.

BULB-TITE® blind rivets are available in small packs, too! Marked with the abbreviation KV.

BULB-TITE® BLIND RIVETS

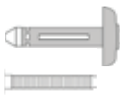
Alu/alu
Dome head

Aluminium alloy
Aluminium alloy

*Clearance –
only while stocks last!

D	D x L mm	mm	TYP	No. KV	
4 4.2 - 4.3 mm	**4 x 25.1**	6.4 - 12.7	RV 6604-5-8	-	-
5.2 5.3 - 5.5 mm	**5.2 x 17.5**	1.3 - 4.8	RV 6604-6-3	-	B 250
	5.2 x 19.1	1.6 - 6.4	RV 6604-6-4	**145 5606**	"
	5.2 x 22.2	4.7 - 9.5	RV 6604-6-6	**145 5607***	"
with EPDM washer	**5.2 x 17.5**	0.5 - 4.8	RV 6604-6-3 W	**145 5620**	B 250
CE	**5.2 x 19.1**	1.6 - 6.4	RV 6604-6-4 W	**145 5621**	"
	5.2 x 22.2	4.7 - 9.5	RV 6604-6-6 W	**145 5622**	"
	5.2 x 25.4	7.9 - 12.7	RV 6604-6-8 W	**145 5623**	"
7.7 CE 7.8 - 8.2 mm	**7.7 x 27.7**	1.0 - 9.5	RV 6603-9-6 W	**145 5632**	"

Alu/alu
Large flange



Aluminium alloy
Aluminium alloy

D	D x L mm	mm	TYP	No. KV	
7.7 - K19 CE 7.8 - 8.2 mm	**7.7 x 27.7**	1.1 - 9.5	RV 6605-9-6 W	**145 5633**	B 100
	7.7 x 34.0	6.4 - 15.9	RV 6605-9-10 W	**145 5634**	B 100

SHEAR AND TENSILE STRENGTH BULB-TITE®

D mm	N	N	d_m mm	max. d_k mm
ALU/ALU				
4	**2,000**	**1,050**	2.4	9.0
5.2	**2,700**	**1,950**	2.9	11.7
7.7	**6,650**	**4,850**	4.5	15.9
7.7 K19	**6,650**	**4,850**	4.5	19.3

TRI-FOLD® FOLDING TYPE BLIND RIVETS

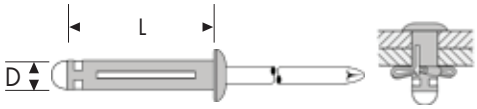
TRI-FOLD® folding Type blind rivets – for soft and porous application materials

THE FUNCTION
The GESIPA® TRI-FOLD® blind rivet forms three press lashes on the closing head side during setting.

THE ADVANTAGES
The large moulded lashes distribute the exerted clamping force evenly and gently onto the riveted material.
Also, the large surface of the lashes offer excellent protection against the rivet being pulled through very soft, porous or brittle application parts.

Thanks to its special design, the TRI-FOLD® is also able to compensate over-dimensional or irregular drill hole diameters.

APPLICATION AREAS
TRI-FOLD® blind rivets are excellently suited for the automotive field, e.g. for plastic panelling, car body parts and for the interior work inside vehicles, but also for all other applications that are particularly soft, brittle, easily deformed or porous.



Alu/alu

Dome head


Aluminium alloy


Aluminium alloy

D	D x L mm	mm	TYP	No.	
4.8	**4.8 x 16.0**	1.0 - 3.0	GAMD64ATF	**143 3821**	B 250
5.1 mm	**4.8 x 20.0**	3.0 - 8.50	GAMD66ATF	**145 5668**	B 250
	4.8 x 25.4	7.9 - 12.7	GAMD68ATF	**145 5669**	B 250

SHEAR AND TENSILE STRENGTH

D mm	N	N	d_m mm	max. d_k mm
TRI-FOLD® Alu/Alu				
4.8	**1,100**	**1,400**	2.9	10.1

Test procedure according to DIN EN ISO 14589

CORDLESS BLIND RIVET SETTING TOOLS

**Manual blind rivet setting tools –
Easy to operate, tried and tested!**

CORDLESS BLIND RIVET SETTING TOOLS

BLIND RIVET HAND TOOLS

62


64

NTS


65

NTX & NTX-F


66

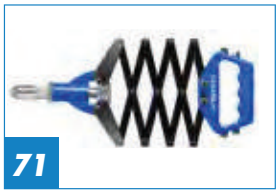
Flipper®


68

Flipper® Plus


70

HN2


71

SN2

BATTERY POWERED BLIND RIVET SETTING TOOLS

72


76

AccuBird® Pro


78

PowerBird® Pro


80

PowerBird® Pro Gold Edition


82

Pro series with spring-loaded trigger system


84

iBird® Pro


92

AccuBird®

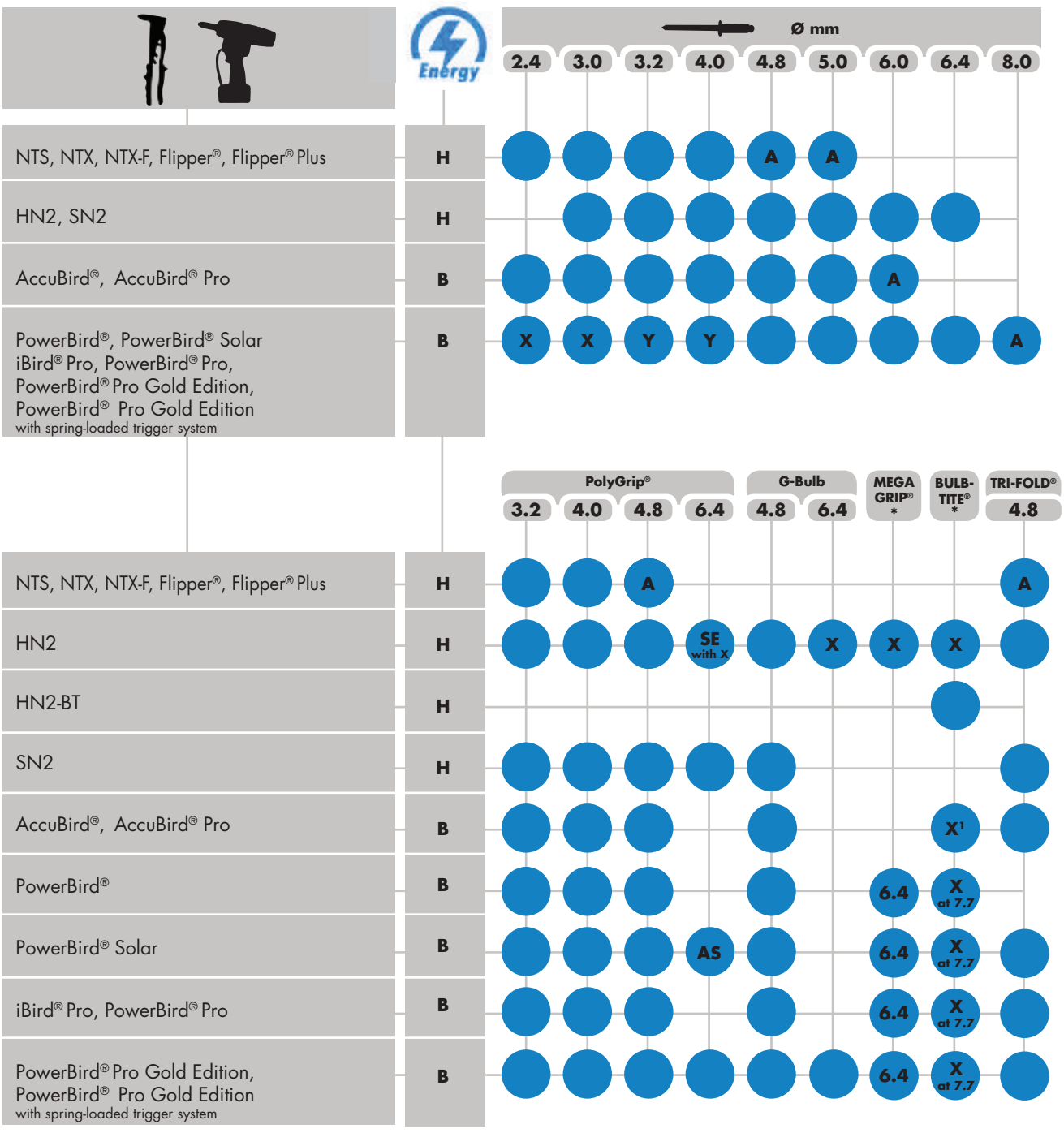

94

PowerBird®


96

PowerBird® Solar

WHAT RIVETS WHAT?



H: Handtool
B: Battery-powered tool
X: Special accessories required
X1: At 6.3 AS
Y: Accessories included in the scope of delivery effectively expand the working range.

A: Alu/Copper
S: Steel
E: Stainless Steel / Monel
Blue box: All materials (ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box.

*: A special nosepiece is **always** required when setting MEGA GRIP® blind rivets and BULB-TITE® blind rivets

BLIND RIVET HAND TOOLS

GESIPA® manual blind rivet setting tools – Easy to operate, tried and tested, always good but now even better!

TRIED AND TESTED TECHNOLOGY AND QUALITY IN A NEW DESIGN

NTX & NTX-F

Locking clip
Optimised locking clip (NTX-F)

Housing
Improved performance thanks to newly designed housing

Surface
Powder-coated abrasion-resistant housing surface in GESIPA® colour

Ergonomics
Ergonomically formed handles for working effi ciently without fatigue

HANDLES

- Ergonomically formed handles for working efficiently without fatigue
- Improved haptics by use of softer material
- Non-slip even in oily environments
- Environmentally compatible thanks to PVC-free handles
- Visually upgraded by GESIPA® logo and contrast stripes
- Optimised locking clip

HOUSING

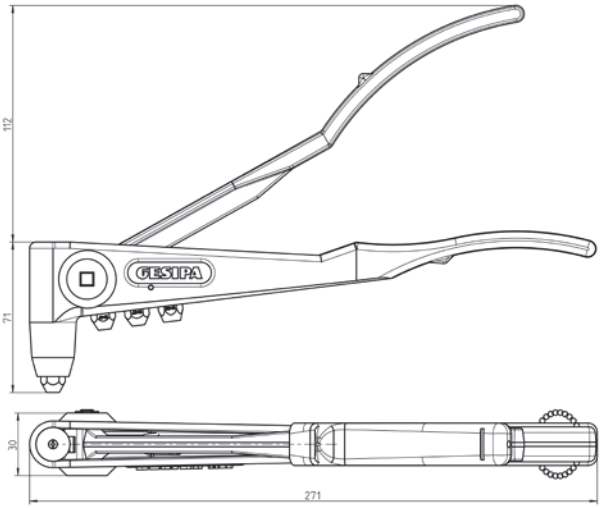
- Improved performance thanks to newly designed housing
- Powder-coated abrasion-resistant housing surface in GESIPA® colour

ADVANTAGES

- Simple one-hand operation
- Effortless lever system
- Specially hardened GESIPA® jaw system
- Rugged design and durable
- Equipped with the most commonly used GESIPA® nosepieces secured directly on the tool
- Nosepieces quick and easy to change
- Worldwide service and spare parts available for decades to come
- Made in Germany

NTS (with self opening spring)

No. 143 4028



Dimensions in mm

TECHNICAL DATA

Weight:	480 g
Total length:	275 mm
Stroke:	8 mm

WORKING RANGE

Blind rivets up to 5 mm Ø aluminium
and 4 mm Ø steel and stainless steel
(max. mandrel Ø 3.0 mm)

SCOPE OF DELIVERY

Nosepieces: 10/18, 10/24, 10/27 and 10/32
1 maintenance wrench, operating instructions with spare parts list

ADVANTAGES

- Body casing in high-quality die cast aluminium
- Body head made of forged steel
- Narrow head for difficult to access rivet locations
- Opening spring for automatic ejection of the mandrel
- Ergonomic handles

JAWS (2-PARTS)

For NTS, NTX, NTX-F and Flipper®

No. 143 4071

71

Nosepiece assignment for NTS, NTX and NTX-F can be found on **page 71**.

BLIND RIVET HAND TOOLS

NTX

No. 143 4040

TECHNICAL DATA

Weight:	575 g
Total length:	260 mm
Stroke:	8 mm

WORKING RANGE

Blind rivets up to 5 mm Ø aluminium and 4 mm Ø steel and stainless steel (max. mandrel Ø 3.0 mm)

SCOPE OF DELIVERY NTX

Nosepieces: 10/18, 10/24 and 10/32
1 maintenance wrench, operating instructions with spare parts list

SCOPE OF DELIVERY NTX-F

Nosepieces: 10/24, 10/27 and 10/32
1 maintenance wrench, operating instructions with spare parts list

JAWS (2-PARTS)

For NTS, NTX, NTX-F and Flipper®

No. 143 4071

NTX-F (with self opening spring)

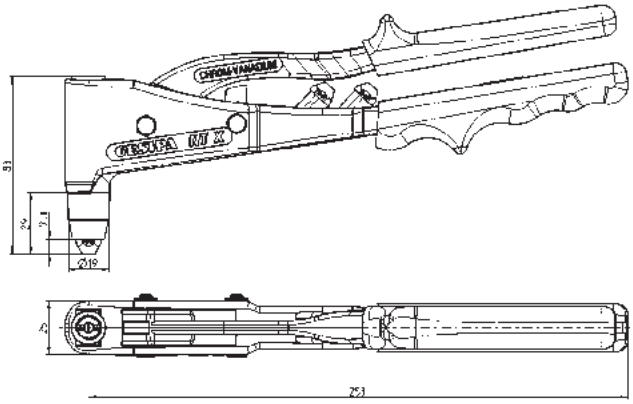
No. 143 4042

ADVANTAGES

- Body casing in high-quality die cast aluminium
- Body head made of chrome-vanadium steel, forged
- Steel inserts on all bearing points subject to wear
- Intermediate lever system reduces the force
- required and dampens the tear-off effect
- Narrow pliers head for difficult to access rivet-locations
- Ergonomic slip handles
- Simple maintenance – fast jaw change

FURTHER ADVANTAGES NTX-F

- With self opening spring for automatic mandrel ejection



Dimensions in mm

FLIPPER®

The blind rivet hand tool for easy handling with only one hand.

No. 143 3950

TECHNICAL DATA

Weight:	750 g
Total length:	221 mm
Total stroke:	16.2 mm
Single action stroke:	1.8 mm

WORKING RANGE

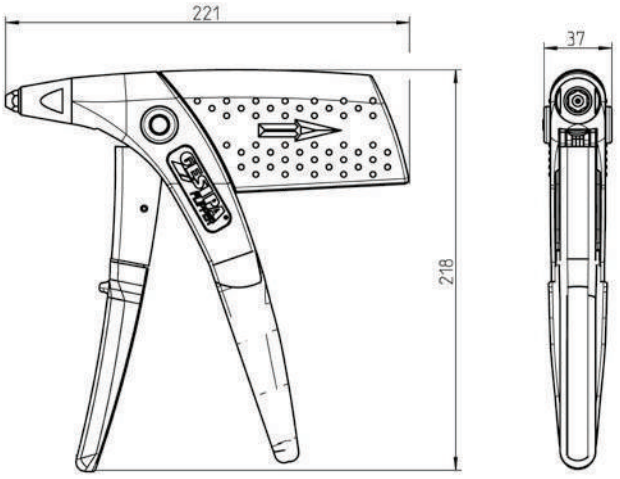
Blind rivets up to 5 mm Ø aluminium
and 4 mm Ø steel and stainless steel
(max. mandrel Ø 2.8 mm)

SCOPE OF DELIVERY

Nosepieces:10/18, 10/24 and 10/29
1 maintenance wrench (on magazine)
Operating instructions with spare parts list

ADVANTAGES

- The force increases when the handle is closed. This is made use of via the special arrangement of the lever when setting blind rivets: ergonomic design
- The required manual force is reduced by aroand 40 percent if actuated several times.
- Actuation lever with an opening spring for easy single-handed operation
- Jaw mechanism with spring reset for safe and automatic mandrel ejection
- Rivet mandrel collection container can be clipped to the body casing and is easy to empty
- Larger device lift: a benefit when handling extra long blind rivets
- Sturdy body casing in high-quality die cast aluminium
- Sturdy actuation lever made of tempered steel
- Link pin on anti-twist bearings
- Ergonomic lever positions and handle design



Dimensions in mm

CONVERSION KIT FOR PLASTIC BLIND RIVETS

No. 143 3984

71

Nosepiece assignment for Flipper® can be found on **page71**.

RIVETING KIT

CONTENTS
Blind rivet hand tool **NTX**
and **12 blind rivet sizes**,
1 maintenance wrench.
Weight: approx. 3.75 kg
Dimensions: 340 x 205 x 40 mm

No. 143 5457

Incl.12 blind rivet sizes

Alu/steel	3.0 x 8.0 mm
Alu/steel	3.0 x10.0 mm
Alu/steel	3.0 x12.0 mm
Alu/steel	4.0 x 5.0 mm
Alu/steel	4.0 x 6.0 mm
Alu/steel	4.0 x 8.0 mm
Alu/steel	4.0 x10.0 mm
Alu/steel	4.0 x12.0 mm
Copper/steel	3.0 x 6.0 mm
Copper/steel	4.0 x 6.0 mm
Alu/steel	3.0 x 5.0 mm
Alu/steel	3.0 x 7.0 mm

JUNIOR RIVETING KIT

CONTENTS
Blind rivet hand tool **NTX**
and **5 blind rivet sizes**,
1 maintenance wrench.
Weight: approx. 2.5 kg
Dimensions: 275 x 145 x 40 mm

Now also available as **Junior riveting kit PolyGrip®** (Part no. 145 7662) with the sizes 3.2 x 8, 4 x10, 4 x17, 4.8 x10 and 4.8 x 17.

JUNIOR RIVETING KIT
No. 143 5459

JUNIOR RIVETING KIT POLYGRIP®
No. 145 7662

Incl. 5 blind rivet sizes:

Alu/steel	3.0 x 6.0 mm
Alu/steel	3.0 x 8.0 mm
Alu/steel	4.0 x 6.0 mm
Alu/steel	4.0 x10.0 mm
Steel/steel	3.0 x 6.0 mm

FLIPPER®-BOX

CONTENTS
Blind rivet hand tool
Flipper® and **3 PolyGrip®**
blind rivet sizes, in a light-
weight plastic carrying case.
Weight: approx. 0.9 kg
Dimensions: 220 x 200 x 40 mm

No. 143 3951

Incl. 3 blind rivet sizes:
PolyGrip® Alu/steel 3.2 x 8.0 mm
PolyGrip® Alu/steel 4.0 x 10.0 mm
PolyGrip® Alu/steel 4.8 x 10.0 mm

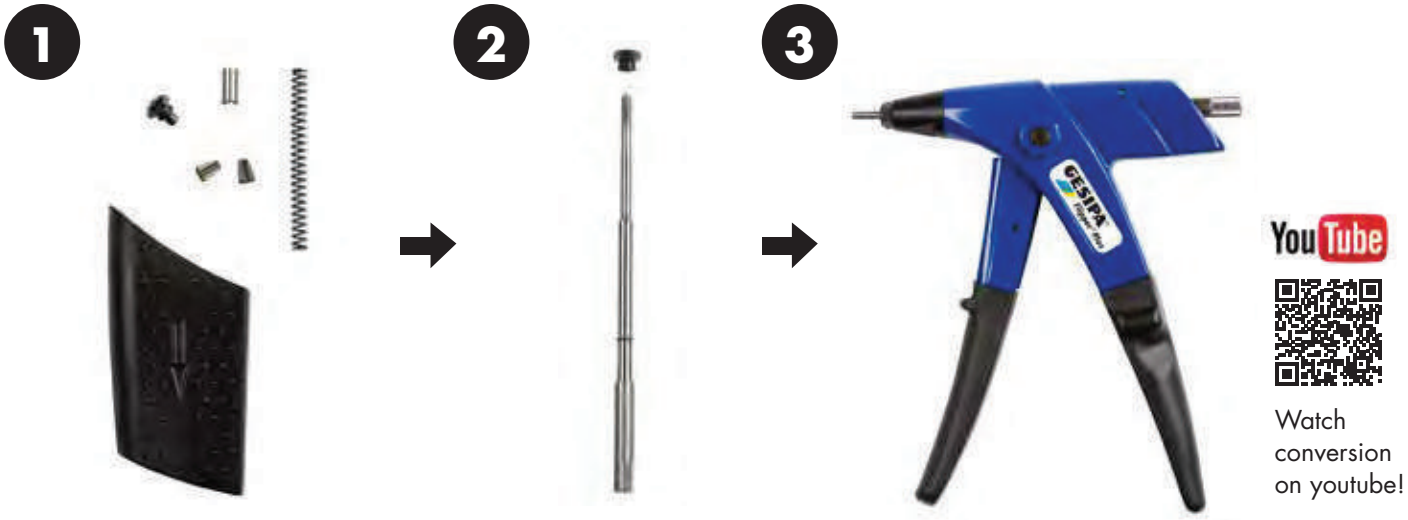
258

Mini pack refills can be found on page **258**.

FLIPPER® PLUS Combi setting tool

The combi setting tool for blind rivets and blind rivet nuts!

Converted in under 1 minute in just a few simple steps



Watch conversion on youtube!

1. REMOVAL
Remove the parts shown in the image

2. INSTALLATION
Install the threaded mandrel and nosepiece

3. CONVERTED
Converted to a blind rivet nut setting tool

ONE SETTING TOOL – TWO FUNCTIONS

Virtually tool-free conversion from blind rivet to blind rivet nut setting tool

No. 157 1258

TECHNICAL DATA

Weight:	750 g
Total length:	217 mm
Total stroke:	16.2 mm
Single action stroke:	1.8 mm

SCOPE OF DELIVERY

Nosepieces:12/20,12/24,12/29,12/M4,12/M5 and 12/M6
Threaded mandrel conversion kit: M4, M5 and M6
1 maintenance wrench, 1 Allen key
1 jaw insertion aid
Operating instructions with spare parts list

WORKING RANGE BLIND RIVETS

Blind rivets up to 5 mm Ø aluminium and 4 mm Ø steel and stainless steel (max. mandrel Ø 2.7 mm)

ADVANTAGES WHEN SETTING BLIND RIVETS

- Jaw mechanism with spring reset for safe and automatic mandrel ejection
- Rivet mandrel collection container can be clipped to the body casing and is easy to empty
- Larger device lift: a benefit when handling extra long blind rivets

SHARED ADVANTAGES

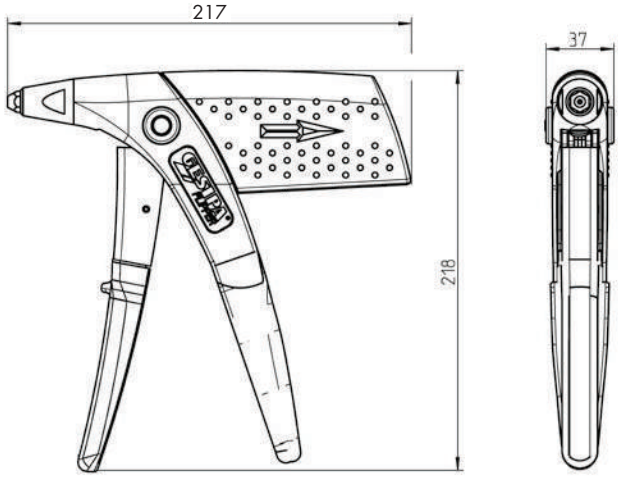
- New ratchet function
- The force increases when the handle is closed. This finding is put to good use in a special lever arrangement for setting blind rivets and blind rivet nuts: ergonomic design
- The required manual force is reduced by around
- 40 percent if actuated several times.
- Actuation lever with an opening spring for easy single-handed operation

WORKING RANGE BLIND RIVET NUTS

Blind rivet nuts from M4 up to M6 aluminium as well as from M4 up to M5 steel

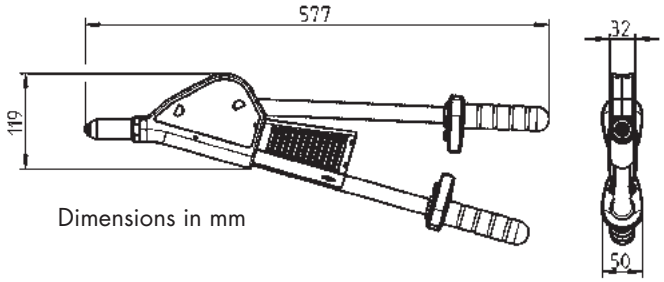
ADVANTAGES WHEN SETTING BLIND RIVET NUTS

- The total stroke is 16.2 millimeter long for setting of new generation multigrip blind rivet nuts like the GESIPA® PolyGrip® blind rivet nuts
- Simplified setting procedure for blind rivet nuts



Dimensions in mm

LEVER RIVETING TOOLS



Dimensions in mm

HN2 No. 143 4107

TECHNICAL DATA

Weight:	1.85 kg
Total length:	570 mm
Stroke:	10 mm

WORKING RANGE

Blind rivets from 3.0 to 6.4 mm Ø all materials, except PolyGrip® blind rivets with 6.4 mm Ø made of stainless steel and G-Bulb blind rivets (max. mandrel Ø 4.3 mm)

SCOPE OF DELIVERY

Nosepieces:
16/29, 16/32, 16/36, 16/40 and 16/45
Spent mandrel container
Maintenance instructions with spare parts list

JAWS (3 PARTS)

No. 143 4103

HN2-BT No. 145 6714

(only for BULB-TITE® see page 56)

TECHNICAL DATA

Weight:	1.85 kg
Total length:	570 mm
Stroke:	10 mm

WORKING RANGE

Blind rivets up to 7.7 mm Ø all materials (max. mandrel Ø 4.5 mm)

SCOPE OF DELIVERY

Nosepieces:
16/26 BT, 16/32 BT, 16/42 BT and 16/48 BT
Spent mandrel container
Maintenance instructions with spare parts list

JAWS (3 PARTS)

No. 143 4173

ADVANTAGES

- Pliers casing in high-quality die cast aluminium, its sturdy design protects it against soiling
- Link pin on anti-twist bearings and with inner axial protection, wear-proof and smooth running
- Tooth segment transmission with favourable lever arm arrangement reduces the force required and dampens the tear-off effect
- Fixed casing lever and ergonomic handle design: simple and easy handling
- Actuation lever: repeated re-engagement very easy, even on workpiece; highly beneficial for oversized blind rivets
- Gear rack: supported on a brass plate; smooth running
- Rivet mandrel collection tank: swivel-mounted to the casing; can be emptied easily and safely

71 Nosepieces and performance see **page 71**.

LAZY TONG RIVETING TOOL

SN2

No. 145 6674

TECHNICAL DATA

Weight:	1.93 kg
Length when closed:	310 mm
Length when opened:	810 mm
Stroke:	10.5 mm

WORKING RANGE

Blind rivets from 3.0 up to 6.4 mm Ø all materials
G-Bulb blind rivets up to 4.8 mm Ø.
(max. mandrel Ø 4.3 mm)

SCOPE OF DELIVERY

Nosepieces for Ø 3.2 mm, 4.0 mm, 4.8 mm, 6.0 mm and 6.4 mm, 1 maintenance wrench, Operating instructions with spare parts list

ADVANTAGES

- Pliers casing and handle in high-quality die cast aluminium
- Shear system in high strength steel, galvanised
- Moulded handle — double bearing
- Narrow casing for difficult to access rivets
- Enclosed pliers casing prevents soiling
- Favourable lever arm arrangement with 4-joint slide block bearing — reduced effort

JAWS (3 PARTS)

No. 143 4958

100 Retaining nosepiece **page 100.**

NOSEPIECE ASSIGNMENT for manual, lazy tongue and lever rivet devices

D	Rivet material	NTS, NTX, NTX-F, Flipper®	Flipper® Plus	SN2	HN2	HN2-BT
2.4	Alu	10/18	12/20	–	–	–
3.2	CAP®-Alu, CAP®-Cu	10/18	12/20	–	–	–
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu, PG-Alu, PG-Steel	10/24	12/24	17/24	16/24	–
4	Alu, Cu	10/24	12/24	17/24	16/24	–
4	CAP®-Alu, CAP®-Cu, Alu, PG-Alu	10/27	12/24	17/27	16/27	–
4	Steel, Stainless steel, Stinox, PG-Steel	10/29	12/29	17/29	16/29	–
4.8	CAP®-Alu, CAP®-Cu	10/29	12/29	17/29	16/29	–
5 and 4.8	Alu, PG-Alu	10/32	12/32	17/29	16/29	–
5 and 4.8	Steel, Alu	–	12/32	17/32	16/32	–
5 and 4.8	Stainless steel, Stinox, PG-Steel	–	–	17/36	16/36	–
6	Alu	–	–	17/36	16/36	–
6	Steel	–	–	17/40	16/40	–
6.4	Alu, PG-Alu	–	–	17/40	16/40	–
6.4	Steel, Alu	–	–	17/45	16/45	–
4	alle **BULB-TITE®**	–	–	–	–	16/26
5.2	alle **BULB-TITE®**	–	–	–	–	16/32
6.3	alle **BULB-TITE®**	–	–	–	–	16/42
7.7	alle **BULB-TITE®**	–	–	–	–	16/48

Nosepiece assignment data apply to DIN and GESIPA® blind rivets.

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

134 All nosepieces **page 134.**

BIRD PRO SERIES

Die Bird Pro Serie mit bürstenlosem Motor – Zuverlässig für hohe Stückzahlen und schnelle Arbeitsfolge

THE BIRD PRO SERIES

GESIPA®, which invented battery-powered blind riveting technology, has been producing the Bird series for over twenty years now. To this day, it sets the standard for the battery-powered blind riveting devices market. Not least due to changing customer requirements, the Bird family's modular system is updated on a regular basis. GESIPA® has therefore built a new platform that will supplement the current Bird series to meet the highest customer requirements. The new tools in this series are the ***iBird® Pro***, ***PowerBird® Pro Gold Edition, PowerBird® Pro***, ***AccuBird® Pro*** and the blind rivet nut setting tools ***FireBird® Pro, FireBird® Pro Gold Edition*** and ***FireBird® Pro S Gold Edition***.

WELL-PROVEN AND ERGONOMICALLY DESIGNED

The Bird Pro series is equipped with the low-wear jaws system and features the same ergonomic design as the TAURUS® series, already proven a thousand times over.

BLDC TECHNOLOGY

A BLDC motor is a brushless DC motor that, instead of brushes that are susceptible to wear, uses electrical sensors to detect the rotor's position and commutate the stator coil via circuit breakers. A special software in the electronics controls the motor.

The advantages of a BLDC motor include high efficiecy, long service life, particularly smooth running with a precision ball bearing and a reduction in electrical noise radiation.

AccuBird® Pro

PowerBird® Pro

PowerBird® Pro Gold Edition

iBird® Pro

Battery-powered blind rivet setting tools with **brushless motor**

LI-ION BATTERIES

The GESIPA® Bird Pro series is equipped as standard with a new rechargeable 2.1 Ah li-ion slide-on battery. These rechargeable li-ion batteries feature the new Deep Sleep function. To keep intrinsic consumption as low as possible, after a set idle time, the battery automatically assumes „Deep Sleep" mode. The battery can then be woken directly in the tool. There is no delay after being woken and the battery is immediately ready for use.

CHARGING TECHNOLOGY

The GESIPA® li-ion chargers are available for 110 V and 240 V AC voltages. The charger comes with a Euro plug as standard. Other versions for China, UK and USA are available on request.

PACKAGING

All tools in the Bird Pro series come in a practical plastic case.

CHARACTERISTICS

1. Autoreverse function

Immediately after mandrel break-off, this optional operating mode stops the pulling process and moves the jaw assembly back into the initial position. This saves time and energy while making sure the tool is immediately ready for use.

2. Lighting

The light-emitting diodes precisely aligned to the work piece are integrated into the adjusting ring. There are three possible switch positions:
Process-controlled: The diodes remain illuminated after the setting process, which allows a continuous workflow even in bad lighting conditions.
Torch function: Steady glow of diode (max.10 minutes)
Lighting off: saves electricity.

3. Sliding battery

New sliding battery with exact optical and acoustic charging status display prevents unpleasant surprises. The deep sleep function and the electrical feedback of the braking energy extend the battery range – a battery charge lasts for up to 2,000 riveting operations. Additional catching grids prevent falling.

4. Charging unit

Charging unit with quick-charge function. The battery can be used again after only 45 minutes of charging, and is fully charged after just 90 minutes.

❷

❸

❹

ADVANTAGES

- More powerful and longer-lasting BLDC motor for quick flow of work
- 25 mm stroke for long blind rivets
- Up to 20 kN setting force for particularly large blind rivets
- Variable lighting in the adjusting ring
- Increased stability due to larger, non-slip stand surface and lower centre of gravity
- Easy-to-grasp housing thanks to Softgrip
- New sliding battery
- Charging unit with quick-charge function

OVERVIEW Bird Pro Series

TOOL		SETTING FORCE IN N	WORKING RANGE
ACCUBIRD® PRO		**10,000**	Blind rivets from Ø 2.4 mm aluminium, up to Ø 5 mm all materials and blind rivets up to Ø 6 mm aluminium. BULB-TITE® blind rivets up to Ø 6.3 mm aluminium and steel. G-Bulb blind rivets up to Ø 4.8 mm all materials. (max. mandrel Ø 3.0 mm)
POWERBIRD® PRO		**15,000**	Blind rivets from Ø 4.8 mm steel, up to Ø 6.4 mm all materials, up to Ø 8 mm aluminium, except G-Bulb Ø 6.4 mm and stainless steel PolyGrip® Ø 6.4 mm, BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)
POWERBIRD® PRO GOLD EDITION		**20,000**	Blind rivets up to Ø 6.4 mm all materials and up to to Ø 8 mm aluminium. BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® and G-Bulb blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)
iBIRD® PRO		**15,000**	Blind rivets from Ø 2.4 mm alu/steel, up to Ø 6.4 mm all materials, up to Ø 8 mm aluminium, except G-Bulb Ø 6.4 mm and stainless steel PolyGrip® Ø 6.4 mm, BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)

SYMBOLS FOR BATTERY AND CHARGER

Slide-on battery 18 V/2.1 Ah (Li-Ion)

Charger 18 V Li-Ion

2 batteries in scope of delivery

Tool is delivered in a carton

Tool is delivered in a plastic case

DRIVE	STROKE	BATTERY LI-ION	WEIGHT	PAGE
Brushless DC motor (BLDC)	25 mm	18 Volt 2.1 Ah	2.1 kg with battery	**76**
Brushless DC motor (BLDC)	25 mm	18 Volt 2.1 Ah	2.1 kg with battery	**78**
Brushless DC motor (BLDC)	25 mm	18 Volt 2.1 Ah	2.1 kg with battery	**80**
Brushless DC motor (BLDC)	25 mm	18 Volt 2.1 Ah	2.2 kg with battery	**84**

ACCUBIRD® PRO

Up to 4x faster than other battery-powered tools on the market!

No. 143 5447

No. 143 2365

TECHNICAL DATA

Setting force:	10,000 N
Weight:	2.1 kg with battery
Drive:	18 V brushless DC motor (BLDC)
Stroke:	25 mm

SCOPE OF DELIVERY

Nosepieces: 17/24, 17/27, 17/29 and 17/32

WORKING RANGE

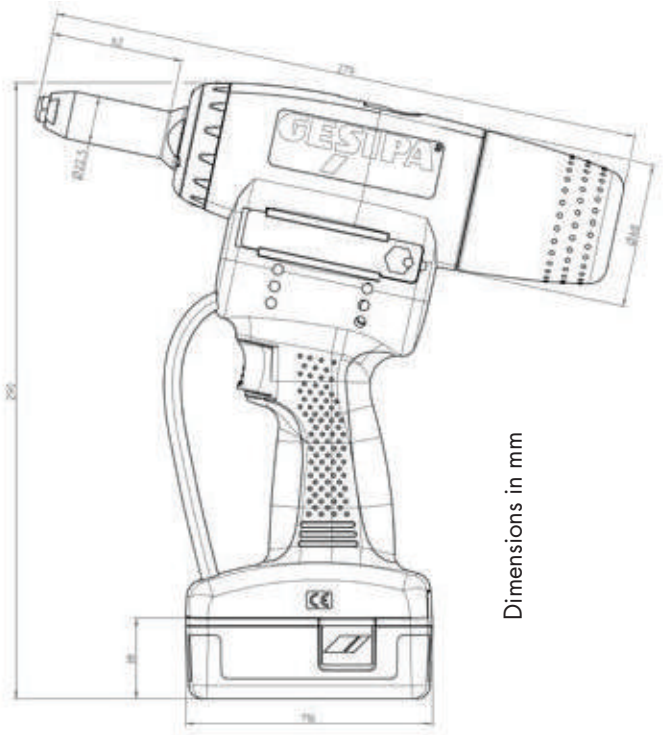
Blind rivets from Ø 2.4 mm aluminium, up to Ø 5 mm all materials and blind rivets up to Ø 6 mm aluminium. BULB-TITE® blind rivets up to Ø 6.3 mm aluminium and steel. G-Bulb blind rivets up to Ø 4.8 mm all materials. (max. mandrel Ø 3.0 mm)

ADVANTAGES

Brushless motor
The brushless motor and 10,000 N setting force make the AccuBird® Pro extremely fast for setting blind rivets of any material up to Ø 5 mm.

Extremely fast, virtually no wear
The BLDC motor of the AccuBird® Pro has an extremely long service life and is virtually non-wearing. Compared to commercially available battery-powered tools, setting can be done up to 4x faster making it comparable with hydropneumatic blind rivet setting tools.

Well-proven and ergonomically designed
The AccuBird® Pro is equipped with the low-wear jaws system and features the same ergonomic design as the TAURUS® series, already proven a thousand times over.



Dimensions in mm

Make sure the correct jaw pusher is used as specified in the operating instructions!

The battery-powered blind rivet setting tool with **10 kN** setting force and brushless motor

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge	Nosepiece	No.
2.4	Alu	**1,800**	17/18*	**143 4976**
3.2	CAP®-Alu, CAP®-Cu	**1,300**	17/18*	**143 4976**
3 and 3.2	Alu	**1,100**	17/24	**143 4955**
3 and 3.2	Steel	**1,100**	17/24	**143 4955**
3 and 3.2	Stainless steel	**1,100**	17/24	**143 4955**
4	Alu	**1,100**	17/24	**143 4955**
4	Steel	**1,000**	17/27	**143 4973**
4	stainless steel	**950**	17/29	**143 4974**
4.8 and 5	Alu	**850**	17/29	**143 4974**
4.8 and 5	Steel	**750**	17/32	**143 4975**
4.8 and 5	Stainless steel	**550**	17/36*	**143 4977**
6	Alu	**400**	17/36*	**143 4977**

BULB-TITE® BLIND RIVETS

4	Alu	**1,300**	17/26 BT*	**143 4985**
5.2	Alu	**1,100**	17/32 BT*	**143 4986**
6.3	Alu	**800**	17/42 BT*	**143 4988**
6.3	Steel	**550**	17/42 BT*	**143 4988**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

88 Spare parts and special accessories AccuBird® Pro **page 88.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

POWERBIRD® PRO

PowerBird® Pro – the all-rounder in the Pro series. It combines exceptional speed with high power!

No. 145 0810

No. 145 0814

TECHNICAL DATA

Setting force:	15,000 N
Weight:	2.1 kg with battery
Drive:	18 V brushless DC motor (BLDC)
Stroke:	25 mm

SCOPE OF DELIVERY

Nosepieces: 17/32, 17/36, 17/40 and 17/45
Additional jaw pusher for smaller blind-rivet dimensions (Required nosepieces page 136)

WORKING RANGE

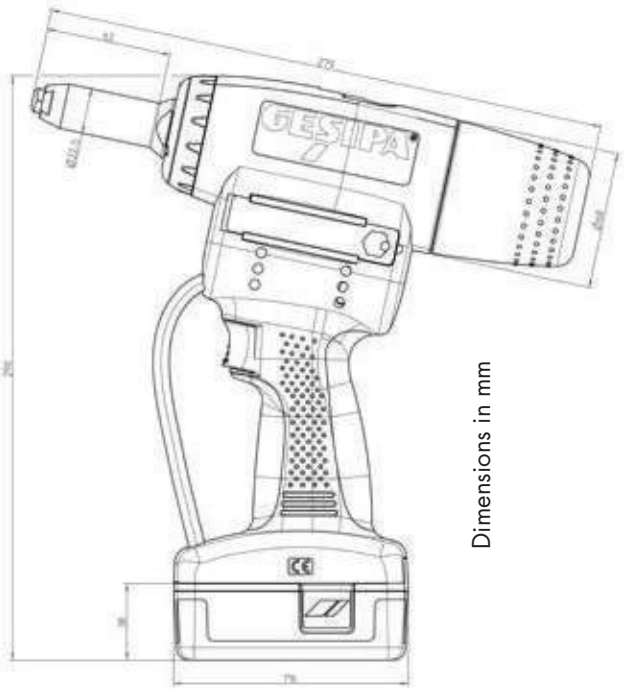
Blind rivets from Ø 4.8 mm steel, up to Ø 6.4 mm all materials, up to Ø 8 mm aluminium, except G-Bulb Ø 6.4 mm and stainless steel PolyGrip® Ø 6.4 mm, BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)

ADVANTAGES

Powerful and fast
The PowerBird® Pro enhances the new Pro series. With a setting force of 15,000 N and the well-proven brushless motor, the PowerBird® Pro is powerful and fast when setting blind rivets up to Ø 6.4 mm in any material. The optional Autoreverse function additionally shortens the pulling process, ensuring the PowerBird® Pro is immediately ready for operation. The stroke has been substantially increased to 25 mm for the purpose of setting particularly long rivets.

Even faster, virtually no wear
Since no wear-prone brushes are use, the motor of the PowerBird® Pro has an extremely long service life, is virtually non-wearing and and reliably guarantees the fastest setting frequencies.

Well-proven and ergonomically designed
The PowerBird® Pro is equipped with the low-wear jaws system and features the same ergonomic design as the TAURUS® series, already proven a thousand times over.



Dimensions in mm

Make sure the correct jaw pusher is used as specified in the operating instructions!

The battery-powered blind rivet setting tool with **15 kN** setting force and brushless motor

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge	Nosepiece	No.
4.8 and 5.0	Steel, Alu	**1,000**	17/32	**143 4975**
4.8 and 5.0	Stainless steel	**700**	17/36	**143 4977**
6.0	Alu	**650**	17/36	**143 4977**
6.0	Steel	**500**	17/40	**143 4999**
6.4	Alu, PG-Alu	**550**	17/45	**143 4860**
6.4	Steel	**450**	17/45	**143 4860**
8	Alu	**500**	17/45	**143 4860**
BULB-TITE® BLIND RIVETS				
4.0	Alu	**1,200**	17/26 BT*	**143 4985**
5.2	Alu	**1,000**	17/32 BT*	**143 4986**
6.3	Alu	**800**	17/42 BT*	**143 4988**
6.3	Steel	**700**	17/42 BT*	**143 4988**
6.3	Monel	**650**	17/42 BT*	**143 4988**
7.7	Alu	**700**	17/48 BT*	**143 4989**
MEGA GRIP® BLIND RIVETS				
4.8	Alu	**800**	17/31 MG*	**143 4993**
4.8	Steel	**750**	17/31 MG*	**143 4993**
4.8	Stainless steel	**750**	17/31 MG*	**143 4993**
6.4	Alu	**700**	17/41 MG*	**143 4865**
6.4	Steel	**300**	17/41 MG*	**143 4865**
6.4	Stainless steel	**250**	17/41 MG*	**143 4865**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

88 Spare parts and special accessories PowerBird® Pro **page 88.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

POWERBIRD® PRO GOLD EDITION

PowerBird® Pro Gold Edition – the strong one for high volumes and fast working sequences

No. 145 7636

No. 145 7640

TECHNICAL DATA

Setting force:	20,000 N
Weight:	2.1 kg with battery
Drive:	18 V brushless DC motor (BLDC)
Stroke:	25 mm

SCOPE OF DELIVERY

Nosepieces: 17/32, 17/36, 17/40 and 17/45
Additional jaw pusher for smaller blind-rivet dimensions (Required nosepieces page 136)

WORKING RANGE

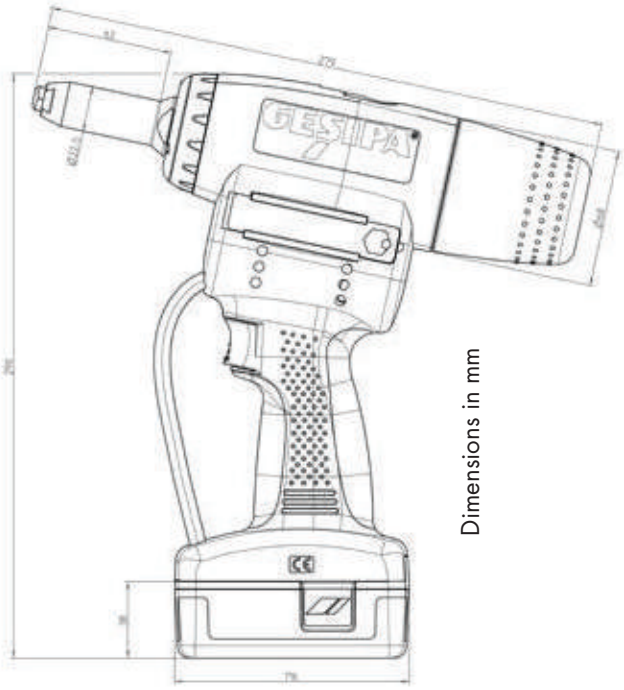
Blind rivets up to Ø 6.4 mm all materials and up to Ø 8 mm aluminium. BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® and G-Bulb blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)

ADVANTAGES

Even more powerful: Thanks to the brushless motor and the 20,000 N setting force the PowerBird® Pro Gold Edition is even more powerful and can even set G-Bulb and PolyGrip® blind rivets up to Ø 6.4 mm in any material. The optional Autoreverse function additionally shortens the pulling process, ensuring the PowerBird® Pro Gold Edition is immediately ready for operation. The stroke has been substantially increased to 25 mm for the purpose of setting particularly long rivets.

Even faster, virtually no wear: Since no wear-prone brushes are use, the motor of the PowerBird® Pro Gold Edition has an extremely long service life, is virtually non-wearing and and reliably guarantees the fastest setting frequencies.

Well-proven and ergonomically designed: The PowerBird® Pro Gold Edition is equipped with the low-wear jaws system and features the same ergonomic design as the TAURUS® series, already proven a thousand times over.



Dimensions in mm

Make sure the correct jaw pusher is used as specified in the operating instructions!

The battery-powered blind rivet setting tool with **20 kN** setting force and brushless motor

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge	Nosepiece	No.
4.8 and 5.0	Steel, Alu	**1,800**	17/32	**143 4975**
4.8 and 5.0	Stainless steel	**1,600**	17/36	**143 4977**
6.0	Alu	**1,000**	17/36	**143 4977**
6.0	Steel	**650**	17/40	**143 4999**
6.4	Alu, PG-Alu	**600**	17/45	**143 4860**
6.4	Steel	**550**	17/45	**143 4860**
8	Alu	**550**	17/45	**143 4860**
BULB-TITE® BLIND RIVETS				
4.0	Alu	**1,300**	17/26 BT*	**143 4985**
5.2	Alu	**1,200**	17/32 BT*	**143 4986**
6.3	Alu	**800**	17/42 BT*	**143 4988**
6.3	Steel	**550**	17/42 BT*	**143 4988**
6.3	Monel	**600**	17/42 BT*	**143 4988**
7.7	Alu	**700**	17/48 BT*	**143 4989**
MEGA GRIP® BLIND RIVETS				
4.8	Alu	**1,000**	17/31 MG*	**143 4993**
4.8	Steel	**950**	17/31 MG*	**143 4993**
4.8	Stainless steel	**900**	17/31 MG*	**143 4993**
6.4	Alu	**950**	17/41 MG*	**143 4865**
6.4	Steel	**250**	17/41 MG*	**143 4865**
6.4	Stainless steel	**250**	17/41 MG*	**143 4865**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

88 Spare parts and special accessories PowerBird® Pro Gold Edition **page 88.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

BIRD PRO SERIES WITH SPRING-LOADED TRIGGER SYSTEM

The well-proven spring-loaded trigger system of the TAURUS® series now also for the Bird Pro series

AccuBird® Pro with spring-loaded trigger system

No. 150 2102

PowerBird® Pro with spring-loaded trigger system

No. 150 2103

PowerBird® Pro Gold Edition with spring-loaded trigger system

No. 145 7638

Example image of PowerBird® Pro

TECHNICAL DATA

See AccuBird® Pro page 76
See PowerBird® Pro page78
See PowerBird® Pro Gold Edition page 80

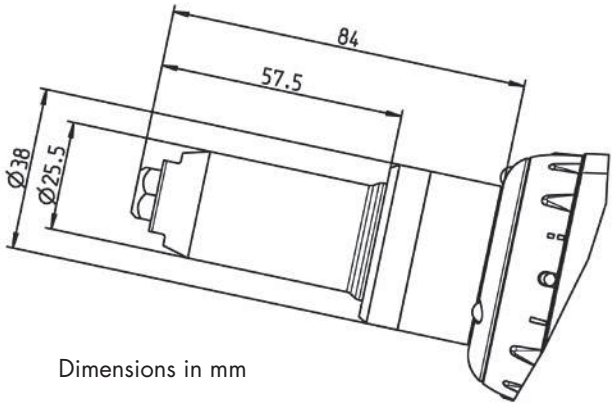
The spring-loaded trigger system ensures that the parts to be riveted reliably make contact without any gaps before riveting. Furthermore, the operator will be certain that the blind rivet has reached its end position in the hole before setting and the setting head is in contact with the material. The pressing force can be varied with springs depending on the application.

FUNCTIONAL PRINCIPLE

The surface contact trigger mechanism is also installed on the trigger button of the device. It only allows the riveting device to trigger when a set compressive force on the part is reached. This ensures that the various components in the application are pressed correctly onto each other before the riveting process. This means that uncontrolled deformation of the rivet body between the materials is prevented, which would otherwise go andetected.

The surface contact force can be varied in five steps. It is set by either adding or removing springs. This rules out the possibility of unintentionally changing the defined surface contact force. A row of pushbuttons is arranged in front of the standard trigger button. On overcoming the spring force and reaching the defined surface contact force, the riveting process can only be triggered by pressing the yellow button.

DIMENSIONED DRAWING OF BIRD PRO SERIES WITH SPRING-LOADED TRIGGER SYSTEM



Dimensions in mm

ANGLE HEAD 90° for the Bird Pro series

The angle head can be positioned freely in every position (360°) on the tensile axis.

No. 146 4882

TECHNICAL DATA

Weight:	1.1 kg
Stroke:	23 mm
Traction power:	up to 20 kN

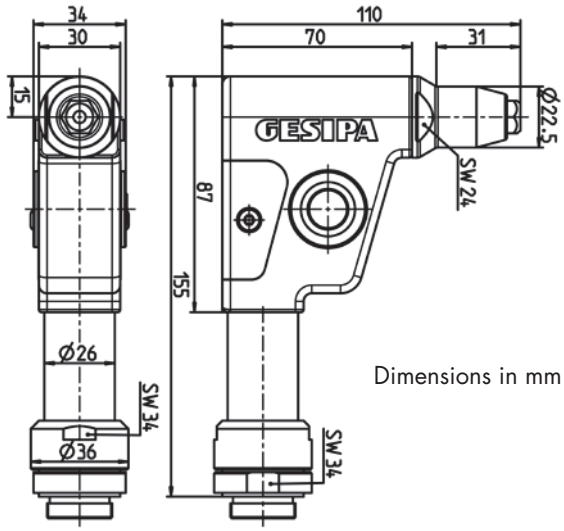
SCOPE OF DELIVERY

Nosepiece:17/45 (No. 143 4860)

The angle head 90° is designed for use in very narrow and confined spaces. The rugged design makes it possible to set blind rivets with a high setting force even in working areas that are difficult to access.

The angle head 90° can set standard blind rivets with a diameter up to 6.4 mm in all materials and 8 mm in aluminium with a setting force up to 20 kN. The smallest edge distance is 15 mm, the head length 110 mm.

The 17/45 nosepiece is included in the scope of delivery as standard. Nosepieces from 17/18 to 17/40 can also be used with the angle head 90°; however, this depends on the working range of the respective tool type (AccuBird® Pro, PowerBird® Pro or PowerBird® Pro Gold Edition).



