

## Speed Fastening® Systems

Reduce Assembly Costs with the most effective blind fastening technology.

Holding your world together®



## Speed fasteners

High precision, system-compatible function, ease of operation and quick processes are guaranteed because you can fasten continuously from magazine or bowl fed fasteners and place up to 60 fasteners per minute. For fast and reliable assembly processes.

Speed Fastening Systems can reduce assembly costs, shorten cycle times, increase productivity and reduce rework and other quality costs. Speed Fastening Systems are well suited for use in small, medium and large batch processes as well as continuous production lines.

## Installation

For smaller batches, we offer a choice of power tools and simple assembly workstations. For larger batches, multihead systems offer a cost effective solution. For continuous flow lines, we have the technology to develop fully automated assembly systems.

## Applications

Speed Fastening Systems can be used to assemble metal and plastics, composite material and electronic components. With an average cycle time of less than two seconds, these systems provide a fast installation from one side (blind).

## Mission

Together with our customers, we develop blind fastening systems that simplify your production process and improve the quality of your products. In every case, we not only see ourselves as a provider of fasteners, tools and machines but as a development and system partner with the objective of helping our customers improve their assembly performance.



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# Speed Fastening<sup>®</sup> Systems

Speed Fastening is a unique assembly system designed for rapid and reliable fastening in medium and high volume applications. Originally designed for the aviation industry, Speed Fastening Systems are now used by many of the world's foremost manufacturing companies in sectors as diverse as household goods, lighting, electronic sub-assemblies, light metal fabrication and automotive. Speed fasteners are available in a wide range of materials, finishes, lengths and diameters and are ideal for fastening metals, plastics, composites and electronic components.

Speed fasteners are single piece fasteners which are either magazine fed or fed via a vibrating bowl to a wide choice of installation equipment. This ranges from the ultra-lightweight 753 power tool to fully automated, state of the art assembly systems.

## Benefits of assembly

### Increased manufacturing throughput

A Speed Fastening System can be fully optimised to give cycle times of less than two seconds. This rapid, blind sided process delivers a throughput up to four times greater than a traditional threaded or riveted solution.

### Reduced component handling

The fasteners are fed via a magazine or into a bowl feeder. This eliminates the need for individual component handling, saves time and reduces the potential for operator injury.

### No component spillage

Because the fasteners are captively held they will not be dropped onto the floor or into the application. This avoids wasted time and improves product quality while improving the work environment.

### No stem loss

Traditional breakstem rivets all too often suffer from stem loss once installed. This can lead to application rattle, electrical short circuits or worse. Speed fasteners have no stems.

### Improved joint quality

Speed installation technology provides a consistent, repeatable joint. What's more, unlike threaded fasteners, there is no requirement for torque control – no more problems of stripped holes or loose joints.

### Improved joint performance

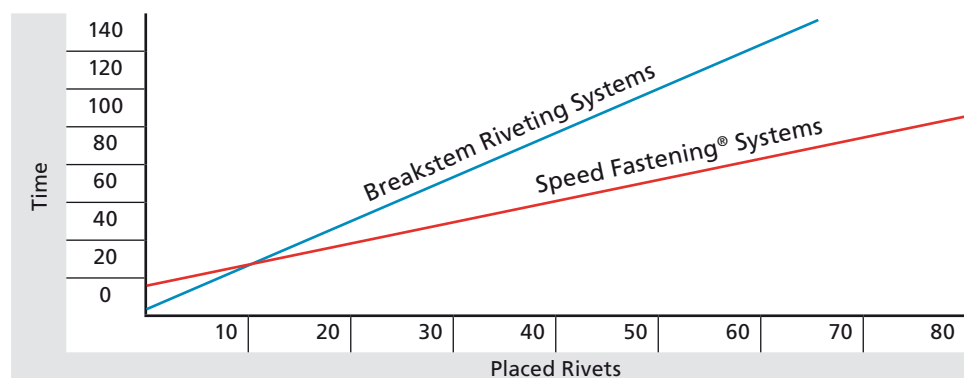
Once installed speed fasteners give excellent clamp up, shear and tension performance. They are also virtually immune from vibration loosening.