Dimensions in mm

ADVANTAGES

- Realisation of small edge clearances
- High setting force in tight installation areas
- Large stroke
- Simple assembly
- Compact and robust design
- Simple jaws maintenance
- Use of standard jaws

iBIRD® PRO

iBird® Pro – the optional setting process assistant from GESIPA® provides assistance when evaluating riveting processes

No. 156 7800

No. 156 7801

With GESIPA-App

TECHNICAL DATA

Connection:	WiFi 2.4/5.0 GHz and Bluetooth
Setting force:	15,000 N
Weight:	2.2 kg with battery
Drive:	18 V brushless DC motor (BLDC)
Stroke:	25 mm

SCOPE OF DELIVERY

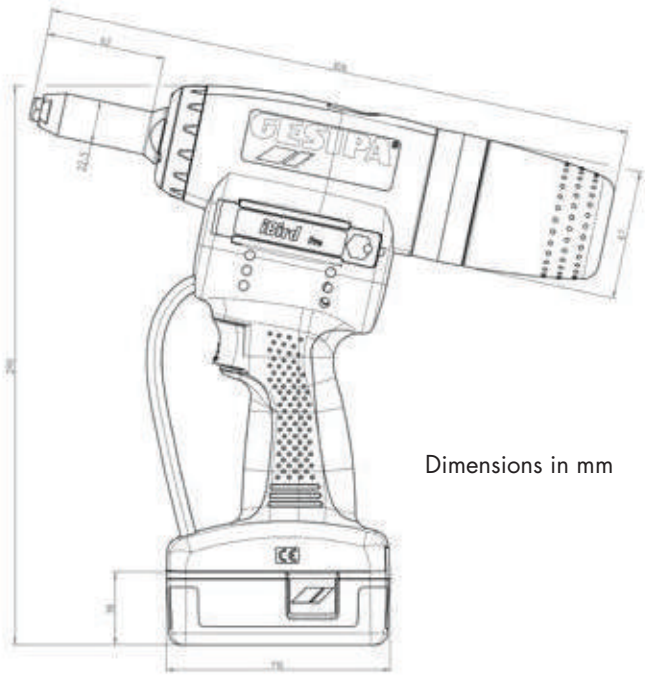
Nosepieces: 17/32, 17/36, 17/40 and 17/45
Additional jaw pusher for smaller blind-rivet dimensions (Required nosepieces page 136)

WORKING RANGE

Blind rivets from Ø 2.4 mm alu/steel, up to Ø 6.4 mm all materials, up to Ø 8 mm aluminium, except G-Bulb Ø 6.4 mm and stainless steel PolyGrip® Ø 6.4 mm, BULB-TITE® blind rivets up to Ø 7.7 mm all materials. MEGA GRIP® blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm)

INDUSTRY 4.0 WITH THE IBIRD® PRO

Known as Industry 4.0, M2M or the Internet of Things, these concepts refer to intelligent and digitally networked systems in the production industry. The aim is to ensure that production is as self-organised as possible. GESIPA® has developed the iBird® Pro with this in mind. The iBird® Pro is a networked battery-powered setting tool that can be connected to smartphones, tablets or a customer's IT infrastructure using WiFi or Bluetooth via a free GESIPA® app. This networking provides a number of additional benefits such as the monitoring of riveting processes, processing safety, status and service indicators, as well as quick and simple access to operating, maintenance and repair instructions – ultimately resulting in optimisation of the value chain.



Dimensions in mm

Make sure the correct jaw pusher is used as specified in the operating instructions!

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge	Nosepiece	No.
4.8 and 5.0	Steel, Alu	**1,000**	17/32	**143 4975**
4.8 and 5.0	Stainless steel	**700**	17/36	**143 4977**
6.0	Alu	**650**	17/36	**143 4977**
6.0	Steel	**500**	17/40	**143 4999**
6.4	Alu, PG-Alu	**550**	17/45	**143 4860**
6.4	Steel	**450**	17/45	**143 4860**
8	Alu	**500**	17/45	**143 4860**
BULB-TITE® BLIND RIVETS*				
4.0	Alu	**1,200**	17/26 BT*	**143 4985**
5.2	Alu	**1,000**	17/32 BT*	**143 4986**
6.3	Alu	**800**	17/42 BT*	**143 4988**
6.3	Steel	**700**	17/42 BT*	**143 4988**
6.3	Monel	**650**	17/42 BT*	**143 4988**
7.7	Alu	**700**	17/48 BT*	**143 4989**
MEGA GRIP® BLIND RIVETS*				
4.8	Alu	**800**	17/31 MG*	**143 4993**
4.8	Steel	**750**	17/31 MG*	**143 4993**
4.8	Stainless steel	**750**	17/31 MG*	**143 4993**
6.4	Alu	**700**	17/41 MG*	**143 4865**
6.4	Steel	**300**	17/41 MG*	**143 4865**
6.4	Stainless steel	**250**	17/41 MG*	**143 4865**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

88 Spare parts and special accessories iBird® Pro **page 88.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

iBird® Pro – Advantages at a glance!

ADVANTAGES

- For smartphone, tablet, PC
- Simple connection to the tool with GESIPA® app via QR
- Data availability at any time
- A signal ring (andon ring) for visualising riveting processes
- Optional connection to three devices at the same time
- Premium software: optional (availability of) setting process

TECHNICAL FACTS

- WiFi 2.4/5.0 GHz and Bluetooth (LE) wireless connection
- Tilt sensor can be connected via the app; during use, the tool is only enabled for the next riveting process once the tilting motion for ejecting the mandrel body has been performed
- Andon ring: Signal ring for visualising the riveting process, the colours can be set individually via the app

THE ANDON RING

The iBird® Pro incorporates a signal ring for visualising riveting processes. The colours can be set individually via the app.

PREMIUM SOFTWARE

Optional setting process assistant*

- Setting process evaluation with fault detection, notification in app and via Andon ring (signal ring lights up based on the setting process evaluation and colour setting)
- Teaching mode for teaching in rivet configurations
- Creation of job lists to process various rivet configurations

No. 157 0451

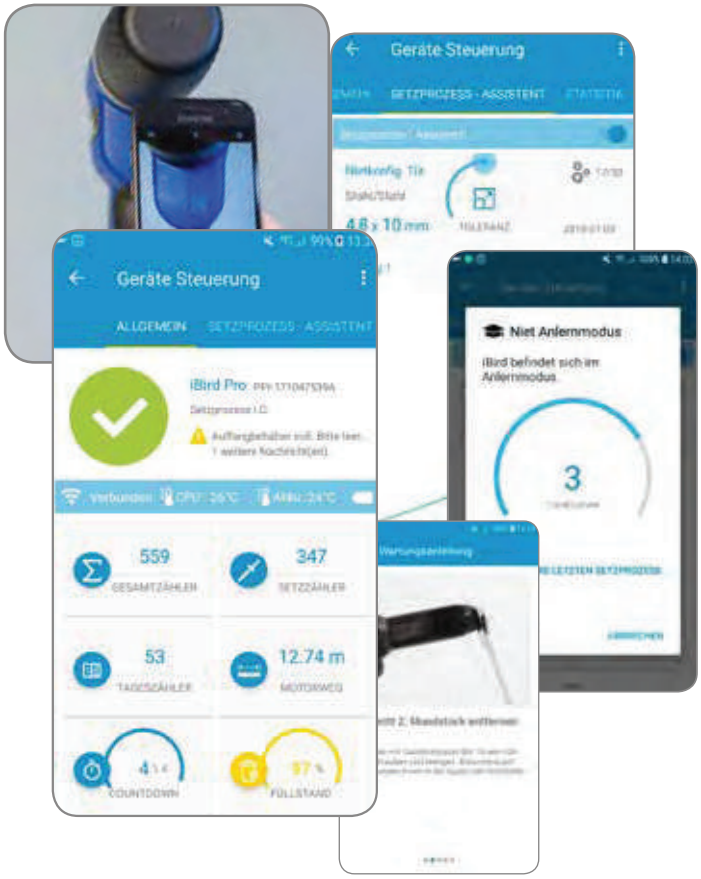
*Once paid premium software has been activated

Die GESIPA® app – simple connection and all information you need at a glance!

THE GESIPA® APP

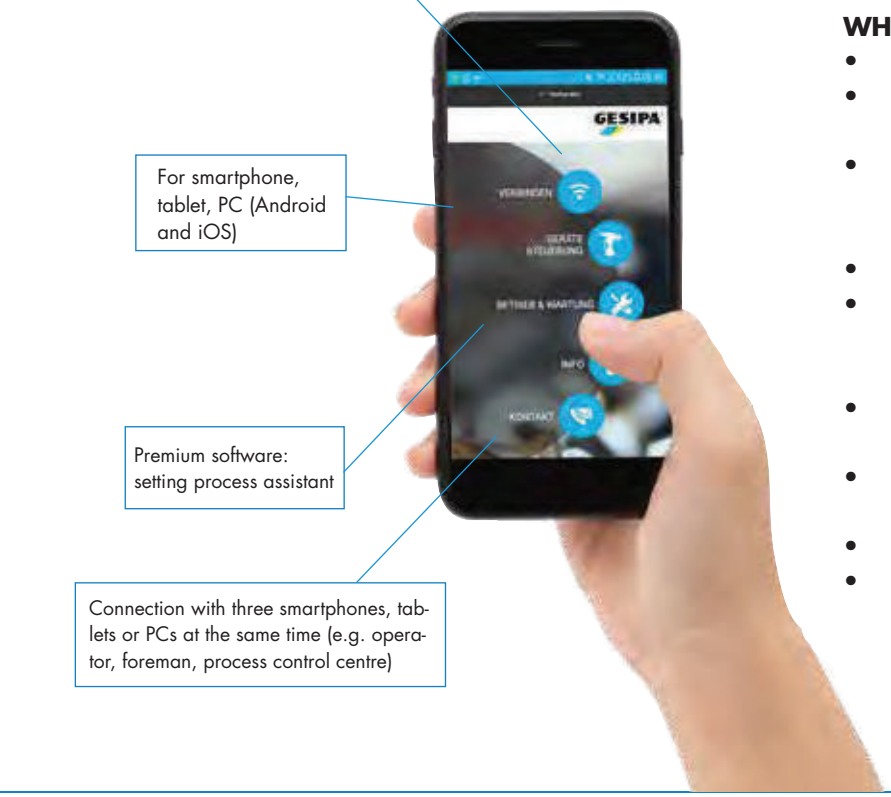
Using a QR code, the iBird® Pro can be connected to the GESIPA® app with ease. The app is available for smartphones, tablets and PCs (Android and iOS).

The iBird® Pro can be connected to three devices at the same time.



JETZT BEI Google Play

Laden im App Store



WHAT THE IBIRD® PRO APP OFFERS:

- Various counters:
- Total, day, setting counter, countdown, OK*, NOK*.
- Fill level indicator, service indicator (spent mandrel container, cleaning or oiling jaws, full service)
- Optional setting process assistant*
- Monitoring of battery charge level, battery temperature and temperature of the tool control
- Maintenance instructions, maintenance history
- Error message, error history, acknowledgement history
- Tips and tricks
- Operating instructions

*Once paid premium software has been activated

SPARE PARTS / SPECIAL ACCESSORIES for Bird Pro series

18.0 V/2.1 AH (LI-ION) SLIDE-ON BATTERY PACK
Weight: 0.4 kg / available as special accessory

No. 145 7641

CHARGER FOR 18.0 V LI-ION BATTERY

Technical data

Input voltage:	100 - 240 V / 50 - 60 Hz
Output voltage:	21 V DC
Charging time:	45 to 90 minutes
Weight:	0.6 kg

No. 145 7642

Akku RECYCLING

Note: Equipped with Euro plug as standard (other versions on request)

RETAINING NOSEPIECE
Special accessory (also for SN2)

- Inserted rivet stays in any position
- Set rivets with only one hand
- Safer working

*Exept AccuBird® Pro

17/18R	**No. 165 5422**
17/20R	**No. 165 5424**
17/22R	**No. 165 5426**
17/24R	**No. 165 5427**
17/27R	**No. 165 5428**
17/29R	**No. 165 5429**
17/32R	**No. 165 5430**
17/36R	**No. 165 5431**
17/40R*	**No. 165 5433**
17/45R*	**No. 165 5434**

JAWS (3-PART)

No. 143 5568

TRANSPARENT SPENT MANDREL CONTAINER
The classic spent mandrel container allows you to keep an eye on the amount of spent mandrels.

No. 145 0837

EXTENSION FOR SPENT MANDREL

Extended by 30 mm
No. 145 0838
Extended by 60 mm
No. 145 0839

ANGLE HEAD 90°
For use in very narrow and confined spaces

No. 146 4882

SPARE PARTS / SPECIAL ACCESSORIES for Bird Pro series

EXTENSION UNITS

ONE-PIECE

replace the steel head sleeve, they are slim and are therefore particularly suitable for tight spaces that are difficult to access

TOOL	+35 mm	+85 mm	+135 mm
AccuBird® Pro	**145 0860**	**145 0861**	**145 0862**
PowerBird® Pro	**145 7650**	**145 7651**	**145 0823**
PowerBird® Pro Gold Edition	**145 7650**	**145 7651**	**145 0823**

TOOL	+50 mm	+100 mm	+150 mm
PowerBird® Pro Gold Edition with spring-loaded trigger system	**145 0821**	**145 0822**	-

MULTI-PIECE

are suitable for riveting in low-lying places. They are screwed on between the tool and the existing steel head sleeve

Variable extension of the steel head sleeve is possible in steps of 100 mm

TOOL	+100 mm
AccuBird® Pro	**145 0859**
PowerBird® Pro	**145 0820**
PowerBird® Pro Gold Edition	**145 0820**

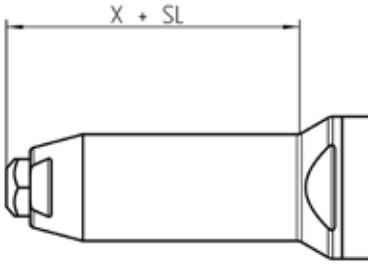
EXAMPLE one-piece

Bird Pro Geräte
Example: + SL 35 mm

Steel head sleeve length =
62 mm (X) + SL 35 = 97 mm

PowerBird Pro GE with spring-loaded trigger system
Example: + SL 50 mm

Steel head sleeve length =
57,5 mm (X) + SL 50 mm = 107,5 mm



The variable X can be found in the dimension drawings of the devices.

Dimension X = Standard steel head sleeve length (with standard nosepiece)

BEISPIEL multi-piece

Bird Pro Geräte
Example: + SL 100 mm

Steel head sleeve length =
62 mm (X) + SL 100 mm = 162 mm

THE BIRD SERIES

From the creator of the battery-powered blind rivet setting tool!

THE BIRD SERIES

The development of this Bird series for professional use by specialists and industrial users made GESIPA® the inventor of the cable-free and hose-free blind rivet setting technology. In 2017 the first of the devices, the AccuBird®, celebrated its twentieth birthday.

PRODUCTION

- Made in Germany
- GESIPA® developement, market launch and further developement since 1992 (AccuBird®),
- 1996 (PowerBird®), 1995 (FireBird®)
- 2014 Development and market launch of the new Bird Pro series

MODERNISED ON ITS 25TH ANNIVERSARY

On the 25th anniversary of the AccuBird® the Bird series has been technically modernised and visually upgraded. The following modernisations have been implemented on the AccuBird®, PowerBird® and PowerBird® Solar:

- New battery management ensuring the longer-life battery is always ready
- Shorter pulling process with the new additional auto-reverse function. This reduces wear and increases the battery life.
- New lightweight and stable plastic case, same as the Pro series case.

The Bird series

PACKAGING

AccuBird®, PowerBird® and FireBird® are supplied in a plastic case .

ASING AND ACCESSORIES

- Exchange for nosepieces and wrench for the AccuBird® and PowerBird® on the device, for the FireBird® in the spent mandrel container
- The spent mandrel container, has an approx. volume of 190 cm³, which means it does not need to be emptied frequently
- Accessories and special models have been continuously

WITH LI-ION ENERGY

- No memory effect
- High energy yield through high voltage and low weight for easy and fast operation
- Extremely low self discharge
- Battery shape allows the tool to be stored standing on its battery

PRACTICAL ASPECTS

- Exchange nosepieces and wrench always included in the tool
- Compact, shockproof tool housing
- Spent mandrel evacuation into the mandrel container through backfilling and forwards through the nosepiece by gravity
- Fatigue-free working through well balanced weight repartition and ergonomic grip

MECHANICS, CONTROL SYSTEM AND BATTERY

- Reliable connection of the mechanics and control system
- Cast control system is water and dust-tight
- User-friendly pluggable rechargeable battery

LI-ION RECHARGEABLE BATTERIES

The GESIPA® AccuBird® and FireBird® battery-powered rivet setting tools are equipped as standard with a 1.3 Ah li-ion rechargeable battery. The GESIPA® PowerBird® variants come with a 2.6 Ah li-ion rechargeable battery. These li-ion batteries are equipped with a new battery management system that enables even longer battery life. The batteries are therefore always ready to use.

The powerful 2.6 Ah battery is also optionally available as a special accessory for the AccuBird® and FireBird®. Older tools can of course also be operated with the Li-Ion batteries. Due to the different charging principle used in the Li-Ion technology, the charging unit must also be replaced when switching over to Li-Ion batteries; the proven charging units for NiCd batteries are however still available.

*The 1.3 Ah Li-Ion battery and the 2.6 Ah Li-Ion battery are discontinued models. Delivery only while stocks last.

CHARGING TECHNOLOGY

A special, intelligent circuit in the GESIPA® Li-Ion batteries protects against deep discharging, and ensures that the last setting cycle can be completed, before the battery signals its empty condition by switching off. The empty battery is ready for use again after a charging time of only about one hour. The new GESIPA® Li-Ion charging units are of course also available for the alternating voltages of 110 VAC and 230 VAC.

ACCUBIRD®

The well-proven blind rivet setting tools with Li-Ionen energy

No. 143 4898

No. 145 7235

TECHNICAL DATA

Stroke:	10,000 N
Weight:	2.0 kg with battery
Traction power:	20 mm
Drive:	DC motor

SCOPE OF DELIVERY

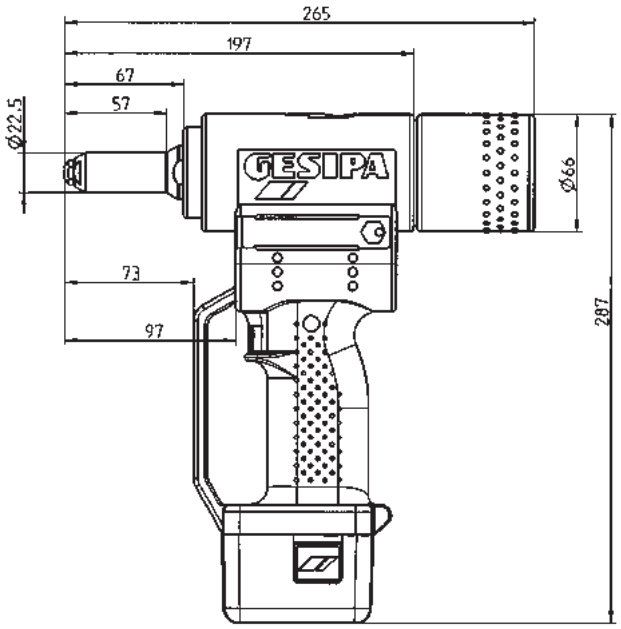
Nosepieces: 17/24, 17/27, 17/29 and 17/32

WORKING RANGE

Blind rivets from Ø 2.4 mm aluminium, up to Ø 5 mm all materials and blind rivets up to Ø 6 mm aluminium. BULB-TITE® blind rivets up to Ø 6.3 mm aluminium and steel., G-Bulb blind rivets up to Ø 4.8 mm all materials. (max. mandrel Ø 3.0 mm)

ADVANTAGES

- Developed and produced in Germany since 1992 by the inventor of the battery blind rivet setting tool
- High speed of operation through automatic resetting of the jaw mechanism immediately after each setting process
- High pulling force for safe setting of blind rivets up to 5 mm diameter in all materials
- Large 20 mm stroke
- Electronic control
- No mechanical switching components
- Electronic temperature and overload protection
- High reliability through low loss power transmission via a highly efficient ball screw drive
- Cablefree tool for flexible operation in installation jobs and industry production
- Auto-reverse function:
  Immediately after mandrel break-off, this additional operating mode stops the pulling process and moves the jaw assembly back into the initial position. This reduces wear, saves time and energy while making sure the tool is immediately ready for use.



Dimensions in mm

BULB-TITES® can only be set with a conversion kit. Jaws need to be changed! Conversion kit on **page 100.**

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge 1.3 Ah Li-Ion battery	Nosepiece	No.
2.4	Alu	**1,500**	17/18*	**143 4976**
3.2	CAP®-Alu, CAP®-Cu	**1,000**	17/18*	**143 4976**
3 and 3.2	Alu	**800**	17/24	**143 4955**
3 and 3.2	Steel	**800**	17/24	**143 4955**
3 and 3.2	Stainless steel	**800**	17/24	**143 4955**
4	Alu	**800**	17/24	**143 4955**
4	Steel	**700**	17/27	**143 4973**
4	Stainless steel	**650**	17/29	**143 4974**
4.8 and 5	Alu	**550**	17/29	**143 4974**
4.8 and 5	Steel	**450**	17/32	**143 4975**
4.8 and 5	Stainless steel	**350**	17/36*	**143 4977**
6	Alu	**250**	17/36*	**143 4977**
BULB-TITE® Blind rivets				
4	Alu	**1,000**	17/26 BT*	**143 4985**
5.2	Alu	**800**	17/32 BT*	**143 4986**
6.3	Alu	**600**	17/42 BT*	**143 4988**
6.3	Steel	**300**	17/42 BT*	**143 4988**
			and jaws 4**	**143 4173**
			and jaw pusher 5**	**143 4992**

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.
**Available as a complete conversion kit, see spare parts/special accessories on page 100.

100 Spare parts and special accessories **page 100.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

No. 145 7240

No. 145 7230

POWERBIRD®

The well-proven blind rivet setting tool with Li-Ion energy and even higher setting performance

VIDEO

20 more than YEARS PowerBird®

No. 145 7186 14 V 14 V

No. 145 7190 14 V 14 V 14 V

TECHNICAL DATA

Stroke:	14,000 N
Weight:	2.2 kg with battery
Traction power:	20 mm
Drive:	DC motor

SCOPE OF DELIVERY

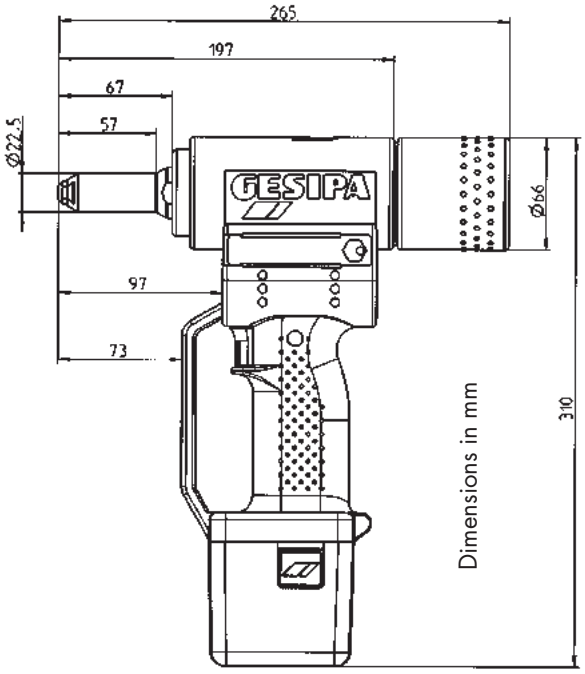
Nosepieces: 17/32, 17/36, 17/40 and 17/45

WORKING RANGE

Blind rivets from Ø 4.8 mm steel, up to Ø 8 mm alu, up to 6.4 mm all materials, except G-Bulb Ø 6.4 mm and stainless steel PolyGrip® Ø 6.4 mm, BULB-TITE® blind rivets up to Ø 7.7 mm, all materials, MEGA GRIP® blind rivets up to Ø 6.4 mm, all materials. (max. mandrel Ø 4.3 mm)

ADVANTAGES

- Practical: User oriented scope of delivery: metal carrying case with one battery charger, one battery and four nosepieces
- Good price-performance ratio
- Large working range
- Short processing times
- High service life thanks to 2.6 Ah power battery
- Even greater production rate per battery charge thanks to the new battery management system
- Auto-reverse function: Immediately after mandrel break-off, this additional operating mode stops the pulling process and moves the jaw assembly back into the initial position. This reduces wear, saves time and energy while making sure the tool is immediately ready for use.
- 2.6 Ah battery, alternatively 1.3 Ah on request



Make sure the correct jaw pusher is used as specified in the operating instructions!

Rechargeable 14.4 volt power battery riveting tool with Li-Ion battery for even higher performance

NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge 2.6 Ah Li-Ion battery	Nosepiece	No.
4.8 und 5.0	Alu	**700**	17/29	**143 4974**
4.8 und 5.0	Steel	**700**	17/32	**143 4975**
4.8 und 5.0	Stainless steel	**600**	17/36	**143 4977**
6.0	Alu	**600**	17/36	**143 4977**
6.0	Steel	**300**	17/40	**143 4999**
6.4	Alu, PG-Alu	**450**	17/45	**143 4860**
6.4	Stainless steel	**250**	17/45	**143 4860**
8	Alu	**350**	17/45	**143 4860**
BULB-TITE® Blind rivets				
4.0	Alu	**1,000**	17/26 BT*	**143 4985**
5.2	Alu	**900**	17/32 BT*	**143 4986**
6.3	Alu	**600**	17/42 BT*	**143 4988**
6.3	Steel	**350**	17/42 BT*	**143 4988**
6.3	Monel	**400**	17/42 BT*	**143 4988**
7.7	Alu	**500**	17/48 BT*	**143 4989**
			and jaws 4*	**143 4173**
MEGA GRIP® Blind rivets				
4.8	Alu	**600**	17/31 MG*	**143 4993**
4.8	Steel	**450**	17/31 MG*	**143 4865**
4.8	Stainless steel	**450**	17/31 MG*	**143 4993**
6.4	Alu	**450**	17/41 MG*	**143 4993**
6.4	Steel	**150**	17/41 MG*	**143 4865**
6.4	Stainless steel	**150**	17/41 MG*	**143 4865**

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

100 Spare parts and special accessories PowerBird® **page 100.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

POWERBIRD® SOLAR

Ideal for deep, difficult to access areas in solar applications

No. 145 7191

TECHNICAL DATA

Traction power:	14,000 N
Weight:	2.4 kg with battery
Working stroke:	20 mm
Drive:	DC motor
Extension unit:	ca.167 mm

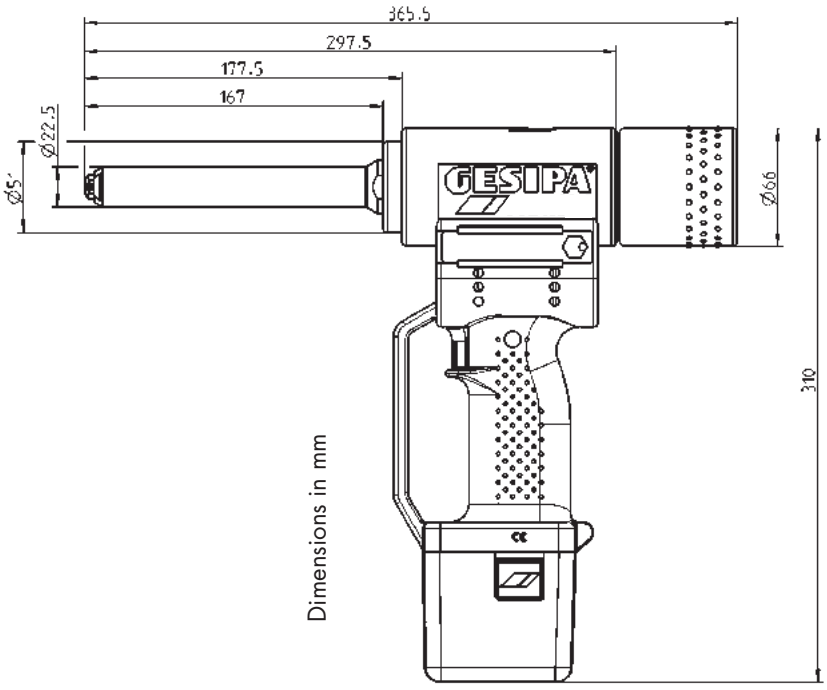
SCOPE OF DELIVERY

approx. 167 mm extension unit
two Li-Ion power batteries 2.6 Ah/14.4 V
Quick charger
Nosepieces 17/32, 17/36,
17/40, 17/45 and 17/48 BT
Plastic carrying case

WORKING RANGE

Blind rivets from Ø 4.8 mm steel up to 6.4 mm all materials, except G-Bulb Ø 6.4 mm. BULB-TITE® blind rivets up to Ø 7.7 mm, all materials. MEGA GRIP® blind rivets up to Ø 6.4 mm all materials. (max. mandrel Ø 4.3 mm, BT 4.5 mm)

41 The GESIPA® SolarGrip® blind rivet program can be found on **page 41**.



NOSEPIECE ASSIGNMENT Power per battery charge

D	Material	approx.pc / battery charge 2.6 Ah Li-Ion battery	Nosepiece	No.
4.8 and 5.0	Alu	**700**	17/29	**143 4974**
4.8 and 5.0	Steel	**700**	17/32	**143 4975**
4.8 and 5.0	Stainless steel	**600**	17/36	**143 4977**
6.0	Alu	**600**	17/36	**143 4977**
6.0	Steel	**300**	17/40	**143 4999**
6.4	Alu, PG-Alu	**450**	17/45	**143 4860**
6.4	Steel	**250**	17/45	**143 4860**
8	Alu	**350**	17/45	**143 4860**
BULB-TITE® Blind rivets				
4.0	Alu	**1,000**	17/26 BT*	**143 4985**
5.2	Alu	**900**	17/32 BT*	**143 4986**
6.3	Alu	**600**	17/42 BT*	**143 4988**
6.3	Steel	**350**	17/42 BT*	**143 4988**
6.3	Monel	**400**	17/42 BT*	**143 4988**
7.7	Alu	**500**	17/48 BT*	**143 4989**
			and jaws 4*	**143 4173**
MEGA GRIP® Blind rivets				
4.8	Alu	**600**	17/31 MG*	**143 4993**
4.8	Steel	**450**	17/31 MG*	**143 4993**
4.8	Stainless steel	**450**	17/31 MG*	**143 4993**
6.4	Alu	**450**	17/41 MG*	**143 4865**
6.4	Steel	**150**	17/41 MG*	**143 4865**
6.4	Stainless steel	**150**	17/41 MG*	**143 4865**

* available as special accessory. Special design nosepieces are available on request.
The nosepiece allocation data applies to DIN and GESIPA® blind rivets.

100 Spare parts and special accessories PowerBird® Solar **page 100.**

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

SPRING-LOADED TRIGGER SYSTEM for AccuBird® and PowerBird®

Process-secure blind riveting even of parts with gaps or recoiling

AccuBird® with spring-loaded trigger sytem
with Nosepieces 17/24, 17/27, 17/29 and 17/32

No. 145 7232

PowerBird® with spring-loaded trigger sytem
with Nosepieces 17/32, 17/36, 17/40 and 17/45

No. 145 7207

PowerBird® Solar with spring-loaded trigger sytem
with Nospieces 17/32, 17/36, 17/40 and 17/45
approx. 160 mm extension unit

No. 146 4037

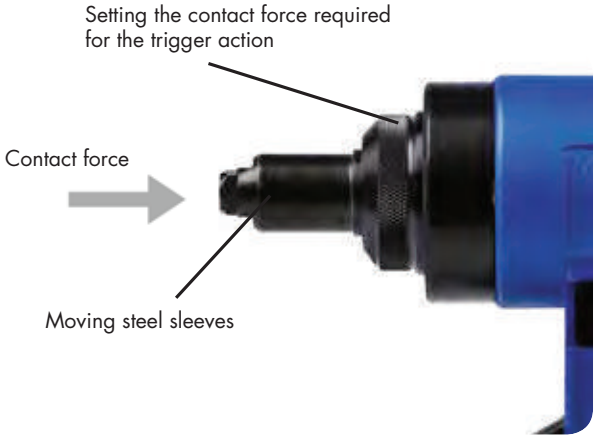
This feature ensures that the materials of the riveting application will be pressed together before the rivet is installed, thus avoiding gaps in between. Moreover the operator will be certain that the rivet has reached its end position in the application and that the setting head is in contact with the upper side of the material. The pressing force can be adjusted variably with springs depending on the application.

THE FUNCTION

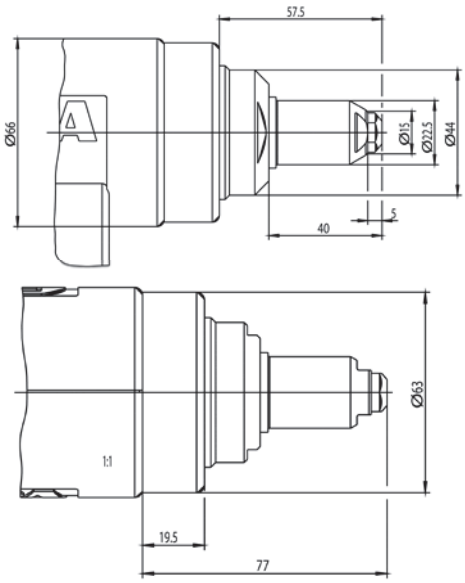
The surface contact trigger mechanism is also installed on the trigger button of the device. It only allows the rivet device to be triggered if a settable compressive force on the part is reached. This ensures that the various components of the application are pressed correctly onto each other before the riveting process. In turn, this means that the uncontrolled deformation of the rivet body between the materials is prevented, which would otherwise go andetected.

The surface contact force may vary in five steps. It is set by either adding or removing springs. This rules out the possibility of unintentionally adjusting the defined surface contact force. Push buttons are arranged in series in front of the standard trigger button. The rivet process can only be triggered by pressing the yellow trigger button when the spring force has been overcome and the defined surface contact force has been reached.

ENSURING CORRECT PROCESSING OF THE BLIND RIVETS BY MEANS OF A DEFINED CONTACT PRESSURE



POWERBIRD® DIMENSION DRAWING WITH SPRING-LOADED TRIGGER SYSTEM



Dimensions in mm

140 Nosepieces and performance see **page 140.**

ANGLE HEAD 90° COMPACT for AccuBird® and PowerBird®

Can be swivelled 360° on the AccuBird® and PowerBird® tensile axis

No. 145 7252

TECHNICAL DATA

Weight:	0.7 kg
Stroke:	20 mm
Traction power:	up to 10 kN

SCOPE OF DELIVERY

Nosepieces:	17/36

DESCRIPTION

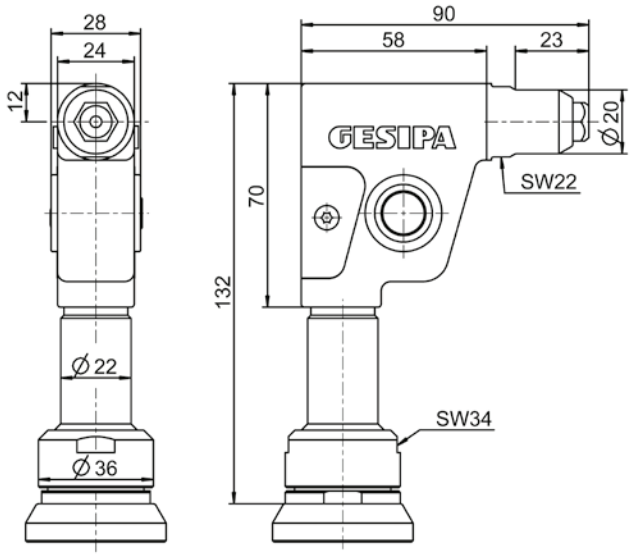
Using the angle head 90° compact for PowerBird® and AccuBird® allows to set all Types of standard blind rivets up to 5 mm in diameter and aluminium up to 6 mm diameter, depending on the tool Type. The minimum edge clearance is 12 mm, the head length is 90 mm. The angle head can be freely fixed in any position aroand the AccuBird® and PowerBird® tensile axis (360° free rotation).

APPLICATION

The angle head 90° compact is designed for use in tight spaces. Its sturdy design allows it to apply large setting forces when setting blind rivets even in difficult of access work areas with up to10 kN.

ADVANTAGES

- Realisation of small edge clearances (12 mm)
- High setting force in tight installation areas (up to 10 kN)
- Large stroke (up to20 mm)
- Simple assembly
- Compact and robust design
- Simple jaws maintenance
- Use of standard jaws
- Low vibration, even at high breaking force level



Dimensions in mm

SPARE PARTS / SPECIAL ACCESSORIES Bird tools

BATTERY 14.4 V/1.3 AH (LI-ION)
Weight: 0.35 kg

No. 143 4921

POWER BATTERY
14.4 V/2.6 AH (LI-ION)
Weight: 0.50 kg

No. 145 7269

CHARGER 14.4 V LI-ION

Technical data

Input voltage:	230 V / 50 Hz
Output voltage:	14.4 V DC
Recharging time:	50 to 100 minutes (battery depending)
Weight:	0.6 kg

No. 145 7282

RETAINING NOSEPIECE
Special accessory (also for SN 2)

- Inserted rivet remains in any position
- Rivets may be set with only one hand
- Safer work

*Except AccuBird®

17/18R	**No. 165 5422**
17/20R	**No. 165 5424**
17/22R	**No. 165 5426**
17/24R	**No. 165 5427**
17/27R	**No. 165 5428**
17/29R	**No. 165 5429**
17/32R	**No. 165 5430**
17/36R	**No. 165 5431**
17/40R*	**No. 165 5433**
17/45R*	**No. 165 5434**

JAWS (3 PARTS)

AccuBird®	**No. 143 4958**
PowerBird®	**No. 143 4104**

EXTENDED SPENT MANDREL CONTAINER
to suit AccuBird®, PowerBird® and SolarBird®

No. 143 5034

CHANGEOVER SET FOR
BULB-TITE® BLIND RIVETS
for AccuBird®

No. 143 5033

SPARE PARTS / SPECIAL ACCESSORIES Bird tools

UNIVERSAL NOSEPIECE – 17

To suit AccuBird®, PowerBird® and SN2

No. 143 4960

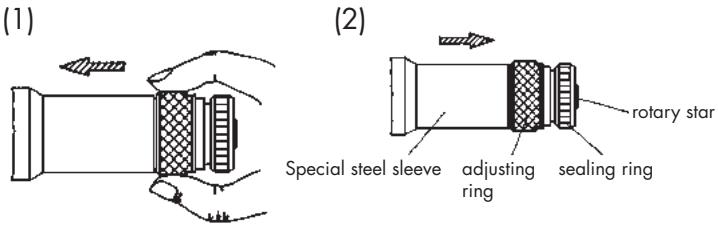
The universal nosepiece replaces five nosepiece sizes. The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece

Working range

Blind rivets from 2.4 up to 5 mm Ø alu, copper and steel and up to 4 mm Ø stainless steel.

Operation

Operate the tool and hold trigger, then push back adjusting ring to end position (1).
By turning the rotary star (2).



The universal nosepiece includes: Special steel sleeve, complete adjusting ring, rotary star and sealing ring.

EXTENSION UNIT

ONE-PIECE EXTENSION UNIT

Replaces the steel case, is especially slim and therefore particularly well suited to narrow, hard-to-reach places.

TOOL	50 mm	100 mm	150 mm
AccuBird®	**145 7273**	**145 7274**	**145 0622**
PowerBird®	**145 7214**	**145 7215**	**146 4038**
PowerBird® Gold Edition	**145 7214**	**145 7215**	**146 4038**
PowerBird® with spring loaded trigger system	**145 7222**	**145 7224**	-

MULTI-PIECE EXTENSION UNITS

For riveted joints in low-lying places. Screwed in between the device and the existing steel case

TOOL	100 mm
AccuBird®	**145 7318**
PowerBird®	**145 7229**
PowerBird® Gold Edition	**145 7229**

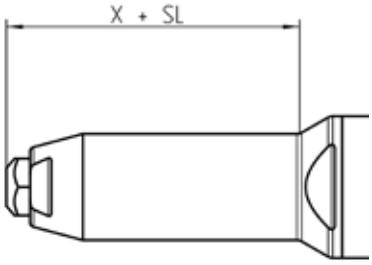
EXAMPLE one-piece

Bird tools Example: + SL 50 mm

Steel head sleeve length =
57 mm (X) + SL 50 mm = 107 mm

PowerBird® mit AV Beispiel: + SL 50 mm

Steel head sleeve length = 40 mm (X) + SL 50 mm = 88 mm



The variable X can be found in the dimension drawings of the devices.

Dimension X = Standard steel head sleeve length (with standard nosepiece)

EXAMPLE multi-piece

Bird tools Example: + SL 100 mm

Steel head sleeve length = 57 mm (X) + SL 100 mm = 157 mm

Variable extension of the steel head sleeve is possible in steps of +100 mm.

PNEUMATIC BLIND RIVET SETTING TOOLS

HYDRO-PNEUMATIC BLIND RIVET SETTING TOOLS

104

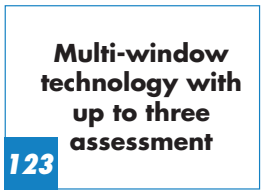
TAURUS® 1-6

TAURUS® 1-4 with counter device

TAURUS® 1-4 with counter device eco

TAURUS® 1-4 Axial eco
TAURUS® 1-4 Axial

TAURUS® 1-4 C AV



TAURUS® WinTech

TAUREX 1-6

TAUREX 1-4 Axial
TAUREX 1-4 Axial compact

PH 2

PH 2-VK

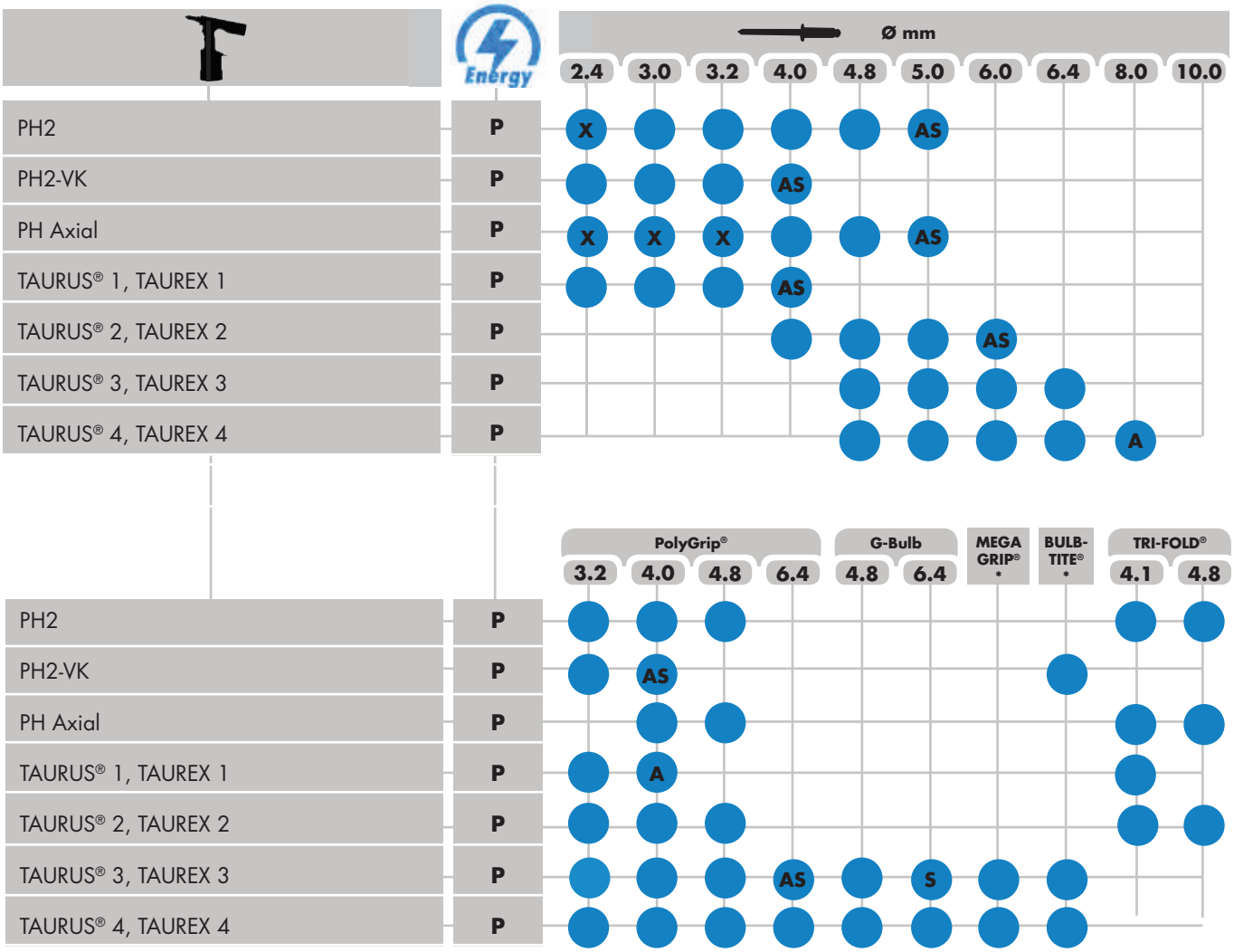
PH Axial

GAV 8000 / GAV 8000 eco

GAV HF

Interface 4.0

WHAT RIVETS WHAT?



P: Hydro-pneumatic tool

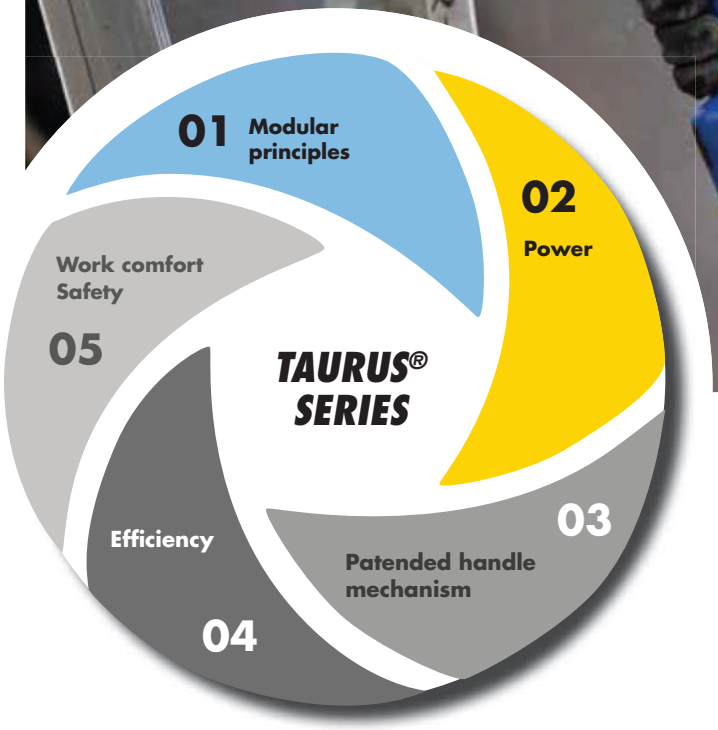
X: Special accessoires required

A: Alu/Copper
S: Steel
E: Stainless Steel / Monel
Blue box: All materials(ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box.

*: A special nosepiece is **always** required when setting MEGA GRIP® blind rivets and BULB-TITE® blind rivets.

THE TAURUS® SERIES

The cost-efficient construction, perfect handling properties and practical accessories are what make the TAURUS® series so unique and flexible.



Since the market introduction of the **TAURUS® 2** in the year 2002, the TAURUS® series has managed to convince thousand times over in trade and industry. The TAURUS® 2 especially is a true all-rounder.

TAURUS®

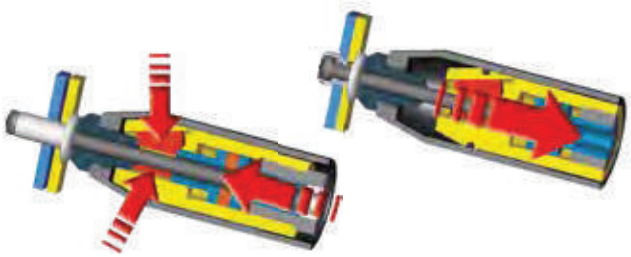
TAURUS® 1 | TAURUS® 2 | TAURUS® 3 | TAURUS® 4 | TAURUS® 5 | TAURUS® 6

ADVANTAGES WHICH SIMPLY CANNOT FAIL TO CONVINCE YOU!

01 MODULAR PRINCIPLES
- Widest possible parts commonality – low spare part stocks required and simple maintenance
- Flexible adaption to new applications

02 POWER
- High setting forces combined with low weight
- Fast work cycle
- Optimised stroke for the entire series

03 PATENTED HANDLE MECHANISM*
- With forcibly actuated jaws by pneumatic pressing
- Safe, non-slip gripping of the rivet mandrel
- Just one model of jaws for all tools
- Very long service lives



* Patented jaw system
> The three jaws move in separate channels while being under forced control.
> The jaws are pressed onto the mandrel by using com pressed air instead of spring force – the force being ten times higher than usual.
> Due to the high pressure the jaws immediately cling to the mandrels upon triggering the riveting process, only then the pulling movement starts.

GESIPA®-system – decisive advantages
> The complete stroke of the tool is used for setting the rivet guaranteeing a reliable setting process.
> The immediate and non-slip grip of the mandrel reduces abrasion and troublesome soiling.
> Since the jaws do not slide along the mandrel, the wear and tear of the jaw profiles is reduced.

Lower costs due to longer service life and low requirements regarding maintenance and spare parts needed.

04 EFFICIENCY**
- Little compressed air consumption thanks to dual function: setting the rivets and extracting the spent mandrels use the same air
- Air suction needed only for vertical downwards riveting.
- Can be permanently switched-off if not needed.

** **Optimum use of compressed air ensures maximum efficiency and low operating costs**
Compressed air is used very often in industrial production because of its flexibility. It does, however, cause relatively high costs and its consumption damages the environment. These disadvantages are more than enough reason for GESIPA® to equip the TAURUS® tool series with a special technique that allows to save compressed air and is unique throughout the world. The GESIPA® System uses the compressed air required for the setting process twice. First, to set the blind rivet and secondly, to extract the spent mandrel. Dual use of the compressed air means no expensive, fresh compressed air is needed which other tools on the market constantly need just to extract the spent mandrel. And, last but not least, noise emission from the TAURUS®-tools is extremely low.

In two-shift operation and with compressed air costs of approximately € 0.03 per m³ this innovative technique allows savings of up to € 720 per year and tool.
A TAURUS® 2 can pay for itself in less than one year.

05 WORK COMFORT / SAFETY
- Rubberised, moulded grip
- • Balanced center of gravity
- • Low-vibration and soandproofed
- • Little activation force required
- • Spent mandrel container with swivelling air deflector
- • Overpressure valve for prevention of overload
- • Integrated protection feature prevents the ejection of spent
- mandrels while the spent mandrel container is removed

TAURUS® DEVICE SERIES – THE MODULAR CONCEPT

The TAURUS® series – unique modular principle. Minimal spare parts stocks, easy maintenance

Nosepieces
different sizes

Extension units
Free access to difficult-to-reach riveting points

Single-piece
(different sizes)

Multi-piece
(different sizes)

Hanger

Spring-loaded trigger system
for gap-free riveting

External trigger
for external triggering

Air suction function

Nosepiece allocation

GESIPA®-Interface

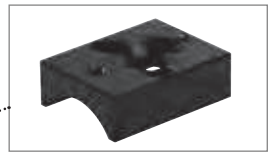
Setting process monitoring
for reliable setting processes

The TAURUS® device series – Versatile accessories complete the range

The modular concept for the TAURUS® series 1-4 lets the user customise the TAURUS® devices to match his individual requirements.

Many identical parts that can be used across all devices reduce the need to stock spare parts and make maintenance easy. This wide range of options provides the user with a high degree of flexibility. Each device in the TAURUS® series 1-4 can be fitted with many different spare parts or refitted according to the application.

Tool mount
for integration into automated applications



Rivet mandrel evacuation

Blind rivet counters

GRiv-Count

GRiv-Amp

Spent mandrel container
adoptable for TAURUS® tools1-4

TAURUS® 1-2

TAURUS® 3-4

PH-2000

TAURUS® 1-2

TAURUS® 3-4

Swivel air connector

Counter eco

Flexible base
Optimized stability

TAURUS® SERIES

With silencer

TAURUS® 1

No. 145 7665

TECHNICAL DATA

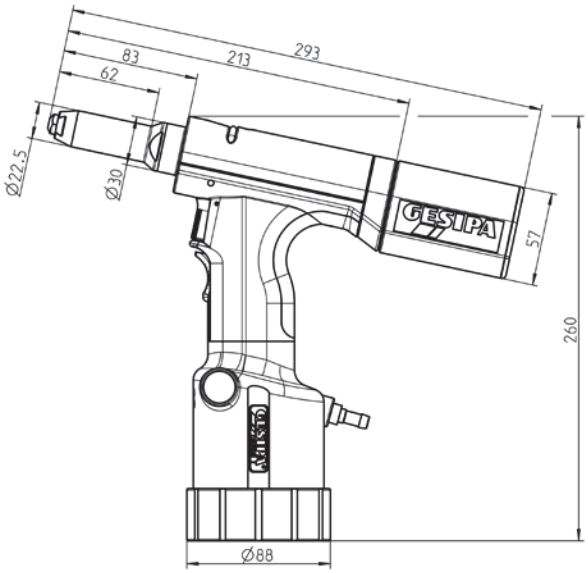
Weight:	1.3 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 1.0 ltr. per rivet
Traction power:	5,500 N at 6 bar
Stroke:	15 mm

WORKING RANGE

Sets blind rivets from 2.4 up to 3.2 mm Ø all materials and up to 4 mm Ø alu/steel (max. mandrel Ø 2.0 mm)

SCOPE OF DELIVERY

Nosepieces:17/18, 17/20 and 17/22, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml, 1 oil refill can, Operating instructions with spare parts list



Dimensions in mm

TAURUS® 2

No. 145 7771

TECHNICAL DATA

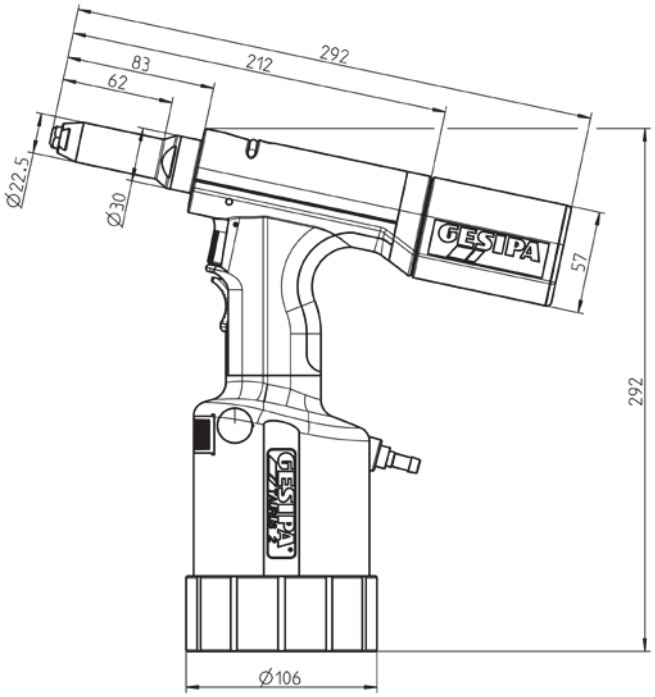
Weight:	1.6 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 2.3 ltr. per rivet
Traction power:	11,000 N at 6 bar
Stroke:	18 mm

WORKING RANGE

Sets blind rivets up to 5 mm Ø all materials and up to 6 mm Ø alu/steel (max. mandrel Ø 3.0 mm)

SCOPE OF DELIVERY

Nosepieces:17/24, 17/27, 17/29 and 17/32, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml,1 oil refill can, Operating instructions with spare parts list



Dimensions in mm

TAURUS® 3

No. 145 7871

TECHNICAL DATA

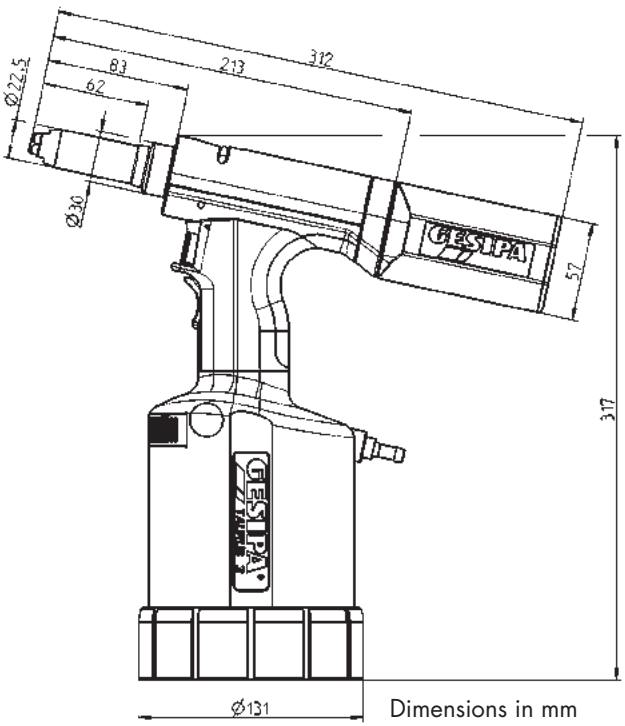
Weight:	1.9 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 4.8 ltr. per rivet
Traction power:	18,000 N at 6 bar
Stroke:	25 mm

WORKING RANGE

Sets blind rivets up to 6.4 mm Ø all materials (max. mandrel Ø 4.3 mm)

SCOPE OF DELIVERY

Nosepieces:17/36, 17/40 and 17/45, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml, 1 oil refill can, Operating instructions with spare parts list



Dimensions in mm

TAURUS® 4

No. 145 7964

TECHNICAL DATA

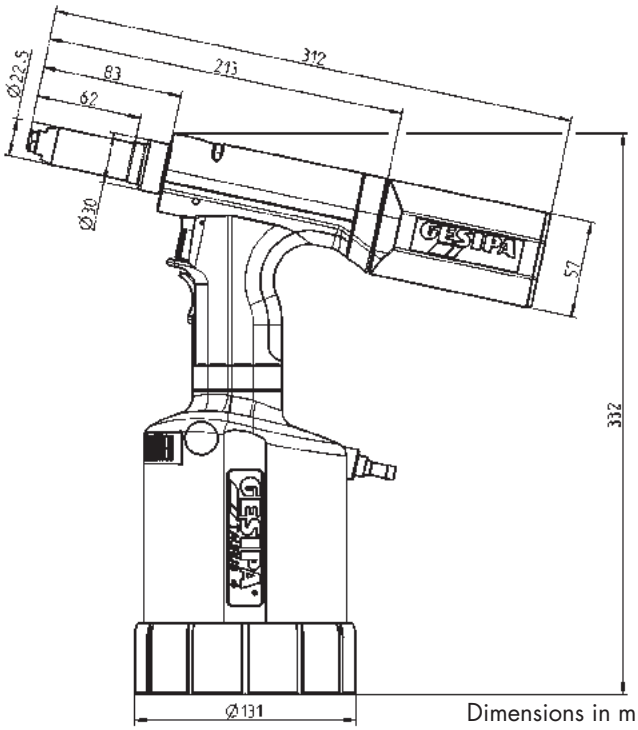
Weight:	2.0 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 4.8 ltr. per rivet
Traction power:	23,000 N at 6 bar
Stroke:	19 mm

WORKING RANGE

Sets blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel Ø 4.3 mm)

SCOPE OF DELIVERY

Nosepieces:17/36, 17/40 and 17/45, maintenance wrench SW12/14, SW14/17, 1 hydraulic oil bottle 100 ml, 1 oil refill can, Operating instructions with spare parts list



Dimensions in mm

TAURUS® SERIES

TAURUS® 5

Basic tool

No. 145 8002

TECHNICAL DATA

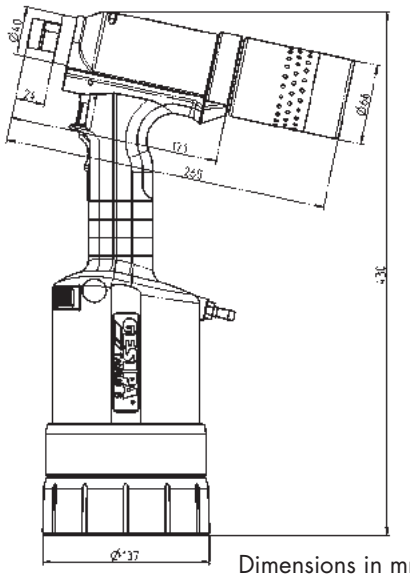
Weight:	3.4 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 6.9 ltr. per rivet
Traction power:	42,000 N at 7 bar
Stroke:	17 mm

WORKING RANGE

Blind rivets above 6.4 mm Ø all materials and lockbolts up to10 mm Ø with corresponding pulling heads (look on page 130).

SCOPE OF DELIVERY

1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



Dimensions in mm

TAURUS® 5 and 6 need to be fitted with nosepieces to match the application. Will be produced on request.

131 The pulling heads can be found on **page 131**.

TAURUS® 6

Basic tool

No. 145 8022

TECHNICAL DATA

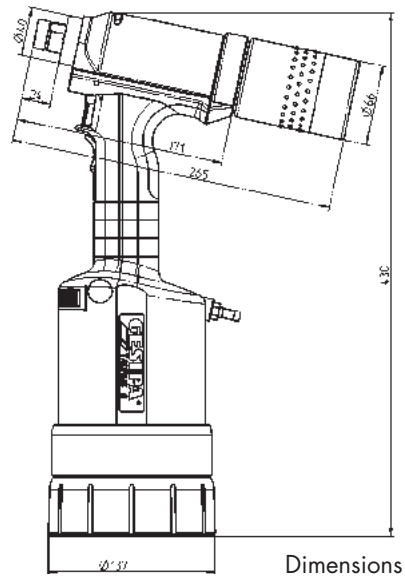
Weight:	3.4 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 6.9 ltr. per rivet
Traction power:	50,000 N at 7 bar
Stroke:	15 mm

WORKING RANGE

Blind rivets above 6.4 mm Ø all materials and lockbolts up to10 mm Ø with corresponding pulling heads (look on page 130).

SCOPE OF DELIVERY

1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list



Dimensions in mm

TAURUS® 5 and 6 need to be fitted with nosepieces to match the application. Will be produced on request.

131 The pulling heads can be found on **page 131**.

NOSEPIECES

For long mandrels, special blind rivets and other challenges

The use of the correct nosepiece is essential for ensuring reliable riveting and a neat riveted joint. A large selection of standard and special nosepieces makes it possible to quickly adapt to various types of blind rivet. Even special versions are generally available on request. All nosepiece allocation data relate to DIN and GESIPA® blind rivets.

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

136 Extended nosepieces, special lengths and special nosepieces on **page 136.**

NOSEPIECE ASSIGNMENT

D	Material	Nosepiece	No.
STANDARD			
2.4	Alu	17/18	**143 4976**
3.2	CAP®-Alu, CAP®-Cu	17/18	**143 4976**
3	Alu/Cu	17/20	**143 4994**
3	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu	17/22	**143 5018**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, PG-Alu, PG-Steel, PG-Stainless steel	17/24	**143 4955**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	17/24	**143 4955**
4	Steel, Alu, PG-Alu	17/27	**143 4973**
4	Stainless steel, Stinox, PG-Steel, PG-Stainless steel	17/29	**143 4974**
4.8 and 5	Alu, CAP®-Alu, CAP®-CU, PG-Alu	17/29	**143 4974**
4.8 and 5	Steel, Alu	17/32	**143 4975**
4.8 and 5	Stainless steel, Stinox, PG-Steel, PG-Stainless steel, G-Bulb	17/36	**143 4977**
6	Alu	17/36	**143 4977**
6	Steel	17/40	**143 4999**
6.4	Alu	17/40	**143 4999**
6.4	Steel, Alu, Stainless steel, PG-Stainless steel, G-Bulb	17/45	**143 4860**
8	Alu	17/45	**143 4860**
BULB-TITE®			
4	Alu	17/26 BT	**143 4985**
5.2	Alu	17/32 BT	**143 4986**
6.3	Alu, Steel, Monel	17/42 BT	**143 4988**
7.7	Alu	17/48 BT	**143 4989**
MEGA GRIP®			
4.8	Alu, Steel, Stainless steel	17/31 MG	**143 4993**
6.4	Alu, Steel, Stainless steel	17/41 MG	**143 4865**

SPARE PARTS / SPECIAL ACCESSORIES TAURUS® SERIES 1-4

SWIVEL AIR CONNECTOR
For the complete TAURUS® series in 1/8“

No. 143 5479

SET OF JAWS (3 PCS.)

Patented jaw system for the complete TAURUS® series

No. 143 5568

FLEXIBLE BASE FOR TAURUS® 1 AND 2

With the flexible base made from MBR and the larger surface area, the TAURUS® tools are standing even more stably.

T1 No. 143 6394

T2 No. 143 6371

SMALL JAW ASSEMBLY TAURUS® 1-2

The small jaw assembly is particularly suitable where rivet sites are difficult to access. The TAURUS® 1 with the small jaw assembly handles aluminium/steel blind rivets up to Ø 4 mm and steel/steel blind rivets up to Ø 3.2 mm. The small jaw assembly for the TAURUS® 2 handles aluminium/steel blind rivets up to Ø 5 mm and steel/steel blind rivets up to Ø 4 mm. The jaw assembly is 100 mm long and the diameter of the steel head sleeve is 18 mm.

T1 No. 145 7705

T2 No. 145 7846

Nosepieces to be used

NOSEPIECE	TAURUS® 1	TAURUS® 2
10/18	**143 4055**	**143 4055**
10/24	**143 4061**	**143 4061**
10/27	-	**143 4062**
10/29	-	**143 4064**

TOOL MOUNT FOR TAURUS® 1-4

For integration into automated systems or connection to handling modules.

*Device support not available individually. The tool is delivered pre-mounted on a new device or can be retrofitted on an existing device at the GESIPA® Walldorf site.

Can only be mounted by GESIPA®

No. 143 5538*

PROTECTIVE SLEEVE

The plastic-dipped steel head sleeve protects sensitive workpiece surfaces (e.g. painted surfaces) from being scratched by the nosepiece or the steel head sleeve during riveting.

for **AccuBird®** and **PowerBird®** **No. 156 7288**

for **TAURUS® standard tools** and **Bird Pro series** **No. 156 7289**

TRANSPARENT COLLECTING CONTAINER FOR TAURUS® 1-4

T1-T2 No. 145 7744

T3-T4 No. 145 7951

The classic residual mandrel collecting container in the TAURUS® series is also available in a transparent version.The transparent collecting container allows the amount of residual mandrels to be monitored constantly.

The transparent collecting container will be available in a small version for the TAURUS® devices 1-2 and a large version for the TAURUS® devices 3-4.

MANDREL EXTRACTION TUBE

For the full TAURUS® series

No. 145 7864

By attaching a special-purpose hose nipple, the spent mandrel container can be replaced by the spent mandrel evacuation hose*. In stationary use, this can be of great advantage as frequent disposal is not required. The spent mandrels are collected in a container so that the work place remains clean and tidy, with no interruption to the work.

*The use of TAURUS® tools with a 1.5 m long evacuation hose requires permanent employment of the suction unit.

TAURUS® CONVERSION KIT

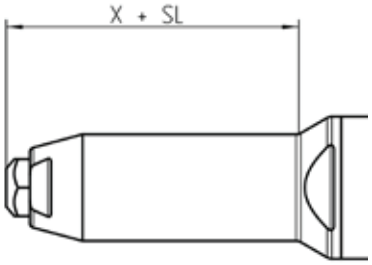
For conversion to the PH 2000 spent mandrel container (description and full offer on page 127).

T1 No. 145 7700

T2-T4 No. 145 7703

EXTENSION UNITS

Allows easy access to rivet sites which are difficult to reach.
The extension units are used for riveting sites which are situated low down or are difficult to access. We offer one-piece extension units of 35, 85, 135 and 185 mm length for the TAURUS® 1-4.
The extension units consist of three parts.



The variable X can be found in the dimension drawings of the devices.

Dimension X = Standard steel head sleeve length (with standard nosepiece)

ONE-PIECE
Example: TAURUS® 1 + SL 35 mm

Steel head sleeve length =
62 mm (X) + SL 35 mm = 97 mm

TOOL	+35 mm	+85 mm	+135 mm	+185 mm
TAURUS® 1	**146 4345**	**146 4346**	**146 4347**	-
TAURUS® 2	**145 8042**	**146 4350**	**146 4351**	**146 4352**
TAURUS® 3 and 4	**145 7932**	**145 7933**	**145 7937**	**-**

TOOL	+ 50 mm	+ 100 mm
TAURUS® 1 with spring loaded trigger system	**145 0880**	**145 7727**
TAURUS® 2 with spring loaded trigger system	**145 7857**	**145 7858**
TAURUS® 3 and 4 with spring loaded trigger system	**145 7959**	**145 7960**

MULTI-PIECE
Example: TAURUS® 1 + SL 100 mm

Steel head sleeve length = 62 mm (X) + SL 100 mm = 162 mm
On TAURUS® 1-4 the steel head sleeve can be extended variably in steps of 100 mm.

TOOL	+100 mm
TAURUS® 1	**145 7743**
TAURUS® 2	**145 7848**
TAURUS® 3 and 4	**145 7947**

ANGLE HEAD 90° AND ANGLE HEAD 90° COMPACT

The **angle head 90°** and the **angle head 90° compact** are designed for use in tight spaces. Its sturdy design allows it to apply large setting forces when setting blind rivets even in difficult of access work areas. The angle head 90° for TAURUS® 1-4 allows to set all Types of standard blind rivets up to Ø 6.4 mm all materials and Ø 8 mm alu, depending on the tool type. The minimum edge clearance is 15 mm, the head length is 110 mm.

The angle head 90° compact for the TAURUS® 1 and 2 allows to set standard blind rivets of all Types of material up to 5 mm in diameter and alu/steel blind rivets up to 6 mm in diameter, depending on the tool Type. The minimum edge clearance is 12 mm, the head length is 90 mm. Both angle heads can be freely fixed in any position aroand the TAURUS® tensile axis (360° free rotation).

ANGLE HEAD 90° for TAURUS® 1-4

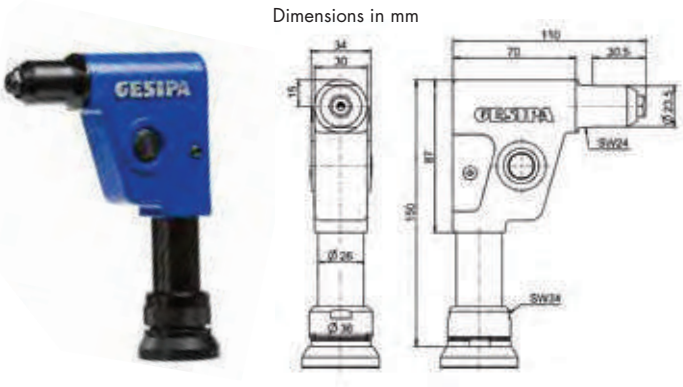
TECHNICAL DATA

Weight:	1.1 kg
Stroke:	20 mm (TAURUS® 1,2 and 4)
Stroke:	25 mm (TAURUS® 3)
Traction power:	up to 20 kN

SCOPE OF DELIVERY

Nosepiece 17/45 WK
Jaws up to rivet-Ø 4mm (Nosepiece 17/24)

Dimensions in mm



TAURUS® 1, 2, 4 **No. 155 9513**
TAURUS® 3 **No. 155 9512**

JAWS (3 PARTS) for TAURUS® 1-4
Jaws up to rivet-Ø 4mm (Nosepiece 17/24)

No. 143 4958

Up to Ø 6.4 mm of all materials, Ø 8.0 mm Alu

No. 143 4173

ANGLE HEAD 90° COMPACT for TAURUS® 1-2

TECHNICAL DATA

Weight:	0.7 kg
Stroke:	20 mm
Traction power:	up to 10 kN

SCOPE OF DELIVERY

Nosepieces:17/36

Dimensions in mm

TAURUS® 1, 2 **No. 145 7921**

JAWS (3 PARTS) for TAURUS® 1-2

No. 143 4104

TAURUS® VERSIONS

A wide variety of options means higher flexibility. All of the TAURUS® varieties are customized and designed and made to fit the application. Please contact our team from the Technical Sales department should you require individual advice or have any further queries or need information on prices.

TAURUS® 2/K

No. 145 7804

The TAURUS® 2/K has been designed for setting plastic rivets. In its functionality the TAURUS® 2/K is identical to the standard tool, however has a stroke of 24 mm instead of 18 mm. Plastic rivets only need a low setting force, however, normally require large setting strokes due to the toughness of the plastic material. The TAURUS® 2/K allows to safely set plastic rivets with only one setting stroke! The TAURUS® 2/K comes with 3 nose pieces for plastic rivets 17/30 K, 17/35 K and 17/40 K included.

TECHNICAL DATA

Strength:	24 mm
Tensile strength:	8,400 N

WORKING RANGE
Blind rivets plastic from 4 up to 6 mm Ø.

SCOPE OF SUPPLY
Nosepieces 17/30K; 17/35K; 17/40K

TAURUS® 2/AS

No. 145 7794

The TAURUS® 2/AS is a special version of theTAURUS® 2 with a VAS slide switch which does not engage when in its highest position, thus achieving that vacuum absorption is automatically deactivated once the tool is not in use. This way, unintentional activation of the vacuum absorption with unnecessary air consumption can be effectively avoided.

Other TAURUS® sizes upon request.

TAURUS® 2/24

No. 145 7803

As far as technology and functionality are concerned, the TAURUS® 2/24 is identical to the standard tool, however has a stroke of 24 mm instead of 18 mm. This tool provides the advantage of being able to safely set critical rivet Types requiring a large setting stroke with only one setting stroke without re-engagement. This applies, for example, to our BULB-TITE® or similar rivets.

TECHNICAL DATA

Strength:	24 mm
Tensile strength:	8,400 N

WORKING RANGE
Blind rivets up to Ø4 mm all materials, Ø5 mm steel; Ø 6 mm alu.

TAURUS® 1-4 WITH COUNTER DEVICE

TAURUS® 1-4 (with counter device)

The TAURUS® series 1-4 with counter device – detects and counts the spent mandrels

The tools are equipped with a sensor which detects and counts the spent mandrels after the setting process has been finished. The sensor is positioned on the tool head in front of the spent mandrel container.

For a completely independent workstation, the amplifier GRivAmp or the counter and display unit GRivCount can be used for processing and analysing the signals.

GRiv-Count

GRiv-Amp

For retrofitting existing tools a conversion kit suitable for all TAURUS® Types (except TAURUS® with PH 2000 spent mandrel container) is available:

Conversion kit TAURUS® 1 with sensor
No. 145 7698

Conversion kit TAURUS® 2-4 with sensor
No. 151 6858

GRiv-Count
No. 146 3062

GRiv-Amp
No. 145 7699

Power supply (24 V) is to be provided on site.

TAURUS® 1-4 WITH COUNTER ECO

TAURUS® 1-4 with counter – the cost-effective variant for monitoring the number of setting strokes

In contrast to the TAURUS® with counter, the eco counter only counts the number of setting strokes and not the spent mandrels. The sensor is fitted on the air cylinder. The counter is not available on its own. It is supplied mounted on a new tool or it can be retrofitted at the Walldorf factory.

Retrofit kit for the eco counting device

GERÄT	No.
TAURUS® 1	**145 0892**
TAURUS® 2	**145 0933**
TAURUS® 3	**145 0963**
TAURUS® 4	**145 0993**

*eco counting device is not available separately. It can be retrofitted to an existing tool at the Walldorf plant or in a qualified GESIPA® workshop.

Can only be mounted by GESIPA®.

The TAURUS® series 1-4 in axial version – for special applications

TAURUS® 1-4 AXIAL

TECHNICAL DATA

Operating pressure:	5 to 7 bar
Air hose connection:	6 mm (1/4“)
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²
Weight:	
TAUREX 1 Axial compact	3.1 kg
TAUREX 2 Axial compact	3.4 kg
TAUREX 3 Axial compact	3.7 kg
TAUREX 4 Axial compact	4.1 kg

APPLICATIONS

The special pistols of TAURUS® Axial offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action.

In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAURUS® Axial can be additionally supplied with a spring loaded-trigger system. A compressed air supply is additionally required for reliable mandrel evacuation. Depending on the application, this is preferably achieved via the balancer with valve or the time delay valve (see page 131).

WORKING RANGE

- Processing blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
- Same performance and technical data as the respective individual units in the TAURUS® series 1-4

ADVANTAGES

- Pressure transducer attached in a space-saving manner directly to the device, i.e. also for applications in tight spaces
- Technical design close to the TAUREX Axial
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, spring loaded trigger system and remote control
- The handle in the rivet axis allows ergonomic work – especially in vertical applications
- Can be suspended on a balancer

TOOL	No.
TAURUS® 1 Axial	**145 7682**
TAURUS® 2 Axial	**145 7795**
TAURUS® 3 Axial	**145 7893**
TAURUS® 4 Axial	**145 0981**
TAURUS® 1 Axial with spring-loaded trigger system	**145 7683**
TAURUS® 2 Axial with spring-loaded trigger system	**145 7796**
TAURUS® 3 Axial with spring-loaded trigger system	**145 7894**
TAURUS® 4 Axial with spring-loaded trigger system	**145 0982**

The TAURUS®-series 1-4 in axial version – the cost-efficient introductory version for special applications

TAURUS® 1-4 AXIAL ECO

TECHNICAL DATA

Operating air pressure:	5 to 7 bar
Air hose connection :	6 mm (1/4“)
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²
Weight:	
TAURUS® 1 Axial eco	2.0 kg
TAURUS® 2 Axial eco	2.3 kg
TAURUS® 3 Axial eco	2.6 kg
TAURUS® 4 Axial eco	3.0 kg

APPLICATIONS
Analog to the TAURUS® 1-4 Axial (S. 120)

WORKING RANGE
Analog to the TAURUS® 1-4 Axial

ADVANTAGES
Analog to the TAURUS® 1-4 Axial

ADDITIONAL ADVANTAGES
- Cost-efficient basic version
- Integrated mandrel evacuation for disposal of the spent mandrel

TOOL	No.
TAURUS® 1 Axial eco	**145 7676**
TAURUS® 2 Axial eco	**145 7798**
TAURUS® 3 Axial eco	**145 7898**
TAURUS® 4 Axial eco	**145 7980**
TAURUS® 1 Axial eco with spring-loaded trigger system	**145 7677**
TAURUS® 2 Axial eco with spring-loaded trigger system	**145 7799**
TAURUS® 3 Axial eco with spring-loaded trigger system	**145 7899**
TAURUS® 4 Axial eco with spring-loaded trigger system	**145 7981**

TAURUS® 1-4 C AV - with integrated setting process monitoring

TAURUS® 1-4 C AV

TAURUS® C 1-4 (with setting process monitoring)

Setting process monitoring is achieved by direct real-time analysis of traction force and traction course recorded during the setting of the rivet. All system components necessary for this operation are integrated in the tools. Analysing a setting process takes less than 1 µs.The results are directly shown by a green or red LED installed in the tool base and optionally by an acoustic signal. In addition to this individual analysis the system also provides collective analysis for the complete workpiece. The tool stores more than 260,000 setting process data which can be retrieved at any time. The system also identifies failure patterns and memorizes them for failure analysis and troubleshooting. The tools can be operated as stand-alone devices or as integrated part of a customer´s production system via the GESIPA® interface.

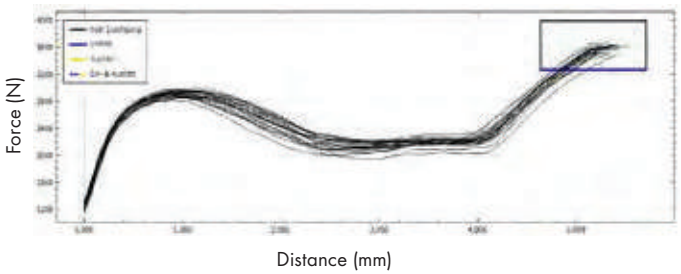
GESIPA®-INTERFACE 4.0

The GESIPA-Interface has been developed in-house at GESIPA® based on an embedded PC system. It features 16 digital inputs and outputs for communication with a PLC. Other new features compared to the Interface 2.0 are:

- 2 x Ethernet interfaces, router functions
- 1 x USB and 1 x USB-OTG
- Screen connection, graphic output via DVI
- Wi-Fi, as access point and as client, Wi-Fi router function
- Local OLED display to show status and error messages
- M.2 SSD interface, the module can be retrofitted with an SSD (large databases)
- PCIe connector for Hilscher netJACK modules (i.e. direct connection to industrial buses such as PROFINET, SERCOS and EtherCAT possible)

HIGH-GRADE GESIPA® BLIND RIVET WITH MINIMAL SCATTER:

- Minimal scatter of the graphs
- All graphs end in the break-off window
- 20x OK riveting



WinTech – multi-window technology with up to three assessment windows

TAURUS® WINTECH

Ideal for demanding joining technology used for safety components such as in the aviation industry. The basis for monitoring the WinTech setting process is the tried and tested TAURUS® C. The setting process is evaluated with the aid of position and force sensors as well as integrated electronic circuitry. Up to three evaluation windows can be configured with special setup software. A coloured LED on the tool shows the result of setting process monitoring. With a data line, the values can also be recorded and further processed.

Consultation, price and delivery time on request

APPLICATION

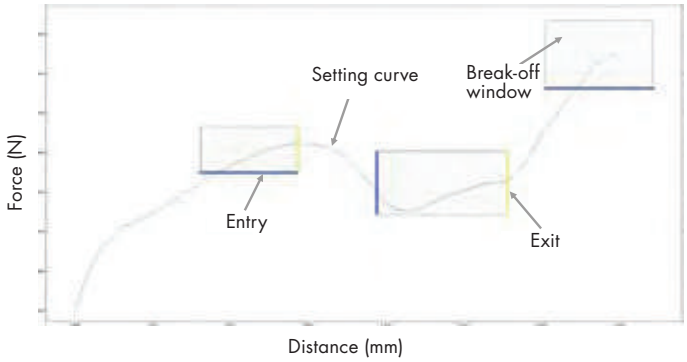
In the production of critical components as well as in automatic setting processes, the TAURUS® C can facilitate monitoring and documentation of the results.

ADVANTAGES

- High process reliability
- Documentation of each individual setting operation
- Less scrap as faults are detected immediately
- Avoidance of additional costs/quality costs due to NOK parts
- The customer can configure how to enter and exit the assessment window
- Flush-break rivets (MEGA GRIP®) can also be monitored

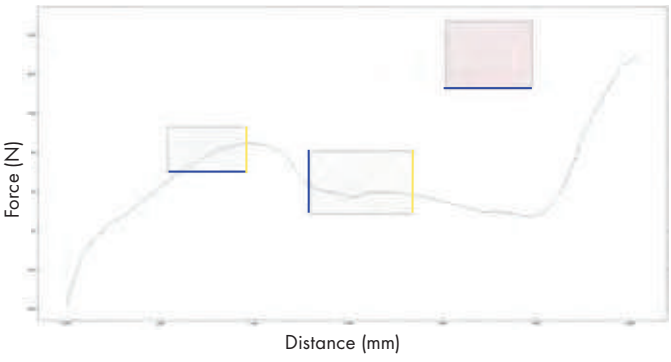
EXAMPLE OF OK PROCESS

Window entry and exit at customer-defined positions



EXAMPLE OF NOT OK PROCESS

Material to be joined too thin due to missing compo-



VIDEO

The whole TAURUS® series with remote pressure transducer – for even more flexibility, versatility and ergonomy

TAUREX 1-6

Now with even more flexible hose

COMMON TECHNICAL DATA

Operating air pressure:	5 to 7 bar
Air hose connection:	6 mm (1/4“)
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²

WORKING RANGE

- All blind rivets and lockbolts up to a mandrel
- breaking force of 50 kN
- Same performance and technical characteristics as the respective individual units in the TAURUS® series 1-4, 5-6 with different stroke
- 3 metres hose length between pressure transducer and setting pistol

ADVANTAGES

- Low weight of the hand held tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side:
- No oil leak and no air bleeding
- Ideally suited for setting of blind rivets and lockbolts in poorly accessible locations
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Can be combined with almost all supplements and options of the TAURUS® series: head extensions, mandrel containers, rivet counting units, process control, pressure trigger and remote control

TOOL	No.
TAUREX 1	**145 8025**
TAUREX 2	**145 8031**
TAUREX 3	**145 8044**
TAUREX 4	**145 8058**
TAUREX 5*	**145 8060**
TAUREX 6*	**145 8062**

*TAUREX 5 and 6 tools must be equipped with heads that are specially designed for their application field. Production on request.

The TAURUS® series 1-4 with remote mounted pressure transducer in axial version – making it more flexible, versatile and ergonomic

TAUREX 1-4 AXIAL

TECHNICAL DATA

Operating air pressure:	5 to 7 bar
Air hose connection:	6 mm (1/4“)
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²
Weight:	
TAUREX 1 Axial	2.4 kg
TAUREX 2 Axial	2.7 kg
TAUREX 3 Axial	3.0 kg
TAUREX 4 Axial	3.1 kg

APPLICATIONS

The TAUREX Axial is a particular advantage in restricted spaces due to the separate pressure transducer mounted in the working direction. The special pistols of TAUREX Axial offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action.
In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAUREX Axial can be additionally supplied with a spring-loaded trigger system.
It is essential to use an external suction system with the TAUREX Axial!

A compressed air supply is additionally required for reliable mandrel evacuation. Depending on the application, this is preferably achieved via the balancer with valve or the time delay valve (see page 130).

WORKING RANGE

- Sets blind rivets up to 6.4 mm Ø all materials and up to 8 mm Ø alu (max. mandrel dia 4.5 mm)
- Same performance and technical data as the respective TAURUS® series 1-4
- 3 metre hose length between pressure transducer and setting pistol

ADVANTAGES

- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Low weight of the hand held tool
- Tubing connection with quick-connect feature (upon request) on the pressure transducer side: No oil leak and no air bleeding
- The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, spring loaded trigger system and remote control
- The handle in the rivet axle allows ergonomic work – especially in vertical applications
- Can be suspended on a balancer

TOOL	No.
TAUREX 1 Axial	**145 8026**
TAUREX 2 Axial	**145 8032**
TAUREX 3 Axial	**145 8047**
TAUREX 4 Axial	**145 1019**
TAUREX 1 Axial with spring-loaded trigger system	**145 1002**
TAUREX 2 Axial with spring-loaded trigger system	**145 8033**
TAUREX 3 Axial with spring-loaded trigger system	**145 1016**
TAUREX 4 Axial with spring-loaded trigger system	**145 1020**

The TAURUS® series 1-4 with an axial pressure transducer mounted directly on the device – for use in tight working spaces

TAUREX 1-4 AXIAL COMPACT

TECHNICAL DATA

Operating pressure:	5 to 7 bar
Air hose connection:	6 mm (1/4")
Noise emission:	max. 79 dB
Vibrations:	< 2.9 m/s²
Weight:	
TAUREX 1 Axial compact	3.1 kg
TAUREX 2 Axial compact	3.4 kg
TAUREX 3 Axial compact	3.7 kg
TAUREX 4 Axial compact	4.1 kg

APPLICATIONS

The TAUREX Axial compact is a particular advantage in enclosed spaces due to the pressure transducer mounted close and parallel to the tool's axis. The special pistols of TAUREX Axial compact offer the option of installation in production systems and simultaneously allow flexible and handheld ergonomic work in applications with restricted accessibility that require a vertical, downwards oriented riveting action. In order to ensure that no gap is left between the components to be riveted and the setting head effectively makes contact with the application, the TAUREX Axial compact can be additionally supplied with a spring-loaded trigger system (see page 130).

WORKING RANGE

Processing blind rivets up to 6.4 Ø all materials and up to 8 mm Ø alu (max. mandrel dia. 4.5 mm)
Same performance and technical data as the respective individual units in the TAURUS® series 1-4

ADVANTAGES

- Pressure transducer attached in a space-saving manner directly to the device, i.e. also for applications in tight spaces
- Technical design close to the TAUREX Axial
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- The tool can be equipped with almost all TAURUS® series options: e.g. extension units, blind rivet counter, springloaded trigger system and remote control
- The handle in the rivet axis allows ergonomic work – especially in vertical applications.
- Can be suspended on a balancer

TOOL	No.
TAUREX 1 Axial compact	**145 1003**
TAUREX 2 Axial compact	**145 8034**
TAUREX 3 Axial compact	**145 8048**
TAUREX 4 Axial compact	**145 8059**
TAUREX 1 Axial compact with spring-loaded trigger system	**145 8027**
TAUREX 2 Axial compact with spring-loaded trigger system	**145 8035**
TAUREX 3 Axial compact with spring-loaded trigger system	**145 8049**
TAUREX 4 Axial compact with spring-loaded trigger system	**145 1022**

TAURUS® 1-4 WITH SPRING-LOADED TRIGGER SYSTEM

The spring-loaded trigger system ensures that the components which are to be riveted are reliably placed one on top of the other gapfree prior to the riveting process. Furthermore, this ensures that the blind rivet reaches its end position in the bore prior to the setting process and that the setting head is in the right position.
The pressure force can be variably applied depending on the application.
The spring-loaded trigger system cannot be retrofitted but is supplied completely attached.

TAURUS® 1 with spring-loaded trigger system
No. 145 7680

TAURUS® 2 with spring-loaded trigger system
No. 145 7778

TAURUS® 3 with spring-loaded trigger system
No. 143 5869

TAURUS® 4 with spring-loaded trigger system
No. 145 7965

New feature:
Adjustable range from 15 to 75 N / Guaranteed easy-to-apply contact / force by use of springs

TAURUS® 1-4 WITH PH2000 SPENT MANDREL CONTAINER

The fixed mounted, large PH 2000 mandrel container is very sturdy and particularly suited to long mandrels from 50 to 70 mm in length. The container fits all TAURUS® versions 1 to 4.

TAURUS® 1 with PH 2000 spent mandrel container
No. 145 7669

TAURUS® 2 with PH 2000 spent mandrel container
No. 145 7780

TAURUS® 3 with PH 2000 spent mandrel container
No. 145 7878

TAURUS® 4 with PH 2000 spent mandrel container
No. 145 7970

113 You will find the corresponding conversion kits on **page 113**

TAURUS® TOOLS FOR STATIONARY USE IN PRODUCTION SYSTEMS

The TAURUS® tools can be integrated as stationary units in automatic production systems and operated by remote control, if required. As an option, a low-pressure connection can be used to detect the blind rivet in the nosepiece.

If required, the spent mandrel can be disposed of by means of an evacuation tube and also monitored by a sensor. In stationary production systems, several tools can be operated automatically and in parallel in order to achieve the highest possible level of efficiency.

PH 2

Hydro-pneumatic blind rivet setting tool

No. 145 6771

TECHNICAL DATA

Weight:	1.3 kg
Operating air pressure:	5 - 7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	1.2 - 1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	8,800 N at 6 bar
Stroke:	15 mm

WORKING RANGE

Blind rivets from 3 up to 5 mm Ø all materials and blind rivets with 2.4 mm up to 3.2mm Ø with small jaws (page 155). **Not suitable for stainless steel CAP® blind rivets**.

SCOPE OF DELIVERY

Nosepieces: 16/24, 16/27, 16/29, 16/32 and 16/36
1 set of jaws, 1 spent mandrel bottle,
1 wrench each of MSU and MSZ,
Maintenance instructions with spare parts list

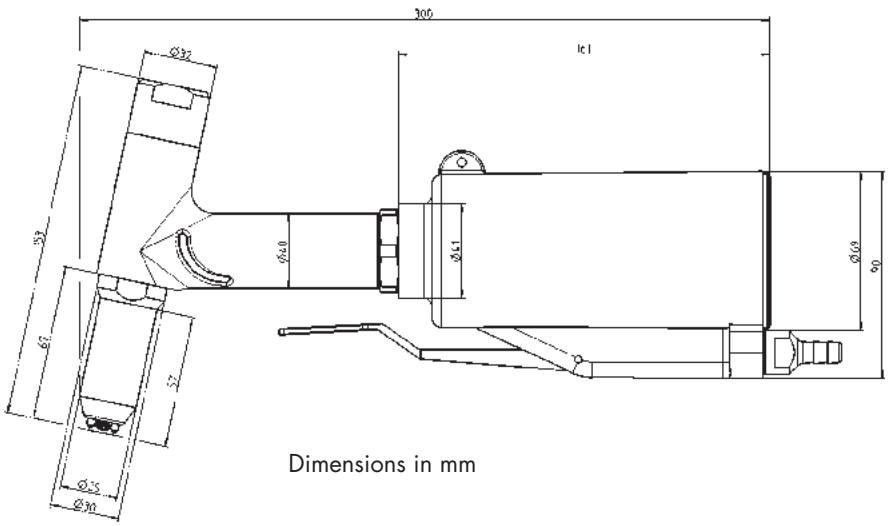
ADVANTAGES

- Hydraulic head made of aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Pistons: Steel hardened and chrome-plated – smooth operation and wear-proof
- Compact seals are wear-proof for a long service life
- Fast venting valve for fast return and high working sequence
- Low-noise pneumatic switching
- Simple, low-interruption valve design
- Hydraulic head can be adjusted by 360°
- Favourable centre of gravity and handle design for fatigue-free handling

JAWS (3 PARTS)

for PH 2 and PH 2000

No. 143 4103



Dimensions in mm

PH 2-VK

Hydro-pneumatic blind rivet setting tool

No. 145 6774

TECHNICAL DATA

Weight:	1.3 kg
Operating air pressure:	5 - 7 bar
Air hose connection:	6 mm Ø (1/4'')
Air consumption:	1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	6,200 N at 6 bar
Stroke:	14 mm

WORKING RANGE
Blind rivets up to 4 mm Ø alu, steel and copper

SCOPE OF DELIVERY
Nosepieces: 10/18, 10/24 and 10/27
1spent mandrel bottle,
1 maintenance wrench of MSU and MSZ,
maintenance instructions with spare parts list

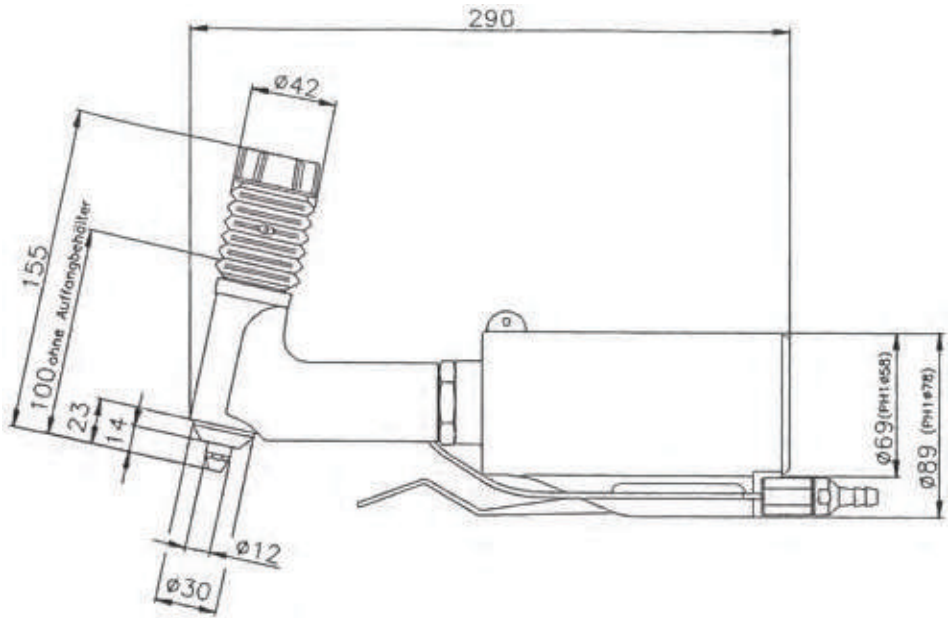
JAWS (2 PARTS)
for PH 2-VK

No. 143 4071

VK: Shorter version of the pistol head for difficult to access rivets

ADVANTAGES

- Due to the shortened gun head, the PH2-VK is ideal for difficult-to-access areas/riveting points

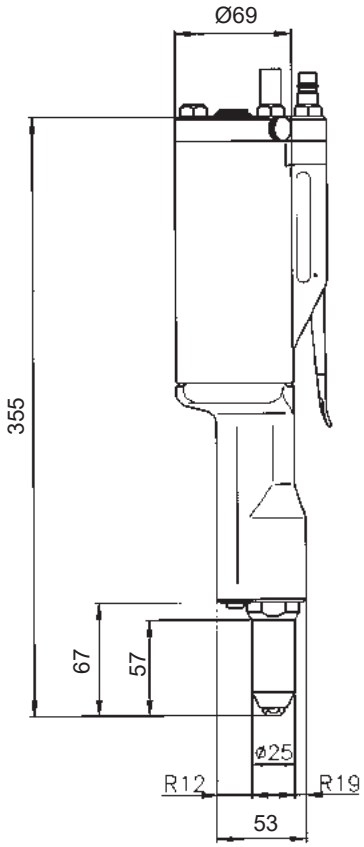


Dimensions in mm

PH AXIAL

Hydro-pneumatic blind rivet setting tool

No. 145 8063



Dimensions in mm

TECHNICAL DATA

Weight:	1.8 kg
Operating air pressure:	5 - 7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	1.2-1.8 ltr. per rivet (0.3 ltr. compr. air)
Traction power:	8,800 N at 6 bar
Stroke:	15 mm

WORKING RANGE

Blind rivets from 4 up to 5 mm Ø steel and 2.4 up to 3.2 mm Ø with small jaw assemly (page 132).

SCOPE OF DELIVERY

Nosepieces: 16/24, 16/27, 16/29 and 16/32
Jaw pusher with reducing tube no.125 for 4 mm Ø blind rivets in alu and copper
Ejection tube with socket for spent mandrels
Maintenance instructions and spare parts list

JAWS (3 PARTS) for PH Axial

No. 143 4103

ADVANTAGES

- Pneumatic cylinder and hydraulic head with jaw mechanism arranged axially behind each other: simple and easy handling when used vertically (e.g. desktop assembly points)
- Integrated blind rivet suction and rivet mandrel ejection system: does not need to be retrofitted, secure disposal of the spent mandrels in a central container via a hose
- Hydraulic head in aluminium with wear-proof cylinder surface
- Pneumatic cylinder made of die cast aluminium
- Working piston made of hardened and hard chromium plated steel macke the device easy to handle and wear-proof
- Compact seals are wear-proof with large scraper effect, long service life
- Fast venting system: faster return; high work sequence
- Low-noise pneumatic switching
- Simple valve structure: interruption free

HEAD MODULES FOR TAURUS® 5-6 AND TAUREX 5-6

Adaption takes priority
The TAURUS® 5 and 6 riveting tools must be adapted to the different kinds of rivets and lockbolts through specific pulling head modules

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!

Head module for 7.8 mm Titgemeyer TIBULB*

No. 145 8008

Head module for 9.8 mm Huck Magna-Lok®*

No. 145 8009

* partly registered trademarks of TITGEMEYER GmbH & Co. KG or Alcoa Fastening Systems

Other head modules on request.

BALANCER AND TIME DELAY VALVE

for all TAURUS® 1-4-Axial- and TAUREX 1-4-Axial tools

To cover various requirements, two balancer models for suspending the TAURUS® Axial tools are available. If the tube for evacuating the spent mandrel can be kept very short, no external mandrel evacuation assistance is necessary which means a balancer without valve is sufficient.

However, if due to the tube length external evacuation assistance of the mandrel becomes necessary it can be switched on and off by means of the valve balancer in order to save cost-intensive compressed air.

Balancer without valve

No. 143 4734

BALANCER WITH DISCONNECTING VALVE

The balancer with disconnecting valve is used when the blind rivet is to be inserted into the tool. In this case the valve interrupts the compressed air necessary to generate negative pressure when in its highest position.

Balancer with disconnecting valveil

No. 145 7733

SPECIAL ACCESSORIES TAURUS®/TAUREX versions/PH tools

TIME DELAY VALVE
The time delay valve on the other hand is used when the blind rivet is to be inserted into the part. During the rivet setting procedure, the valve activates the compressed air required to create a vacuum and shuts it off after a set time.

Time delay valve
No. 145 0893

INTERFACE 4.0 FOR CONNECTION TO EXTERNAL CONTROLLERS
The new communication interface between GESIPA® tools and production

No. 163 4326

SMALL JAW ASSEMBLY FOR PH 2, PH 2000 AND PH-AXIAL

With reduced head diameter (18 mm) and 2 part jaws.

WORKING RANGE
up to 4 mm Ø stainless steel and 5 mm Ø alu

SCOPE OF SUPPLY
Standard: nosepiece 10/24 (optional also with nosepiece 10/18.10/27, 10/29, 10/32)

PH 2
No. 145 6783

PH 2000
No. 143 4234

PH Axial
No. 145 8075

MULTI-PIECE EXTENSION UNITS

For riveted joints in low-lying places. Screwed in between the device and the existing steel case

Total length = steel head sleeve + extension + standard nosepiece

PH tools
The total length of the steel head sleeve, including the extension unit, is 157 mm for 100 mm.

TOOL	100 mm
PH 2	145 6779
PH 2000	145 6765

UNIVERSAL NOSEPIECE – 16

for blind rivet tools HN 2, PH 2, PH 2000

The universal nosepiece replaces five nosepiece sizes. The integrated rotary star in the steel sleeve can be unlocked easily without tools in order to select the appropriate size of nosepiece.

No. 145 6776

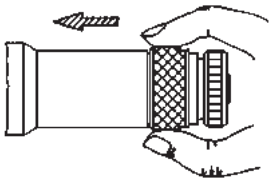
WORKING RANGE

Blind rivets from 2.4 up to 5 mm Ø alu, copper and steel and up to 4 mm Ø stainless steel.

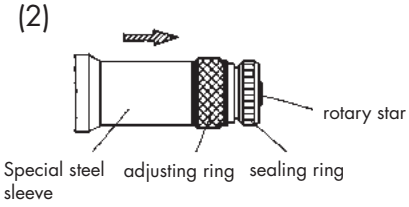
OPERATION

Operate the tool and hold trigger, then push back adjusting ring to end position (1).
By turning the rotary star (2).

(1)



(2)



The universal nosepiece includes: Special steel sleeve, complete adjusting ring, rotary star and sealing ring.

VAS

Vacuum absorption system for PH2

No. 145 7579

This device absorbs the spent mandrel after the riveting operation and transports it automatically into the mandrel container. A further advantage is offered when the rivet, inserted into the nosepiece, is held in the jaw mechanism even if the tool head is in the vertical downwards position. The vacuum absorption device is available as a complete built-in and can also be retrofitted to existing GESIPA® riveting power tools at any time.

TECHNICAL DATA

Weight of kit:	430 g
Operating air pressure:	4-6 bar

SCOPE OF DELIVERY

1 air deflector
1 wrench MSU
Maintenance instructions with spare parts list

OFFSET HEAD FOR PH2

For setting rivets in places with difficult access and in corners

Offset head for PH2 with 3 part jaws

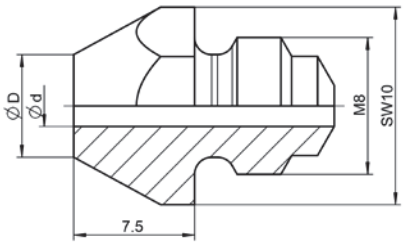
No. 145 6612

NOSEPIECES STANDARD + SPECIAL LENGTH

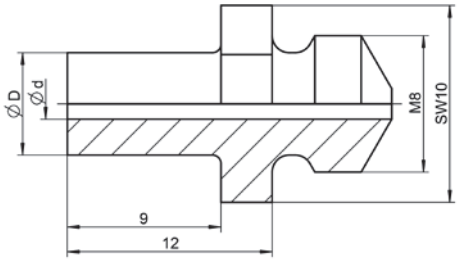
NTS, NTX, NTX-F, Flipper®, SN 1, PH 1, PH 2-VK

Ø	Material	Ø d	Ø D	Standard	No.	V (9mm)	No.
2.4	Alu	1.6	6.0	10/16	**143 4054**		
2.4	Alu	1.8	6.0	10/18	**143 4055**	V-10/18	**143 4096**
3.2	CAP®-Alu, CAP®-Copper	1.8	6.0	10/18	**143 4055**	V-10/18	**143 4096**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.0	10/24	**143 4061**	V-10/24	**143 4097**
4	Alu, Cu	2.4	6.0	10/24	**143 4061**	V-10/24	**143 4097**
4	Steel, CAP®-Alu, CAP®-Cu, Alu/Alu, PG-Alu	2.7	6.0	10/27	**143 4062**	V-10/27	**143 4098**
4	Stainless steel, Stinox, PG-Steel	2.9	8.0	10/29	**143 4064**	V-10/29	**143 4099**
4.8	CAP®-Alu, CAP®-Cu	2.9	8.0	10/29	**143 4064**	V-10/29	**143 4099**
4.8 and 5	Alu, PG-Alu	3.2	8.0	10/32	**143 4065**	V-10/32	**143 4100**
4	Plastic	3.0	-	10/30 K	**143 4092**	-	**-**
5	Plastic	3.5	-	10/35 K	**143 4093**	-	**-**
6	Plastic	4.0	-	10/40 K	**143 4094**	-	**-**

Standard version
10/..... Nosepieces



Extended version (9mm)
V-10/.....Nosepieces



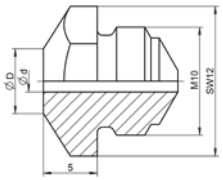
The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

NOSEPIECES STANDARD

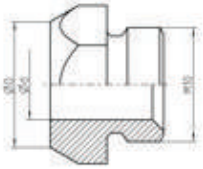
Flipper® Plus

Ø	Material	Ø d	Ø D	Standard	No.
2.4	Alu	2.0	6.0	12/20	**157 2920**
3.2	CAP®-Alu, CAP®-Cu	2.0	6.0	12/20	**157 2920**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu, PG-Alu, PG-Steel	2.4	6.0	12/24	**157 2924**
4	Alu, Cu	2.4	6.0	12/24	**157 2924**
4	Steel, CAP®-Alu, CAP®-Cu, Alu,	2.4	6.0	12/24	**157 2924**
4	Stainless steel, Stinox, PG-Steel	2.9	8.0	12/29	**157 2925**
4.8	CAP®-Alu, CAP®-Cu	2.9	8.0	12/29	**157 2925**
4.8 and 5	Alu, PG-Alu	3.2	8.0	12/32	**161 8800**
4.8 and 5	Steel, Alu	3.2	8.0	12/32	**161 8800**
BLIND RIVET NUTS					
M4	Alu, Steel	4.15	11.0	12/M4	**157 2926**
M5	Alu, Steel, PG-Alu, PG-Steel	5.15	11.0	12/M5	**157 2927**
M6	Alu, PG-Alu	6.15	11.0	12/M6	**157 2929**

Standard version
12/..... Nosepieces



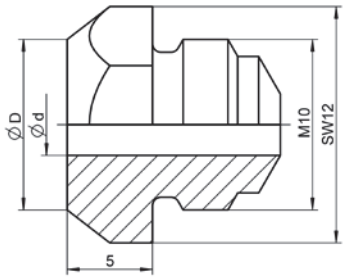
Standard version BRN
12/M..... Nosepieces



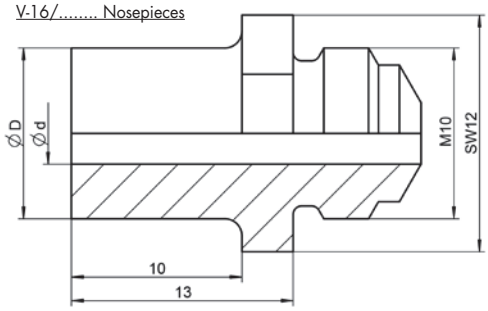
NOSEPIECES STANDARD + SPECIAL LENGTH HN 2, PH 1, PH 2, PH 2-VK, PH Axial, PH 2000

Ø	Material	Ø d	Ø D	Standard	No.	V (10 mm)	No.
2.4	Alu	1.8	**6.0**	16/18	**143 4285**	V-16/18	**143 4370**
3.2	CAP®-Alu, CAP® Copper	1.8	**6.0**	16/18	**143 4285**	V-16/18	**143 4370**
3	Alu/Cu	2.0	**6.0**	16/20	**143 4287**	V-16/20	**143 4371**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	**6.0**	16/24	**143 4288**	V-16/24	**143 4372**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	**6.0**	16/24	**143 4288**	V-16/24	**143 4372**
4	Steel, Alu/Alu, PG-Alu	2.7	**8.0**	16/27	**143 4289**	V-16/27	**143 4373**
4	Stainless steel, Stinox, PG-Steel	3.0	**8.0**	16/29	**143 4290**	V-16/29	**143 4374**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	**8.0**	16/29	**143 4290**	V-16/29	**143 4374**
4.8 and 5	Steel, Alu/Alu	3.35	**8.0**	16/32	**143 4291**	V-16/32	**143 4375**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	**10.0**	16/36	**143 4292**	V-16/36	**143 4376**
6	Alu	3.6	**10.0**	16/36	**143 4292**	V-16/36	**143 4376**
6	Steel	4.0	**10.0**	16/40	**143 4293**	V-16/40	**143 4369**
6.4	Alu, PG-Alu	4.0	**10.0**	16/40	**143 4293**	V-16/40	**143 4369**
6.4	Steel, Alu/Alu	4.5	**10.0**	16/45	**143 4300**	V-16/45	**143 4378**
4	Plastic	3.0	-	16/30 K	**143 4130**		
5	Plastic	3.5	-	16/35 K	**143 4131**		
6	Plastic	4.0	-	16/40 K	**143 4132**		

Standard version
16/..... Nosepieces

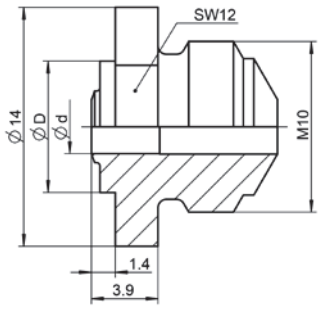


Extended version (10 mm)
V-16/..... Nosepieces



MEGA GRIP® / Monobolt®

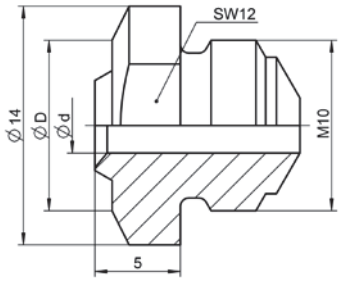
Ø	Material	Ø d	Ø D	Designation	No.
4.8	all MEGA GRIP®	3.1	8.0	16/31 MG	**143 4380**
6.4	all MEGA GRIP®	4.2	10.0	16/41 MG	**143 4381**
4.8	Monobolt®	3.15	7.7	16/31 MB	**143 4379**
6.4	Monobolt®	4.2	9.5	16/42 MB	**143 4163**



The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!

BULB-TITE®

Ø	Material	Ø d	Ø D	Designation	No.
4	all BULB-TITE®	2.64	8.0	16/26 BT	**143 4301**
5.2	all BULB-TITE®	3.23	10.0	16/32 BT	**143 4302**
6.3	all BULB-TITE®	4.2	11.0	16/42 BT	**143 4303**
7.7	all BULB-TITE®	4.8	10.0	16/48 BT	**143 4304**



NOSEPIECES STANDARD + SPECIAL LENGTH

SN2, AccuBird®, AccuBird® Pro, PowerBird®, PowerBird® Pro, PowerBird® Pro Gold Edition, TAURUS®

Ø	Material	Ø d	Ø D	Standard	No.	V (8mm)	No.
2.4	Alu	1.6	6.0	17/16	**143 4972**	-	-
2.4	Alu	1.8	6.0	17/18	**143 4976**	V-17/18	**143 4979**
3.2	CAP®-Alu, CAP® Copper	1.8	6.0	17/18	**143 4976**	V-17/18	**143 4979**
3	Alu/Cu	2.0	6.0	17/20	**143 4994**	V-17/20	**145 7315**
3	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu	2.2	6.0	17/22	**143 5018**	V-17/22	**145 7323**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Stahl	2.4	6.0	17/24	**143 4955**	V-17/24	**143 4980**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	6.0	17/24	**143 4955**	V-17/24	**143 4980**
4	Steel, Alu/Alu, PG-Alu	2.7	8.0	17/27	**143 4973**	V-17/27	**143 4981**
4	Stainless steel, Stinox, PG-Steel	3.0	8.0	17/29	**143 4974**	V-17/29	**143 4982**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	8.0	17/29	**143 4974**	V-17/29	**143 4982**
4.8 and 5	Steel, Alu/Alu	3.35	8.0	17/32	**143 4975**	V-17/32	**143 4983**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	10.0	17/36	**143 4977**	V-17/36	**143 4984**
6	Alu	3.6	10.0	17/36	**143 4977**	V-17/36	**143 4984**
6	Steel	4.0	10.0	17/40	**143 4999**	V-17/40	**143 5038**
6.4	Alu, PG-Alu	4.0	10.0	17/40	**143 4999**	V-17/40	**143 5038**
6.4	Steel, Alu/Alu	4.5	10.0	17/45	**143 4860**	V-17/45	**143 4866**
4	Plastic	3.0	-	17/30 K	**143 4933**	-	-
5	Plastic	3.5	-	17/35 K	**143 5824**	-	-
6	Plastic	4.0	-	17/40 K	**143 4998**	-	-

MEGA GRIP® / Monobolt®

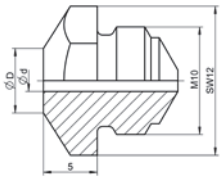
4.8	all MEGA GRIP®	3.1	8.0	17/31 MG	**143 4993**
6.4	all MEGA GRIP®	4.2	10.0	17/41 MG	**143 4865**
4.8	Monobolt®	3.1	8.0	17/31 MB	**143 4868**
6.4	Monobolt®	4.2	9.5	17/42 MB	**143 4869**

BULB-TITE®

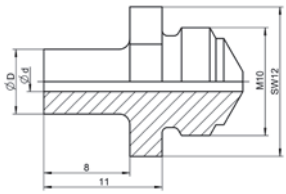
4	all BULB-TITE®	2.64	8.0	17/26 BT	**143 4985**
5.2	all BULB-TITE®	3.23	10.0	17/32 BT	**143 4986**
6.3	all BULB-TITE®	4.2	11.0	17/42 BT	**143 4988**
7.7	all BULB-TITE®	4.8	10.0	17/48 BT	**143 4989**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

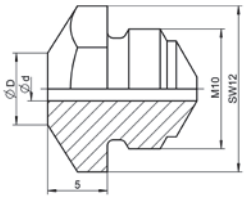
Standard version
17/.....Nosepieces



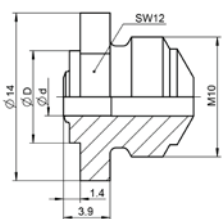
Extended version (8 mm)
V-17/.....Nosepieces



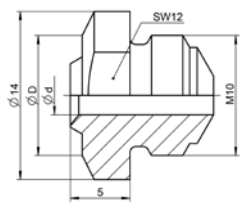
Special version
17/.....MG Nosepieces



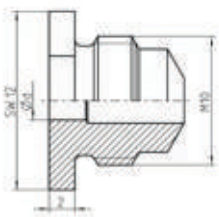
Special version
17/.....MB Nosepieces



Special version
17/.....BT Nosepieces



Special version
17/.....Plastic Nosepieces

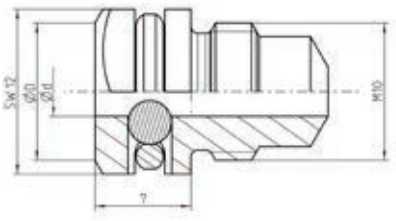


The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!

RETAINING NOSEPIECES

for SN 2, AccuBird®, AccuBird® Pro, PowerBird®, PowerBird® Pro, PowerBird® Pro Gold Edition

Ø	Material	Ø d	Designation	No.
2.4	Alu	1.85	17/18 R	**165 5422**
3.2	CAP®-Alu, CAP® Copper	1.85	17/18 R	**165 5422**
3	Alu/Cu Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu	2.0	17/20 R	**165 5424**
3	Alu, Cu, Steel, Stainless steel, Stinox	2.2	17/22 R	**165 5426**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	17/24 R	**165 5427**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	17/24 R	**165 5427**
4	Steel, Alu/Alu, PG-Alu	2.7	17/27 R	**165 5428**
4	Stainless steel, Stinox, PG-Steel	2.9	17/29 R	**165 5429**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	2.9	17/29 R	**165 5429**
4.8 and 5	Steel, Alu/Alu	3.2	17/32 R	**165 5430**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	17/36 R	**165 5431**
6	Alu	3.6	17/36 R	**165 5431**
6	Steel	4.0	17/40 R*	**165 5433**
6.4	Alu, PG-Alu	4.0	17/40 R*	**165 5433**
6.4	Steel, Alu/Alu	4.5	17/45 R*	**165 5434**

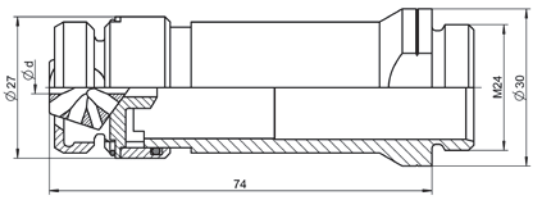


*Except AccuBird® and AccuBird® Pro

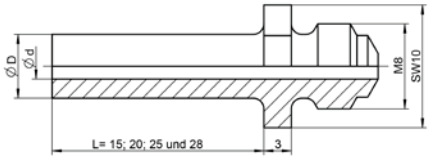
UNIVERSAL NOSEPIECE

HN2, SN 2, PH 1, PH 2, PH 2000, AccuBird®, PowerBird®

Ø	Material	Ø d	HN 2, SN 2, PH 1, PH 2, PH 2000	Bird® series
2.4	Alu	1.8	**No. 145 6776**	**No. 143 4960**
3.2	CAP®-Alu, CAP® Copper	1.8		
3 and 3.2	Alu, Cu, Stahl, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4		
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4		
4	Steel, Alu/Alu, PG-Alu	2.7		
4	Stainless steel, Stinox, PG-Steel	2.9		
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	2.9		
4.8 and 5	Steel, Alu/Alu			

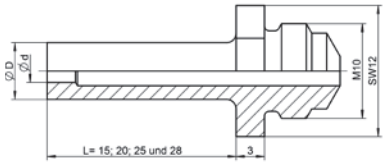


SPECIAL NOSEPIECES



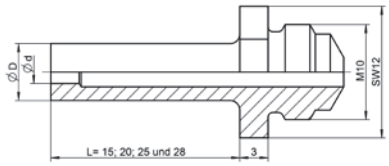
NTS, NTX, NTX-F, Flipper®, PH 1, PH 2-VK

Ø	Material	Ø d	Ø D	Designation	15 mm	20 mm	25 mm	28 mm
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.5	10/24 SL...	**145 6631**	**145 6630**	**145 6632**	**145 6633**
4	Alu, Cu	2.4	6.5	10/24 SL...	**145 6631**	**145 6630**	**145 6632**	**145 6633**
4	Steel, CAP®-Alu, CAP®-Cu, Alu/Alu, PG-Alu	2.7	7.0	10/27 SL...	**145 6634**	**145 6635**	**145 6636**	**145 6637**
4	Stainless steel, Stinox, PG-Steel	2.9	8.0	10/29 SL...	**145 6638**	**145 6639**	**146 4001**	**145 6640**
4.8	CAP®-Alu, CAP®-Cu	2.9	8.0	10/29 SL...	**145 6638**	**145 6639**	**146 4001**	**145 6640**
4.8 and 5	Alu, PG-Alu	3.2	8.0	10/32 SL...	**145 6641**	**145 6642**	**145 6643**	**145 6644**



HN 2, PH 1, PH 2, PH 2-VK, PH Axial, PH 2000

Ø	Material	Ø d	Ø D	Designation	15 mm	20 mm	25 mm	28 mm
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.0	16/24 SL...	**145 6812**	**145 6813**	**145 6814**	**145 6815**
4	Alu, Cu	2.4	6.0	16/24 SL...	**145 6812**	**145 6813**	**145 6814**	**145 6815**
4	Steel, PG-Alu	2.7	8.0	16/27 SL...	**145 6816**	**145 6817**	**145 6818**	**145 6819**
4	Stainless steel, Stinox, PG-Steel	3.0	8.0	16/29 SL...	**145 6820**	**145 6821**	**145 6822**	**145 6823**
4.8 and 5	Alu, PG-Alu	3.0	8.0	16/29 SL...	**145 6820**	**145 6821**	**145 6822**	**145 6823**
4.8 and 5	Steel	3.35	8.0	16/32 SL...	**145 6824**	**145 6825**	**145 6826**	-
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	10.0	16/36 SL...	**145 6828**	**145 6829**	-	**145 6830**
6	Alu	3.6	10.0	16/36 SL...	**145 6828**	**145 6829**	-	**145 6830**
6.4	Alu, PG-Alu	4.0	10.0	16/40 SL...	**145 6807**	**145 6808**	-	-
6.4	Steel, Alu/Alu	4.5	10.0	16/45 SL...	**145 6805**	**145 6806**	-	-



SN2, AccuBird®, AccuBird® Pro, PowerBird®, PowerBird® Pro Gold Edition, TAURUS®

Ø	Material	Ø d	Ø D	Designation	15 mm	20 mm	25 mm	28 mm
2.4	Alu	1.8	6.0	17/18 SL...	**145 7367**	**145 7368**	**146 4039**	**146 4040**
3.2	CAP®-Alu, CAP® Copper	1.8	6.0	17/18 SL...	**145 7367**	**145 7368**	**146 4039**	**146 4040**
3	Alu/Cu	2.0	6.0	17/20 SL...	**145 7314**	**145 7305**	**146 4041**	**145 7369**
3	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu	2.2	6.0	17/22 SL...	**145 7351**	-	**145 7349**	**145 0668**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.0	17/24 SL...	**145 7370**	**145 7371**	**145 7372**	**145 7373**
4	Alu, Cu	2.4	6.0	17/24 SL...	**145 7370**	**145 7371**	**145 7372**	**145 7373**
4	Steel, PG-Alu	2.7	8.0	17/27 SL...	**145 7374**	**145 7376**	**145 7377**	**143 5035**
4	Stainless steel, Stinox, PG-Steel	3.0	8.0	17/29 SL...	**145 7378**	**145 7379**	**145 7381**	**145 7382**
4.8 and 5	Alu, PG-Alu	3.0	8.0	17/29 SL...	**145 7378**	**145 7379**	**145 7381**	**145 7382**
4.8 and 5	Steel	3.35	8.0	17/32 SL...	**145 7383**	**145 7385**	**145 7386**	**145 7388**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	10.0	17/36 SL...	**145 7390**	**145 7392**	**145 7393**	**145 7394**
6	Alu/Alu	3.6	10.0	17/36 SL...	**145 7390**	**145 7392**	**145 7393**	**145 7394**
6	Steel	4.0	10.0	17/40 SL...	**145 7399**	**145 7400**	**145 7401**	**145 7402**
6.4	Alu, Stainless steel, PG-Alu, PG-Steel und G-Bulb	4.5	10.0	17/45 SL...	**145 7265**	**145 0673**	**145 7404**	**145 7398**

CAUTION!
Blind rivets must be ordered as a custom-made product with extended mandrel!

DELIVERY TIMES ON REQUEST!

PLATE NOSEPIECES P WITHOUT CUT-OUT

for SN2, HN 2, PH 1, PH 2, PH Axial, PH 2000, Bird series, Bird Pro series, TAURUS®

Ø	Material	Ø d	Designation	HN 2, PH 1, PH 2, PH Axial, PH 2000 No.	Designation	TAURUS® Bird series Bird Pro series SN 2 No.
3 and 3.2	Alu, Cu, Stahl, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	P 16/24	**145 6649**	P 17/24	**145 7335**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	P 16/24	**145 6649**	P 17/24	**145 7335**
4	Steel, Alu/Alu, PG-Alu	2.7	P 16/27	**145 6650**	P 17/27	**145 7336**
4	Stainless steel, Stinox, PG-Steel	3.0	P 16/29	**145 6651**	P 17/29	**145 7337**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	P 16/29	**145 6651**	P 17/29	**145 7337**
4.8 and 5	Steel, Alu/Alu	3.35	P 16/32	**145 6657**	P 17/32	**145 7338**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	P 16/36	**145 6656**	P 17/36	**145 7339**
6	Alu	3.6	P 16/36	**145 6656**	P 17/36	**145 7339**

For countersunk head blind rivets

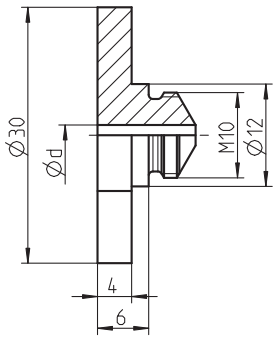
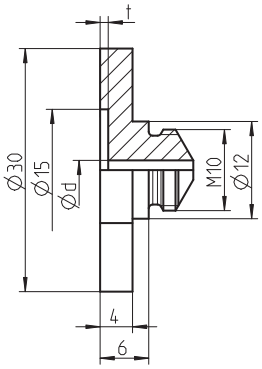


PLATE NOSEPIECE PA WITH CUT-OUT

for SN2, HN 2, PH 1, PH 2, PH Axial, PH 2000, Bird series, Bird Pro series, TAURUS®

Ø	Material	Ø d	Designation	t	HN 2, PH 1, PH 2, PH Axial, PH 2000 No.	Designation	t	TAURUS® Bird series Bird Pro series SN 2 No
3 and 3.2	Alu, Cu, Stahl, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	PA 16/24	1.0	**145 6659**	PA 17/24	1.0	**145 7330**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	PA 16/24	1.0	**145 6659**	PA 17/24	1.0	**145 7330**
4	Steel, Alu/Alu, PG-Alu	2.7	PA 16/27	1.0	**145 6660**	PA 17/27	1.0	**145 7331**
4	Stainless steel, Stinox, PG-Steel	3.0	PA 16/29	1.1	**145 6661**	PA 17/29	1.1	**145 7341**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	PA 16/29	1.1	**145 6661**	PA 17/29	1.1	**145 7341**
5	Al-large flange K 11 and K 14	3.0	PA 16/29 K	1.5	**145 6652**	PA 17/29 K	1.5	**145 7332**
4.8 and 5	Steel, Alu/Alu	3.35	PA 16/32	1.1	**145 6653**	PA 17/32	1.1	**145 7333**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	PA 16/36	1.1	**145 6662**	PA 17/36	1.1	**145 7342**
6	Alu	3.6	PA 16/36	1.3	**145 6666**	PA 17/36	1.3	**145 7334**

For standard blind rivets (dome head)

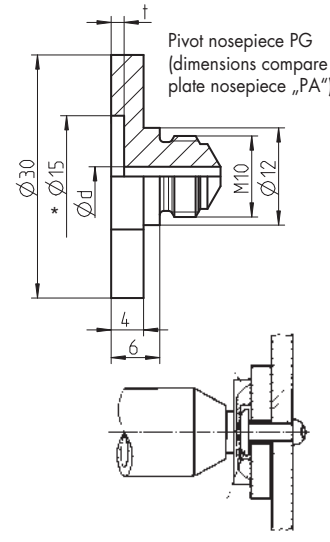


PIVOT NOSEPIECES PG (for the production of articular rivet connections)

for SN2, HN 2, PH 1, PH 2, PH Axial, PH 2000, Bird series, Bird Pro series, TAURUS®

Ø	Material	Ø d	Designation	t	HN 2, PH 1, PH 2, PH Axial, PH 2000 No.	Designation	t	TAURUS® Bird series Bird Pro series SN 2 No.
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	PG 16/24	1.6	**145 6663**	PG 17/24	1.6	**143 5002**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	PG 16/24	1.6	**145 6663**	PG 17/24	1.6	**143 5002**
4	Steel, Alu/Alu, PG-Alu	2.7	PG 16/27	1.6	**145 6664**	PG 17/27	1.6	**143 5003**
4	Stainless steel, Stinox, PG-Steel	3.0	PG 16/29	1.6	**145 6655**	PG 17/29	1.6	**143 5007**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	PG 16/29	1.6	**145 6655**	PG 17/29	1.6	**143 5007**
5	Al-large flange K 11 and K 14	3.0	PG 16/29 K	2.0	**145 6658**	PG 17/29 K	2.0	**143 5004**
5	Al-large flange K 16	3.0	-	-	**-**	PG 17/29 K16*	2.0	**143 5009**
4.8 and 5	Steel, Alu/Alu	3.35	PG 16/32	1.6	**145 6654**	PG 17/32	1.6	**143 5005**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	PG 16/36	1.6	**145 6665**	PG 17/36	1.6	**143 5006**
6	Alu	3.6	PG 16/36	2.0	**146 4002**	PG 17/36	2.0	**145 7340**

Pivot nosepiece PG (dimensions compare plate nosepiece „PA")



*Please note:
For PG 17/29 K16, the Ø is 17, not 15.

SPECIAL ACCESSORIES / NOSEPIECES Blind rivet setting tools with AV*

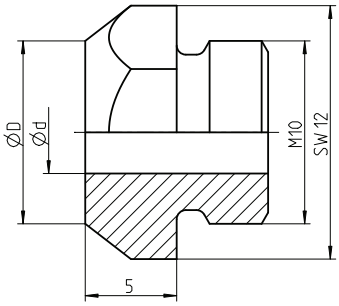
*AV = spring-loaded trigger system

NOSEPIECES FOR SETTING TOOLS WITH SPRING-LOADED TRIGGER SYSTEM STANDARD + EXTENDED VERSION Bird Pro series and TAURUS®

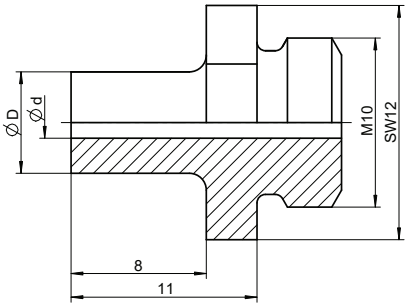
Ø	Material	Ø d	Ø D	Standard	No.	V (8mm)	No.
2.4	Alu	1.85	6.0	17/18 AV	**143 5591**	V-17/18 AV	**145 7291**
3.2	CAP®-Alu, CAP® Copper	1.85	6.0	17/18 AV	**143 5591**	V-17/18 AV	**145 7291**
3	Alu/Cu	2.0	6.0	17/20 AV	**143 4990**	V-17/20 AV	**145 0666**
3	Alu, Cu, Stahl, Stainless steel, Stinox, Alu/Alu	2.2	6.0	17/22 AV	**143 4991**	V-17/22 AV	**145 0667**
3 und 3.2	Alu, Cu, Stahl, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.0	17/24 AV	**143 5592**	V-17/24 AV	**145 7292**
4	Alu, Cu, CAP®-Alu, CAP®-Cu	2.4	6.0	17/24 AV	**143 5592**	V-17/24 AV	**145 7292**
4	Steel, Alu/Alu, PG-Alu	2.7	8.0	17/27 AV	**143 5593**	V-17/27 AV	**145 0628**
4	Stainless steel, Stinox, PG-Steel	3.0	8.5	17/29 AV	**143 5594**	V-17/29 AV	**145 0629**
4.8 and 5	Alu, CAP®-Alu, CAP®-Cu, PG-Alu	3.0	8.5	17/29 AV	**143 5594**	V-17/29 AV	**145 0629**
4.8 and 5	Steel, Alu/Alu	3.35	8.5	17/32 AV	**143 5595**	V-17/32 AV	**145 7725**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	10.0	17/36 AV	**143 5596**	V-17/36 AV	**145 0630**
6	Alu	3.6	10.0	17/36 AV	**143 5596**	V-17/36 AV	**145 0630**
6	Steel	4.0	10.0	17/40 AV	**143 5597**	V-17/40 AV	**145 7293**
6.4	Alu, PG-Alu	4.0	10.0	17/40 AV	**143 5597**	V-17/40 AV	**145 7293**
6.4	Steel, Alu/Alu	4.5	10.0	17/45 AV	**143 5598**	V-17/45 AV	**145 0631**

The name of the nosepiece (e.g. 17/32) can be found directly on the nosepiece.

Standard version
17/.....Nosepieces



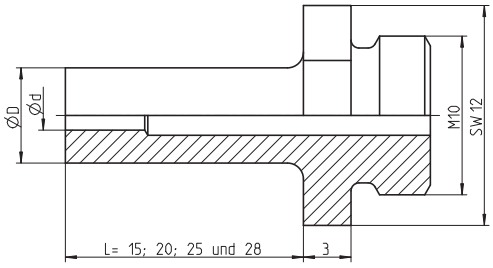
Extended version (8 mm)
V-17/.....Nosepieces



DELIVERY TIMES ON REQUEST!

NOSEPIECES EXTENDED VERSION FOR SETTING TOOLS WITH SPRING-LOADED TRIGGER SYSTEM Bird Pro series and TAURUS®

Ø	Material	Ø d	Ø D	Designation	15 mm	20 mm	25 mm	28 mm
2.4	Alu	1.85	6.0	17/18 AV SL...	**145 0634**	**145 0635**	**145 0636**	**145 0637**
3.2	CAP®-Alu, CAP® Copper	1.85	6.0	17/18 AV SL...	**145 0634**	**145 0635**	**145 0636**	**145 0637**
3	Alu/Cu	2.0	6.0	17/20 AV SL...	**145 0658**	**145 0659**	**145 0660**	**145 0661**
3	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu	2.2	6.0	17/22 AV SL...	**145 0662**	**145 0663**	**145 0664**	**145 0665**
3 and 3.2	Alu, Cu, Steel, Stainless steel, Stinox, Alu/Alu, PG-Alu, PG-Steel	2.4	6.0	17/24 AV SL...	**145 0638**	**145 7321**	**145 0639**	**145 0640**
4	Alu, Cu	2.4	6.0	17/24 AV SL...	**145 0638**	**145 7321**	**145 0639**	**145 0640**
4	Steel, PG-Alu	2.7	8.0	17/27 AV SL...	**145 0641**	**145 7322**	**145 0642**	**145 7726**
4	Stainless steel, Stinox, PG-Steel	3.1	8.0	17/29 AV SL...	**145 7324**	**145 0643**	**145 7325**	**145 0644**
4.8 and 5	Alu, PG-Alu	3.1	8.0	17/29 AV SL...	**145 7324**	**145 0643**	**145 7325**	**145 0644**
4.8 and 5	Steel	3.35	8.0	17/32 AV SL...	**145 0645**	**145 7326**	**145 0646**	**145 0647**
4.8 and 5	Stainless steel, Stinox, PG-Steel	3.6	10.0	17/36 AV SL...	**145 0648**	**145 0649**	**145 0650**	**145 0651**
6	Alu/Alu	3.6	10.0	17/36 AV SL...	**145 0648**	**145 0649**	**145 0650**	**145 0651**
6	Steel	4.0	10.0	17/40 AV SL...	**145 7327**	**145 7328**	**145 0652**	**145 0653**
6.4	Alu, Stainless steel, PG-Alu, PG-Steel and G-Bulb	4.5	10.0	17/45 AV SL...	**145 0654**	**145 0655**	**145 0656**	**145 0657**



CAUTION!
Blind rivets must be ordered as a custom-made product with extended mandrel!

DELIVERY TIMES ON REQUEST!

*AV= spring-loaded trigger system

GESIPA® AUTOMATIC RIVETING MACHINES

GESIPA® automatic riveting machines – fully-automatic, practical, reliable

GAV 8000 ECO
GAV 8000 ELECTRONIC
GAV HF

- All GESIPA® blind rivet machines are perfectly suited for use in industrial large-scale production.
- GAVs can either be operated manually or used as component in a robot-controlled system; integration into a production system is also possible.
- The automatic riveting machines support the setting of a wide range of blind rivets from 2.4 – 6.4 mm in diameter.
- Up to 40 riveting processes per minute can be realized depending of the Type of application.

THE PRACTICAL MODULAR PRINCIPLE

THE PRACTICAL MODULAR PRINCIPLE GUARANTEES EFFICIENCY AND QUALITY

Individual conception for efficiency and flexibility

GESIPA®'s fully-automatic blind rivet processing systems are constructed to meet the customer's special production environment. All factors, such as workplace design, production Type, application, securing of flawless work processes, integration into the sequential organisation and also process documentation for safety-relevant parts, are taken into consideration.

GAV are therefore available with various pistol models, hose length packages, special accessories for various rivet dimensions and production requirements.
This results in a large variety of models and a high level of efficiency thanks to the solutions that are adapted to meet requirements. The GAV can be integrated into the system or operated independently. If the application changes, the system can be quickly and easily adapted to the new environment.

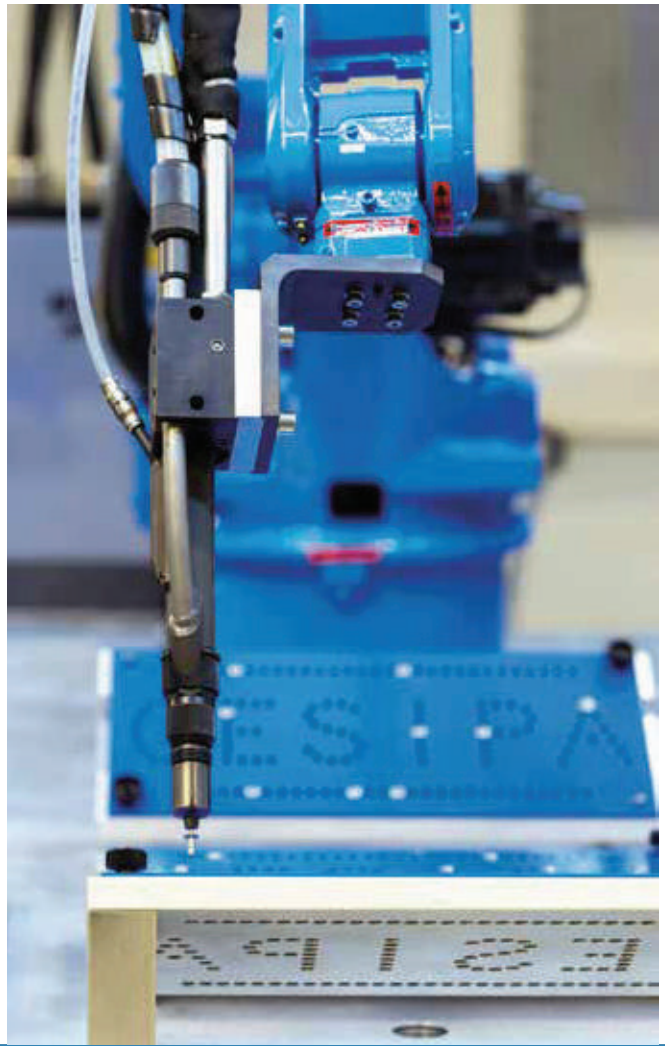
GAV – USE IN ROBOT APPLICATIONS

Use by industry in robot-controlled applications

Both versions of the GAV 8000 can be integrated into robot systems. Industrial robots are used almost everywhere in the production environment. They can be programmed to carry out various movements and can therefore be used highly efficiently in combination with the GESIPA® rivet equipment.

With the controlled, fast and secure production processes it is possible to achieve the following benefits by using a fully-automatic GAV combined with a multi-axle robot:

- **First rate precission**
- **High efficiency**
- **Short cycle times**
- **High flexibility**



BLIND RIVET FUNCTION DOCUMENTATION AND SETTING PROCESS MONITORING

THE INTEGRATED GESIPA® QUALITY MANAGEMENT SYSTEM GUARANTEES PRECISION AND ACCURACY RIGHT FROM THE VERY FIRST PRODUCTION STEP THROUGH TO THE PROCESSED BLIND RIVET.

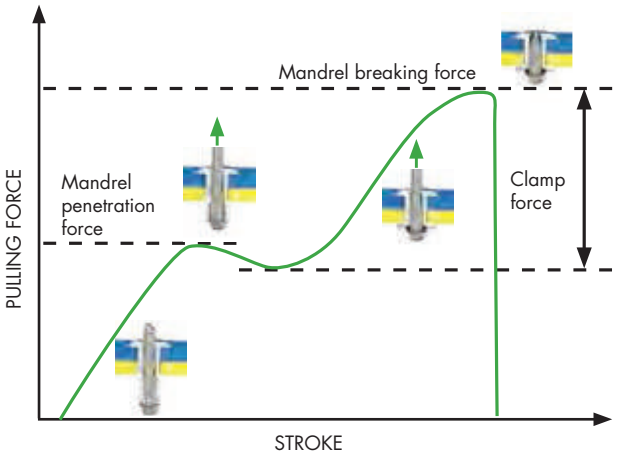
The combination of the use of function-documented blind rivets and the use of the setting process monitoring function of the GAV 8000 electronic guarantees processsecure connections.

The quality management system comprises of three areas:

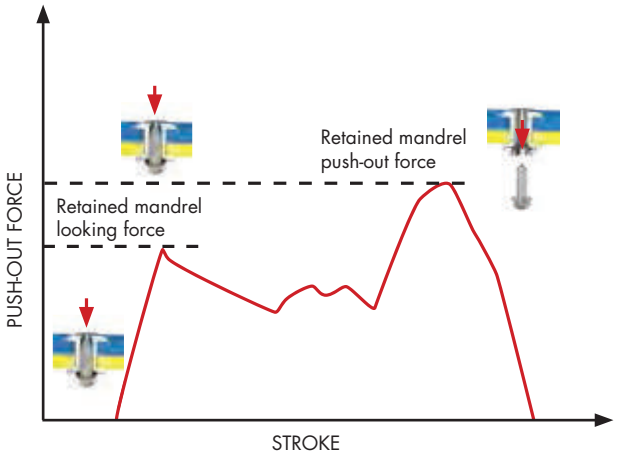
- Dimensional review
- Function test
- Setting process monitoring

.

(1)



(2)



Function documentation / Setting curve (1)
In addition to other parameters, the setting curve is measured using calibrated testing equipment for every batch of application-specific blind riveting. The measuring results of the shaft deformation, slip-in behaviour, mandrel break load and torque are compared to target values to ensure that the blind rivet in the application is deformed as required and creates a secure connection.

Function documentation / Mandrel ejection force (2)
The remaining part of the mandrel enclosed in the set rivet is pressed out with the aid of a needle. The measured force can be used to determine whether the remaining part of the pin is properly locked and will not cause any rattling noises or fall out. The batch is only released if both these values are within tolerances.

Monitored process – Reliable connection
100% inspections of the riveting processes are required for safety-relevant applications for industrial processing of blind rivets. In this case, the fully-automatic rivet device GAV 8000 electronic allows application-compatible efficient solutions ranging from the basic system through to a system with a barcode scanner.

THE CONCEPT TO THE INTEGRATED SETTING PROCESS MONITORING

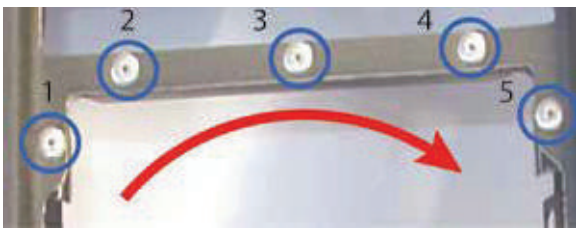
Display of a GAV 8000 electronic indicating the setting curve as part of the setting process monitoring

THE PROCESS MONITORING SYSTEM IS AN INTEGRAL PART OF THE GAV 8000 ELECTRONIC.

It offers the following benefits:

- Optimum process security thanks to integrated quality concept
- Blind rivet-specific process monitoring
- System can be operated independently
- No memory-programmable control system (SPS) required to operate the device
- No system calibration required when system is exchanged
- Little installation effort required
- Interfaces to the control integration

PROGRAMMING THE SETTING PROCESS MONITORING



The setting sequence

STEP 1:
Setting up blind rivet position-specific profiles
Recording and archiving of the relevant process parameters to create a blind rivet connection with reference process curves after defining the analysis window

STEP 2:
Generation of part-specific profile lists
Summary of the profile in the setting sequence as a control file for the process sequence and process assessment

STEP 3:
Operating the device
Online analysis and saving of the setting process data with process interruption if deviations are detected

GESIPA® AUTOMATIC RIVETING MACHINES

COMPARISON OF GAV 8000 ECO, ELECTRONIC AND GAV HF

PROPERTIES	GAV 8000 eco	GAV 8000 electronic
Range of possible sizes 2.4 mm - 6.4 mm (Alu) x x	x	x
Up to 40 rivet settings per minute x x	x	x
Independent system operation possible x x	x	x
PLC control possible x x	x	x
Intelligent control – excellent process safety x x	x	x
Setting of all operating parameters via the display x x	x	x
Customer-specific software modification x x	x	x
Maintenance display x x	x	x
Process monitoring x		x
Process parameter memory for up to 9,999 different parts x		x
Online transfer of the process data x		x
The last 2 million rivet processes are saved in the device		x

COMPARISON OF GAV 8000 ECO, ELECTRONIC AND GAV HF

On request our technical sales team will send you more information about application possibilities in your company.

	GAV 8000 eco and GAV 8000 electronic	GAV HF
SUPPLY UNIT		
Weight	100 kg	270 kg
Spent mandrel container volume	approx. 1,800 to 5,500 pcs. (3.5 l) depending on size	approx. 1,800 to 5,500 pcs. (3.5 l) depending on size
ELECTRICS		
Nominal voltage	230 Volt ~ 50 Hz	230 Volt ~ 50 Hz
Nominal current	< 2.5 A	< 8 A
Protection class	IP 54	IP 54
PNEUMATICS		
Supply pressure	< 10 bar	< 10 bar
Operating pressure	6 bar	5 bar
Air consumption/riveting	15 NL	30 NL
Air consumption/ spent mandrel extraction	340 NL / min.	340 NL / min.
Connection line	½" (12.5 mm) max. length 5 m	¾ " (18.75 mm) max. length 5 m
Rest mandrel extraction tube	Outer Ø 8 mm/ Inner Ø 5 mm	Outer Ø 10 mm/ Inner Ø 6 mm
Pressure transducer	hydro-pneumatic	hydro-pneumatic
RIVET PISTOL		
Weight	ca. 2.5 kg	ca. 7 kg
Stroke	16 - 20 mm	20 mm
Traction power	12,000 N	25,000 N
Standard tube package length	3.75 m (max. 5.0 m)	6 m (max. 25 m)
rking cycle (theoretical)	1.25 Sek.	2 Sek.

GAV 8000 ELECTRONIC / GAV 8000 ECO

Fully automatic blind rivet system for industrial production with and without setting process monitoring

Advice and delivery time on request

integrated setting process monitoring

WORKING RANGE GAV Electronik

- 2.4 mm up to 6.4 mm Ø alu and copper
- Up to 6 mm Ø steel
- Up to 5 mm Ø stainless steel
- Up to flange diameter 11.4 mm
- Rivet body lengths above 30 mm
- Traction power up to 12,000 N at 6 bar air pressure

SCOPE OF DELIVERY (both variants)
The scope of delivery always includes one setting pistol.
This can be freely modified as required.

SYSTEM DESCRIPTION (both variants)

- Electronic system controls
- Intuitive menu guidance via navigation and function keys
- Function display
- Maintenance display and simple fault diagnosis
- Customer-specific software modification is possible
- Rivet mandrels are disposed of by vacuum system
- Spring loaded trigger system as an optional extra
- available
- Can be integrated into the system or operated independently
- Interface for external memory programmable control system (SPS) can be realised via the GESIPA® interface

WITHOUT setting process monitoring Ideal for applications that do not require any process monitoring

Subsequent upgrade to GAV 8000 electronic possible in our Walldorf factory at extra price

Advice and delivery time on request

WORKING RANGE GAV eco

- 2.4 mm up to 6.4 mm Ø alu and copper
- Up to 6 mm Ø steel
- Up to 5 mm Ø stainless steel
- Up to flange diameter 11.4 mm
- Rivet body lengths above 30 mm
- Traction power up to 12,000 N at 6 bar air pressure

ADVANTAGES (both variants)

Productivity and savings potential

- Cost effective from an annual quantity of aroand 500,000 blind rivets (in relation to the german market)
- Up to 50 % time and costs savings compared to standard blind rivet devices
- Rivet pistol has a large action radius thanks to the hose package that is up to 5.0 m in length (Standard length 3.75 m)
- No trained personnel required for operation
- Can be easily integrated into fully-automatic production systems
- Up to 40 blind rivets can be processed every minute

PISTOL VERSION for GAV 8000 electronic / GAV 8000 eco

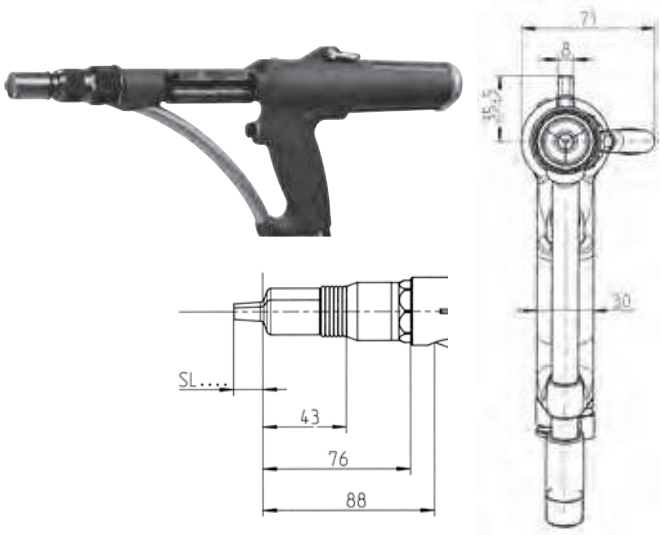
SPECIFIC WORKSTATION CONFIGURATION
For all GAV versions, three different setting pistol variants are available for the ideal configuration of the workstation. For manual workstations, pistols are available as overhead versions with overhead hose assembly or standard pistols with floor-mounted hose assembly. Both versions are equipped with a balancer to ensure fatigue-free working.

The robotic pistol has been developed exclusively for use in fully automatic production systems or robot-controlled systems. It is supplied from stock with corresponding drilled holes for easy installation. For further questions, please contact our Technical Sales team.
A setting pistol suitable for your application is supplied at time of delivery.

STANDARD PISTOL
Total length: 447 mm (+ SL nose)

The standard pistol is primarily used for **manual operator-controlled** use.

Advantages
- Can be used for vertical and horizontal riveting
- Inexpensive variant
- On request, it can be fitted with an extra handle to improve ergonomics, in particular for applications involving vertical riveting

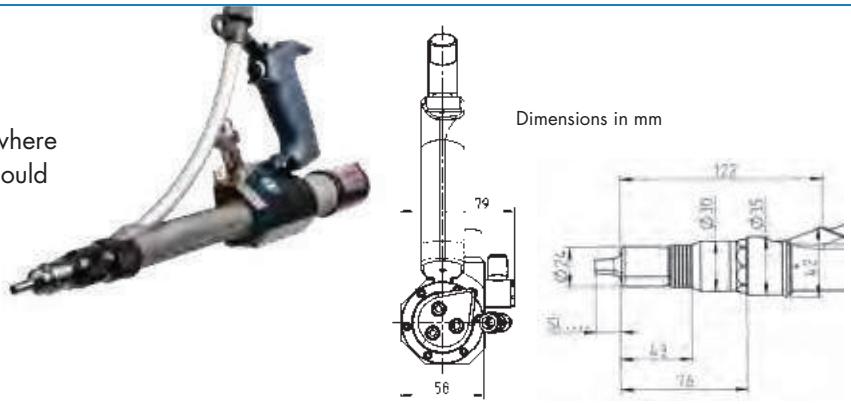


Dimensions in mm

OVERHEAD PISTOL
Total length: 447 mm (+ SL nose)

The overhead pistol can be used everywhere where the hose package is cumbersome or where it could come into contact with sensitive surfaces.

Advantage
- Available with contact pressure monitoring

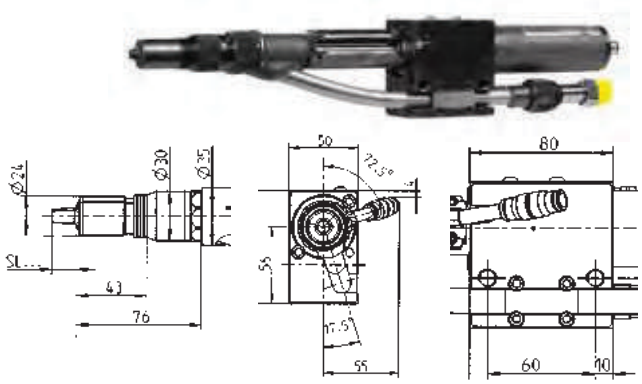


Dimensions in mm

ROBOTIC PISTOL
Total length: 441 mm (+ SL nose)

The robotic pistol has been developed primarily for use in fully automatic production applications/system (linear units/robots).

Advantages
- Ideal for integration in a production system
- On request, it can also be fitted with an extra handle (with trigger button) for vertical riveting so that it can be used manually



Dimensions in mm

GAV HF

Fully-automatic blind rivet system for very strong blind rivets

WORKING RANGE

- Blind rivet sizes from 4.8 mm to 8.0 mm Ø all materials
- Rivet body lengths up to 35 mm
- Setting head diameter up to 19 mm
- Mandrel up to 5.5 mm Ø
- Traction power up to 25,000 N at 6 bar air pressure

Size comparison between a possible blind rivet of the GAV HF, a GESIPA®-PolyGrip® and an 1 Euro coin.

ADVANTAGES

- Conveyor pot filling level display
- Operating pressure: 5 bar
- Vibration-dampened pressure intensifier attachment
- Multiple monitoring of the blind rivet pistol by means of sensors
- Industrial control with an 8" colour display
- Conveyor distances of up to 25 m are possible when used in fully-automatic production systems
- Electronic system controls
- Intuitive menu guidance via navigation and function keys
- Function display
- Maintenance display and simple fault diagnosis
- Customer-specific software modification is possible
- Ideal for applications that do not require any process monitoring
- Rivet mandrels are disposed of via a vacuum system
- Surface contact trigger available as an optional extra
- Can be integrated into the system or operated independently
- Interface for external memory-programmable control system (SPS) can be realised via the GESIPA®-Interface

Advice, price and delivery time on request

SPECIAL ACCESSORIES for GAV automatic riveting machines

INTERFACE 4.0 – FOR CONNECTION TO EXTERNAL CONTROL

The new features are:

- 2 x Ethernet interfaces, router functions
- 1 x USB and 1 x USB-OTG
- Screen connection, graphic output via DVI
- Wi-Fi, as access point and as client, Wi-Fi router function
- Local OLED display to show status and error messages
- M.2 SSD interface, the module can be retrofitted with an SSD (large databases)
- PCIe connector for Hilscher netJACK modules (i.e. direct connection to industrial buses such as PROFINET, SERCOS and EtherCAT possible)

No. 163 4326

ELECTRICAL FOOT PEDAL

The electrial foot pedal is a good solution wherever applications require both hands to affix the parts that need to be riveted.

MAINTENANCE AGREEMENT AND TRAINING

Ask us about our servicing and maintenance agreements. We can also provide training for your operating, servicing and maintenance personnel when you purchase a GESIPA® blind rivet processing system or at a later date.

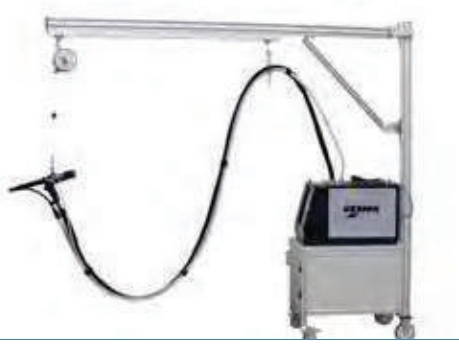
ONLY FOR GAV 8000 (both variants)

SPECIAL LENGTH TUBE PACKAGES

A larger working radius can be achieved, e.g. for use on fully automatic production lines, by using packages of special hose lengths. These are available in various dimensions between 3.75 m and 5.0 m to meet the requirements of the various applications.

GAV carriage

The trolley that has been specially designed for the GAV enables it to be mobile thereby allowing the workplace to be changed quickly and easily.



GESIPA®-Balancer
For ergonomic and fatigue-free working, it is essential that the pistol and the hose package can be suspended. The Balancer from GESIPA® is the perfect solution.

ONLY FOR GAV HF

SURFACE CONTACT MONITORING WITH DUAL-HAND OPERATION
This special Type of surface contact monitoring guarantees the manipulation-proof processsecure joining of parts. In applications that are relevant for safety, it is often necessary to completely rule out manipulations in the riveting process.

GSM RADIO MODUL
In the event of any deviations to the target status e.g. nearly empty feed unit, the GSM radio module (GSM = Global System for Mobile Communications) reports this to a mobile telephone or a process control centre via a call or an SMS. This allows short response times.

ELECTRONIC KEY SYSTEM AND SAFETY SWITCH
An electronic key system and a safety switch guarantee safe access control for at least two user groups and lock the covering hood to prevent unauthorised access to the components in the supply unit.

SPECIAL LENGTH TUBE PACKAGES
A larger working radius can be achieved, e.g. for use on fully automatic production lines, by using packages of special hose lengths. These are available in various dimensions up to aroand 25 m to meet the requirements of the various applications.

OPERATINGSTATUS DISPLAY
The signal lamps attached to the device in the colours red, green and white indicate the operating status of the system. An empty rivet tank, any deviations from the target operating status etc. are indicated immediately.

GESIPA® ASSEMBLY CELL

THE NEW GESIPA® ASSEMBLY CELL GUARANTEES OPTIMUM, PRECISE HANDLING WITH A WIDE RANGE OF GESIPA® PROCESSING DEVICES AND A WORKSPACE TAILORED PERFECTLY TO THE CUSTOMER'S REQUIREMENTS.

The desk is adapted individually to customer requirements and designed ergonomically (e.g. adjustable height). Everything – be it the desk, work piece socket, compressed air supply, electrical supply or processing tools – comes from one source, with process monitoring on request.

The optimised work piece socket allows the desk to be converted for different products and processing tools easily, saving costs.

The GESIPA® assembly cell is produced from high quality materials and components. Needless to say, you also have the option of transferring system components already used at your company.

ADVANTAGES

- Ergonomic working
- Individually adjustable
- Existing work tools can be integrated
- Easy and time-saving conversion for other products from your portfolio
- Setting process monitoring possible

More information on the individually adjusted assembly cell on request. Contact person:
Uwe Herth, Head of BU Equipment Manufacturer,
uwe.herth@gesipa.com

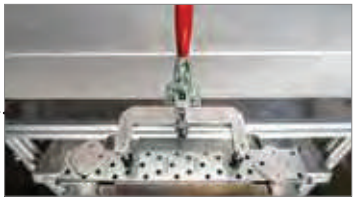
Example:
Can be individually adjusted for each customer

Specifics

Operating status display
The signal light installed on the desk uses different colours to show the process status.

Counting device
The counting device registers and counts the torn off residual rivet mandrels.

GESIPA® setting tool
The setting tool is completely integrated in the assembly cell.



Individual work piece carrier
The optimised work piece carrier allows the desk to be converted for different products and processing tools easily, saving costs.

Foot pedal
The foot pedal allows you to use both hands to join individual parts and fasten the components to be riveted in place.

GESIPA® SPEED RIVET TECHNOLOGY

Up to 60 rivets per minute! – Endorsed by major customers! GESIPA® speed rivets are a cost-effective alternative to automation

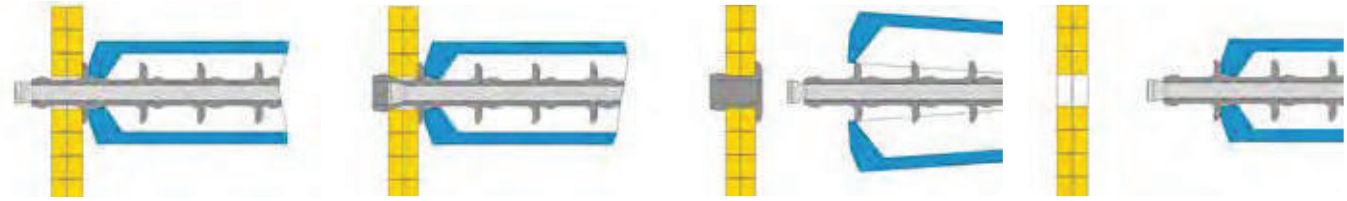
Speed rivet technology is a joining method that requires access from only one side and which enables fast cycle times thanks to the preloaded rivets and automatic feed. After the setting operation the tool automatically makes the next rivet available. This technology is predominantly used in the industry, electronics, lighting, lightweight construction and aviation. Simple one-hand operation ensures rapid hole location and subsequent implementation of the joining process.

A particular feature of the GESIPA® Speed Rivet Technology is that the speed rivet is immediately ready for use. The disposable mandrel with captive speed rivets ensures the speed rivets are immediately ready for use, thus guaranteeing fast loading and fast magazine change (the joining elements do not need to be inserted individually by hand in the processing tool).

The relevant application of the rivet magazine is indicated by a distinct colour marking. With GESIPA® Speed Rivet Technology no spent mandrel remains in the joint after riveting.

Speed riveting technology completes GESIPA Blindniettechnik GmbH's product portfolio. The new speed rivet setting tools by GESIPA® are the product of decades of expertise and the unbeatable advantages of the wellknown, tried-and-tested TAURUS® series. Our engineers' main objectives in its development were for the Speed Rivet tools to be safe, quick and reliable. The very light and ergonomically shaped device will set new standards.

THE SETTING PROCESS



1 The speed rivet is introduced into the joint.

2 The mandrel is pulled through the rivet thus joining the materials.

3 The next speed rivet is ready automatically.

4 The setting process can now be repeated.

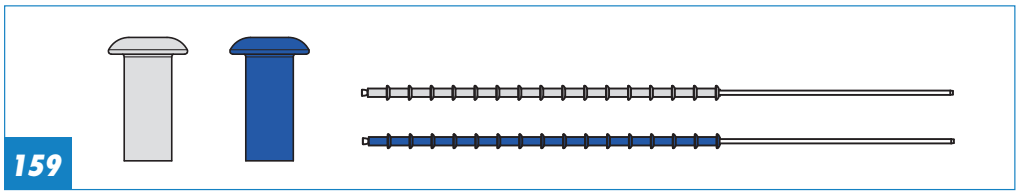
ADVANTAGES OF THE GESIPA® SPEED RIVET

- Ready to use rivet magazine
- Extremely fast processing and cycle times
- Quick magazine change
- One-hand operation
- Vibration-proof
- Stable in use
- Reduced parts handling
- Versatile application
- Easy to operate
- Ideal for medium- and high-volume production
- No spent mandrel, therefore:
  - No corrosion
  - No lost mandrels
  - No noise
  - No short-circuits caused by loose parts
- Joining elements cannot drop off during processing
- Low-price alternative to fully automatic systems
- Made in Germany

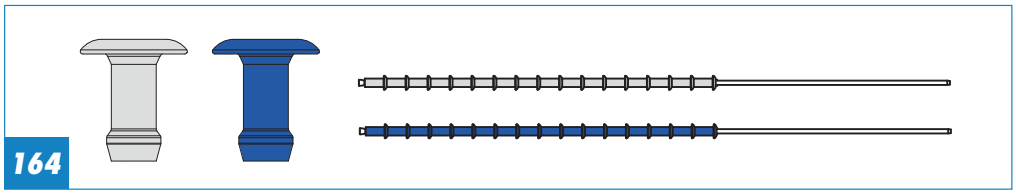
OVERVIEW GESIPA® SPEED RIVET TECHNOLOGY

SPEED RIVETS

159



G-Speed® alu and steel



Speed Bulb® alu and steel

SPEED RIVET SETTING TOOLS

167

TAURUS® 1 Speed Rivet

TAURUS® 2 Speed Rivet

TAURUS® 1 and 2
Speed Rivet Axial eco

WHAT RIVETS WHAT?

		Ø mm 2.4	3.0	3.2	4.0	4.8	5.0	6.0	6.4
TAURUS® 1 Speed Rivet / Axial	P	●	●	●	●	A			
TAURUS® 2 Speed Rivet / Axial	P	●	●	●	●	●	●	●	●

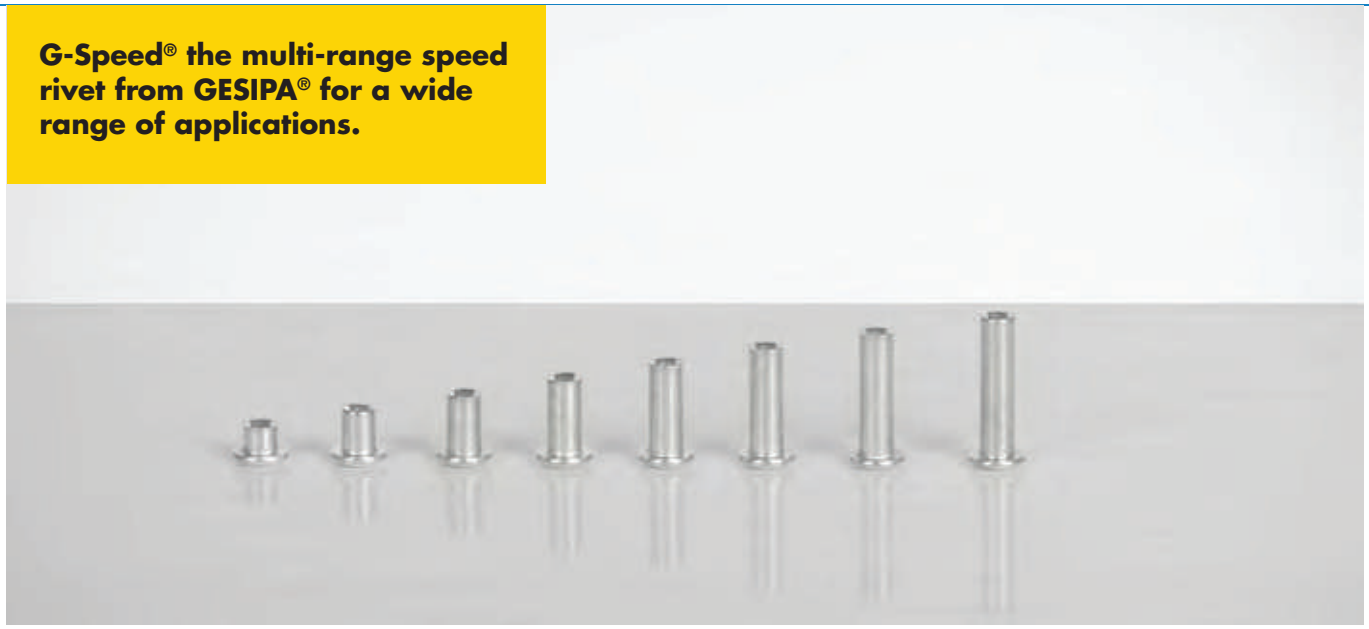
P: Hydro-pneumatic tool

A: Alu/Copper
S: Steel
E: Stainless Steel/Monel

Blue box: All materials (ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box..

G-SPEED®

G-Speed® the multi-range speed rivet from GESIPA® for a wide range of applications.



ADVANTAGES

- Large grip range
- Reduced variation
- Optimum hole filling capabilities and bearing stress
- Ideally suited for transferring shear strengths with moderate clamping force
- Ideal for:
  - LED light strips
  - Electronic/pcb assembly
  - Lightweight sheet metal structures
  - PC housings
  - Rating plates
  - Blind holes

Grip range	⊕⊕⊕
Shear strength	⊕⊕
Tensile strength	⊕
Pulling strength	⊕⊕

Two mandrel lengths are available for the speed rivet:

S ≈ 485 mm for the standard nosepiece
L ≈ 510 mm for the long or curved nosepieces

To achieve an optimum riveted joint for different bore diameters, a number of mandrel size groups are available. The application range of each speed rivet is denoted by a clear colour code, ensuring the unequivocal classification of the mandrel size groups.

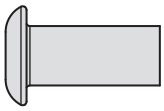
CLASSIFICATION OF THE MANDREL SIZE GROUPS

mandrel size groups		Hollow-rivet diameter (mm)			
		3.0	3.2	4.0	4.8
		Bore diameter (mm)			
	Standard	3.05 - 3.15	3.25 - 3.35	4.05 - 4.15	4.85 - 4.95
	1st oversize	3.15 - 3.25	3.35 - 3.45	4.15 - 4.25	4.95 - 5.05
	2nd oversize (on request)	3.25 - 3.35	3.45 - 3.55	4.25 - 4.35	5.05 - 5.15
	3rd oversize (on request)	3.35 - 3.45	3.55 - 3.65	4.35 - 4.45	5.15 - 5.25

G-SPEED®

Alu

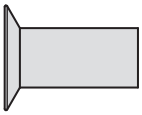
Dome head



D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	3.2 x 4.0	1.0 - 3.0	57	20,000	L4 (485 mm)	146 3628	146 3636
					L5 (510 mm)	146 3975	146 3981
	3.2 x 5.5	1.0 - 4.5	45	15,000	L4 (485 mm)	146 3629	146 3637
					L5 (510 mm)	146 3979	146 3982
	3.2 x 7.0	1.0 - 6.0	37	12,500	L4 (485 mm)	146 3630	146 3638
					L5 (510 mm)	146 4006	146 4011
	3.2 x 8.5	1.0 - 7.5	31	10,000	L4 (485 mm)	146 3631	146 3639
					L5 (510 mm)	146 4007	146 4012
4.0	4.0 x 4.0	1.0 - 3.0	57	20,000	L4 (485 mm)	151 9021	151 9125
					L5 (510 mm)	151 9198	151 9302
	4.0 x 5.5	1.0 - 4.5	45	15,000	L4 (485 mm)	151 9023	151 9126
					L5 (510 mm)	151 9199	151 9303
	4.0 x 7.0	1.0 - 6.0	37	12,500	L4 (485 mm)	151 9025	151 9127
					L5 (510 mm)	151 9200	151 9305
	4.0 x 8.5	1.0 - 7.5	31	10,000	L4 (485 mm)	151 9026	151 9128
					L5 (510 mm)	151 9201	151 9306
4.8	4.8 x 4.0	1.0 - 3.0	54	15,000	L4 (485 mm)	151 9041	151 9133
					L5 (510 mm)	151 9206	151 9360
	4.8 x 5.5	1.0 - 4.5	43	12,500	L4 (485 mm)	151 9042	151 9134
					L5 (510 mm)	151 9207	151 9361
	4.8 x 7.0	1.0 - 6.0	35	10,000	L4 (485 mm)	151 9043	151 9135
					L5 (510 mm)	151 9219	151 9362
	4.8 x 8.5	1.0 - 7.5	30	10,000	L4 (485 mm)	151 9044	151 9136
					L5 (510 mm)	151 9218	151 9363

Alu

Countersunk

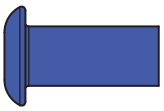


D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	3.2 x 4.0	1.0 - 3.0	75	25,000	L4 (485 mm)	146 3660	146 3668
					L5 (510 mm)	146 4047	146 4054
	3.2 x 5.5	1.0 - 4.5	55	20,000	L4 (485 mm)	146 3661	146 3669
					L5 (510 mm)	146 4048	146 4055
	3.2 x 7.0	1.0 - 6.0	43	15,000	L4 (485 mm)	146 3662	146 3670
					L5 (510 mm)	146 4049	146 4056
	3.2 x 8.5	1.0 - 7.5	35	12,500	L4 (485 mm)	146 3663	146 3671
					L5 (510 mm)	146 4050	146 4057

D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
4.0	**4.0 x 4.0**	1.0 - 3.0	75	25,000	L4 (485 mm)	**151 9027**	**151 9129**
					L5 (510 mm)	**151 9202**	**151 9308**
	4.0 x 5.5	1.0 - 4.5	55	17,500	L4 (485 mm)	**151 9028**	**151 9130**
					L5 (510 mm)	**151 9203**	**151 9356**
	4.0 x 7.0	1.0 - 6.0	43	15,000	L4 (485 mm)	**151 9029**	**151 9131**
					L5 (510 mm)	**151 9204**	**151 9357**
	4.0 x 8.5	1.0 - 7.5	35	12,500	L4 (485 mm)	**151 9030**	**151 9132**
					L5 (510 mm)	**151 9205**	**151 9359**
4.8	**4.8 x 4.0**	1.0 - 3.0	75	20,000	L4 (485 mm)	**151 9046**	**151 9137**
					L5 (510 mm)	**151 9217**	**151 9364**
	4.8 x 5.5	1.0 - 4.5	55	15,000	L4 (485 mm)	**151 9047**	**151 9138**
					L5 (510 mm)	**151 9216**	**151 9365**
	4.8 x 7.0	1.0 - 6.0	43	12,500	L4 (485 mm)	**151 9048**	**151 9139**
					L5 (510 mm)	**151 9214**	**151 9366**
	4.8 x 8.5	1.0 - 7.5	35	10,000	L4 (485 mm)	**151 9050**	**151 9140**
					L5 (510 mm)	**151 9213**	**151 9367**

Steel

Dome head



D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	**3.2 x 4.0**	1.0 - 3.0	57	20,000	L4 (485 mm)	**146 4076**	**146 4084**
					L5 (510 mm)	**146 4168**	**146 4176**
	3.2 x 5.5	1.0 - 4.5	45	15,000	L4 (485 mm)	**146 4077**	**146 4085**
					L5 (510 mm)	**146 4169**	**146 4177**
	3.2 x 7.0	1.0 - 6.0	37	12,500	L4 (485 mm)	**146 4078**	**146 4086**
					L5 (510 mm)	**146 4170**	**146 4178**
	3.2 x 8.5	1.0 - 7.5	31	10,000	L4 (485 mm)	**146 4079**	**146 4087**
					L5 (510 mm)	**146 4171**	**146 4179**
4.0	**4.0 x 4.0**	1.0 - 3.0	57	20,000	L4 (485 mm)	**151 9059**	**151 9152**
					L5 (510 mm)	**151 9260**	**151 9369**
	4.0 x 5.5	1.0 - 4.5	45	15,000	L4 (485 mm)	**151 9060**	**151 9154**
					L5 (510 mm)	**151 9281**	**151 9389**
	4.0 x 7.0	1.0 - 6.0	37	12,500	L4 (485 mm)	**146 4507**	**146 4505**
					L5 (510 mm)	**146 4495**	**146 4493**
	4.0 x 8.5	1.0 - 7.5	31	10,000	L4 (485 mm)	**146 4506**	**146 4504**
					L5 (510 mm)	**146 4494**	**146 4492**

159

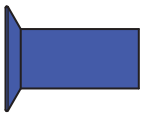
Other oversizes available on request. For details see table on **page 159** and **page163**

G-SPEED®

D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
4.8	**4.8 x 4.0**	1.0 - 3.0	54	15,000	L4 (485 mm)	**151 9073**	**151 9157**
					L5 (510 mm)	**151 9284**	**151 9441**
	4.8 x 5.5	1.0 - 4.5	43	12,500	L4 (485 mm)	**151 9078**	**151 9159**
					L5 (510 mm)	**151 9285**	**151 9442**
	4.8 x 7.0	1.0 - 6.0	35	10,000	L4 (485 mm)	**151 9082**	**151 9160**
					L5 (510 mm)	**151 9286**	**151 9443**
	4.8 x 8.5	1.0 - 7.5	30	10,000	L4 (485 mm)	**151 9109**	**151 9161**
					L5 (510 mm)	**151 9287**	**151 9444**

Steel

Countersunk head



D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	**3.2 x 4.0**	1.0 - 3.0	75	25,000	L4 (485 mm)	**146 4136**	**146 4144**
					L5 (510 mm)	**146 4200**	**146 4208**
	3.2 x 5.5	1.0 - 4.5	55	20,000	L4 (485 mm)	**146 4137**	**146 4145**
					L5 (510 mm)	**146 4201**	**146 4209**
	3.2 x 7.0	1.0 - 6.0	43	15,000	L4 (485 mm)	**146 4138**	**146 4146**
					L5 (510 mm)	**146 4202**	**146 4210**
	3.2 x 8.5	1.0 - 7.5	35	12,500	L4 (485 mm)	**146 4139**	**146 4147**
					L5 (510 mm)	**146 4203**	**146 4211**
4.0	**4.0 x 4.0**	1.0 - 3.0	75	25,000	L4 (485 mm)	**151 9071**	**151 9155**
					L5 (510 mm)	**151 9282**	**151 9390**
	4.0 x 5.5	1.0 - 4.5	55	17,500	L4 (485 mm)	**151 9072**	**151 9156**
					L5 (510 mm)	**151 9283**	**151 9391**
	4.0 x 7.0	1.0 - 6.0	43	15,000	L4 (485 mm)	**146 4499**	**146 4498**
					L5 (510 mm)	**146 4487**	**146 4486**
	4.0 x 8.5	1.0 - 7.5	35	12,500	L4 (485 mm)	**146 4912**	**146 4911**
					L5 (510 mm)	**146 4910**	**146 4909**
4.8	**4.8 x 4.0**	1.0 - 3.0	75	20,000	L4 (485 mm)	**151 9121**	**151 9190**
					L5 (510 mm)	**151 9288**	**151 9445**
	4.8 x 5.5	1.0 - 4.5	55	15,000	L4 (485 mm)	**151 9122**	**151 9191**
					L5 (510 mm)	**151 9289**	**151 9446**
	4.8 x 7.0	1.0 - 6.0	43	12,500	L4 (485 mm)	**151 9123**	**151 9194**
					L5 (510 mm)	**151 9290**	**151 9447**
	4.8 x 8.5	1.0 - 7.5	35	10,000	L4 (485 mm)	**151 9124**	**151 9196**
					L5 (510 mm)	**151 9301**	**151 9461**

159

Other oversizes available on request. For details see table on **page 159** and **page163**

G-SPEED®

G-Speed® is available in a large number of versions
The individual properties are shown in the following table of possible combinations

Head shape	Material	D mm	D x L mm	mm	Number of rivets on mandrel ± 1 Dome head	Number of rivets on mandrel ± 1 Countersunk head	
Dome head / Countersunk	Alu/Steel	3.0	**3.0 x 2.5**	1.0 - 1.5	81	115	30,000
			3.0 x 4.0	1.0 - 3.0	57	75	20,000
			3.0 x 5.5	1.0 - 4.5	45	55	15,000
			3.0 x 7.0	1.0 - 6.0	37	43	12,500
			3.0 x 8.5	1.0 - 7.5	31	35	10,000
			3.0 x 10.0	1.0 - 9.0	27	26	10,000
			3.0 x 11.5	1.0 - 10.5	23	23	10,000
		3.2	**3.2 x 2.5**	1.0 - 1.5	81	115	30,000
			3.2 x 10.0	1.0 - 9.0	27	30	10,000
			3.2 x 11.5	1.0 - 10.5	23	26	10,000
			3.2 x 13.0	1.0 - 12.0	21	23	10,000
		4.0	**4.0 x 2.5**	1.0 - 1.5	85	115	30,000
			4.0 x 10.0	1.0 - 9.0	27	30	10,000
			4.0 x 11.5	1.0 - 10.5	23	26	10,000
			4.0 x 13.0	1.0 - 12.0	21	23	7,500 / 10,000
		4.8	**4.8 x 2.5**	1.0 - 1.5	75	115	20,000 / 30,000
			4.8 x 10.0	1.0 - 9.0	26	30	7,500 / 10,000
			4.8 x 11.5	1.0 - 10.5	23	26	7,500
			4.8 x 13.0	1.0 - 12.0	20	23	5,000 / 7,500
			4.8 x 14.5	1.0 - 13.5	18	20	5,000
			4.8 x 16.0*	1.0 - 15.0	17	18	5,000

Example: Countersunk head– Steel 3.0 x 10.0 mm

SHEAR STRENGTH G-SPEED®*

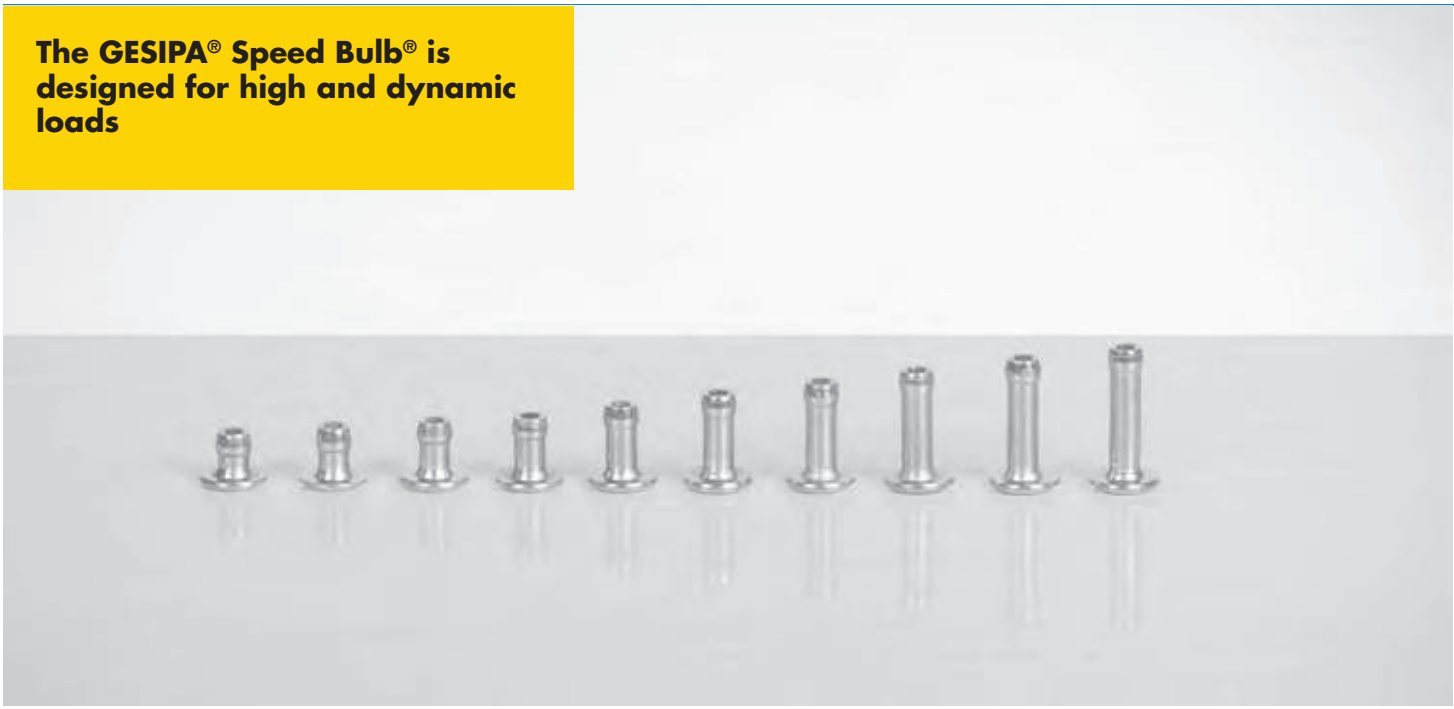
D mm	N Alu	N Steel	max. k mm	max. d_k mm
DOME HEAD ALU AND STEEL				
3.0	**630**	**1,060**	1.2	5.5
3.2	**900**	**1,400**	1.2	5.5
4.0	**1,600**	**2,400**	1.5	6.5
4.8	**2,000**	**3,200**	1.5	8.9
COUNTERSUNK HEAD ALU AND STEEL				
3.0	**630**	**1,060**	1.0	5.5
3.2	**900**	**1,400**	1.0	5.7
4.0	**1,600**	**2,400**	1.0	6.7
4.8	**2,000**	**3,200**	1.4	9.1

D = Rivet body Ø
k = Height of head
d_k = Setting head Ø

*Typical data, measured at the longest rivet body length

SPEED BULB®

The GESIPA® Speed Bulb® is designed for high and dynamic loads



ADVANTAGES

- Optimally adapted to specific grip range
- Distinct bulb formation
  - High grip force
  - High pulling force
- For higher loads
- Ideally suited for transmitting shear and tensile forces
- Ideal for:
  - Higher dynamic loads
  - Sheet metal structures
  - Electrical devices
  - White goods

Grip range	⊕⊕
Shear strength	⊕⊕
Tensile strength	⊕⊕
Pulling strength	⊕⊕⊕

Two mandrel lengths are available for the speed rivet:

L4 ≈ 485 mm for the standard nose
L5 ≈ 510 mm for the long or curved nosepieces

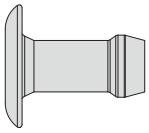
To achieve an optimum riveted joint for different bore diameters, a number of mandrel size groups are available. The application range of each speed rivet is denoted by a clear colour code, ensuring the unequivocal classification of the mandrel size groups.

CLASSIFICATION OF THE MANDREL SIZE GROUPS

mandrel size groups:		Hollow-rivet diameter (mm)		
		3.2	4.0	4.8
		Bore diameter (mm)		
	Standard	3.25 - 3.35	4.05 - 4.15	4.85 - 4.95
	1st oversize	3.35 - 3.45	4.15 - 4.25	4.95 - 5.05
	2nd oversize (on request)	3.45 - 3.55	4.25 - 4.35	5.05 - 5.15

Alu

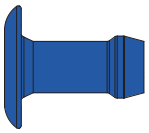
Dome head



D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	3.2 x 4.2	1.0 - 2.3	59	17,500	L4 (485 mm)	151 9636	151 9645
					L5 (510 mm)	151 9646	151 9729
	3.2 x 4.7	1.5 - 2.8	54	17,500	L4 (485 mm)	151 9731	151 9742
					L5 (510 mm)	151 9775	152 0860
	3.2 x 5.2	2.0 - 3.3	49	15,000	L4 (485 mm)	151 9732	151 9743
					L5 (510 mm)	151 9776	152 0833
	3.2 x 6.2	3.0 - 4.3	42	12,500	L4 (485 mm)	151 9733	151 9744
					L5 (510 mm)	151 9777	152 0836
	3.2 x 7.2	4.0 - 5.3	37	12,500	L4 (485 mm)	151 9734	151 9745
					L5 (510 mm)	151 9778	152 0837
	3.2 x 8.2	5.0 - 6.3	33	10,000	L4 (485 mm)	151 9735	151 9750
					L5 (510 mm)	151 9779	152 0838

Steel

Dome head



D	D x L mm	mm	Number of rivets on mandrel ± 1		Mandrel length for nosepiece	* No.	* No.
3.2	3.2 x 4.2	1.0 - 2.3	59	17,500	L4 (485 mm)	151 9644	151 9727
					L5 (510 mm)	151 9728	151 9730
	3.2 x 4.7	1.5 - 2.8	54	17,500	L4 (485 mm)	151 9736	151 9760
					L5 (510 mm)	152 0855	152 0839
	3.2 x 5.2	2.0 - 3.3	49	15,000	L4 (485 mm)	151 9737	151 9771
					L5 (510 mm)	152 0856	152 0840
	3.2 x 6.2	3.0 - 4.3	42	12,500	L4 (485 mm)	151 9738	151 9772
					L5 (510 mm)	152 0857	152 0871
	3.2 x 7.2	4.0 - 5.3	37	12,500	L4 (485 mm)	151 9740	151 9773
					L5 (510 mm)	152 0858	152 0872
	3.2 x 8.2	5.0 - 6.3	33	10,000	L4 (485 mm)	151 9741	151 9774
					L5 (510 mm)	152 0859	152 0873

164

Other oversizes available on request. For details see table on **page 164** and **page166**

SPEED BULB®

Speed Bulb® is available in a large number of versions.
The individual properties are shown in the following table of possible combinations.

Head shape	Material	D mm	D x L mm	mm	Number of rivets on mandrel ± 1	
Dome head	Alu/Steel	3.2	3.2 x 3.7	0.5 - 1.8	65	20,000
			3.2 x 9.2	6.0 - 7.3	29	10,000
			3.2 x 10.2	7.0 - 8.3	27	10,000
			3.2 x 11.2	8.0 - 9.3	25	10,000
		4.0	4.0 x 4.3	1.0 - 2.3	57	17,500
			4.0 x 4.8	1.5 - 2.8	52	17,500
			4.0 x 5.3	2.0 - 3.3	48	15,000
			4.0 x 6.3	3.0 - 4.3	41	15,000
			4.0 x 7.3	4.0 - 5.3	36	12,500
			4.0 x 8.3	5.0 - 6.3	32	12,500
			4.0 x 9.3	6.0 - 7.3	29	12,500
			4.0 x 10.3	7.0 - 8.3	26	10,000
			4.0 x 11.3	8.0 - 9.3	24	10,000
		4.8	4.8 x 5.2	1.5 - 2.8	47	12,500
			4.8 x 5.7	2.0 - 3.3	43	10,000
			4.8 x 6.7	3.0 - 4.3	38	10,000
			4.8 x 7.2	3.5 - 4.8	35	10,000
			4.8 x 7.7	4.0 - 5.3	34	10,000
			4.8 x 8.7	5.0 - 6.3	30	7,500
			4.8 x 9.7	6.0 - 7.3	27	7,500
			4.8 x 10.7	7.0 - 8.3	25	7,500
			4.8 x 11.7	8.0 - 9.3	23	7,500

SHEAR AND TENSILE STRENGTH SPEED BULB® *

D mm	N	N	max. k mm	max. d_k mm
DOME HEAD ALU				
3.2	**700**	**1,300**	1.0	6.6
4.0	**1,100**	**1,700**	1.0	8.3
4.8	**1,500**	**2,700**	1.2	9.8
DOME HEAD STEEL				
3.2	**1,100**	**1,800**	1.0	6.6
4.0	**1,600**	**2,800**	1.0	8.3
4.8	**2,200**	**3,700**	1.2	9.8

D = Rivet body Ø
k = Height of head
d_k = Setting head Ø

*Typical data, measured at the longest rivet body length

TAURUS® 1 SPEED RIVET

The hydro-pneumatic-magazine setting tool with quick setting process and fast rates!

With silencer

No. 145 7684

TECHNICAL DATA

Traction power:	3,500 N at 6 bar
Stroke:	26 mm
Operating pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Weight:	1.8 kg

WORKING RANGE

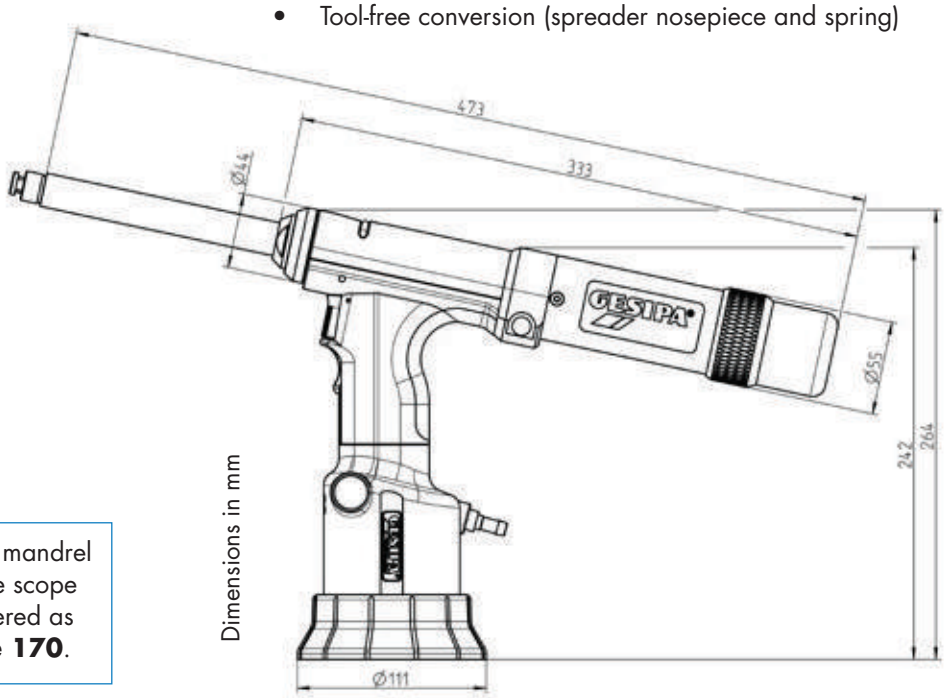
The rivet setting tool is designed for setting standard speed rivets from 2.4 - 4.8 mm Ø of all materials, as well as up to 4 mm Ø in stainless steel.

SCOPE OF DELIVERY

Tag on device head
1 hydraulic oil bottle 100 ml
1 oil refill can
1 oil press
Operating instructions with spare parts list

ADVANTAGES

- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)



Dimensions in mm

The spreader nosepiece and mandrel spring are not included in the scope of delivery. They can be ordered as special accessories on **page 170**.

TAURUS® 2 SPEED RIVET

The hydro-pneumatic-magazine setting tool with quick setting process and fast rates!

No. 145 7833

TECHNICAL DATA

Traction power:	6,500 N at 6 bar
Stroke:	30 mm
Operating pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Weight:	2.0 kg

WORKING RANGE

The rivet setting tool is designed for setting standard speed rivets from 2.4 - 6.4 mm Ø of all materials.

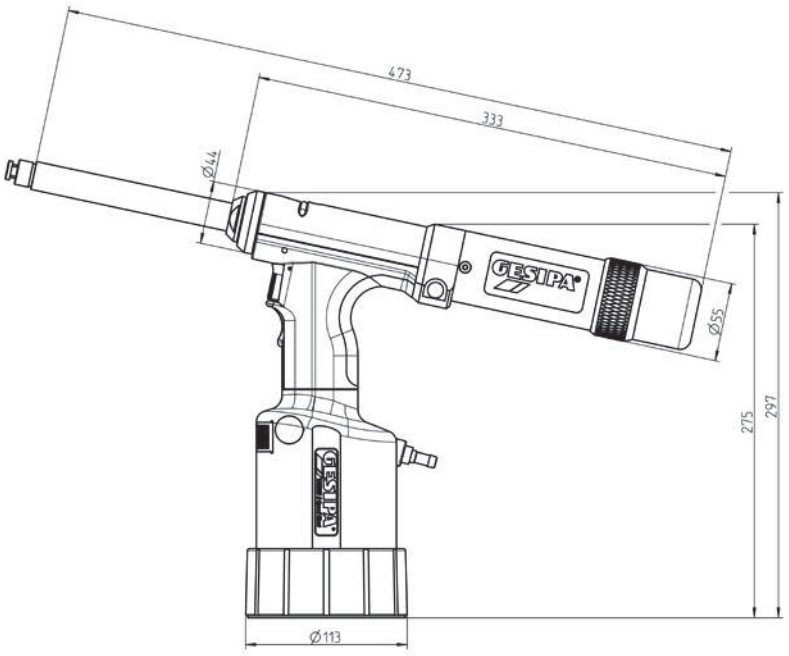
SCOPE OF DELIVERY

Tag on device head
1 hydraulic oil bottle 100 ml
1 oil refill can
1 oil press
Operating instructions with spare parts list

ADVANTAGES

- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)

The spreader nosepiece and mandrel spring are not included in the scope of delivery. They can be ordered as special accessories on **page 170**.



Dimensions in mm

TAURUS® SPEED RIVET AXIAL ECO 1/2

Axial version of the speed riveting setting tool for special applications

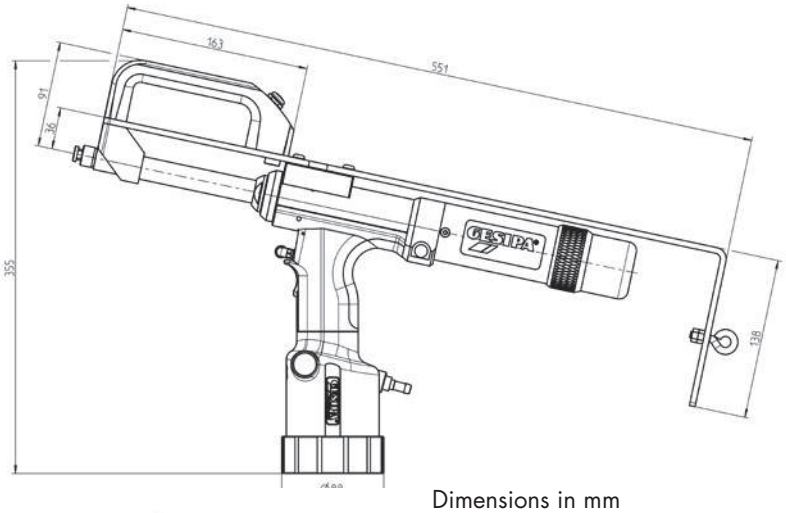
TAURUS® 1 Speed Rivet Axial Eco
No. 145 7692

TAURUS® 2 Speed Rivet Axial Eco
No. 145 0931

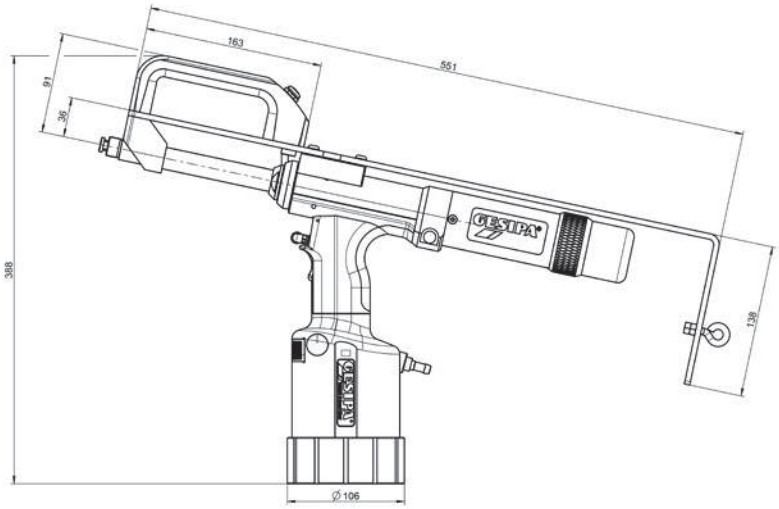
Technical data and working range
analog to TAURUS® 1 and 2 Speed Rivet.

SCOPE OF DELIVERY
1 hydraulic oil bottle 100 ml
1 oil refill can
1 oil press
Operating instructions with spare parts list

ADVANTAGES
- Also perfectly designed for fixed installation in production lines or semi-automatic workstations
- Very practical for processing blind rivets in positions that require a vertical rivet setting process
- Can be suspended on a balancer
- Quick setting process, fast rates
- Safe working through disposable mandrel and optional automatic switchoff
- Ergonomic handling for fatigue-free work
- Light and compact design
- Modular construction based on the TAURUS® design
- Softgrip
- Tool-free conversion (spreader nosepiece and spring)



Dimensions in mm



The spreader nosepiece and mandrel spring are not included in the scope of delivery. They can be ordered as special accessories on **page 170**.

NOSEPIECES

- **Standard:** For easy to access riveting points
- **Standard pointed:** For countersunk head rivets
- **Extended and extended bent:** For difficult to access riveting points
- **With opening mechanism:** Makes it easier to open the nosepiece so that speed rivets can be changed more conveniently and quickly.

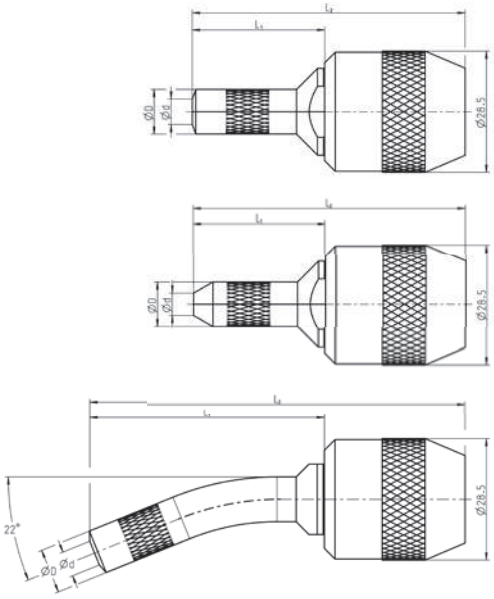
MANDREL SPRING

- **Standard:** For standard spreader nosepiece with or without opening mechanism.
- **Extended:** For extended spreader nosepiece with or without opening mechanism.

	Rivet Ø (mm)	No.
Standard	**2.4**	**155 3517**
	3.2	**145 7759**
	4.0	**145 7761**
	4.8	**145 7763**
Extended	**3.2**	**145 7760**
	4.0	**145 7762**
	4.8	**145 7764**

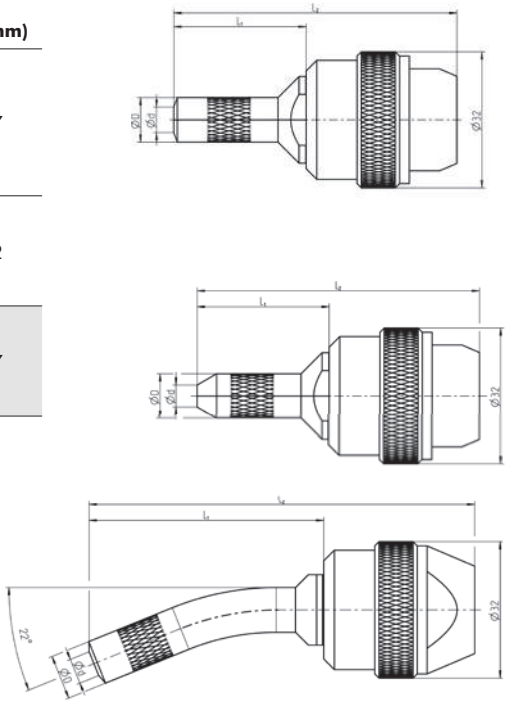
SPREADER NOSEPIECE WITHOUT OPENING MECHANISM

	Rivet Ø (mm)	No.	Ø d (mm)	Ø D (mm)	L1 (mm)	L2 (mm)
Standard	**2.4**	**155 6918**	5	9.5	31	64
	3.2	**145 7753**	6	10.5		
	4.0	**145 7754**	7.5	12		
	4.8	**145 7755**	9	14		
Extended	**3.2**	**145 7756**	6	10.5	57	90
	4.0	**145 7757**	7.5	12		
	4.8	**145 7758**	9	14		
Standard pointed	**3.2**	**145 0900**	6	10.5	31	64
	4.0	**145 0901**	7.5	12		
	4.8	**145 0902**	9	14		
Extended bent	**3.2**	**145 0903**	6	10.5	55	88
	4.0	**145 0904**	7.5	12	55.5	88.5
	4.8	**145 0905**	9	14	56	89



SPREADER NOSEPIECE WITH OPENING MECHANISM

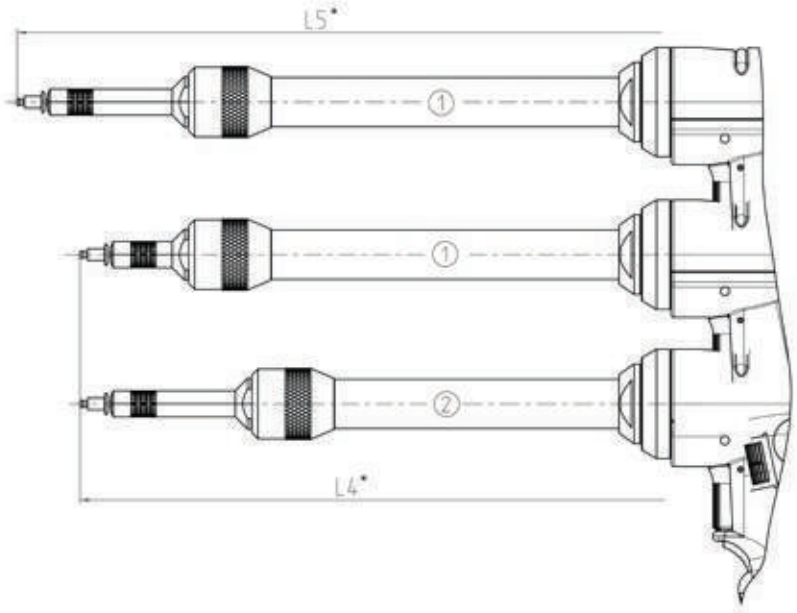
	Rivet Ø (mm)	No.	Ø d (mm)	Ø D (mm)	L1 (mm)	L2 (mm)
Standard	**2.4**	**155 6919**	5	9.5	31	67
	3.2	**145 0906**	6	10.5		
	4.0	**145 0907**	7.5	12		
	4.8	**145 0908**	9	14		
Extended	**3.2**	**145 0909**	6	10.5	57	92
	4.0	**145 0910**	7.5	12		
	4.8	**145 0911**	9	14		
Standard pointed	**3.2**	**145 0912**	6	10.5	31	67
	4.0	**145 0913**	7.5	12		
	4.8	**145 0914**	9	14		
Extended bent	**3.2**	**145 0915**	6	10.5	55	91
	4.0	**145 0916**	7.5	12		
	4.8	**145 0917**	9	14	56	



Other spreader nosepieces and mandrel springs on request.

GUIDE TUBE

The short guide tube means that TAURUS® Speed Rivet setting tools can work with the standard L4 mandrel length even with long and curved nosepieces.



Standard 1
No. 143 5710

L5 mandrel length required **L5 ≈ 510 mm** for a long or curved nosepiece

Shortened 2
No. 163 9244

Suitable for standard mandrel length **L4 L4 ≈ 485 mm** for standard nosepiece

SCHLIESSRINGBOLZEN-SETZGERÄTE

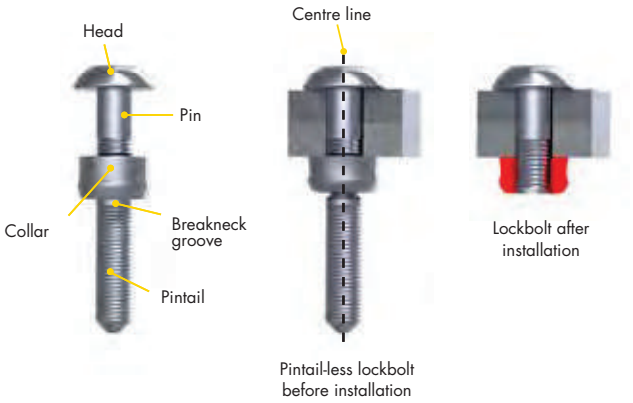
Innovative, strong and reliable – Pneumatichydraulic lockbolt setting tools ensure that connections last long and are free from vibration.

Lockbolts are used where there are particularly high requirements regarding the durability and vibration safety of the connection. The connection requires the components of the lockbolt to be accessible from two sides. Because the locking ring moulds into the retaining grooves during the setting process, the connection is extremely durable and secure against coming loose on its own.
The GESIPA® lock bolt setting devices in the TAURUS® and Bird® series have been developed using a modular concept and are an ideal composition of experience and consistent further development by our experienced engineers.
The lockbolt setting devices guarantee high-quality setting processes and therefore long-lasting and permanently tight connections. In the truck & trailer field in particular, GESIPA® devices ensure fast, trouble-free working processes.

Fastening material by means of lockbolts

With standard lockbolts, the setting process itself is very similar to the blind riveting process.

1. The pin is positioned on one side and the collar on the other side of the materials to be joined.
2. The setting tool grasps the pin while pushing itself against the collar.
3. By pulling the pin the application materials are pressed together and the collar is forced into the grooves of the pin.
4. The joining process is finished once the setting tool hits the joint´s surface and the pin breaks off at the predetermined fracture point because of the increasing tensile strength.



173

PowerBird® SRB 4.8

PowerBird® SRB 6.4

TAURUS® 3 SRB

TAURUS® 4 SRB

TAURUS® 4 SRB with angle head 90° compact

POWERBIRD® SRB 4.8

PowerBird® for lock bolts
4.8 mm (3/16") Magna-Grip®*

No. 145 0607

PowerBird® for lock bolts
4.8 mm (3/16") C6L

No. 145 0605

*Registered trademark of Alcoa Fastening Systems

TECHNICAL DATA

Weight:	2.2 kg with battery
Stroke:	20 mm
Drive:	Gleichstrommotor
Traction power:	14,000 N

WORKING RANGE

4.8 lockbolts C6L and Magna-Grip®*

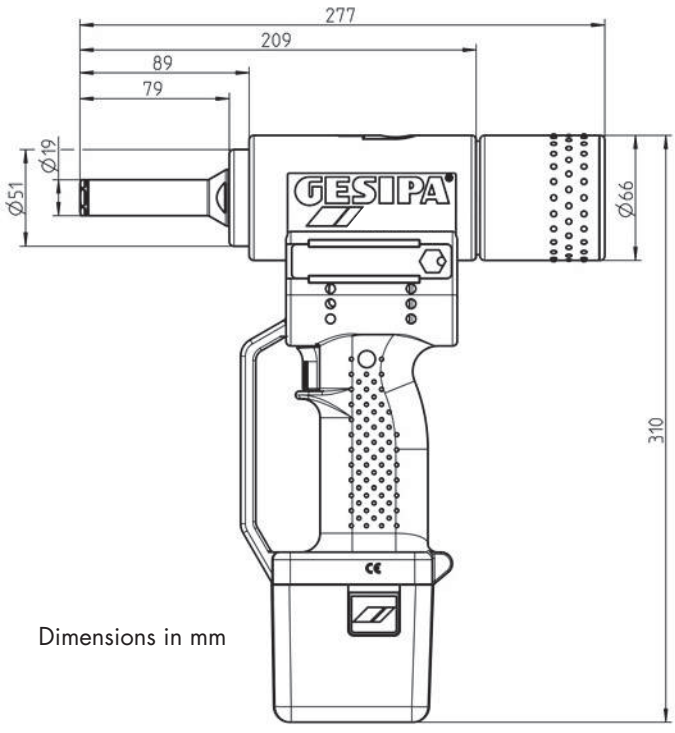
SCOPE OF DELIVERY

Nosepiece in working position
Swivelling hanger
Li-Ion power battery 2.6 Ah/14.4 V
Charger
Operating manual with spare parts list
Plastic carrying case

ADVANTAGES

- Battery-operated lock bolt setting device
- Processing anywhere
- Modular structure
- Ergonomic handling

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!



Dimensions in mm

JAW MECHANISM ASSIGNMENT

For lockbolts 4.8 mm Magna-Grip®

Designation	No.
Nosepiece	**143 4810**
Jaw	**144 6118**
Jaw housing	**143 5945**

For lockbolts 4.8 mm C6L

Designation	No.
Nosepiece	**143 4809**
Supporting ring	**143 5995**
Jaw	**144 6117**
Jaw housing	**143 5944**

POWERBIRD® SRB 6.4

PowerBird® for lockbolts
6.4 mm (1/4") Magna-Grip®*
No. 145 0608

PowerBird® for lockbolts
6.4 mm (1/4") C6L
No. 145 0606

*Registered trademark
of Alcoa Fastening Systems

TECHNICAL DATA

Weight:	2.4 kg with battery
Stroke:	20 mm
Drive:	14.4 V
Traction Power:	18,000 N

WORKING RANGE

6.4 lockbolts MagnaGrip®* and C6L

SCOPE OF DELIVERY

Nosepiece in working position
Swivelling hanger
Li-Ion power battery 2.6 Ah/14.4 V
Charger
Operating manual with spare parts list
Plastic carrying case

ADVANTAGES

- Battery powered lockbolt setting tool
- Processing anywhere
- Light and compact design
- Modular structure
- Ergonomic handling

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!

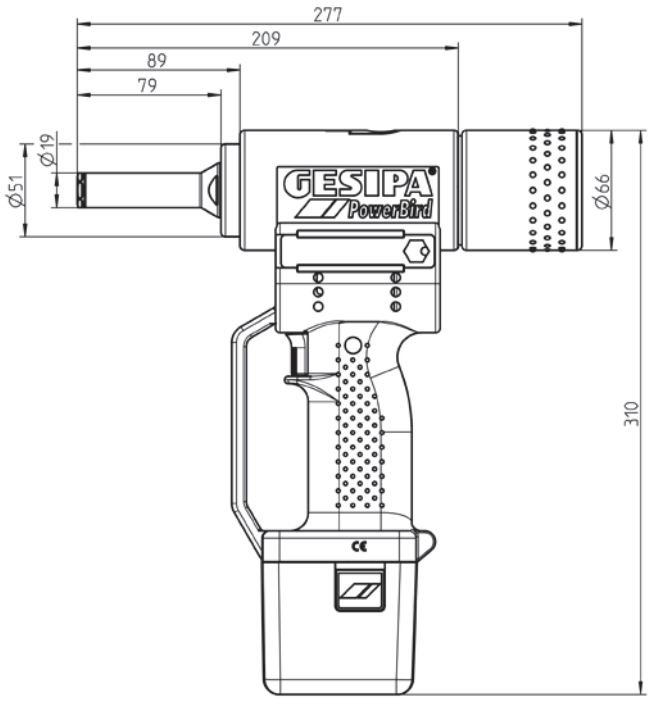
JAW MECHANISM ASSIGNMENT

For lockbolts 4.8 mm Magna-Grip®

Designation	No.
Nosepiece	**143 5942**
Supporting ring	**143 5943**
Jaw	**144 6105**
Jaw housing	**143 5997**

For lockbolts 4.8 mm C6L

Designation	No.
Nosepiece	**143 5993**
Supporting ring	**143 5995**
Jaw	**144 6116**
Jaw housing	**143 5997**



Dimensions in mm

TAURUS® 3 SRB

TAURUS® 3 For lockbolts 4.8 mm Magna-Grip®

No. 145 0953

TAURUS® 3 for lockbolts 4.8mm C6L

No. 145 0952

*Registered trademark of Alcoa Fastening Systems

TECHNICAL DATA

Weight:	2.0 kg
Operating air pressure:	5 - 7 bar
Air hose connection Ø:	6 mm
Air consumption:	4.8 NL / stroke
Traction power:	18,000 N at 6 bar
Stroke:	25 mm

WORKING RANGE

4.8 lockbolts MagnaGrip®* and C6L

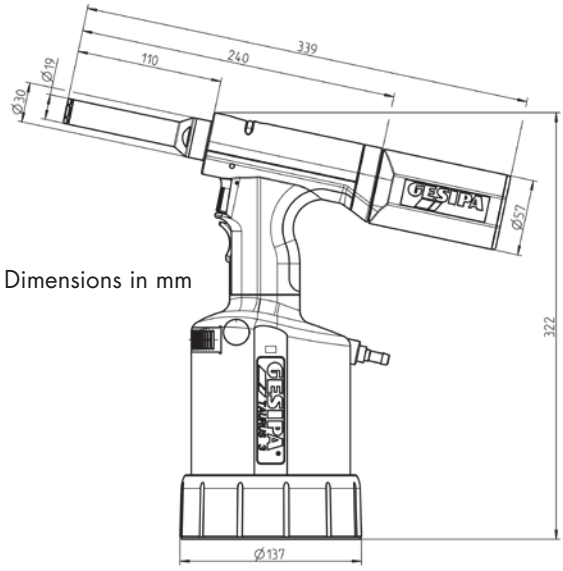
SCOPE OF DELIVERY

1 hydraulic oil bottle 100 ml
1 oil refill can
Hanger on tool head
Operating instructions with spare parts list

ADVANTAGES

- Specially adjusted stroke for setting lockbolts
- Very high tensile strength allows fast setting
- Extremely handy and leightweight due to its compact design
- Economic consumption of compressed air
- Minimum wear and tear due to use of pulling head modules with jaws respectively adjusted in their numbers of parts
- Efficient operation through extraction of spent mandrels
- Large spent mandrel container
- Attractive price-performance ratio
- Modular structure

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!



Dimensions in mm

JAW MECHANISM ASSIGNMENT

For lockbolts 4.8 mm Magna-Grip®

Designation	No.
Nosepiece	**143 4810**
Jaw	**144 6118**
Jaw housing	**143 5945**

For lockbolts 4.8 mm C6L

Designation	No.
Nosepiece	**143 4809**
Supporting ring	**143 5995**
Jaw	**144 6117**
Jaw housing	**143 5944**

TAURUS® 4 SRB

TAURUS® 4 for lockbolts
6.4 mm (1/4") Magna-Grip®*
No. 145 0986

TAURUS® 4 for lockbolts
6.4 mm (1/4") C6L
No. 145 0985

*Registered trademark
of Alcoa Fastening Systems

TECHNICAL DATA

Weight:	2.2 kg
Operating air pressure:	5-7 bar
Schlauchanschluss:	6 mm Ø (1/4")
Air hose connection:	ca. 4.8 ltr. pro Niet
Setting force:	23,000 N at 6 bar
Stroke:	19 mm

WORKING RANGE

6.4 lockbolts MagnaGrip®* and C6L

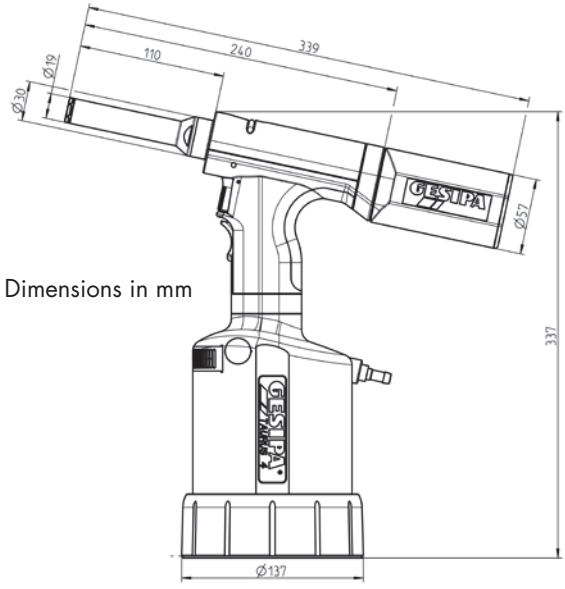
SCOPE OF DELIVERY

1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list
Hanger on tool head

ADVANTAGES

- Specially adjusted stroke for setting lockbolts
- Very high tensile strength allows fast setting
- Extremely handy and leightweight due to its compact design
- Economic consumption of compressed air
- Minimum wear and tear due to use of pulling head modules with jaws respectively adjusted in their numbers of parts
- Efficient operation through extraction of spent mandrels
- Large spent mandrel container
- Attractive price-performance ratio
- Modular structure

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!



Dimensions in mm

JAW MECHANISM ASSIGNMENT

For lockbolts 6.4 mm (1/4") Magna-Grip®*

Designation	No.
Nosepiece	**143 5942**
Supporting ring	**143 5943**
Jaw	**144 6105**
Jaw housing	**143 5997**

For lockbolts 6.4 mm (1/4") C6L

Designation	No.
Nosepiece	**143 5993**
Supporting ring	**143 5995**
Jaw	**144 6116**
Jaw housing	**143 5997**

TAURUS® 4 SRB *with angle head 90° compact*

TAURUS® 4 for SRB 6.4 mm MagnaGrip®*

No. 145 7990

TAURUS® 4
for SRB 6.4 mm C6L

No. 145 7989

*Registered trademark of Alcoa Fastening Systems

TECHNICAL DATA

Weight:	2.6 kg
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption:	approx. 4.8 NL per rivet
Setting force:	23,000 N at 6 bar
Stroke:	19 mm

WORKING RANGE

6.4 lockbolts MagnaGrip®* and C6L

SCOPE OF DELIVERY

Angle head with nosepiece in working position
Swivelling hanger
1 hydraulic oil bottle 100 ml
1 oil refill can
Operating instructions with spare parts list

ADVANTAGES

- Hydro-pneumatic lock bolt setting device
- Accessibility in tight working spaces
- Light and compact design
- Modular structure
- Ergonomic handling

The suitability of nosepiece and fastener needs to be tested by the user and is user's own responsibility!

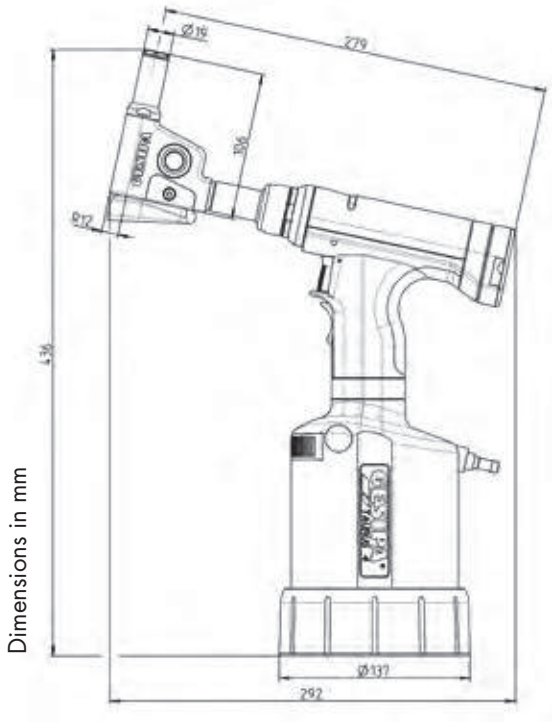
JAW MECHANISM ASSIGNMENT

For lockbolts 6.4 mm (1/4") Magna-Grip®*

Designation	No.
Nosepiece	**143 5942**
Supporting ring	**143 5943**
Jaw	**144 6105**
Jaw housing	**143 5997**

For lockbolts 6.4 mm (1/4") C6L

Designation	No.
Nosepiece	**143 5993**
Supporting ring	**143 5995**
Jaw	**144 6116**
Jaw housing	**143 5997**

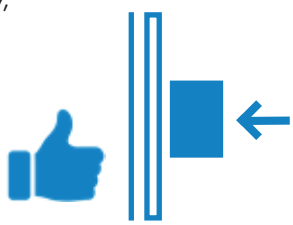


BLIND RIVET NUTS TECHNOLOGY

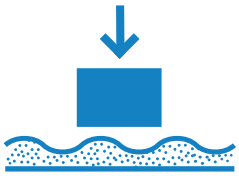
» trust
» move
» know
» understand
» create

GESIPA® BLIND RIVET NUT TECHNOLOGY GIVES YOU A MULTITUDE OF BENEFITS!

Easy and quick assembly, and the component only needs to be accessed from one side.

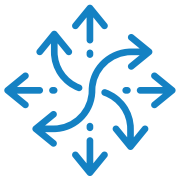


Placement of **high-quality** threads in **thin** and **soft** materials (steel, aluminium, magnesium, plastic, etc.)



No thermal influences on the components and therefore **no thermal distortion** or damage to the surfaces of the components. No reworking is necessary.

High degree of **flexibility** in the production process.



Production of **watertight** and **gas-tight** connections.

No emission of heat, smoke or welding fumes into the surrounding area and therefore no danger to people or the environment.

Low investment for assembly equipment. Versatile, can also be used for hybrid joints and soft materials.

GESIPA® BLIND RIVET NUTS

JOINING ELEMENT WITH THREAD

GESIPA® blind rivet nuts and blind rivet studs are joining elements used to produce load-bearing, high stress threads for non-permanent connections. Blind rivet nuts have an inside thread whereas blind rivet studs have an outside thread (threaded pin). As with blind rivets, two or more components can be joined with both joining elements.

APPLICATION-OPTIMISED JOINING ELEMENTS

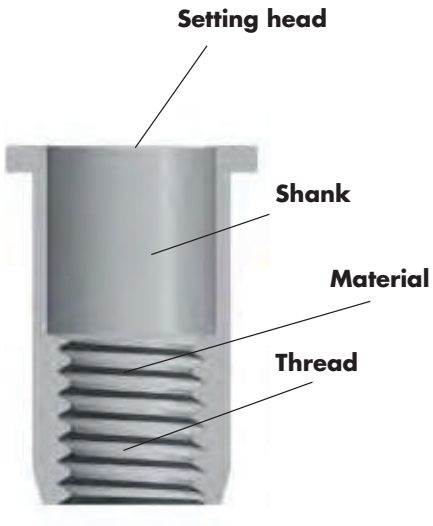
By manufacturing the joining elements ourselves at the GESIPA® production sites we are able to implement specific customer requirements economically and efficiently. We are the specialists for application-optimised blind rivet nuts and blind rivet studs.

APPLICATIONS

Blind rivet nuts and blind rivet studs are used in the most diverse areas of trade and industry – wherever a strong, non-permanent connection needs to be made. For example:

- Automotive
- White goods
- Heating and air conditioning
- Electronics
- Solar
- Construction
- Food

PROCESSING



GESIPA® BLIND RIVET NUT – TERMINOLOGY

The setting head is the part of the blind rivet nut that rests on the visible surface of the component. The user can choose between the following variants:

- **Dome head** – for a large contact surface on the
- component
- **Small head** – for minimum overlap of the blind rivet nut thus allowing the component to rest almost flat
- **Countersunk head** – for flat surfaces in countersunk holes

The **shank** is the part of the blind rivet nut that deforms during the setting procedure and fixes the blind rivet nut in the component. The so-called bulb is formed in this process. The user can choose from the following variants: Round, Knurled and Polygon (hexagon or square)

The material

Specific to the application, the customer can use blind rivet nuts made from steel, aluminium or stainless steel.

The thread

The GESIPA® blind rivet nuts have a metric thread as standard. The steel blind rivet nuts meet the requirements of strength class 8.8. Other dimensions, such as imperial or coarse thread, are available on request.

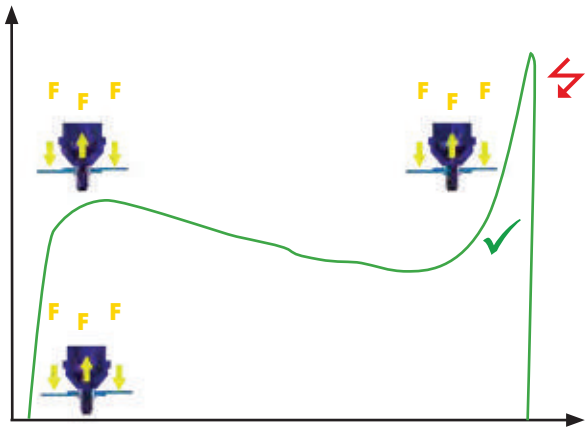
TECHNICAL DATA

» high quality
» tested
» safe

YOUR BENEFIT
The specified forces and torques correspond to calculated values or values determined in tests. They aim to help the user select the suitable fastener. GESIPA® recommends testing the blind rivet nuts in the application. The actual values may differ from the information in the catalogue due to different circumstances. Please contact our technical team for further help and advice.

THE SETTING PROCESS
The picture shows a diagram of the force-stroke curve for setting a blind rivet nut in the lower clamping range. Initially the force rises steeply because the deformation zone of the blind rivet nut is first compressed. Once a certain force is reached, the deformation zone starts to fold outwards. Due to the fact that the resistance of the material is lower during the deformation and creation of the closing head, the force drops slightly.

FORCE DIAGRAM FOR A SETTING PROCESS
When the closing head meets the backside of the application, the pulling force starts increasing again. To ensure that the blind rivet nut sits tightly on the application material and does not slip when subjected to torque, the closing head must lie completely flat on the joining material (see cross-sections of the blind rivet nuts on the following page). If the setting process is not interrupted, the force will continue to rise until the thread is destroyed.



TECHNICAL DATA

SCHEMATIC LAYOUT FOR THE TORQUE TEST

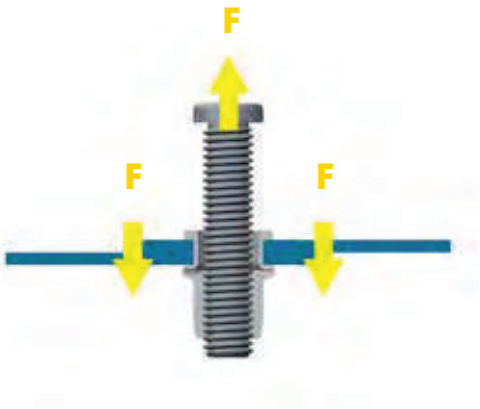
The tightening torque [(Nm) or (lb-ft)] specifies the maximum torque with which the screw can be tightened.

For testing, GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants. A hardened washer is used as the clamping part. The test is carried out in the lower and the upper clamping range, where the blind rivet nuts are loaded with the specified torque. Then the screw is screwed out again.

The thread must still turn smoothly in order to pass the test. Then the blind rivet nut is loaded again up to the overtorque.

SCHEMATIC LAYOUT FOR THE THREAD TEAR-OUT TEST

The maximum bearable axial load on the thread is the thread breaking force [(N) and (kp)]. GESIPA® uses screws of the strength class 10.9 or higher that are free of all lubricants for the test. The test takes place in the lower and upper clamping range.



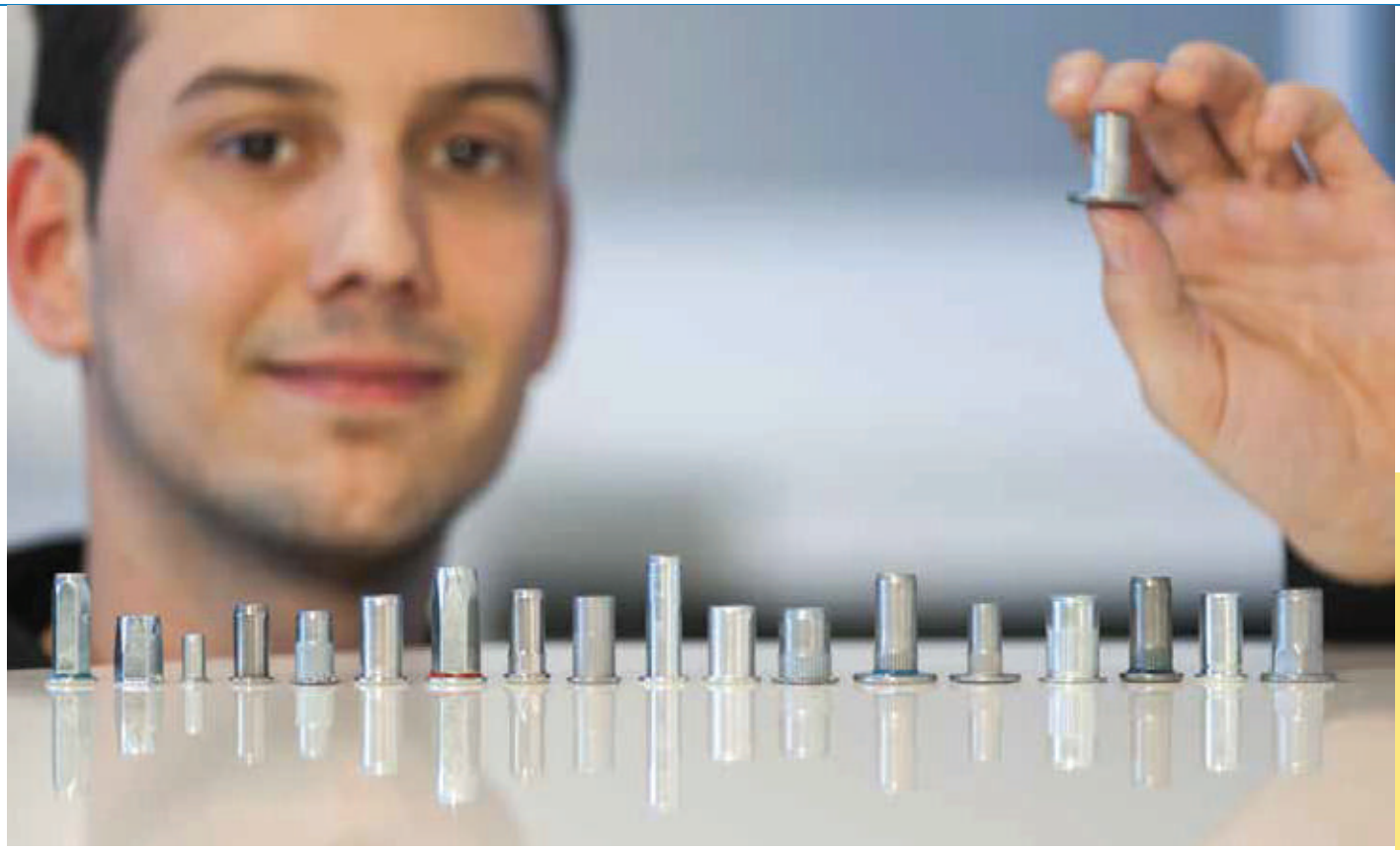
THE TIGHTENING TORQUE (NM) AND (LB-FT)

	Alu		Steel		Stainless steel A2 /A4 / Monel®	
	Nm	(lb-ft)	**Nm**	(lb-ft)	**Nm**	(lb-ft)
M4	**2.5**	1.8	**3.0**	2.2	**5.5**	4.1
M5	**5.0**	3.7	**8.0**	5.9	**14.0**	10.3
M6	**9.5**	7.0	**12.0**	8.9	**27.0**	19.9
M8	**17.5**	12.9	**30.0**	22.1	**40.0**	29.5
M10	**28.0**	20.7	**38.0**	28.0	**-**	

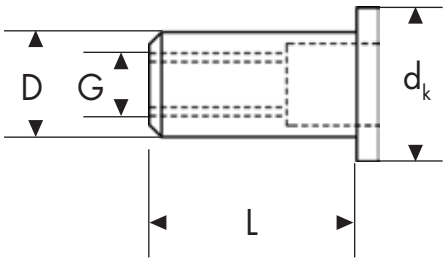
THREAD BREAKING FORCE (N) AND (KP)

	Alu		Steel		Stainless steel A2 /A4 / Monel®	
	N	(kp)	**N**	(kp)	**N**	(kp)
M4	**4,800**	489	**8,000**	815	**10,000**	1,019
M5	**5,700**	581	**11,500**	1,172	**15,000**	1,529
M6	**9,500**	968	**18,000**	1,836	**> 25,000**	2,548
M8	**13,000**	1,325	**28,000**	2,853	**> 30,000**	3,057
M10	**14,000**	1,427	**30,000**	3,057	**-**	

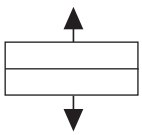
TECHNICAL DATA



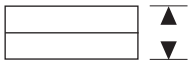
GESIPA® BLIND RIVET NUTS – DIMENSIONS



D = Rivet nut body Ø
L = Rivet nut body length
d_k = Setting head Ø
G = Thread dimension



Shear strength



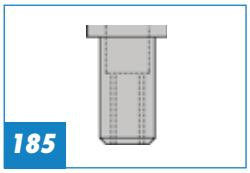
Grip range

Hole Ø = d_h

BLIND RIVET NUTS RANGE

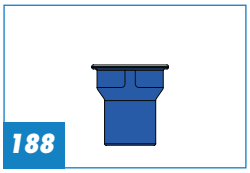
STANDARD

185



Alu

Steel splined



Steel square bodied

Steel half hexagonal

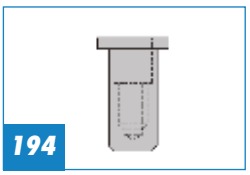
Stainless steel A2

Stainless steel A2
half hexagonal

Stainless steel A4

Stainless steel A4
half hexagonal

Monel®



Alu closed end (CAP®)

Steel closed end (CAP®)

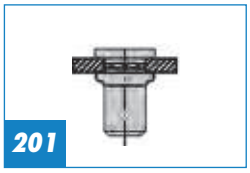
196

Light Weight

High Strenght

Torque resistant

G-Sealed®



PolyGrip® alu

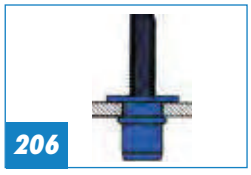
PolyGrip® steel

PolyGrip®
stainless steel A2

PolyGrip®
stainless steel A4

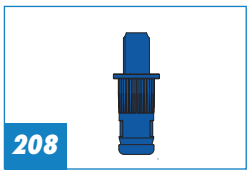
PolyGrip® splined steel

SoftGrip® steel and
stainless steel A2

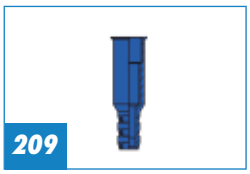


Blind rivet nut stud steel

Blind rivet nut stud steel
half hexagonal



PolyGrip® blind rivet nut
stud steel splined

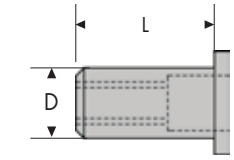


Blind rivet nuts with
hose connection

All steel blind rivet nuts
are splined!

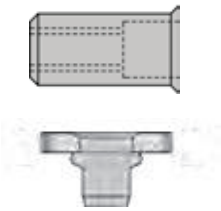
BLIND RIVET NUTS ALU Material: AlMg 3

Standard
Dome head



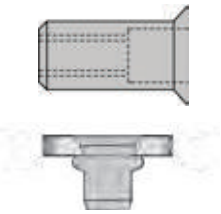
D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 11.0**	0.25 - 3.0	**143 3676**	A 500
	6 x 13.0	2.5 - 4.5	**143 3677**	"
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	**143 3678**	A 500
	7 x 13.5	2.5 - 5.0	**143 3679**	"
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**143 3680**	A 250
	9 x 18.0	3.0 - 5.5	**143 3681**	"
M 8 11.1 mm	**11 x 17.0**	0.25 - 3.5	**143 3682**	A 100
	11 x 20.0	3.0 - 6.0	**143 3683**	"
M 10 12.1 mm	**12 x 17.5**	0.25 - 3.5	**143 3684**	A 100
	12 x 20.5	3.0 - 6.0	**145 5345**	"

Small head



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	0.5 - 3.0	**143 3685**	A 500
M 5 7.1 mm	**7 x 12.5**	0.5 - 3.0	**143 3686**	A 500
M 6 9.1 mm	**9 x 15.5**	0.5 - 3.5	**143 3687**	A 250

Countersunk
(90°)



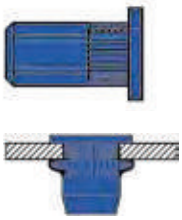
D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	1.5 - 3.5	**145 5346**	A 500
	6 x 13.5	3.0 - 5.0	**145 5347**	"
M 5 7.1 mm	**7 x 13.5**	1.5 - 4.0	**145 5348**	A 500
	7 x 15.5	3.5 - 6.0	**145 5349**	"
M 6 9.1 mm	**9 x 17.0**	1.5 - 4.5	**145 5350**	A 250
	9 x 19.0	4.0 - 6.5	**145 5351**	"
M 8 11.1 mm	**11 x 18.5**	1.5 - 4.5	**145 5352**	A 100
	11 x 20.5	4.0 - 6.5	**145 5353**	"
M 10 12.1 mm	**12 x 19.0**	1.5 - 4.5	**145 5354**	A 100
	12 x 21.0	4.0 - 6.5	**145 5355**	"

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS STEEL SPLINED Material: Steel, zinc-plated

Standard



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 11.0**	0.25 - 3.0	**143 3703**	A 500
	6 x 13.0	2.5 - 4.5	**145 5362**	"
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	**143 3704**	A 500
	7 x 13.5	2.5 - 5.0	**143 3705**	"
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**143 3706**	A 250
	9 x 18.0	3.0 - 5.5	**145 5363**	"
	9 x 21.0	5.5 - 8.0	**145 0364****	A 200
	9 x 24.5	8.0 - 11.0	**145 0365****	"
M 8 11.1 mm	**11 x 17.0**	0.25 - 3.5	**143 3707**	A 100
	11 x 20.0	3.0 - 6.0	**143 3708***	"
	11 x 21.5	6.0- 9.0	**145 0366***	"
	11 x 25.5	9.0 - 12.0	**145 0367***	"
M 10 12.1 mm	**12 x 17.5**	0.25 - 3.5	**143 3709**	A 100
	12 x 20.5	3.0 - 6.0	**143 3710**	"

*Cannot be used with the standard mandrel + nosepiece. A longer mandrel + nosepiece, or a conversion kit for DIN screws, is needed for this, page 231, 243, 249, 251and page 215/216 (**does not apply to GMB 40-R /GBM 50)

Small head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	0.25 - 3.0	**143 3711**	A 500
M 5 7.1 mm	**7 x 12.5**	0.25 - 3.0	**143 3712**	A 500
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**143 3713**	A 250
	9 x 19.0	3.5 - 5.5	**145 0368**	"
	9 x 22.0	5.5 - 8.0	**145 0369****	"
M 8 11.1mm	**11 x 17.0**	0.25 - 3.5	**143 3714**	A 100
	11 x 21.0	3.5 - 5.5	**145 0370***	"
	11 x 23.0	5.5 - 9.0	**145 0371***	"
M 10 12.1mm	**12 x 18.0**	1.5 - 4.5	**146 4890**	A 100
	12 x 20.0	4.0 - 6.5	**146 4889**	"

*Cannot be used with the standard mandrel + nosepiece. A longer mandrel + nosepiece, or a conversion kit for DIN screws, is needed for this, page 231, 243, 249, 251and page 215/216 (**does not apply to GMB 40-R /GBM 50)

BLIND RIVET NUTS STEEL SPLINED Material: Steel, zinc-plated

Countersunk
(90°)

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	1.5 - 3.5	**145 5365**	A 500
	6 x 13.5	3.0 - 5.0	**145 5366**	"
M 5 7.1 mm	**7 x 13.5**	1.5 - 4.0	**145 5367**	A 500
	7 x 15.5	3.5 - 6.0	**145 5368**	"
M 6 9.1 mm	**9 x 17.0**	1.5 - 4.5	**145 5369**	A 250
	9 x 19.0	4.0 - 6.5	**145 5370**	"
	9 x 23.0	6.5 - 9.0	**145 0372****	A 200
M 8 11.1 mm	**11 x 18.5**	1.5 - 4.5	**143 3715**	A 100
	11 x 20.5	4.0 - 6.5	**145 5371***	"
	11 x 23.0	6.5 - 9.0	**145 0373***	"
M 10 12.1 mm	**12 x 19.0**	1.5 - 4.5	**145 5372**	A 100
	12 x 21.0	4.0 - 6.5	**145 5373**	"

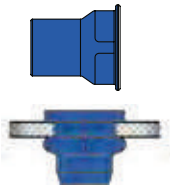
*Cannot be used with the standard mandrel + nosepiece. A longer mandrel + nosepiece, or a conversion kit for DIN screws, is needed for this, page 231, 243, 249, 251and page 215/216 (**does not apply to GMB 40-R /GBM 50)

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS STEEL Material: Steel, zinc-plated

Square bodied
Standard
Dome head



D	D x L mm	mm	No.	
M 5 SW7.1 + 0.1	**7 x 12**	0.5 - 3.0	**146 4921**	A 500
M 6 SW9.1 + 0.1	**9 x 15.5**	0.5 - 3.0	**146 4922**	A 250
M 8 SW11.1 + 0.1	**11 x 17**	0.5 - 3.0	**146 4923**	A 100

Half hexagonal
Standard
Dome head

D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5377**	A 500
M 5 SW7 + 0.1	**7 x 12.0**	0.5 - 3.0	**145 5378**	A 500
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5379**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**143 3716**	A 100

Half hexagonal
Small head

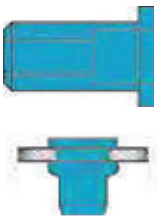
D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5380**	A 500
M 5 SW7 + 0.1	**7 x 12.5**	0.5 - 3.0	**145 5381**	A 500
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5382**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**145 5383**	A 100

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS STAINLESS STEEL A2 Material: Stainless steel A2 1.45677

Standard
Dome head



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 11.0**	0.25 - 3.0	**145 5444**	A 500
	6 x 13.0	2.5 - 4.0	**145 5445**	"
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	**143 3725**	A 500
	7 x 13.5	2.5 - 4.5	**143 3726**	"
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**145 5446**	A 250
	9 x 18.0	3.0 - 5.5	**145 5447**	"
M 8 11.1 mm	**11 x 17.0**	0.25 - 3.5	**145 5448**	A 100
	11 x 20.0	3.0 - 6.0	**145 5449**	"

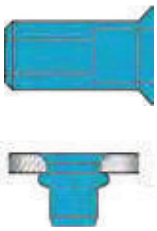
Material surcharge will be added at a daily rate

Small head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	0.25 - 3.0	**143 3727**	A 500
M 5 7.1 mm	**7 x 12.5**	0.25 - 3.0	**143 3728**	A 500
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**143 3729**	A 250
M 8 11.1mm	**11 x 17.0**	0.25 - 3.5	**143 3730**	A 100

Material surcharge will be added at a daily rate

Countersunk



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	1.5 - 3.0	**143 3731**	A 500
	6 x 13.0	2.5 - 4.0	**145 5450**	"
M 5 7.1 mm	**7 x 13.5**	1.5 - 4.0	**143 3732**	A 500
	7 x 15.5	3.5 - 6.0	**145 5451**	"
M 6 9.1 mm	**9 x 17.0**	1.5 - 4.5	**143 3733**	A 250
	9 x 18.5	4.0 - 6.0	**145 5452**	"
M 8 11.1 mm	**11 x 18.5**	1.5 - 4.5	**143 3734**	A 100
	11 x 20.0	4.0 - 6.0	**145 5453**	"

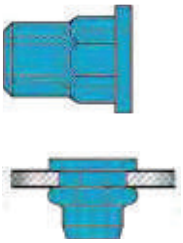
Material surcharge will be added at a daily rate

BLIND RIVET NUTS STAINLESS STEEL A2 HALF HEXAGONAL

Material: Stainless steel A2 1.4567

Standard

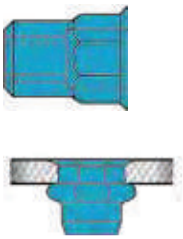
Dome head



D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5454**	A 500
M 5 SW7 + 0.1	**7 x 12.0**	0.5 - 3.0	**145 5455**	"
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5456**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**145 5457**	A 100

Material surcharge will be added at a daily rate

Small head



D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5458**	A 500
M 5 SW7 + 0.1	**7 x 12.0**	0.5 - 3.0	**145 5459**	"
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5460**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**145 5461**	A 100

Material surcharge will be added at a daily rate

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS STAINLESS STEEL A4

Material: Stainless steel A4 1.4578

Standard
Dome head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 11.0**	0.25 - 3.0	**145 5468**	A 500
	6 x 13.0	2.5 - 4.0	**145 5473**	"
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	**145 5475**	"
	7 x 13.5	2.5 - 4.5	**145 5478**	"
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**145 5462**	A 250
	9 x 18.0	3.0 - 5.5	**145 0381**	"
M 8 11.1 mm	**11 x 17.0**	0.25 - 3.5	**145 5480**	A 100
	11 x 20.0	3.0 - 6.0	**145 5485**	"

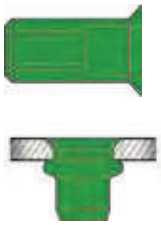
Material surcharge will be added at a daily rate

Small head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	0.25 - 3.0	**145 5472**	A 500
M 5 7.1 mm	**7 x 12.5**	0.25 - 3.0	**145 5476**	"
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**145 5465**	A 250
M 8 11.1mm	**11 x 17.0**	0.25 - 3.5	**145 5481**	A 100

Material surcharge will be added at a daily rate

Countersunk



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 12.0**	1.5 - 3.0	**145 5471**	A 500
	6 x 13.0	2.5 - 4.0	**145 5474**	"
M 5 7.1 mm	**7 x 13.5**	1.5 - 4.0	**145 5479**	"
	7 x 15.5	3.5 - 6.0	**145 0382**	"
M 6 9.1 mm	**9 x 17.0**	1.5 - 4.5	**145 5464**	A 250
	9 x 18.5	4.0 - 6.0	**145 5463**	"
M 8 11.1 mm	**11 x 18.5**	1.5 - 4.5	**145 5484**	A 100
	11 x 20.0	4.0 - 6.0	**145 5486**	"

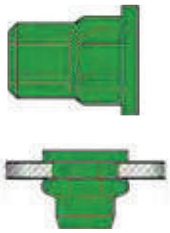
Material surcharge will be added at a daily rate

BLIND RIVET NUTS STAINLESS STEEL A4 HALF HEXAGONAL

Material: Stainless steel A4 1.4578

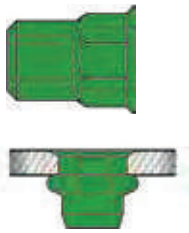
Standard

Dome head



D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5469**	A 500
M 5 SW7 + 0.1	**7 x 12.0**	0.5 - 3.0	**144 6456**	"
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5466**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**145 5482**	A 100

Small head



D	D x L mm	mm	No.	
M 4 SW6 + 0.1	**6 x 11.0**	0.5 - 2.0	**145 5470**	A 500
M 5 SW7 + 0.1	**7 x 12.0**	0.5 - 3.0	**145 5477**	"
M 6 SW9 + 0.1	**9 x 15.5**	0.5 - 3.0	**145 5467**	A 250
M 8 SW11 + 0.1	**11 x 17.0**	0.5 - 3.0	**145 5483**	A 100

Material surcharge will be added at a daily rate

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS MONEL®

Material: Monel 400 NiCu30Fe 2.4360

Standard

Dome head

D	D x L mm	mm	No.	
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	**146 4292**	A 500
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.5	**145 5489**	A 250
M 8 11.1 mm	**11 x 17.0**	0.25 - 3.5	**146 4291**	A 100

Material surcharge will be added at a daily rate

SHAFT GEOMETRY ROUND AND SPLINED; ALL MATERIALS

Dome head			Countersunk		Small head	
Size mm	**Head diameter** mm	**Height of head** mm	**Head diameter** mm	**Height of head** mm	**Head diameter** mm	**Height of head** mm
M 4	**9**	**0.80**	**9**	**1.5 - 1.6**	**7.1**	**0.70**
M 5	**10**	**1.00**	**10**	**1.5 - 1.6**	**8.1**	**0.70**
M 6	**12**	**1.50**	**12**	**1.5 - 1.6**	**10.1**	**0.70**
M 8	**14**	**1.50**	**14**	**1.5 - 1.6**	**12.1**	**0.70**
M 10	**15**	**1.50**	**15**	**1.5 - 1.6**	**13.1**	**0.70**

SHAFT GEOMETRY HALF HEXAGONAL; ALL MATERIALS

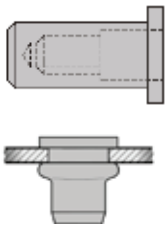
Dome head			Small head	
Size mm	**Head diameter** mm	**Height of head** mm	**Head diameter** mm	**Height of head** mm
M 4	**9**	**0.80**	**7.4**	**0.60**
M 5	**10**	**1.00**	**8.4**	**0.70**
M 6	**13**	**1.50**	**10.4**	**0.70**
M 8	**16**	**1.50**	**12.4**	**0.70**

BLIND RIVET NUTS ALU CLOSED END (CAP®)

Material: AlMg 3

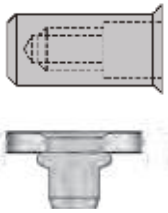
Standard

Dome head



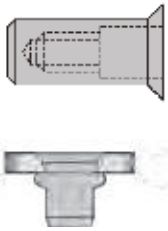
D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 15.0**	0.25 - 3.0	**146 4107**	A 500
	6 x 17.0	2.5 - 4.5	**146 4108**	"
M 5 7.1 mm	**7 x 17.0**	0.25 - 3.0	**146 4109**	A 500
	7 x 19.0	2.5 - 5.0	**146 4110**	A 250
M 6 9.1 mm	**9 x 21.5**	0.25 - 3.5	**146 4111**	A 100
	9 x 24.5	3.0 - 5.5	**146 4112**	"
M 8 11.1 mm	**11 x 24.0**	0.25 - 3.5	**146 4113**	A 100
	11 x 27.0	3.0 - 6.0	**146 4114**	"

Small head



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 16.0**	0.25 - 3.0	**146 4115**	A 500
M 5 7.1 mm	**7 x 18.0**	0.25 - 3.0	**146 4116**	A 500
M 6 9.1 mm	**9 x 21.5**	0.25 - 3.5	**146 4117**	A 250

Countersunk (90°)



D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 16.0**	1.5 - 3.0	**146 4099**	A 500
	6 x 17.5	3.0 - 5.0	**146 4100**	"
M 5 7.1 mm	**7 x 19.0**	1.5 - 4.0	**146 4101**	A 250
	7 x 21.0	3.5 - 6.0	**146 4102**	"
M 6 9.1 mm	**9 x 23.0**	1.5 - 4.5	**146 4103**	A 100
	9 x 25.0	4.0 - 6.5	**146 4104**	"
M 8 11.1 mm	**11 x 25.5**	1.5 - 4.5	**146 4105**	A 100
	11 x 27.5	4.0 - 6.5	**146 4106**	"

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUTS STEEL CLOSED END (CAP®)

Material: Steel, zinc-plated

Standard

Dome head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 15.0**	0.25 - 3.0	**143 2370**	A 500
	6 x 17.0	2.5 - 4.5	**143 2369**	"
M 5 7.1 mm	**7 x 17.0**	0.25 - 3.0	**143 2373**	A 500
	7 x 19.0	2.5 - 5.0	**143 2374**	"
M 6 9.1 mm	**9 x 21.5**	0.25 - 3.5	**143 2375**	A 100
	9 x 24.5	3.0 - 5.5	**143 2376**	"
M 8 11.1 mm	**11 x 24.0**	0.25 - 3.0	**143 2377**	A 100
	11 x 27.0	3.0 - 6.0	**143 2378**	"

Small head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 16.0**	0.25 - 3.0	**146 4295**	A 500
M 5 7.1 mm	**7 x 18.0**	0.25 - 3.0	**146 4294**	A 250
M 6 9.1 mm	**9 x 21.5**	0.25 - 3.5	**146 4293**	A 100

Countersunk (90°)

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 16.0**	1.5 - 3.0	**143 2379**	A 500
	6 x 17.5	3.0 - 5.0	**143 2380**	"
M 5 7.1 mm	**7 x 19.0**	1.5 - 4.0	**143 2381**	A 250
	7 x 21.0	3.5 - 6.0	**143 2382**	"
M 6 9.1 mm	**9 x 23.0**	1.5 - 4.5	**143 2383**	A 100
	9 x 25.0	4.0 - 6.5	**143 2385**	"
M 8 11.1 mm	**11 x 25.5**	1.5 - 4.5	**146 4297**	A 100
	11 x 27.5	4.0 - 6.5	**146 4296**	"

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

BLIND RIVET NUT LIGHT WEIGHT

NEW

**Blind rivet nut Light Weight –
When every gram counts!
Light. Compact. Strong**

LIGHT WEIGHT BLIND RIVET NUT

The new blind rivet nut light weight is the next evolutionary step at the blind rivet technology. This blind rivet nut focus and supports the trends at all industry sectors, which are weight reduction and save of resources.

The blind rivet nut light weight can save up to 50% weight by optimising of material and design and has the equal mechanical characteristics at the same time.

ADVANTAGES

- Weight savings up to 50%
- Less space required (on the blind side)
- Mechanical characteristics equal or better compared to standard blind rivet nuts
- Fast process
- Process control available
- No refinishing operations required
- No third material (glue)
- No aging issues
- Oneside access

5 STANDARD
BLIND RIVET NUTS
21.3 g

≅

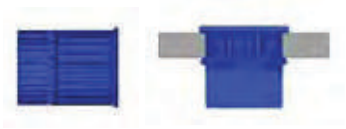
10 LIGHT WEIGHT
BLIND RIVET NUTS
20.6 g

BLIND RIVET NUT LIGHT WEIGHT Material: Steel, zinc-plated

Steel splined
Standard
Dome head

D	D x L mm	mm	No.	
M 5 7.1 mm + 0.1mm	**7 x 9.5**	0.5 - 3.0	**165 8768**	A 500
M 6 9.1 mm + 0.1mm	**9 x 10.5**	0.5-3.5	**165 8766**	A 250

Steel splined
Small head



D	D x L mm	mm	No.	
M 5 7.1 mm + 0.1mm	**7 x 9.5**	0.5 - 3.0	**165 8769**	A 250
M 6 9.1 mm + 0.1mm	**9 x 10.5**	0.5 - 3.5	**165 8767**	A 100

6

THE TIGHTENING TORQUE (NM) AND (LB-FT)

	Steel Nm	(lb-ft)
M5	**8.0**	5.9
M6	**12.0**	8.9

THREAD BREAKING FORCE (N) AND (KP)

	Steel N	(kp)
M5	**11,500**	1,172
M6	**18,000**	1,836

SHAFT GEOMETRY ROUND AND SPLINED; ALL MATERIALS

	Dome head		Countersunk		Small head	
Size mm	**Head diameter** mm	**Height of head** mm	**Head diameter** mm	**Height of head** mm	**Head diameter** mm	**Height of head** mm
M 5	10	1.00	10	1.5 - 1.6	8.1	0.70
M 6	12	1.50	12	1.5 - 1.6	10.1	0.70

BLIND RIVET NUT HIGH STRENGTH

HIGH-STRENGTH BLIND RIVET NUT

The new high-strength blind rivet nut is the ideal choice for all applications where a particularly strong thread is required. The thread-breaking strength far exceeds that of a standard blind rivet nut and the half-hexagonal shank provides the appropriate anti-twist protection.

AREAS OF APPLICATION

> Perfectly suited for high-load applications in shell construction
> Structural components (e.g. safety components, etc.)
>

STRENGTH

> 10.9 or 12.9 for steel blind rivet nut
> 10.9 for steel blind rivet stud
> 8.8 for aluminium blind rivet nut

ADVANTAGES

> Quick assembly with access from only one side
> A solution for high-load applications
> Process monitoring possible
> Mechanical properties are significantly higher than those of standard steel blind rivet nuts
> Optimises the connections for different applications (e.g. weight reduction)
> Can be combined with customer-specific requirements and other GESIPA® innovations

Further information on the new products can be obtained from product management. Please contact us!

BLIND RIVET NUT TORQUE RESISTANT

BLIND RIVET NUT TORQUE RESISTANT
The new torque-resistant blind rivet nut is the perfect solution when it comes to inserting threaded elements into aluminium profiles, with access only required from one side. According to the current state of the art, the rivet nut achieves mechanical properties that would otherwise only be possible when using hexagonal blind rivet nuts.

APPLICATIONS
Aluminium extruded profiles with one-side access to the riveting position:

> Girder/side rail
> Safety systems
> Profile Structures

PRODUCT PORTFOLIO
> Blind Rivet Nut Steel M6 with wedges under the head
> Blind Rivet Nut Steel M8 with wedges under the head
> Blind Rivet Nut Steel M10 with wedges under the head

ADVANTAGES

> **PROCESS RELIABILITY**
Increased Torque Resistance during the assembly process
> **FAST**
Reduction of the costs and the process time per assembly
> **CUSTOMIZED**
Different plating is possible depending
> on corrosion requirements
> **COMPATIBLE WITH COMPLETE GESIPA® SYSTEMS**
Joint integrity control possible with process control
> **ECONOMIC**
Increasing of the economy in comparison to a hexagonal blind rivet nut

BLIND RIVET NUT G-SEALED®

The new blind rivet nut with pre-coating is especially durable

BLIND RIVET NUT G-SEALED®
G-Sealed® is a nonreactive coating that can be applied to create an under head seal to blind rivet nuts, blind rivet nut studs & blind rivets.

APPLICATIONS
G-Sealed® can be used in many areas of application but is especially suited to the automotive industry due to its excellent thermal & chemical resistance.

ADVANTAGES
> Non-reactive and non-hardening coating
> Instant sealing as soon as the fastener is installed
> A dry, elastic, non-slip coating
> Good thermal and chemical resistance
> Applicable for metallic and non-metallic materials
> No markings and therefore not dangerous or harmful to the environment

Standard with G-Sealed®

Dome head

D	D x L mm	mm	No.	
M 4 6.1 mm	**6 x 15.0**	0.25 - 3.0	**166 6799**	A 500
M 5 7.1 mm	**7 x 17.0**	0.25 - 3.0	**166 6800**	A 500
M 6 9.1 mm	**9 x 21.5**	0.25 - 3.5	**166 6801**	A 100
M 8 11.1 mm	**11 x 24.0**	0.25 - 3.0	**166 6802**	A 100

Other dimensions on request.

POLYGRIP® BLIND RIVET NUTS

The GESIPA® blind rivet nuts with a large grip range

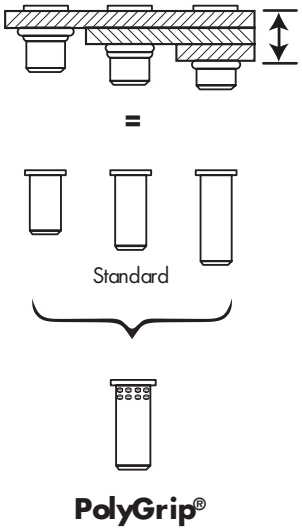
THE POLYGRIP® BLIND RIVET NUTS
Die PolyGrip® blind rivet nuts are the logical further development of many years of experience with our PolyGrip® multi-range blind rivets. Thanks to the benefits of its large drilling hole tolerance and the option of covering various grip ranges with just one fastener, the PolyGrip® blind rivet nut has become a first-choice connector in many industrial applications and in trade.

Bringing together multiple dimensions saves handling and storage costs while also permanently reducing the risk of confusion in the workplace and the quality problems this can result in.

LARGE GRIP RANGE: Ideally, the one PolyGrip® blind rivet nut can replace up to five different dimensions of DIN standard blind rivet nuts thanks to the large grip range.

Your benefits:

- Type simplification
- Limited type variety for reduced stocks
- Lower risk of confusion therefore fewer mistakes in production

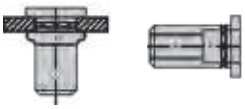


The best setting results can be achieved with GESIPA® FireBird® Pro!

POLYGRIP® BLIND RIVET NUTS

Aluminium
Standard

Dome head



Material: AlMg 2.5

D	D x L mm	mm	No.	
M 5 7.1 mm	**7 x 13.5**	0.25 - 5.0	**143 3791**	A 500
M 6 9.1 mm	**9 x 18.0**	0.25 - 6.0	**143 3792**	A 250
M 8 11.1mm	**11 x 20.0**	0.5 - 6.5	**145 5561**	A 100

Steel
Standard

Dome head

Material: Steel Surface: Zinc-plated

D	D x L mm	mm	No.	
M 5 7.1 mm	**7 x 13.5**	0.25 - 5.0	**143 3793**	A 500
M 6 9.1 mm	**9 x 18.0**	0.25 - 6.0	**143 3794**	A 250
M 8 11.1mm	**11 x 20.0**	0.5 - 6.5	**143 3795**	A 100

Stainless Steel A2
Standard

Dome head

Material: Stainless Steel A2 1.4567, polished

D	D x L mm	mm	No.	
M 5 7.1 mm	**7 x 13.5**	0.25 - 5.0	**143 3796**	A 500
M 6 9.1 mm	**9 x 18.0**	0.5 - 6.0	**143 3797**	A 250
M 8 11.1 mm	**11 x 20.0**	0.5 - 6.5	**143 3798**	A 100

Material surcharge will be added at a daily rate

Stainless Steel A4
Standard

Dome head

Material: Stainless Steel A4 1.4578, polished

D	D x L mm	mm	No.	
M 5 7.1 mm	**7 x 13.5**	0.25 - 5.0	**145 0393**	A 500
M 6 9.1 mm	**9 x 18.0**	0.5 - 6.0	**145 5567**	A 250
M 8 11.1 mm	**11 x 20.0**	0.5 - 6.5	**145 5568**	A 100

Material surcharge will be added at a daily rate

182

The maximum tightening torque and the threaded breaking force and shear strengths for all blind rivet nuts can be found on **page 182.** For head diameters, please report to **page 193**.

POLYGRIP® BLIND RIVET NUTS SPLINED

Splined multi-range blind rivet nuts for improved anti-twist protection in soft materials

The new GESIPA® splined PolyGrip® blind rivet nuts made from M6 and M8 steel are a further development of the well-proven PolyGrip® multi-range blind rivet nuts. They combine the advantages of covering large grip ranges with the knurling for increased anti-twist protection.

The long longitudinal knurling ensures uniform setting characteristics over the entire grip range and a large closing head.

In the ideal case, the splined PolyGrip® blind rivet nut can replace up to 5 different standard DIN dimensions. This saves handling and storage costs while also reducing the risk of confusion in the workplace.

Steel Standard

Dome head

Material: Steel
Surface: galvanised

D	D x L mm	mm	No.	
M 6 9.1 mm	**9 x 18.0**	0.5 - 6.5	**145 5562**	A 250
M 8 11.1mm	**11 x 20.0**	0.5 - 8.0	**145 5563**	A 100

The best setting results can be achieved with GESIPA® FireBird® Pro!
page 224

SOFTGRIP® BLIND RIVET NUTS

SoftGrip® blind rivet nuts from GESIPA® make it easy to produce high-quality threads in sensitive lightweight applications

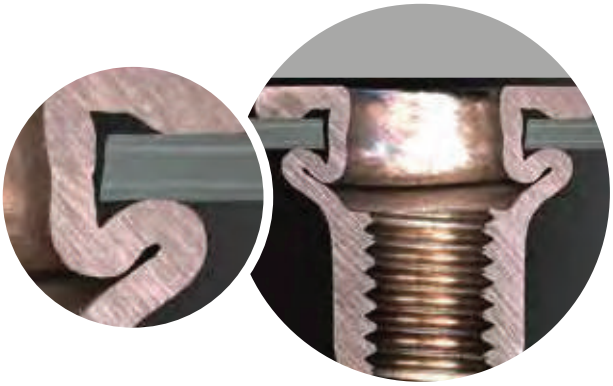
Carbon fibre-reinforced plastics (CFRP) offer indisputable and fascinated advantages when it comes to saving weight. They are, however, particularly demanding when selecting the partner material. Standard joining elements simply will not do for this high-grade material. GESIPA® has now developed a blind rivet nut for composite materials that meets the demanding requirements.

The SoftGrip® blind rivet nut from GESIPA® is a further development of the tried and tested PolyGrip® multi-range blind rivet nut. With the aid of a precisely controlled setting procedure, the component is barely subjected to bearing stress and contact pressure. The bulb that forms flat on the component with a large (larger than average) diameter ensures outstanding mechanical properties. Component damage such as crushing, cracking, delamination etc. are therefore effectively avoided.

Thanks to the controlled formation of the bulb and the thus reduced bearing stress, minimal edge spacing of the blind rivet nut can be realised in connection with large hole tolerances. The use of high-grade stainless steel A2 materials (A4 on request) additionally makes the load bearing thread highly resistant to corrosion.

ADVANTAGES

- Fast processes
- Tight fit with the components
- Process monitoring and process control are possible
- High strength
- Not dependent on surface properties
- No other materials required (adhesive)
- No ageing
- Accessible from one side
- No delamination of the CFRP
- Smaller edge spacing of the holes
- Large grip range
- Stainless steel for high corrosion resistance
- Higher hole drilling tolerances



Perfect for plastics and soft materials
As a cost-effective alternative to the stainless steel SoftGrip®, the SoftGrip® steel blind rivet nut is the ideal functional component for plastics and soft materials where there is no need to prevent contact corrosion.

Steel
Standard

Dome head

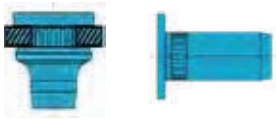
D	D x L mm	mm	No.	
M 6 - K 13 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 8810**	A 100
	9 x 20.0	4.5 - 6.5	**156 8811**	A 100
M 6 - K 16 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 8874**	A 100
	9 x 20.0	4.5 - 6.5	**156 8875**	A 100
M 6 - K 18 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 8878**	A 100
	9 x 20.0	4.5 - 6.5	**156 8879**	A 100

The standard SoftGrip® can be adapted in accordance with special requirements and specific customer requests in many areas. Other dimensions available on request.

Ideal for CFRP applications
The high-quality materials stainless A2 and A4 also ensure that the load-bearing thread is highly resistant to corrosion, making the GESIPA® SoftGrip® stainless steel blind rivet nut ideal for use with CFRP materials.

Stainless Steel A2
Standard

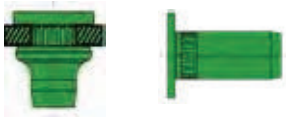
Dome head



D	D x L mm	mm	No.	
M 6 - K 16 9.1 mm	**9 x 20.0**	0.5 - 4.5	**152 3786**	A 100
	9 x 20.0	4.5 - 6.5	**152 3787**	A 100
M 6 - K 18 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 7589**	A 100
	9 x 20.0	4.5 - 6.5	**156 8804**	A 100

Stainless Steel A4
Standard

Dome head



D	D x L mm	mm	No.	
M 6 - K 16 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 8805**	A 100
	9 x 20.0	4.5 - 6.5	**156 8806**	A 100
M 6 - K 18 9.1 mm	**9 x 20.0**	0.5 - 4.5	**156 8807**	A 100
	9 x 20.0	4.5 - 6.5	**156 8808**	A 100

BLIND RIVET NUT STUDS

Combination of blind rivet nut and stud as an alternative or replacement for welding studs and press-in studs

As a combination of blind rivet nut and screw, blind rivet nut studs offer a technical as well as cost-effective alternative to welding studs or other multi-piece T-slot systems. The blind rivet nut stud has two functions. On the one hand, it joins thin materials even if they are different. On the other hand, with the reliably and permanently fixed screw if provides an additional fastening point or a positioning aid. Different dimensions, materials and head shapes cover a wide range of applications. In addition to the standard range, application-specific applications are possible.
.

ADVANTAGES

- Dual function: Joining materials and providing additional fastening point (threaded stud)
- Access only required from one side
- High load bearing capacity of thread
- Simple, neat and fast processing
- Space-saving
- No damage to painted surfaces
- No heat transfer, i.e. no change in material structure
- Suitable for repairing welding studs

APPLICATIONS

The following applications are particularly suitable for the use of GESIPA® blind rivet nut studs:

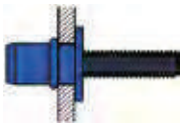
- Accessible from one side
- Thin carrier materials such as sheet metal, plastics, etc.
- Pre-centring required
- Heat transfer, e.g. welding joined materials not possible or permitted
- Surface coatings must not be damaged
- Making electrically conductive joints
- Fast repairs of welding studs

GESIPA® blind rivet nut studs can be set without any problems with the GESIPA® blind rivet nut setting tools FireBird®, GBM 95 and FireFox® using corresponding adapters for blind rivet nut studs (see tool description).

BLIND RIVET NUT STUDS STEEL

Steel
Standard

Dome head



Material: Steel, zinc-plated

D	D x L mm	mm	Thread protrusion min. mm	No.	
M 4 6.1 mm	**6 x 11.0**	0.25 - 3.0	10.0	**143 3665**	A 200
M 5 7.1 mm	**7 x 11.5**	0.25 - 3.0	11.5	**145 5330**	A 150
M 6 9.1 mm	**9 x 15.5**	0.25 - 3.0	13	**145 5331**	A 100
M 8 11.1mm	**11 x 17.0**	0.25 - 3.0	15.5	**145 5332**	A 100

Steel
half hexagonal

Standard

Material: Steel, zinc-plated

D	D x L mm	mm	Thread protrusion min. mm	No.	
M 4 SW6 + 0.1 mm	**6 x 11.0**	0.5 - 2.0	10.0	**145 0359**	A 200
M 5 SW7 + 0.1 mm	**7 x 12**	0.5 - 3.0	11.5	**145 0360**	A 150
M 6 SW9 + 0.1 mm	**9 x 15.5**	0.5 - 3.0	13	**145 0361**	A 100
M 8 SW11 + 0.1 mm	**11 x 17.0**	0.5 - 3.0	15.5	**145 0362**	A 50

Size mm	N (kp)	N (kp)	Max. torque Nm
M 4	**5,160** (525)	**6,030** (614)	**3.0**
M 5	**7,200** (733)	**10,800** (1,100)	**6.0**
M 6	**10,800** (1,100)	**17,800** (1,812)	**13.0**
M 8	**18,400** (1,873)	**27,800** (2,830)	**26.0**

The values were determined using a screw of the strength class 8.8.

Further dimensions, special surface treatments or materials are available on request.

SHAFT GEOMETRY ROUND AND SPLINED; ALL MATERIALS

Dome head		
Size mm	Head diameter mm	Height of head mm
M 4	9	0.80
M 5	10	1.00
M 6	12	1.50
M 8	14	1.50

SHAFT GEOMETRY HALF HEXAGONAL; ALL MATERIALS

Dome head		
Size mm	Head diameter mm	Height of head mm
M 4	9	0.80
M 5	10	1.00
M 6	13	1.50
M 8	16	1.50

POLYGRIP® BLIND RIVET NUT STUDS SPLINED

Splined multi-range blind rivet nut studs for improved anti-twist protection in soft materials

The new GESIPA® splined PolyGrip® blind rivet nut studs made from M6 and M8 steel are a further development of the well-proven PolyGrip® multi-range blind rivet nuts. They combine the advantages of covering large grip ranges with the knurling for increased anti-twist protection.

The long longitudinal knurling ensures uniform setting characteristics over the entire grip range and a large closing head.

In the ideal case, the splined PolyGrip® blind rivet nut studs can replace up to 5 different standard DIN dimensions. This saves handling and storage costs while also reducing the risk of confusion in the workplace.

Steel
Standard

Dome head

D	D x L mm	mm	Thread protrusion min. mm	No.	
M 6 SW9 + 0.1 mm	**9 x 18.0**	0.5 - 6.0	13	**146 4481**	A 100
M 8 SW11 + 0.1 mm	**11 x 20.0**	0.5 - 8.0	15.5	**146 4480**	A 50

Material: Steel Surface: galvanised

The best setting results can be achieved with GESIPA® FireBird® Pro!

BLIND RIVET NUTS with hose connection

Especially for pneumatic plastic hoses

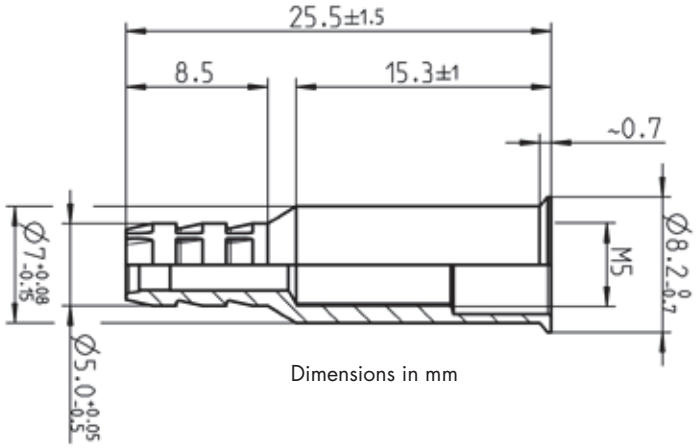
SPECIFICATION
BRN M5x7x26 KK steel,
hose connection, galvanized

GRIP RANGE
0.50 - 2.50 mm

PREDRILLED HOLE Ø
7.1 + 0.1 mm

USE
Connection of a pneumatic hose
(ø 4 mm) for use with liquids and gases

CUSTOMER ADVANTAGES
- Reduction in variety of parts
- Better look (single colour)
- Reduced assembly effort
- Simplified assembly process
- Access to component from one side
- Saving on material and assembly costs



Dimensions in mm

SECTORS
- Ventilation and air conditioning technology
- Pneumatics accessories
- Housing and container manufacturing

No. 145 5364

Example: Blind rivet nut with plastic hose

CORDLESS BLIND RIVET NUT SETTING TOOLS

Cordless blind rivet nut setting tool from GESIPA® – Easy to operate, tried and tested, and simply good!

BLIND RIVET NUT HAND TOOLS

212

GBM 10

GBM 40-R

GBM 50

FireFly

Flipper® Plus

BATTERY-POWERED BLIND RIVET NUT SETTING

222

FireBird® Pro

FireBird® Pro
Gold Edition

FireBird® Pro S
Gold Edition

FireBird®

FireBird® with conversion
kit for blind rivet nut studs

WHAT RIVETS WHAT?

	Energy	M3	M4	M5	M6	M8	M10	M12
GBM 10	H	●	●	●	A			
GBM 40-R	H	●	●	●	●	●	●	AS
GBM 50	H	●	●	●	●	●	●	AS
FireFly	H	●	●	AS	A			
Flipper® Plus	H		AS	AS	A			
FireBird®, FireBird® Pro	B	●	●	●	●	AS	A	
FireBird® Pro Gold Edition / FireBird® Pro S Gold Edition	B	●	●	●	●	●	●	AS

H: Hand tool
B: Battery-powered tool
A: Alu/Copper
S: Steel
E: Stainless Steel

Blue box: All materials (ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box.

BLIND RIVET NUT HAND TOOLS

GESIPA® manual blind rivet nut setting tools – Easy to operate, tried and tested, always good but now even better!

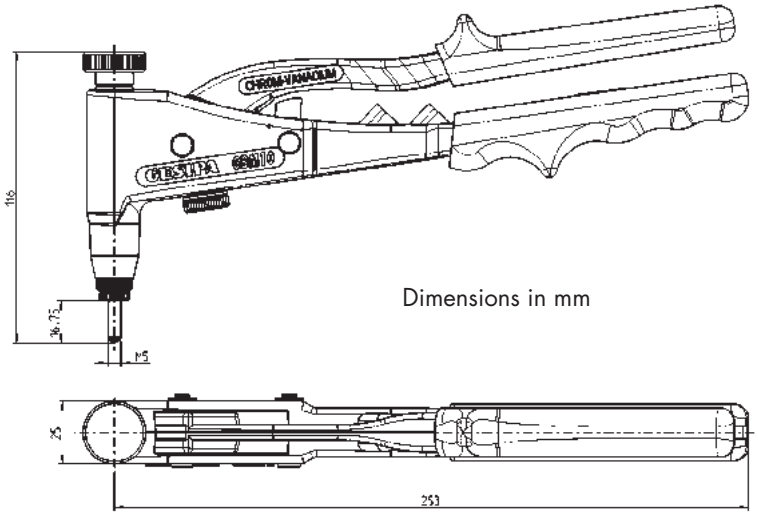
GBM 10

Manual blind rivet nut setting tool with simple stroke setting

GBM 10 – M5
No. 143 4761

GBM 10 – M4
No. 145 7087

GBM 10 – M6
No. 145 7088



Dimensions in mm

TECHNICAL DATA

Weight:	600 g
Total length:	260 mm
Stroke:	7 mm

WORKING RANGE

Blind rivet nuts from M3 up to M6 alu
and up to M5 steel, brass and stainless steel

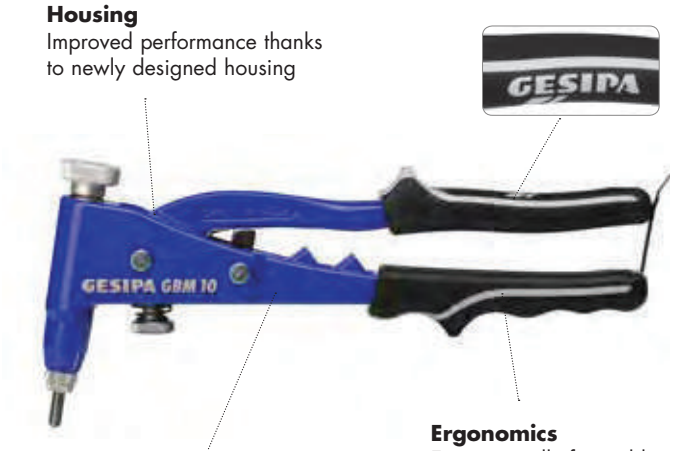
SCOPE OF DELIVERY

Standard: Threaded mandrel and nosepiece (optional M4 - M6)
Maintenance instructions with spare parts list
Stroke table

ADVANTAGES

- Simple lift setting via a knurled nut for safe and complete setting of the blind rivet nuts
- Threaded mandrel protection via spring ring for fast tool-free replacement of the threaded mandrel
- With opening spring for simple handling
- Body in high-quality die cast aluminium
- Body head made of forged chrome-vanadium steel
- Ergonomic handles

Housing
Improved performance thanks to newly designed housing



Surface
Powder-coated abrasion-resistant housing surface in GESIPA® colour

Ergonomics
Ergonomically formed handles for working efficiently without fatigue

7

SPECIAL ACCESSORIES GBM 10

THREADED MANDRELS AND **NOSEPIECES** for GBM 10

THREADED MANDRELS

Threaded mandrels	No.
Threaded mandrels M3*	**145 7096**
Threaded mandrels M4	**143 4776**
Threaded mandrels M5	**143 4779**
Threaded mandrels M6	**143 4781**
Threaded mandrels 8-32 UNC	**143 4784***
Threaded mandrels 10-24	**145 7098***
Threaded mandrels 10-32 UNF	**143 4783***
Threaded mandrels 1/4"-20	**143 4785***

NOSEPIECES

nosepieces	No.
nosepieces M3*	**145 7095**
nosepieces M4/8-32 UNC	**143 4777**
nosepieces M5/10-24 UNC**	**143 4780**
nosepieces M6/ 1/4"-20 UNC	**143 4782**

*Available as special accessoires
**The 10-24 UNC nosepiece can be used for the 10-24 UNC and 10-32 UNF threaded mandrels.

BLIND RIVET NUT BOX

No. 143 5455

GBM 10 with threaded mandrel and nosepiece M5 including threaded mandrels and nosepieces M4 and M 6, different blind rivet nut dimensions M4 to M 6 made of alu for joint thicknesses of 0.25 to 3 mm.

Incl. 4 blind rivet nut sizes:

Alu M4 x 6 x 11.0 mm
Alu M5 x 7 x 11.5 mm
Alu M5 x 7 x 13.5 mm
Alu M6 x 9 x 15.5 mm

GBM 40-R

The new ratchet tool for setting blind rivet nuts

No. 161 9731

Also suitable for blind rivet studs. Conversion possible!

TECHNICAL DATA

Weight: 1.25 kg
Total length: 212 mm

WORKING RANGE

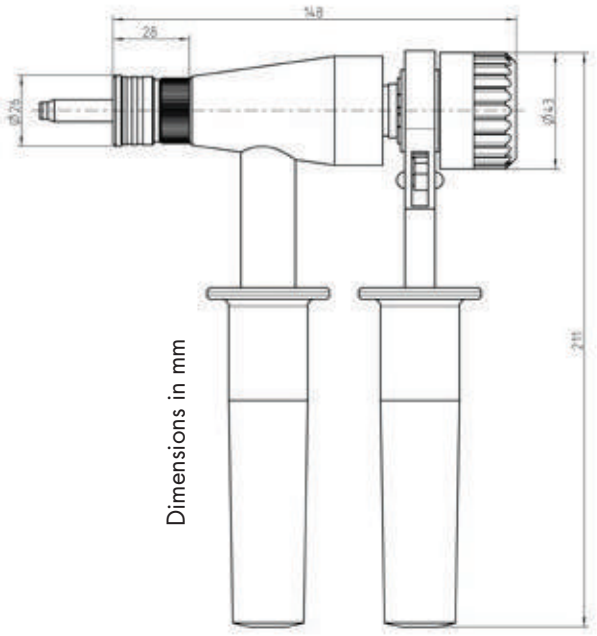
Blind rivet nuts range M3 up to M10 of all materials and M12 aluminium and steel

SCOPE OF DELIVERY

Threaded mandrel and nosepiece:
M5, M6, M8 and M10
1 construction wrench
Maintenance instructions with spare parts list
Plastic carrying case

ADVANTAGES

- The ratchet mechanism enables you to work with extremely low manual force
- Tool-free replacement of threaded mandrel and nosepiece
- Nosepieces and threaded mandrels compatible with GBM 50
- Can be converted for setting blind rivet studs



Dimensions in mm

THREADED MANDRELS AND NOSEPIECES

nosepieces	No.	threaded mandrels	No.
M3*	**162 6929**	M3*	**162 6916**
M4*	**162 6941**	M4*	**162 6917**
M5	**162 2548**	M5	**162 2543**
M6	**162 2549**	M6	**162 2544**
M8	**162 2552**	M8	**162 2545**
M8 SL 30*	**166 4686**	M8 SL 30*	**166 4684**
M10	**162 2553**	M10	**162 2546**
M12*	**162 2554**	M12*	**162 2547**

* Available as special accessories.
Other dimensions on request.

SL 30 special length: Extended nosepiece and threaded mandrel for difficult-to-access and/or deep-seated applications.

CONVERSION KIT for blind rivet studs

Description	No.
M4	**162 2556**
M5	**162 2557**
M6	**162 2558**
M8	**162 2560**

7

GBM 50

Blind rivet nut hand setting tools with quick drill system

No. 161 9730

Also suitable for blind rivet nut studs. Conversion possible!

TECHNICAL DATA

Weight: 2.4 kg
Total length: 485 mm

WORKING RANGE

Blind rivet nuts range M3 up to M10 of all materials and M12 aluminium and steel

SCOPE OF DELIVERY

Threaded mandrel and nosepiece:: M5, M6, M8 and M10
1 construction wrench
Maintenance instructions with spare parts list
Plastic carrying case

ADVANTAGES

- Quick drill system for drilling the threaded mandrel in and out quickly and easily
- Favourable transmission ratio for low effort even when setting large blind rivet nuts
- Easy stroke setting using adjusting ring with stroke scale for safe and complete installation of the blind rivet nut
- Tool-free replacement of threaded mandrel and nosepiece
- Nosepieces and threaded mandrels compatible with GBM 40-R
- Can be converted for setting blind rivet studs

THREADED MANDRELS AND NOSEPIECES

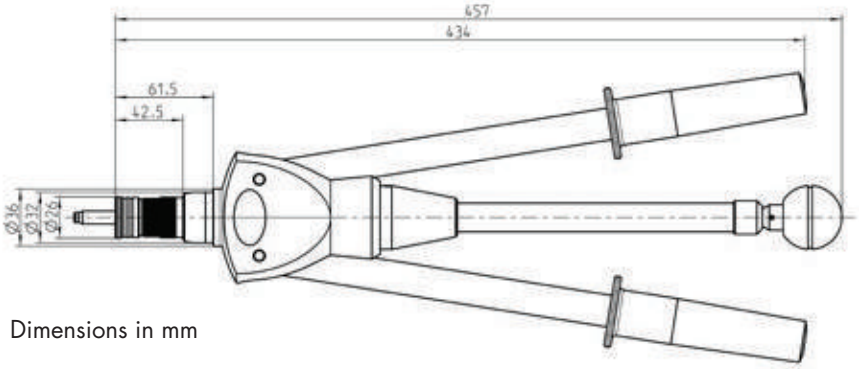
nosepieces	No.	threaded mandrels	No.
M3*	**162 6929**	M3*	**162 6916**
M4*	**162 6941**	M4*	**162 6917**
M5	**162 2548**	M5	**162 2543**
M6	**162 2549**	M6	**162 2544**
M8	**162 2552**	M8	**162 2545**
M8 SL 30*	**166 4686**	M8 SL 30*	**166 4684**
M10	**162 2553**	M10	**162 2546**
M12*	**162 2554**	M12*	**162 2547**

* Available as special accessories.
Other dimensions on request.

SL 30 special length: Extended nosepiece and threaded mandrel for difficult-to-access and/or deep-seated applications.

CONVERSION KIT for blind rivet studs

Description	No.	Description	No.
M4	**162 2556**	M6	**162 2558**
M5	**162 2557**	M8	**162 2560**



Dimensions in mm

FIREFLY-BOX

Force and intelligence for setting blind rivet nuts

No. 143 5453

TECHNICAL DATA

Total stroke:	9 mm
Single action stroke:	1.8 mm
Weight:	750 g

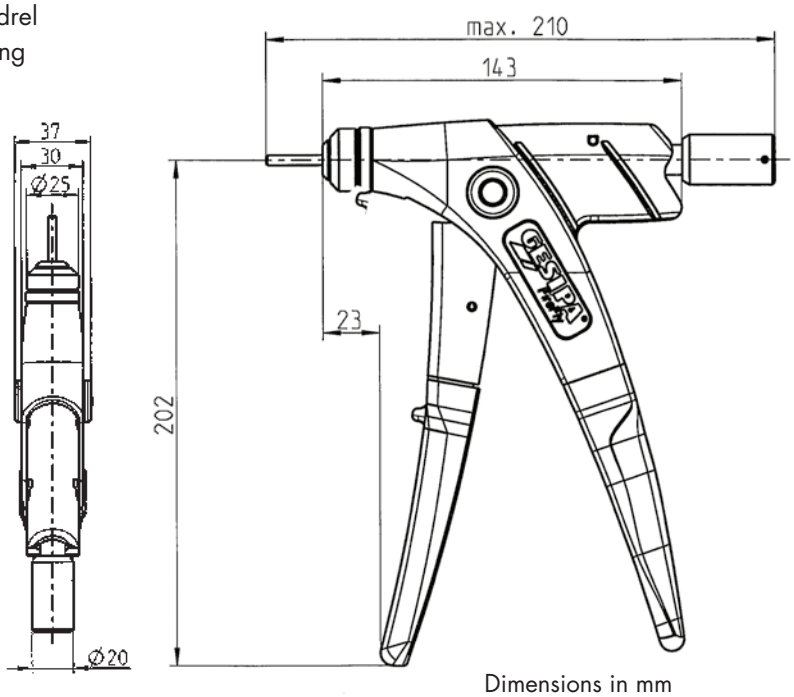
WORKING RANGE

Blind rivet nuts from M3 up to M6 aluminium as well as from M3 up to M5 steel

ADVANTAGES

- The well-proven principle of operation of the GESIPA® hand riveting tool Flipper® spares up to 40% of the hand force for setting blind rivet nuts
- A special lever design as well as the ratchet mechanism provide a reduction of hand force
- Exchange of nosepiece and threaded mandrel
- The total stroke is 9 millimeter long for setting of new generation multigrip blind rivet nuts like new the GESIPA® PolyGrip® blind rivet nuts
- Tool-free setting of stroke and threaded mandrel lengths allows simple setting of blind rivets of different lengths

218 The FireFly is also available separately **page 218.**



Dimensions in mm

SPECIAL ACCESSORIES FireFly

FIREFLY IN CARDBOARD BOX
Equipped with

- Nosepiece
- Threaded mandrel
- Operating instructions and stroke table

TOOL	No.
FireFly M5 in card-board box	**143 5454**
FireFly M3 in card-board box	**145 7653**
FireFly M4 in card-board box	**145 7654**
FireFly M6 in card-board box	**145 7655**
FireFly 6 - 32 UNC in card-board box	**145 7656**
FireFly 8 - 32 UNC in card-board box	**145 7657**
FireFly 10 - 24 UNC in card-board box	**145 7658**
FireFly 10 - 32 UNF in card-board box	**145 7659**
FireFly 1/4" - 20 UNC in card-board box	**145 7660**

THREADED MANDRELS AND **NOSEPIECES**

Article	No.
Threaded mandrels M3	**143 4002**
Threaded mandrels M4	**143 4001**
Threaded mandrels M5	**143 4000**
Threaded mandrels M6	**143 4008**
Nosepiece insert M3	**143 3995**
Nosepiece insert M4	**143 3994**
Nosepiece insert M5	**143 3993**
Nosepiece insert M6	**143 3997**

Article	No.
Threaded mandrels 6 - 32 UNC	**143 4019**
Threaded mandrels 8 - 32 UNC	**143 4020**
Threaded mandrels 10 - 24 UNC	**143 4021**
Threaded mandrels 10 - 32 UNF	**143 4022**
Threaded mandrels 1/4" - 20 UNC	**143 4023**
Nosepiece 6 - 32 UNC	**143 4024**
Nosepiece 8 - 32 UNC	**143 4025**
Nosepiece 10 - 24 UNC	**143 4026***

*The nosepiece insert 10 - 24 UNC can be used for threaded mandrels 10- 24 UNC and 10-32 UNF

REFILL MINI PACKS for blind rivet nuts

M4 x 6 x 13.0
No. 143 3700

M5 x 7 x 13.5
No. 143 3701

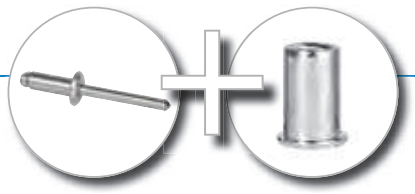
RETROFIT SET FOR blind rivet nut studs

	No.	BRN thread protrusion min.	max.*
M4	**143 4009**	8	22
M5	**143 4010**	9	22
M6	**143 4011**	10	22

* A corresponding extended nosepiece must be used for thread protrusions > 22 mm.

FLIPPER® PLUS combi setting tool

Virtually tool-free conversion from blind rivet to blind rivet nut setting tool



CONVERTED IN UNDER 1 MINUTE IN JUST A FEW SIMPLE STEPS (page 68)

No. 157 1258

YouTube

Watch conversion on youtube!

TECHNICAL DATA

Weight:	750 g
Total length:	217 mm
Total stroke:	16.2 mm
Single action stroke:	1.8 mm

WORKING RANGE BLIND RIVET NUTS

Blind rivet nuts from M4 up to M6 aluminium as well as from M4 up to M5 steel

SCOPE OF DELIVERY

Nosepieces: 12/20, 12/24, 12/29, 12/M4, 12/M5 and 12/M6
Threaded mandrel conversion kit: M4, M5 and M6
1 maintenance wrench, 1 Allen key
1 jaw insertion aid
Operating instructions with spare parts list

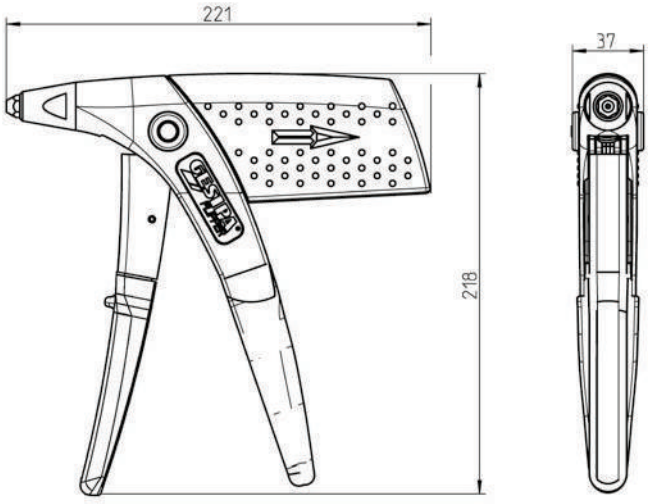
ADVANTAGES

- New ratchet function
- The force increases when the handle is closed. This finding is put to good use in a special lever arrangement for setting blind rivets and blind rivet nuts: ergonomic design
- The required manual force is reduced by around 40 percent if actuated several times.
- Actuation lever with an opening spring for easy single-handed operation

ADVANTAGES WHEN SETTING BLIND RIVET NUTS

- The total stroke is 16.2 millimeter long for setting of new generation multigrip blind rivet nuts like the GESIPA® PolyGrip® blind rivet nuts
- Simplified setting procedure for blind rivet nuts

134 All nosepieces **page 134.**



Dimensions in mm

STROKE- OR SETTING-FORCE ADJUSTMENT ?

GESIPA® blind rivet nut setting tools can be controlled through either stroke or setting force. The FireFox® 2 can do both. When which setting should best be used depends on the application, of course. However, what is guaranteed is that the setting options are **SIMPLE, FAST AND SAFE.**

WHEN IS SETTING FORCE ADJUSTMENT USED?

A blind rivet nut size of the same or varying length (e.g. M6 x 15.5 or M6 x 18) should be set in changing material thicknesses using a constant setting force.

ADVANTAGES OF SETTING FORCE ADJUSTMENT

- Controlling the tool through setting force adjustment protects material and thread and anchors blind rivet nuts securely in the material
- Quick and easy setting force adjustment via the display or the colour-coded setting ring
- Does not need to be adjusted in case of changing material thicknesses or different lengths of blind rivet nuts

ADJUSTING SETTING FORCE ON BIRD PRO TOOLS

1. Read the value* on the setting force guide
2. Enter value* in the display
3. Set blind rivet nut

(1)

Setting force guide – Example: Steel M5 for FireBird® Pro

(2)

(3)

* The values given are only guide values. The values should always be set slightly lower when setting for the first time!

ADJUSTING THE SETTING FORCE ON FIREFOX® TOOLS

When using the setting force adjustment, the maximum tool stroke must be set prior to using the setting force.

Presetting the setting force with colour-coded setting ring

Screwing in the set screw increases the tool's setting force, screwing it out reduces the setting force.

Setzkraftvoreinstellungskarte FireFox® 2

* The values given are only guide values. The values should always be set slightly lower when setting for the first time!

DIFFERENCES Stroke- or setting-force adjustment

ADVANTAGES OF STROKE SETTING

- Controlling the tool through stroke setting guarantees the height of the blind rivet nuts is constant after setting, regardless of any small variations in the nut or the material
- Infinitely variable adjustment of the set stroke
- Stroke setting is preferred above all by experienced users and for large series production

WHEN IS STROKE SETTING USED?

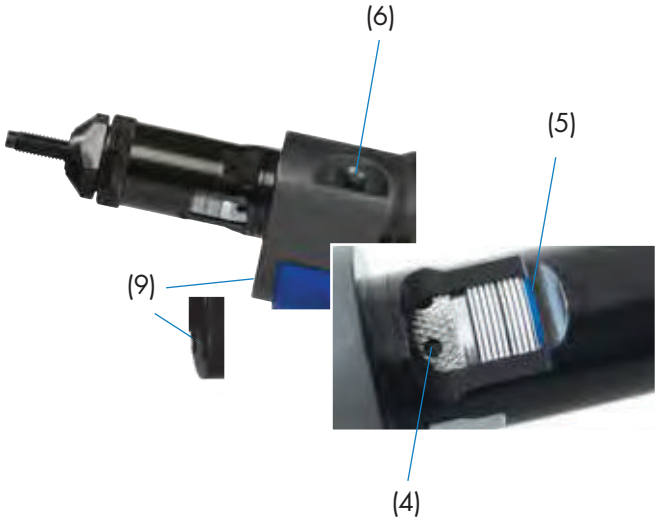
A constant set stroke should be used when a blind rivet nut size of the same length is set in unchanging material thicknesses. The set stroke corresponds to the distance the threaded mandrel is drawn into the nosepiece during the setting process and thus how far the blind rivet nut is compressed. With stroke setting, this distance can be adjusted mechanically on the riveting tool.

ADJUSTING THE SET STROKE ON FIREFOX® TOOLS

When using stroke setting, the setting force must first be set to maximum.

Setting is done in four steps

1. The rivet set screw with colour scale (9) must be screwed in up to the stop with the enclosed hexagon screwdriver SW 3.
2. Then press in the green release button (6) fully.
3. Adjust the set stroke according to the scale (5) by turning the stroke adjuster (4). One line on the scale equals 1 mm of set stroke.
4. Release the green release button. If the release button does (6) not latch automatically, turn the stroke adjuster (4) carefully until it latches.



In contrast to the force adjustment method, blind rivet nuts of different lengths or changing material thicknesses require different set stroke settings.

EXAMPLES

BNM M6 9x15

Rivetable material thickness 0.25 - 3.5 mm
for material thickness 1 mm, the set stroke is approx. 3.0 mm
for material thickness 1.5 mm, the set stroke is approx. 2.5 mm

BNM PolyGrip® M6 9x18

Rivetable material thickness 0.25–6.0 mm
for material thickness 1 mm, the set stroke is approx. 6.0 mm

The values given are only guide values, as different settings may be required depending on the type of blind rivet nut.

THE BIRD PRO SERIES Battery-powered blind rivet nut setting tools

The Bird generation with brushless motor – Reliability for a high run and fast work sequence

THE BIRD PRO SERIES

GESIPA®, which invented battery-powered blind riveting technology, has been producing the Bird series for over twenty years now. To this day, it sets the standard for the battery-powered blind riveting devices market. Not least due to changing customer requirements, the Bird family's modular system is updated on a regular basis. GESIPA® has therefore built a new platform that will supplement thecurrent Bird series to meet the highest customer requirements. The new tools in this series are the ***iBird® Pro***, ***PowerBird® Pro Gold Edition, PowerBird® Pro***, ***AccuBird® Pro*** and the blind rivet setting tools ***FireBird® Pro, FireBird® Pro Gold Edition*** and ***FireBird® Pro S Gold Edition***.

BLDC TECHNOLOGY

A BLDC motor is a brushless DC motor that, instead of brushes that are susceptible to wear, uses electrical sensors to detect the rotor's position and commutate the stator coil via circuit breakers. A special software in the electronics controls the motor.

The advantages of a BLDC motor include high efficiecy, long service life, particularly smooth running with a precision ball bearing and a reduction in electrical noise radiation.

FireBird® Pro

FireBird® Pro Gold Edition

FireBird® Pro S Gold Edition

Advantages at a glance – Battery-powered blind rivet nut setting tools with BLDC

Threaded mandrel
- Mandrel quick-change system
- Nosepiece and mandrel module taken from FireFox®

Lighting
The light-emitting diodes precisely aligned to the work piece are integrated into the adjusting ring. There are three possible switch positions: **Process-controlled:** The diodes remain illuminated after the setting process, which allows a continuous workflow even in bad lighting conditions. **Torch function:** Steady glow of diode (max.10 minutes). **Lighting off:** saves electricity.

LED input field
- Split LED input field
- Switches to energy-saving mode after 15 seconds
- Plastic cover to avoid damage and inadvertently changing the setting
- Presetting in steps of 10 and fine adjustment with 99 individual settings
- 10 freely selectable program memories

Threaded mandrel magazine
- Storage of mandrels in the practical, screw-on mandrel magazine
- Three mandrels and matching nosepieces included in scope of delivery

Trigger
- Automatic screw-on after pressing the switch

Autoreverse function
Immediately after mandrel break-off, this optional operating mode stops the pulling process and moves the jaw assembly back into the initial position. This saves time and energy while making sure the tool is immediately ready for use.

Technical facts
- Almost double the pulling displacement from 5.5 to 10 mm
- Double the previous setting speed
- Setting force increased to 20 KN by new BLDC motor (only FireBird® Pro Gold Edition)
- Fully automatic screw-off procedure after setting

ADVANTAGES
- More powerful and longer-lasting BLDC motor for quick flow of work
- 10 mm stroke for long blind rivets
- Up to 20 kN setting force for particularly large blind rivets
- Variable lighting in the adjusting ring
- Increased stability due to larger, non-slip stand surface and lower centre of gravity
- Easy-to-grasp housing thanks to Softgrip
- New sliding battery
- Charging unit with quick-charge function

FIREBIRD® PRO

FireBird® Pro – The new battery powered blind rivet nut setting tool - for blind rivet nuts up to M8 steel!

No. 152 4639

No. 152 4712

Child's play!

1. Read off number
2. Enter number
3. Set blind rivet nut

➡ Done!

ADVANTAGES OF SETTING FORCE ADJUSTMENT

- Controlling the tool through setting force adjustment protects material and thread and anchors blind rivet nuts securely in the material
- Quick and easy setting force adjustment via the display or the colour-coded setting ring
- Does not need to be adjusted in case of changing material thicknesses or different lengths of blind rivet nuts

TECHNICAL DATA

Weight:	2.4 kg with battery
Traction power:	15,000 N
Drive:	brushless DC motor
Stroke:	10.0 mm

WORKING RANGE

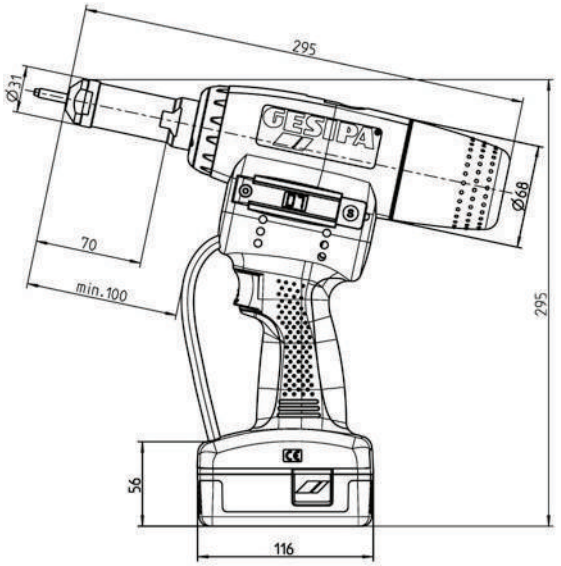
Blind rivet nuts up to M10 Aluminium, M8 steel and M6 stainless steel

SCOPE OF DELIVERY

Threaded mandrel and nosepiece M6 (in working position),
Threaded mandrel and nosepiece M4 and M5 (in magazine)
1x Hexagonal wrench
1x Double open ended wrench SW 24/27
Card Quick adjustment
Card Setting force pre-adjustment
Operating manual

ADVANTAGES

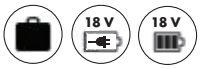
- Foolproof operation
- Virtually no wear by brushless motor
- Modern Li-Ion battery technology
- Controlled solely by the setting force adjustment
- Intelligent error message
- Almost double the pulling displacement from 5.5 to 10 mm
- Fully automatic screw-off procedure

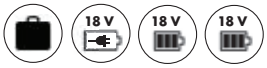


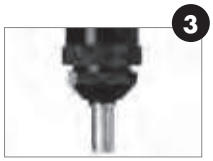
Dimensions in mm

FIREBIRD® PRO GOLD EDITION

FireBird® Pro Gold Edition – The new battery powered blind rivet nut setting tool – for blind rivet nuts up to M12 steel!

No. 145 0841 

No. 152 4713 



Setting force guide – Example: Steel M5

The values given are only guide values. The values should always be set slightly lower when setting for the first time!

TECHNICAL DATA

Weight:	2.4 kg with battery
Traction power:	20,000 N
Drive:	brushless DC motor
Stroke:	10.0 mm

227 Power per battery charge, threaded mandrels and nosepieces **page 227.**

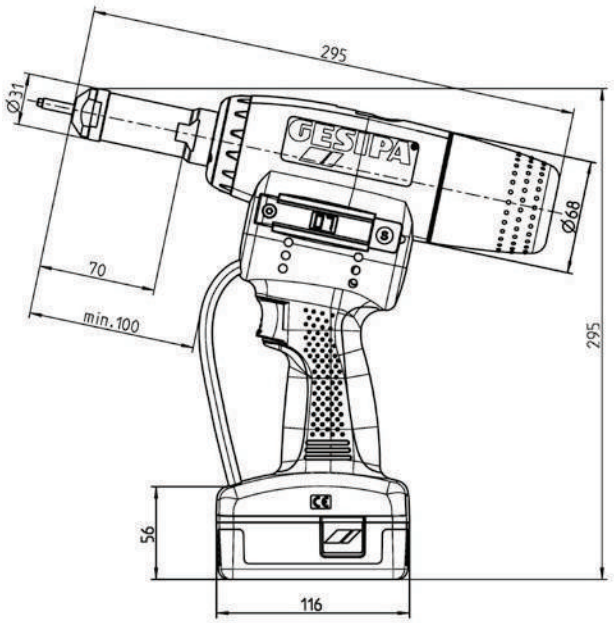
WORKING RANGE

Blind rivet nuts up to M12 alu and steel and M10 stainless steel.

SCOPE OF DELIVERY

Threaded mandrel and nosepiece M6 (in working position),
Threaded mandrel and nosepiece M8 and M10 (in magazine)
1x Hexagonal wrench
1x Double open ended wrench SW 24/27
Card Quick adjustment
Card Setting force pre-adjustment
Operating manual

230 Spare parts, special accessories for FireBird® Pro/FireBird® Pro Gold Edition **page 230.**



Dimensions in mm

7

FIREBIRD® PRO S GOLD EDITION

Der FireBird® Pro with mechanical stroke setting

with mechanical stroke setting

FireBird® Pro S Gold Edition

No. 165 6432 18 V 18 V

WHEN IS STROKE SETTING USED?

A constant set stroke should be used when a blind rivet nut size of the same length is set in unchanging material thicknesses. The set stroke corresponds to the distance the threaded mandrel is drawn into the nosepiece during the setting process and thus how far the blind rivet nut is compressed. With stroke setting, this distance can be adjusted mechanically on the riveting tool.

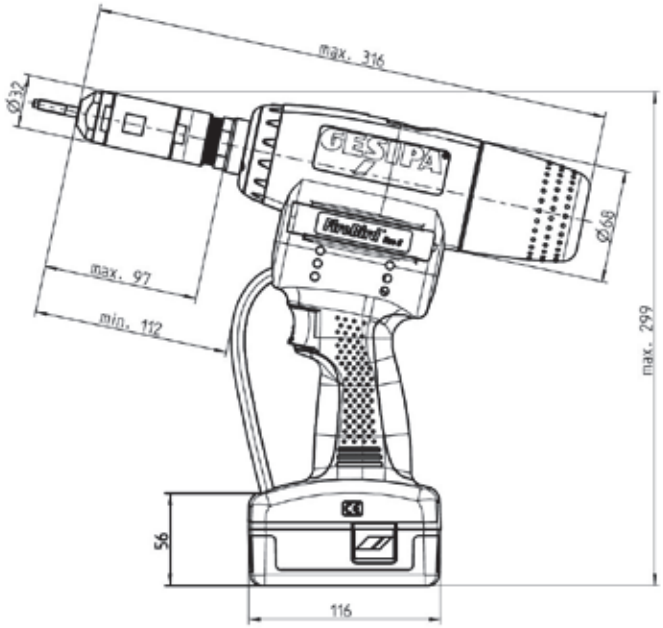
ADVANTAGES OF STROKE SETTING

- Controlling the tool through stroke setting guarantees the height of the blind rivet nuts is constant after setting, regardless of any small variations in the nut or the material
- Infinitely variable adjustment of the set stroke
- Stroke setting is preferred above all by experienced users and for large series production

SCOPE OF DELIVERY

Threaded mandrel and nosepiece M6
(in working position),
Threaded mandrel and nosepiece M8
and M10 (in magazine)
1x Hexagonal wrench
1x Double open ended wrench SW 24/27
1x Double open ended wrench SW 27/30
Card Quick adjustment
Card Setting force pre-adjustment
Operating manual

Technical data, working range and advantages analog to FireBird® Pro Gold Edition



Dimensions in mm

WORKING RANGE FIREBIRD® PRO GE AND FIREBIRD® PRO GE S:
Sets blind rivet nuts up to M12 alu and steel and M10 stainless steel.

POWER PER BATTERY CHARGE/THREADED MANDRELS AND **NOSEPIECES FOR FIREBIRD® PRO TOOLS**

Inner thread	Material	approx. pc per charging process FireBird® Pro	Threaded mandrel	Nosepiece	capprox. pc per charging process FireBird® Pro GE / FireBird® Pro S GE	Threaded mandrel	Nosepiece
			No.	No.		No.	No.
M3	Alu	1,200	143 6211*	143 6218*	1,200	143 6211*	143 6218*
M3	Steel/Stainless steel	1,100			1,100		
M4	Alu	1,100	143 6212	143 6219	1,100	143 6212	143 6219
M4	Steel/Stainless steel	1,000			1,000		
M5	Alu	950	143 6213	143 6220	950	143 6213	143 6220
M5	Steel/Stainless steel	900			900		
M6	Alu	900	143 6214	143 6221	900	143 6214	143 6221
M6	Steel/Stainless steel	800			800		
M8	Alu	850	143 6215*	143 6222*	850	143 6215	143 6222
M8	Steel/Stainless steel	550			550		
M10	Alu	750	143 6216*	143 6223*	750	143 6216	143 6223
M 10	Steel/Stainless steel	500			500		
M12	Alu	-	-	-	500	143 6217*	143 6224*
M12	Steel	-			300		

*Available as special accessory

230 Spare parts, special accessories for FireBird® Pro S Gold Edition **page 230.**

248 All threaded mandrels and nosepiecese **page 248.**

Example and application:
Extended nosepiece and threaded mandrel for difficult-to-access and/or deep-seated applications

FIREBIRD®

The reliable blind rivet nut setting tool with mechanical stroke setting for blind rivet nuts up to M10 Alu.

more than 20 YEARS FireBird®

No. 145 7414 14 V 14 V

No. 145 7413 14 V 14 V 14 V

TECHNICAL DATA

Weight:	2.1 kg with battery
Setting force:	13,000 N
Drive:	DC motor
Stroke:	5.5 mm

WORKING RANGE

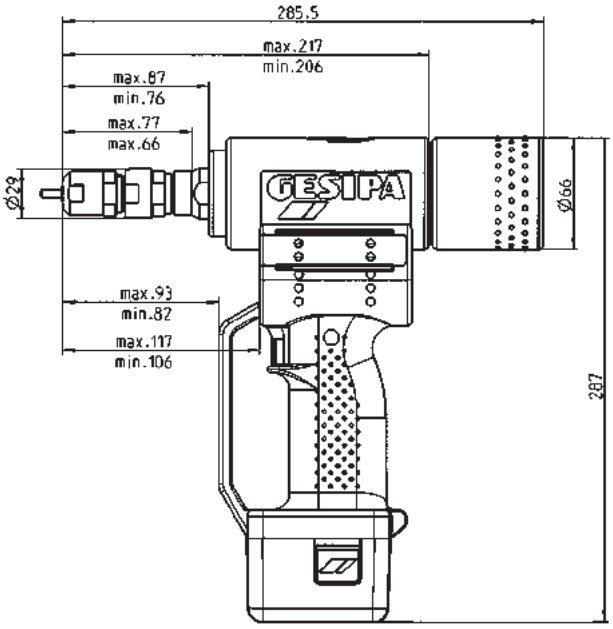
Blind rivet nuts up to M10 aluminium, up to M8 steel and up to M6 stainless steel

SCOPE OF DELIVERY

Threaded mandrel and nosepiece M6 (in working position)
Threaded mandrel and nosepiece M4 und M5 (in magazine)
1x hexagonal wrench
2x double open ended wrench SW 24/27
Operating manual

ADVANTAGES

- Reduced torque
- Automatic switch-off
- Automatic drill-out function
- High energy density
- Low weight
- Simple and safe drilling of



Dimensions in mm

230 Spare parts, special accessories for FireBird® **page 230**

POWER PER BATTERY CHARGE/THREADED MANDRELS AND NOSEPIECES

Blind rivet nuts inner thread	Material	approx. pc per charging process 1,3 Ah Li-Ion battery	No.	
			Threaded mandrel	Nosepiece
M3	Alu	**500**	**143 5052***	**143 5065***
M3	Steel/Stainless steel	**450**		
M4	Alu	**450**	**143 5055**	**143 5066**
M4	Steel/Stainless steel	**400**		
M5	Alu	**400**	**143 5056**	**143 5067**
M5	Steel/Stainless steel	**350**		
M6	Alu	**350**	**143 5059**	**143 5068**
M6	Steel/Stainless steel	**250**		
M8	Alu	**300**	**143 5063***	**143 5069***
M8	Steel	**150**		
M10	Alu	**250**	**143 5064***	**143 5070***

*Available as special accessory

248 All threaded mandrels and nosepiecese **page 248.**

FIREBIRD® Basic tool for blind rivet nut studs conversion kit

The blind rivet nut studs conversion kits enable the FireBird® to be used to set M4 and M8 blind rivet nut studs.

FireBird® Basic tool*

No. 146 4336 14 V 14 V

* The tool is delivered without threaded mandrels and nosepieces. Please order the corresponding conversion kit.
page 231

BATTERY for FireBird®
14.4 V/1.3 Ah LI-ION*
Weight: 0.35 kg

*Discontinued model. Only as long as the stock is sufficient.

No. 143 4921

POWER BATTERY
14.4 V/2.6 Ah LI-ION*
Weight: 0.50 kg

*Discontinued model. Only as long as the stock is sufficient.

No. 145 7269

CHARGER FOR 14,0 V LI-ION BATTERY

Technical data
Input voltage: 230 V / 50 Hz
Output voltage: 14.4 V DC
Recharging time: 50 to100 minutes(battery depending)
Weight: 0.6 kg

No. 145 7282

SLIDE-ON BATTERY PACK 18,0 V/2,1 AH LI-ION
For all FireBird® Pro versions
Weight: 0.4 kg / available as special accessory

No. 145 7641

CHARGER FOR 18,0 V LI-ION BATTERY

Technical data
Input voltage: 100 - 240 V / 50 - 60 Hz
Output voltage: 21 V DC
Charging time: 45 to 90 minutes
Weight: 0.6 kg

No. 145 7642

Note: Equipped with Euro plug as standard (other versions on request)

THREADED MANDREL AND NOSEPIECE SET FOR BLIND RIVET NUT SETTING TOOLS

Equipped with a complete set of nosepieces and threaded mandrels (M3 to M12) in a plastic carrying case. Suitable for:

- FireBird® Pro / FireBird® Pro S
- FireBird® Pro Gold Edition / FireBird® Pro S Gold Edition
- FireFox® 2 (alle Versionen außer FireFox® 2 C)

Metric dimensions
No. 145 8111

UNC/UNF dimensions
No. 145 8112

CONVERSION KIT FOR BLIND RIVET NUT STUDS

	No. FireBird® Pro tools	No. FireBird® tools	BRN thread protrusion min.	max.*
M4	**143 6285**	**143 5117**	8	22
M5	**143 6286**	**143 5118**	9	22
M6	**143 6287**	**143 5119**	10	22
M8	**143 6288**	**143 5121**	12	22

* A corresponding extended nosepiece must be used for thread protrusions > 22 mm.

CONVERSION KIT FOR COARSE THREAD

	No. FireBird® Pro tools	No. FireBird® tools	BRN thread protrusion min.	max.*
M5	**145 8170**	**145 7434**	9	22
M6	**145 8171**	**145 7476**	10	22

CONVERSION KIT FOR HEXAGON SOCKET SCREWS

For the FireBird® Pro series

Can be operated with DIN EN ISO 4762 allen screws instead of threaded mandrels

Special adapters available as accessory for M4 to M8 threads allows the original threaded mandrels to be replaced by allen screws: A substantial cost saving without any quality or performance loss and higher endurance when far away from the spare parts source. Best results are obtained with 12.9 grade screws.

Example:
Conversion kit SL30

Conversion kit for blind rivet nuts	No.
M4 x min. 20	**143 6264**
M5 x min. 25	**143 6279**
M6 x min. 30	**143 6283**
M8 x min. 30	**143 6284**

Conversion kit for extended DIN screws	No. SL30	No. SL50
M4 x min. 50	**145 8182**	**152 9115**
M5 x min. 55	**145 8183**	**156 7148**
M6 x min. 60	**145 8184**	**156 7147**
M8 x min. 60	**145 8178**	**1567146**

HYDRO-PNEUMATIC BLIND RIVET NUT SETTING TOOLS

Technological leadership, experience and in-house production – The hydro-pneumatic blind rivet nut setting tool from GESIPA®

WHAT RIVETS WHAT?

	Energy	M3	M4	M5	M6	M8	M10	M12
FireFox® 1 F	P				AS			
FireFox® 2 (all versions)	P							AS
FireFox® 2 C **FireRex® / FireRex® C**	P							

P: Hydro-pneumatic tool
A: Alu/Copper
S: Steel
E: Stainless Steel

Blue box: All materials (ASE) can be riveted. Where there are exceptions, the letters of the rivetable materials are provided directly in the box.

234

FireFox® 1 F

FireFox® 2 F

FireFox® 2 F L

FireFox® 1 F / FireFox® 2
with conversion kit for blind rivet nut studs

FireFox® 2

FireFox® 1 F Axial eco

FireFox® 2 F Axial eco

FireFox® 2 F Axial eco
with contact pressure monitoring and counting sensor

FireFox® 2 C WinTech

FireRex® and
FireRex® 2 C WinTech

8

FIREFOX® 1 F

The hydropneumatique blind rivet nut setting tool for M3-M6

No. 145 8198

With silencer and improved setting technology

TECHNICAL DATA

Weight:	1.96 kg
Maximum stroke:	approx. 7.5 mm
Adjustable traction force:	up to approx. 12.5 kN at 6 bar
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4")
Air consumption: approx.	1-2 ltr.per setting process (depending on nutsize)

WORKING RANGE

Blind rivet nuts from M3 up to M6 of all materials, except M6 stainless steel.

SCOPE OF DELIVERY

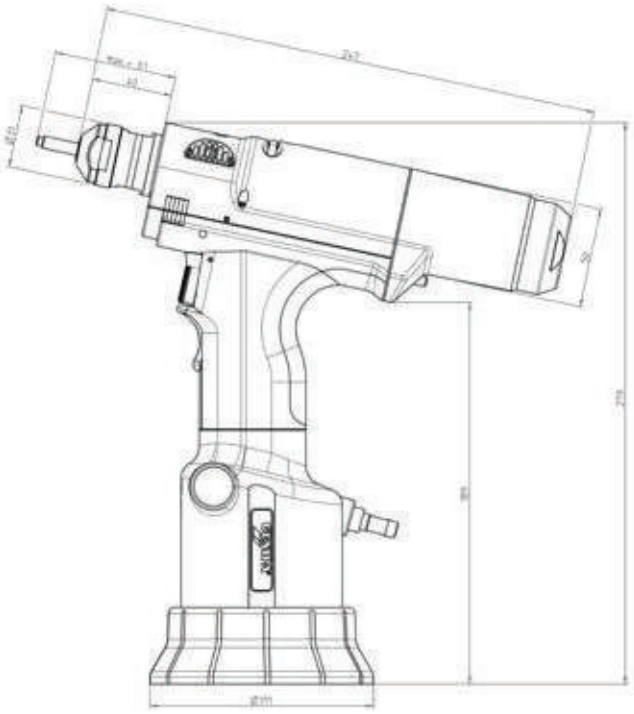
Threaded mandrel and nosepiece M6 (in working position)
Threaded mandrel and nosepiece M3, M4 and M5 (in magazine)
2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Rubber foot
Quick setting guide
Colour code card
Operating instructions with spare parts list

ADVANTAGES

- Easy to use, reliable and safe
- Sets small blind rivet nuts optimally and safely without damaging the material to be joined
- Setting takes place exclusively using setting force adjustment
- Optimum protection of the blind rivet nut thread
- Ergonomic design reduces fatigue when working

242 Spare parts, special accessories **page 242**

248 Threaded mandrels and nosepieceses **page 248**



Dimensions in mm

FIREFOX® 2 F

The hydro-pneumatique blind rivet nut setting tool with pure setting force adjustment

No. 145 1045

TECHNICAL DATA

Weight:	2.4 kg
Adjustable stroke,max:	10mm
Adjustable traction force, max:	22 kN at 6 bar
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4'')
Air consumption:	approx. 2 to 4 ltr. per rivet nut (depending on nut size)

For special applications also with left-hand thread available! **page 236**

WORKING RANGE

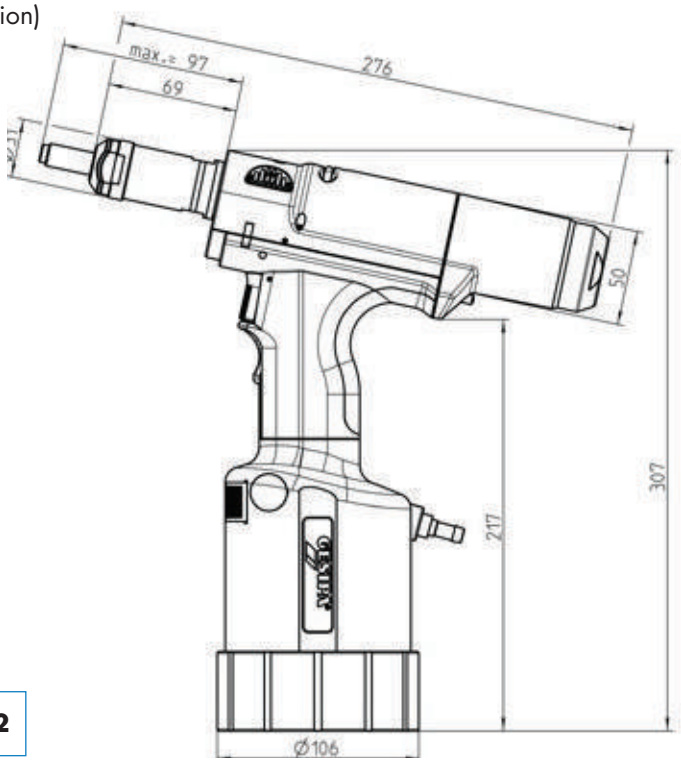
Sets blind rivet nuts from M4 to M10 in all materials as well as M12 in aluminium and steel.

SCOPE OF DELIVERY

Threaded mandrel and nosepiece M6 (in working position)
Threaded mandrel and nosepiece M4, M5 and M8 (in magazine)
2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Quick setting guide
Colour code card
Operating instructions with spare parts list

ADVANTAGES

- With pure setting force adjustment
- Fast and precise setting force adjustment with colour-coded setting ring
- Optimum protection of material to be joined and blind rivet nut thread
- Secure anchoring of the blind rivet nut
- High process reliability



Dimensions in mm

242 Spare parts, special accessories **page 242**

248 Threaded mandrels and nosepieceses **page 248**

FIREFOX® 1 F / FIREFOX® 2 with conversion kit for blind rivet nut studs

The blind rivet stud conversion kits enable the FireFox® F tools to be used to set blind rivet studs.

The tool is delivered without threaded mandrels and nosepieces. Please order the corresponding conversion kit. **page 243**

FireFox® 1 F Basic tool
No. 145 1106

TECHNICAL DATA
Analog to FireFox® 1

WORKING RANGE
Sets blind rivet studs from M4 to M6

SCOPE OF DELIVERY
2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Rubber foot
Quick setting guide
Colour code card
Operating instructions with spare parts list

FireFox® 2 Basic tool
No. 145 8096

TECHNICAL DATA
Analog to FireFox® 2

WORKING RANGE
Sets blind rivet studs from M4 to M8

SCOPE OF DELIVERY
2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Quick setting guide
Colour code card
Operating instructions with spare parts list

FireFox® 2 F L FireFox® 2F with left-hand thread

For setting blind rivet nuts with left-hand thread.

FireFox® 2 F L – M6	**No. 145 1037**
FireFox® 2 F L – M4	**No. 145 1035**
FireFox® 2 F L – M5	**No. 145 1036**
FireFox® 2 F L – M8	**No. 145 8098**
FireFox® 2 F L – M10	**No. 145 8099**
FireFox® 2 F L – M12	**No. 145 8100**

FIREFOX® 2

The hydropneumatic blind rivet nut setting tool – stroke or setting force controlled

With improved setting technology

No. 145 8086

TECHNICAL DATA

Weight:	2.4 kg
Adjustable stroke,max:	10mm
Adjustable traction force, max:	22 kN at 6 bar
Operating air pressure:	5-7 bar
Air hose connection:	6 mm Ø (1/4'')
Air consumption:	approx. 2 to 4 ltr. per rivet nut (depending on nut size)

WORKING RANGE

Sets blind rivet nuts from M4 to M10 in all materials as well as M12 in aluminium and steel.

SCOPE OF DELIVERY

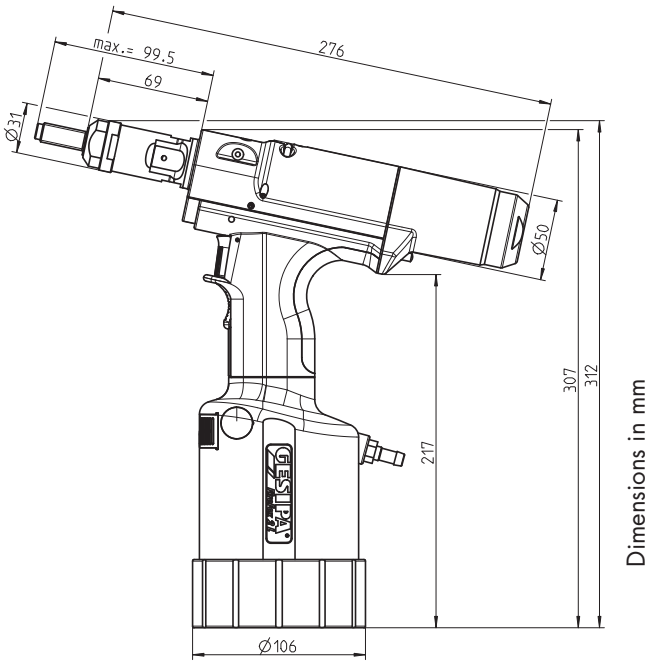
Threaded mandrel and nosepiece M6 (in working position)
Threaded mandrel and nosepiece M4, M5 and M8 (in magazine)
2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Quick setting guide
Colour code card
Operating instructions with spare parts lis

ADVANTAGES

- Stroke- or setting-force adjustment possible
- Fast and precise setting force adjustment with colour-coded setting ring
- New stroke scale quick and easy to set even under poor light conditions
- Maximum stroke clearly identified by blue ring on stroke scale (1)
- Throttle plate: Automatic throttle for even faster and protective setting as from M3 blind rivet nuts
- PTFE (Teflon®) seal. PTFE seal and optimised pilot

242 Spare parts, special accessories **page 242**

248 Threaded mandrels and nosepieceses **page 248**



8

FIREFOX® 1 F AXIAL ECO

The hydropneumatic blind rivet nut setting tools for working vertically

FireFox® 1 F Axial eco – M3 **No. 145 1103**

FireFox® 1 F Axial eco – M4 **No. 145 1104**

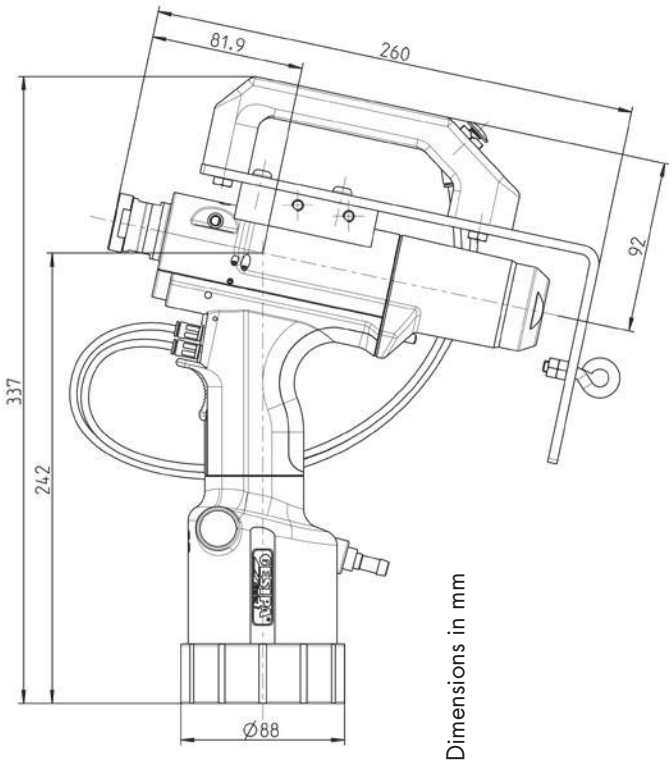
FireFox® 1 F Axial eco – M5 **No. 145 8199**

FireFox® 1 F Axial eco – M6 **No. 145 1105**

TECHNICAL DATA

Weight:	2.8 kg
Max. setting stroke:	approx. 7.5 mm
Max. setting force, adjustable:	approx. 12 kN at 6 bar
Operating pressure:	5-7 bar
Hose connection:	6 mm Ø (1/4")
Compressed air consumption:	max. 2 l per setting (depending on nut size)

Working range and scope of delivery analog to FireFox® 1F



Dimensions in mm

ADVANTAGES

- Costs-effective entry model
- Ideally suited for instillation in assembly cells, fixtures or semi-automatic workstations
- Handy for processing blind rivet nuts in places that require vertical riveting action
- Can be attached to a balancer

FIREFOX® 2 F AXIAL ECO

FireFox® 2 F Axial eco – M4 **No. 145 1040**

FireFox® 2 F Axial eco – M5 **No. 145 1041**

FireFox® 2 F Axial eco – M6 **No. 145 8103**

FireFox® 2 F Axial eco – M8 **No. 145 1042**

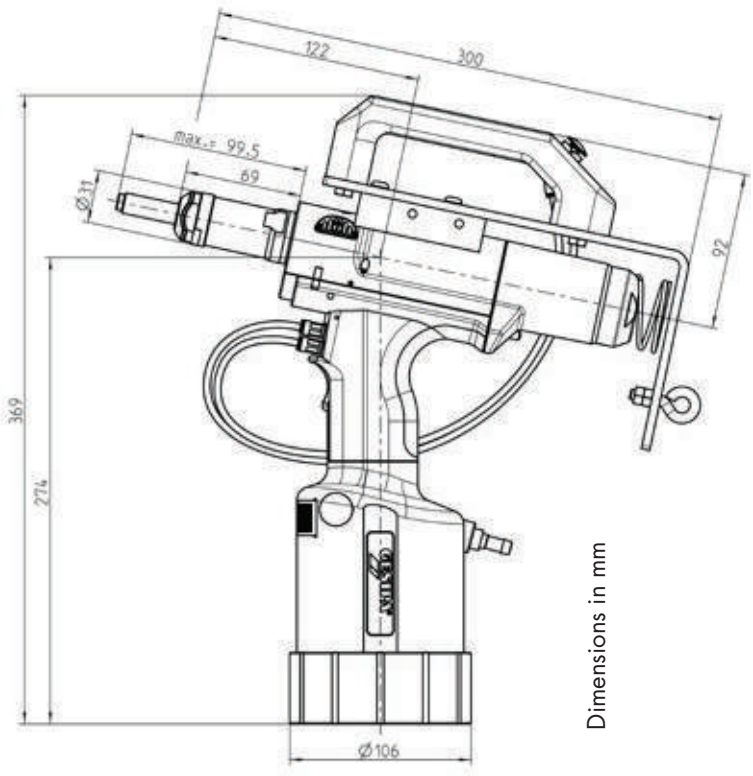
FireFox® 2 F Axial eco – M10 **No. 145 1043**

FireFox® 2 F Axial eco – M12 **No. 145 1044**

TECHNICAL DATA

Weight:	3.3 kg
Max. setting stroke:	10 mm
Drive:	Pneumatic motor
Setting force:	22 kN at 6 bar
Operating pressure:	5-7 bar
Hose connection:	6 mm Ø (1/4'')
Compressed air consumption:	max. 2 l upt to 4 l per setting (depending on nut size))

Working range and scope of delivery analog to FireFox® 2F
Advantages analog to FireFox® 1F Axial eco



Dimensions in mm

242 Spare parts, special accessories **page 242**

248 Threaded mandrels and nosepieceses **page 248**

8

FIREFOX® 2 F AXIAL ECO with contact pressure monitoring and counting sensor

With contact pressure monitoring and counting sensor – in three versions

Consultation, price and delivery time on request

Version with contact pressure monitoring and counting sensor

TECHNICAL DATA

Weight:	3.3 kg
Max. setting stroke:	10 mm
Drive:	Pneumatic motor
Setting force:	22 kN at 6 bar
Operating pressure:	5-7 bar
Hose connection:	6 mm Ø (1/4'')
Compressed air consumption:	max. 2 l upt to 4 l per setting (depending on nut size)

WORKING RANGE

Sets blind rivet nuts from M4 to M12 in all materials except M12 stainless steel.

SCOPE OF DELIVERY

2x double open ended wrenches SW 24/27
1x hexagon screw driver SW 3
1x oil refill bottle with hydraulic oil 100 ml
1x oil refill can
Quick setting guide
Colour code card
Operating instructions with spare parts lis

ADVANTAGES

- Low-price entry-level model for process monitoring
- Ideally suited for instillation in assembly cells, fixtures or semi-automatic workstations
- Handy for processing blind rivet nuts in places that require vertical riveting action
- Can be attached to a balancer

This tool is based on the tried-and-tested FireFox® 2 F Axial eco.

Three versions are available: with contact pressure monitoring, with counting function, or with contact pressure monitoring and counting function.

The counting function is realised by an analogue oil pressure sensor and the contact pressure monitoring via an adjustable spring mechanism.

Using an analogue oil pressure sensor allows the threshold value of the oil pressure, above which the setting process is recognized as valid, to be set on a programmable logic controller (PLC) that is not part of the standard scope of delivery.

FIREFOX® 2 C WINTECH

FireFox® 2 C – With setting process monitoring

The FireFox® 2 C WinTechis based on the proven TAURUS® C model. Here the setting process is analysed via integrated electronics using stroke and force sensors. The user can define an OK window by means of a special software. A coloured LED on the tool shows the results of the setting process monitoring which can also be recorded and processed via data line.

Advice and delivery time on request

TECHNICAL DATA

Weight:	3.1 kg
Max. setting stroke:	10 mm
Setting force:	22 kN at 6 bar
Operating pressure:	5-7 bar
Hose connection:	6 mm Ø (1/4'')
Compressed air consumption:	max. 2 l upt to 4 l per setting (depending on nut size)

WORKING RANGE

Sets blind rivet nuts from M5 to M10 in all materials

APLLICATIONS

In the serial production of safety component parts as well as in automated setting processes the FireFox® C allows checking and documentation of the setting process.

ADVANTAGES

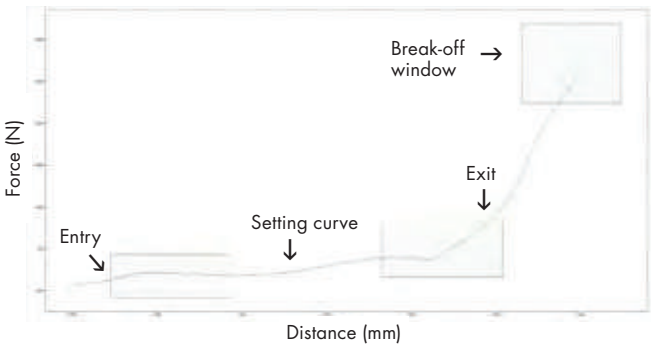
- High process safety
- Documentation of each individual setting process
- Less scrap since errors can be immediately identified
- Avoidance of additional costs/quality costs due to NOK parts

NOK WINDOW

Even incompletely fitted blind rivet nuts are detected!

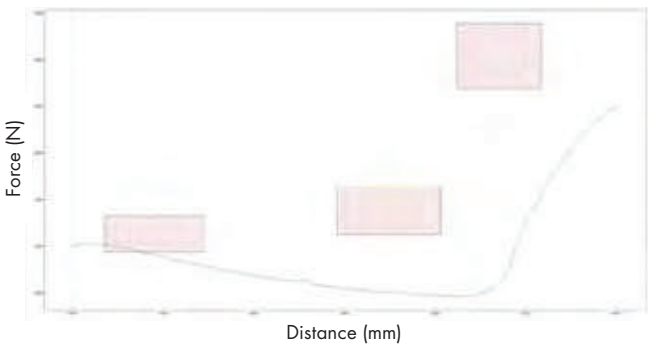
EXAMPLE OF OK PROCESS

Window entry and exit at customer-defined positions



EXAMPLE OF NOT OK PROCESS

Material to be joined too thin due to missing component



8

SPARE PARTS / SPECIAL ACCESSORIES FireFox® series

FLEXIBLE BASE – FIREFOX® 1 AND 2

With the new flexible base made from NBR and the larger surface area, the TAURUS® tools stand even more stably.

Flexible base for FireFox® 1 (for all versions)
No. 143 6394

Flexible base for FireFox® 2 (for all versions)
No. 143 6371

PROTECTIVE COVER for FireFox® 2 with stroke setting.

An additional **protective cover** over the head ensures that the stroke length setting is not unintentionally changed.

Protective cover
No. 143 6313

SWIVEL AIR CONNECTOR for FireFox® 1 F & 2

(all versions except FireFox® 2 C)

No. 143 5479

THREADED MANDREL AND NOSEPIECE SET FOR BLIND RIVET NUT SETTING TOOLS

Equipped with a complete set of nosepieces and threaded mandrels (M3 to M12) in a plastic carrying case. Suitable for:

- FireFox® 2 (all versions except FireFox® 2 C)
- FireBird® Pro / FireBird® Pro S
- FireBird® Pro Gold Edition / FireBird® Pro S Gold Edition

Metric dimensions
No. 145 8111

UNC/UNF dimensions
No. 145 8112

TOOL MOUNT* for FireFox® 1 F & 2

(all versions except FireFox® 2 C)

For integration into automated systems or connection to handling modules

*Tool mount is not available separately. It is supplied mounted on a new tool or can be retrofitted to an existing tool at the Walldorf plant or in a qualified GESIPA® workshop.

No. 145 8175

Can only be mounted by GESIPA®

CONVERSION KIT FOR BLIND RIVET NUT STUDS

Article	No.	BRN thread protrusion min.	BRN thread protrusion max.*1
M4	**143 6285**	8	22
M5	**143 6286**	9	22
M6	**143 6287**	10	22
M8*2	**143 6288**	12	22

*1 A correspondingly extended nosepiece must be used for thread protrusion > 22 mm.

*2 not FireFox® 1 F

CONVERSION KIT FOR COARSE THREAD

	No. FireFox® tools	BRN thread protrusion min.	BRN thread protrusion max.*1
M5	**145 8170**	9	22
M6	**145 8171**	10	22

Further dimensions on request.

SCREW NOSEPIECE for conversion kit

Description	No.
Screw nosepiece M4	**143 5100**
Screw nosepiece M5	**143 5102**
Screw nosepiece M6	**143 5103**
Screw nosepiece M8*2	**143 5105**

SCREW INSERT for conversion kit

Description	No.
Screw insert M4	**143 6278**
Screw insert M5	**143 6280**
Screw insert M6	**143 6281**
Screw insert M8*2	**143 6282**

CONVERSION KIT FOR HEXAGON SOCKET SCREWS

Can be operated with DIN EN ISO 4762 allen screws instead of threaded mandrels.

Special adapters available as accessory for M4 to M8 threads allows the original threaded mandrels to be replaced by allen screws: A substantial cost saving without any quality or performance loss and higher endurance when far away from the spare parts source. Best results are obtained with 12.9 grade screws

Conversion kit for blind rivet nuts	No.
M4 x min. 20	**143 6264**
M5 x min. 25	**143 6279**
M6 x min. 30	**143 6283**
M8*2 x min. 30	**143 6284**

*2 not FireFox® 1 F

Conversion kit for extended DIN screws	No. SL30	No. SL50
M4 x min. 50	**145 8182**	**152 9115**
M5 x min. 55	**145 8183**	**156 7148**
M6 x min. 60	**145 8184**	**156 7147**
M8*2 x min. 60	**145 8178**	**156 7146**

CONVERSION KIT FOR CRIMP NUTS

FireFox® 2 (all variants)

Use

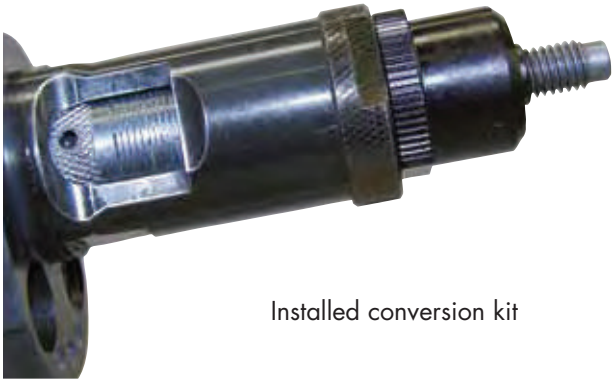
The conversion kits allow the use of the FireFox® 2 for inserting crimp nut sizes M6 to M12. This is done as fast as usual by drilling the nut on and off automatically and by fast insertion.

Delivered version

The conversion kit is delivered as a pre-assembled accessory. For inserting crimp nuts into very thick steel plates special sizes of threaded mandrels have to be used.

Installation

For installing the conversion kit special tools are not necessary. This can be done by using the wrench that comes with the FireFox® 2 standard version.



Installed conversion kit

Conversion kit for setting nut	No.
M6	**143 6354**
M8	**143 6355**
M10	**143 6356**
M12	**143 6357**

The conversion kit is delivered as a preassembled accessory.

The spring-loaded centering bush allows the setting nut to be inserted in an optimum way.

Threaded mandrels for conversion kit

Description	No.
Threaded mandrel M6	**143 6214**
Threaded mandrel M8	**143 6215**
Threaded mandrel M10	**143 6216**
Threaded mandrel M12	**143 6217**

The nut automatically drills on after having been slightly pressed onto the threaded mandrel.

Inserted nut after process has been finished.

FIREREX® / FIREREX® C WINTECH

The hydropneumatic blind rivet nut setting tool with external pressure booster for greater flexibility

Picture: FireRex® 2 C WinTech with supply unit

TECHNICAL DATA

Weight:	4.4 kg
Max. setting stroke, adjustable:	10 mm
Max. setting force, adjustable:	22 kN bei 6 bar
Operating pressure:	5-7 bar
Hose connection:	6 mm Ø (1/4")
Compressed air consumption:	approx. 2 to 4 l per setting (depending on nut size)

WORKING RANGE

Sets blind rivet nuts from M5 to M12 in all materials

SCOPE OF DELIVERY

M5 to M12 threaded mandrel and nosepiece

ADVANTAGES

- Lightweight riveting gun
- Hose connection with quick-release coupling (on request): Disconnects the gun from the external pressure booster without oil loss and without venting
- Ideally suited for setting blind rivet nuts in difficult to access places
- Also ideal for installation in assembly cells, fixtures or semi-automatic workstations
- Can be equipped with almost all FireFox® 2 accessories: e.g. extension units, spent mandrel container, blind rivet nut counter, setting process monitoring, spring-loaded trigger system and remote control

248 Threaded mandrels and nose-pieceses analog to FireFox® 2 F **page 248.**

NOW ALSO AVAILABLE WITH SETTING PROCESS MONITORING!

In the production of critical components as well as in automatic setting processes, the FireRex® 2 C WinTech can facilitate monitoring and documentation of the results. The FireFox® 2 C WinTech is based on the proven TAURUS® C model. Here the setting process is analysed via integrated electronics using stroke and force sensors. The user can define an OK window by means of a special software. A coloured LED on the tool shows the results of the setting process monitoring which can also be recorded and processed via data line.

As a further development of the tried and tested FireFox® 2, the FireRex® is capable of setting blind rivet nuts at any conceivable angle in industrial production processes. The external pressure booster makes the FireRex® particularly suitable for use in tight spaces. The special gun of the FireRex® can be integrated in production systems and facilitates flexible and ergonomically efficient manual working procedures in applications with restricted access and therefore require riveting from above.

FIREREX® as robot application

VIDEO

Integrated in a robot application, the FireRex® is capable of reliably setting blind rivet nuts, also hexagon, at any conceivable angle in industrial production processes. **Cost-effective**, innovative and fast, the new GESIPA® technology will revolutionise the industrial processing of blind rivet nuts.

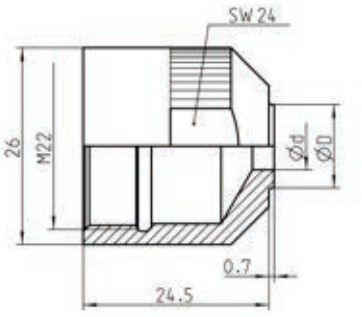
Detailed information on project implementation in your company is available from our Technical Sales department on request.

NOSEPIECES STANDARD

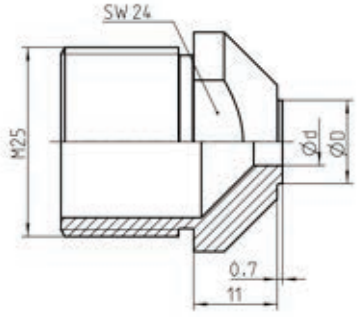
For the Fire Bird®-, Fire Bird® Pro- and FireFox® series

Nosepiece	d Ø mm	D Ø mm	No. FireBird®	No. FireBird® Pro / FireBird® Pro GE / FireBird® Pro S GE	No. FireFox® 2, FireFox® 2 F FireFox® 2 FL	No. FireFox® 1 F
M3	3.2	7.0	**143 5065**	**143 6218**	-	**143 6218**
M4	4.2	8.0	**143 5066**	**143 6219**	**143 6219**	**143 6219**
M5	5.2	9.0	**143 5067**	**143 6220**	**143 6220**	**143 6220**
M6	6.2	11.0	**143 5068**	**143 6221**	**143 6221**	**143 6221**
M8	8.2	13.0	**143 5069**	**143 6222**	**143 6222**	-
M10	10.2	14.0	**143 5070**	**143 6223**	**143 6223**	-
M12	12.2	17.0	-	**143 6224***	**143 6224**	-
6-32 UNC	3.7	7.0	**145 7461**	**143 6256**	**143 6256****	**143 6256**
8-32 UNC	4.4	8.0	**143 5093**	**143 6257**	**143 6257****	**143 6257**
10-24 UNC/10-32 UNF	5.0	9.0	**143 5094**	**143 6258**	**143 6258****	**143 6258**
1/4"-20 UNC	6.5	11.0	**143 5095**	**143 6259**	**143 6259****	-
5/16"-18 UNC	8.2	13.0	-	**143 6222**	**143 6222****	-
3/8"-16 UNC	9.8	14.0	**145 7459**	**143 6261**	**143 6261****	-

*Does not apply to FireBird® Pro / FireBird® Pro S
**Does not apply to FireFox® 2 FL
Other dimensions on request.



Standard nosepiece FireBird®



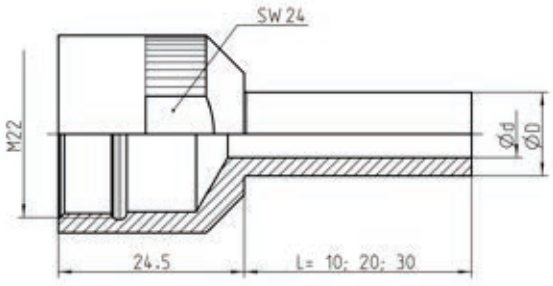
Standard nosepiece FireBird® Pro/FireFox®

SPECIAL NOSEPIECES

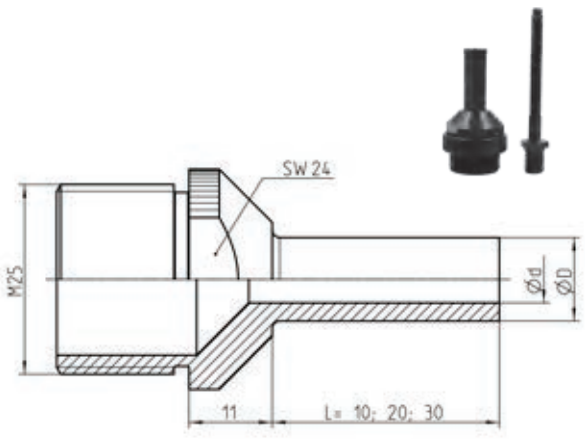
For the Fire Bird®-, Fire Bird® Pro- and FireFox® series

Nosepiece	SL	d Ø mm	D Ø mm	No. FireBird®	No. FireBird® Pro / FireBird® Pro GE / FireBird® Pro S GE	No. FireFox® 2 , FireFox® 2 F	No. FireFox® 1 F
M3	SL10	3.2	7.0	-	**145 8149**	-	**145 8149**
	SL20			-	**145 8134**	-	**145 8134**
	SL30			**145 7470**	**143 6314**	-	**143 6314**
M4	SL10	4.2	8.0	-	**145 8150**	**145 8150**	**145 8150**
	SL20			-	**145 8135**	**145 8135**	**145 8135**
	SL30			**145 7469**	**143 6315**	**143 6315**	**143 6315**
M5	SL10	5.2	9.0	**145 7479**	**145 8151**	**145 8151**	**145 8151**
	SL20			**145 7478**	**145 8136**	**145 8136**	**145 8136**
	SL30			**145 7472**	**143 6316**	**143 6316**	**143 6316**
M6	SL10	6.2	11.0	**145 7481**	**145 8131**	**145 8131**	**145 8131**
	SL20			**145 7480**	**145 8137**	**145 8137**	**145 8137**
	SL30			**145 7473**	**143 6317**	**143 6317**	**143 6317**
M8	SL10	8.2	13.0	**145 7482**	**145 8152**	**145 8152**	-
	SL20			**145 7498**	**145 8138**	**145 8138**	-
	SL30			**145 7474**	**143 6318**	**143 6318**	-
M10	SL10	10.2	14.0	-	**145 8153**	**145 8153**	-
	SL20			-	**145 8139**	**145 8139**	-
	SL30			-	**143 6319**	**143 6319**	-
M12	SL10	12.2	17.0	-	**145 8154***	**145 8154**	-
	SL20			-	**145 8140***	**145 8140**	-
	SL30			-	**143 6320***	**143 6320**	-

*Does not apply to FireBird® Pro / FireBird® Pro S
Other dimensions on request.



SL nosepiece FireBird®



SL nosepiece FireBird® Pro/FireFox®

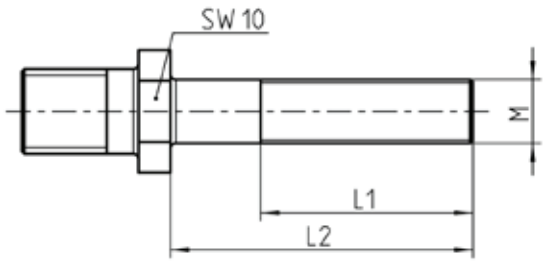
8

THREADED MANDRELS STANDARD

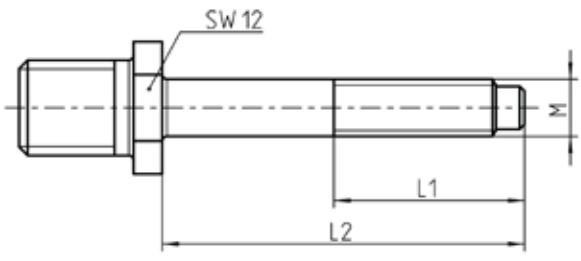
For the Fire Bird®-, Fire Bird®Pro- and FireFox® series

Threaded mandrels	L1 mm	L2 mm	No. FireBird®	L1 mm	L2 mm	No. FireBird® Pro / FireBird® Pro GE / FireBird® Pro S GE	No. FireFox® 1F	No. FireFox® 2 FireFox® 2 F	No. FireFox® 2 FL
M3	13.5	17	**143 5052**	11	23	**143 6211**	**143 6211**	-	-
M4	15.5	19	**143 5055**	14.5	26.5	**143 6212**	**143 6212**	**143 6212**	**143 6364**
M5	16	19.5	**143 5056**	17	29	**143 6213**	**143 6213**	**143 6213**	**143 6365**
M6	20	23.5	**143 5059**	20.5	32.5	**143 6214**	**143 6214**	**143 6214**	**143 6366**
M8	21.5	25	**143 5063**	22	34	**143 6215**	-	**143 6215**	**143 6367**
M10	22	25.5	**143 5064**	23	35	**143 6216**	-	**143 6216**	**143 6368**
M12	-	-	-	30	42	**143 6217***	-	**143 6217**	**143 6369**
6-32 UNC	15.5	19	**145 7460**	15	27	**143 6249**	**143 6249**	**143 6249**	-
8-32 UNC	15.5	19	**143 5090**	15	27	**143 6250**	**143 6250**	**143 6250**	-
10-24 UNC	19.5	23	**145 7475**	17.5	29.5	**143 6251**	**143 6251**	**143 6251**	-
10-32 UNF	19.5	23	**143 5091**	16	28	**143 6252**	**143 6252**	**143 6252**	-
1/4"-20 UNC	24	27.5	**143 5092**	24	36	**143 6253**	-	**143 6253**	-
5/16"-18 UNC	27.5	31	**145 7457**	28	40	**143 6254**	-	**143 6254**	-
3/8"-16 UNC	30.5	34	**145 7458**	29	41	**143 6255**	-	**143 6255**	-

*Does not apply to FireBird® Pro
Other dimensions on request.



Standard threaded mandrel FireBird®



Standard threaded mandrel FireBird® Pro/FireFox®

SPECIAL THREADED MANDRELS

For the Fire Bird®-, Fire Bird® Pro- and FireFox® series

Threaded mandrels	SL	L2 mm	No. FireBird®	SL	L2 mm	No. FireBird® Pro / FireBird® Pro GE / FireBird® Pro S GE	No. FireFox® 2 / FireFox® 2 F	No. FireFox® 1F
M3	SL10	-	-	SL10	33	**145 8156**	-	**145 8156**
	SL20	-	-	SL20	43	**145 8141**	-	**145 8141**
	SL30	47	**145 7471**	SL30	53	**143 6325**	-	**143 6325**
M4	SL10	-	-	SL10	36.5	**145 8157**	**145 8157**	**145 8157**
	SL20	-	-	SL20	46.5	**145 8142**	**145 8142**	**145 8142**
	SL30	49	**145 7464**	SL30	56.5	**143 6326**	**143 6326**	**143 6326**
M5	SL10	29.5	**145 7484**	SL10	39	**145 8158**	**145 8158**	**145 8158**
	SL20	39.5	**145 7483**	SL20	49	**145 8143**	**145 8143**	**145 8143**
	SL30	49.5	**145 7465**	SL30	59	**143 6327**	**143 6327**	**143 6327**
M6	SL10	33.5	**145 7486**	SL10	42.5	**145 8132**	**145 8132**	**145 8132**
	SL20	43.5	**145 7485**	SL20	52.5	**145 8144**	**145 8144**	**145 8144**
	SL30	53.5	**145 7466**	SL30	62.5	**143 6328**	**143 6328**	**143 6328**
M8	SL10	35	**145 7488**	SL10	44	**145 8159**	**145 8159**	-
	SL20	45	**145 7487**	SL20	54	**145 8145**	**145 8145**	-
	SL30	55	**145 7467**	SL30	64	**143 6329**	**143 6329**	-
M10	SL10	-	-	SL10	45	**145 8160**	**145 8160**	-
	SL20	-	-	SL20	55	**145 8146**	**145 8146**	-
	SL30	-	-	SL30	65	**143 6330**	**143 6330**	-
M12	SL10	-	-	SL10	52	**145 8161***	**145 8161**	-
	SL20	-	-	SL20	62	**145 8147***	**145 8147**	-
	SL30	-	-	SL30	72	**143 6331***	**143 6331**	-
6-32 UNC	SL10	-	-	SL10	37	**145 1069**	**145 1069**	-
	SL20	-	-	SL20	47	**145 1059**	**145 1059**	-
	SL30	-	-	SL30	57	**143 6332**	**143 6332**	-
8-32 UNC	SL10	-	-	SL10	37	**145 8162**	**145 8162**	-
	SL20	-	-	SL20	47	**145 1060**	**145 1060**	-
	SL30	-	-	SL30	57	**143 6333**	**143 6333**	-
10-24 UNC	SL10	-	-	SL10	39.5	**145 1070**	**145 1070**	-
	SL20	-	-	SL20	49.5	**145 1061**	**145 1061**	-
	SL30	-	-	SL30	59.5	**143 6334**	**143 6334**	-
10-32 UNF	SL10	-	-	SL10	38	**145 1071**	**145 1071**	-
	SL20	-	-	SL20	48	**145 1062**	**145 1062**	-
	SL30	-	-	SL30	58	**143 6335**	**143 6335**	-
1/4"-20 UNC	SL10	-	-	SL10	46	**145 1072**	**145 1072**	-
	SL20	-	-	SL20	56	**145 1063**	**145 1063**	-
	SL30	-	-	SL30	66	**143 6336**	**143 6336**	-
5/16"-18 UNC	SL10	-	-	SL10	50	**145 1073**	**145 1073**	-
	SL20	-	-	SL20	60	**145 8148**	**145 8148**	-
	SL30	-	-	SL30	70	**143 6337**	**143 6337**	-
3/8"-16 UNC	SL10	-	-	SL10	51	**145 1074**	**145 1074**	-
	SL20	-	-	SL20	61	**145 1064**	**145 1064**	-
	SL30	-	-	SL30	71	**143 6338**	**143 6338**	-

*Does not apply to FireBird® Pro
Other dimensions on request.

POINT OF SALE

Clearly presented & space-saving – the GESIPA® triangular stand

Advice and delivery time on request.

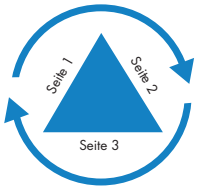
The fact that the Profi Center rotates allows the GESIPA® range to be ideally presented in the smallest of spaces. Just 1.2 square metres are required for the Profi Center at the POS. The high-quality castors and the stable construction allows the position to be changed with minimal effort. As well as the outstanding margins and free provision of the presentation stand, it is the professional and high-end appearance of the Profi Center that makes it so attractive.

All GESIPA® fast turners are clearly presented in a display that promotes sales. See for yourself and impress your customers with the Profi Center from the blind rivet technology professionals.

ADVANTAGES

- Professional goods presentation (area 1.2 m²; height 2.10 m)
- All fast turners in one place
- Presentation stand provided free
- Outstanding margin

SPACE-SAVING:
the rotating triangular stand



DISPLAY SIDE 1:

DIY supplies
Manual blind rivet setting devices and manual blind rivet nut setting devices, mini pack blind rivets and mini pack blind rivet nuts in various designs and materials

PROFI-CENTER Sales display

Image similar

DISPLAY SIDE 2:

Blind rivet technology
3 blind rivet setting devices (dummy), various manual blind rivet setting devices and various PolyGrip® blind rivet dimensions

DISPLAY SIDE 3:

Blind rivet nut technology
Blind rivet nut setting devices (dummy), manual blind rivet nut setting devices and various blind rivet nut dimensions

POINT OF SALE

SALES WALL

The GESIPA® sales wall guarantees the highest level of attention in specialist stores.

All GESIPA® fast turners are professionally and clearly presented on a sales wall that promotes sales. Using light boxes, attention is skilfully drawn to the GESIPA® logo, which serves as an eye-catcher for the customers. The light boxes are suitable for the TEGOMETALL racking system.

Prices and additional information are available on request. The GESIPA® sales team will be happy to advise you!

RIVET HANDBOOK

The ideal companion for the GESIPA® „Do-it-yourself" product range.

With GESIPA® blind rivet technology, both large and small objects in the home can be repaired in next to no time.

The Rivet Handbook explains the advantages of blind rivet technology by means of easily understandable examples. Figures illustrate the range of possible applications for rivets as well as the setting procedure using the corresponding tools.

POINT OF SALE

IN-HOUSE TRADE FAIRS

GESIPA® will gladly take part in your in-house trade show.

In the retail sector information is just as important as the products themselves. Due to the wide range of products available on the market, many products are no longer self-explanatory, and hence experience sharing and a relationship based on trust are becoming increasingly important.

Establishing contacts is very important and, traditionally, this takes place at trade fairs when talking to business partners.

Just contact us and we will be happy to come to your in-house trade fair!

INFORMATION AND ADVERTISING MATERIAL

You will find all the available information quickly on our service portal. Besides the latest catalogue and various operating instructions, a wide range of flyers and brochures can be downloaded here:

www.gesipa.com/en/flyer-brochure

DO IT YOURSELF

NTS Hand riveter

For easy setting blind rivets.

- Narrow head for difficult to access
- rivet locations
- Opening spring for automatic ejection of the mandrel
- Ergonomic handles

No. 143 4029

NIETBOY

No. 143 5461

The handyman's riveting kit including NTS hand riveter and a selection of 100 rivets, washers and a drill.

BLIND RIVET ASSORTMENT

CONTENTS
100 blind rivets
in alu/steel:
4 mm Ø x 6, x 8, x 12

No. 143 3667

GBM 5 Blind rivet nut tool

- Easy stroke adjustment
- Quick exchange of mandrel

Sets blind rivet nuts from M4 bis M6 Alu and up to M5 steel and stainless steel.

No. 143 4803

BLIND RIVET NUT ASSORTMENT

No. 143 3675

CONTENTS
Each one threaded mandrel
M4 and M5 for NTS and NTX.
Each 8 blind rivet nuts M4
short and long.

Each 8 blind rivet nuts M5
short and long.

SERVICE-PACK

No. 143 3668

CONTENTS
50 pcs. of washers 3.1 and 4.1 mm Ø
and one of drills 3.1 and 4.1 mm Ø

MINI-PACKS

MINI-PACK BLIND RIVETS

18 of the most popular blind rivet sizes in **alu/steel, steel/steel** and **copper/bronze** in single boxes.

Alu/steel

D x L mm	mm	No.	
3 x 6	2.5 - 3.5	**143 3530**	100
3 x 8	4.5 - 5.0	**143 3531**	100
3 x 12	7.0 - 9.0	**143 3532**	100
4 x 6	1.5 - 3.0	**143 3533**	100
4 x 8	4.0 - 5.0	**143 3534**	100
4 x 12	6.5 - 8.5	**143 3535**	100
5 x 6	2.0 - 2.5	**143 3536**	50
5 x 10	4.5 - 6.0	**143 3537**	50
5 x 12	6.0 - 8.0	**143 3538**	50

Copper/bronze

4 x 6	0.5 - 3.5	**143 3662**	50
4 x 10	4.5 - 6.5	**143 3663**	50
4 x 12	6.5 - 8.5	**143 3664**	50

Steel/steel

3 x 6	2.0 - 3.0	**143 3568**	100
3 x 10	5.0 - 6.5	**143 3569**	100
3 x 12	6.5 - 8.5	**143 3570**	100
4 x 6	0.5 - 2.5	**143 3571**	100
4 x 10	4.5 - 6.5	**143 3572**	100
4 x 12	6.5 - 8.5	**143 3573**	100

BLIND RIVET NUTS BLISTERED

GBM mini pack blind rivet nuts in **alu** on blister card.

Description	d_h mm	mm	No.	
M4	6.1	0.25 - 3.0	**143 3669**	20
M4	6.1	2.5 - 4.5	**143 3670**	20
M5	7.1	0.25 - 3.0	**143 3671**	15
M5	7.1	2.5 - 5.0	**143 3672**	15
M6	9.1	0.25 -3.5	**143 3673**	8
M6	9.1	3.0 - 5.5	**143 3674**	7

d_h = hole-Ø in mm = Grip range

MINI-PACKS

MINI PACK POLYGRIP® BLIND RIVETS

PolyGrip® alu/steel

D x L mm	mm	No.	
3.2 x 8	0.5 - 5.0	**143 3846**	100
3.2 x 11	3.0 - 8.0	**143 3847**	100
4 x 10	0.5 - 6.5	**143 3848**	100
4 x 17	7.0 - 13.0	**143 3849**	50
4.8 x 10	0.5 - 6.5	**143 3850**	50
4.8 x 17	6.5 - 13.0	**143 3851**	50

PolyGrip® alu/stainless steel

3.2 x 8	0.5 - 5.0	**146 4835**	100
3.2 x 11	3.0 - 8.0	**146 4834**	100
4 x 10	0.5 - 6.5	**146 4831**	100
4 x 17	7.0 - 13.0	**143 2059**	50
4.8 x 10	0.5 - 6.5	**146 4833**	50
4.8 x 17	6.5 - 13.0	**146 4832**	50

Material surcharge will be added at a daily rate.

PolyGrip® alu/steel large flange K16

4.8 x 10	0.5 - 6.5	**143 3852**	25
4.8 x 17	6.5 - 13.0	**143 3853**	25

PolyGrip® steel/steel

D x L mm	mm	No.	
3.2 x 8	1.0 - 5.0	**146 4887**	100
3.2 x 11	3.0 - 8.0	**146 4886**	100
4 x 10	1.5 - 6.5	**146 4884**	100
4 x 13	4.5 - 9.0	**146 4883**	50
4.8 x 10	1.5 - 6.5	**143 2058**	50
4.8 x 15	6.0 - 11.0	**146 4885**	50

PolyGrip® stainless steel

3.2 x 8	1.0 - 5.0	**143 2060**	100
3.2 x 11	3.0 - 8.0	**146 4830**	75
4 x 10	1.0 - 6.5	**146 4827**	75
4 x 17	7.0 - 11.0	**146 4826**	50
4.8 x 10	1.0 - 6.5	**146 4829**	50
4.8 x 15	5.0 - 10.0	**146 4828**	50

Material surcharge will be added at a daily rate.

MINI PACK POLYGRIP® BLIND RIVET NUTS

POLYGRIP® Alu

Description	d_h mm	mm	No.	
M 5	7.1	0.25 - 5.0	**146 4843**	50
M 6	9.1	0.25 - 6.0	**146 4842**	25
M 8	11.1	0.5 - 6.5	**146 4841**	25

Material surcharge will be added at a daily rate.

PolyGrip® steel

M 5	7.1	0.25 - 5.0	**146 4840**	50
M 6	9.1	0.25 - 6.0	**146 4839**	25
M 8	11.1	0.5 - 6.5	**146 4915**	25

d_h = hole-Ø in mm

= Grip range

PolyGrip® A2 stainless steel

M 5	7.1	0.25 - 5.0	**146 4888**	50
M 6	9.1	0.25 - 6.0	**146 4838**	25
M 8	11.1	0.5 - 6.5	**146 4837**	25