### Process flexibility










Speed Fastening Systems can be used for low volume, off-line batch or jobbing shop work through to flow line processes. From hand held power tools to multi-headed modular workstations, we can design a Speed Fastening System to suit your assembly requirements. A wide variety of products in many industries are assembled with these systems including automotive, electronics, domestic appliance and general industrial.

## Time Analysis

Speed Fastening is the more efficient system after only 10 placed rivets.



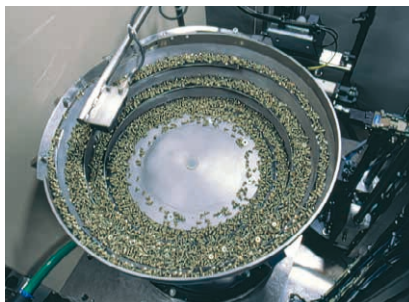
# Range Overview

Brand		Material	Key features
NeoSpeed®		Aluminium Alloy Steel Stainless Steel A4	Wide grip range High joint clamp Hole filling Very high strength
Briv®		Aluminium Alloy Steel Stainless Steel A2 Brass	Bulbed tail form Large headform High joint clamp Good joint gap closure
RivscREW®		Steel	Threaded fastener Removable with hex key and reusable Fastens into materials up to Vickers hardness 105 Hv5
Chobert®		Aluminium Alloy Steel Brass	Internal tapered bore Controlled clamp High shear Ideal for soft and brittle materials
Double Flush Chobert®		Steel	Flush surface on both sides of the joint Reduces excess space requirements within the chassis
Grovit®		Aluminium Alloy Steel	Designed for blind hole applications Annular grooves on body For use in wood, plastics, fibreglass and aluminium
Avtronic®		Brass Aluminium Alloy	Attaches DIN 41612 connectors and other components to PCBs Annular grooves on body
Avsert®		Brass	Threaded stand-off pillars for PCBs Internally threaded bore Many stand-off heights
Avlug®		Brass	Solderable terminal posts for PCBs Rolled/knurled shank

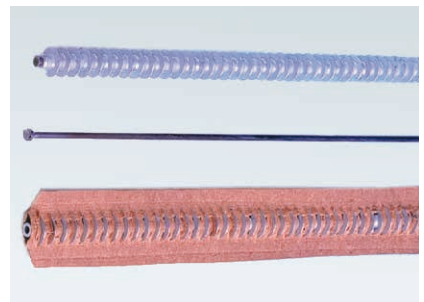
Assembly with standard tool



Fasteners fed via a vibrating bowl



Magazine fed fasteners



# Specifying a Speed Fastening® System

To optimise the performance of your Speed Fastening System, it is important to select the correct combination of fastener, nose equipment, mandrel and follower spring. It is also critical to ensure that the combination selected is suited for use with your choice of installation process. If you need any help in specifying the required components, do not hesitate to contact your local STANLEY Engineered Fastening representative. Further information on corrosion, safety and RoHS can be found on our website [www.StanleyEngineeredFastening.com](http://www.StanleyEngineeredFastening.com).

## Fastener Selection

### Standard Fasteners

#### Removability

Rivcrew® fasteners are ideal for applications requiring disassembly for repair or rework. They can simply be unscrewed using a standard hexagonal allen key.

#### Clamp

Briv® fasteners should be specified in applications requiring high clamp loads. NeoSpeed® fasteners combine high clamp throughout a wide grip range. Chobert® fasteners provide a lighter, controlled clamp making them ideal for softer or low strength materials.

#### Head Style

Fasteners are available with dome head. NeoSpeed®, Briv® and Chobert® are also available with countersunk head style. Other head diameters may also be available as specials – please contact your local STANLEY Engineered Fastening representative.

### Specialist Fasteners

#### Avtronic®

Designed for attaching DIN and other connectors, card ejectors and heatsinks to printed circuit boards.

#### Avsert®

Cost effective stand-off pillars for printed circuit boards.

#### Avlug®

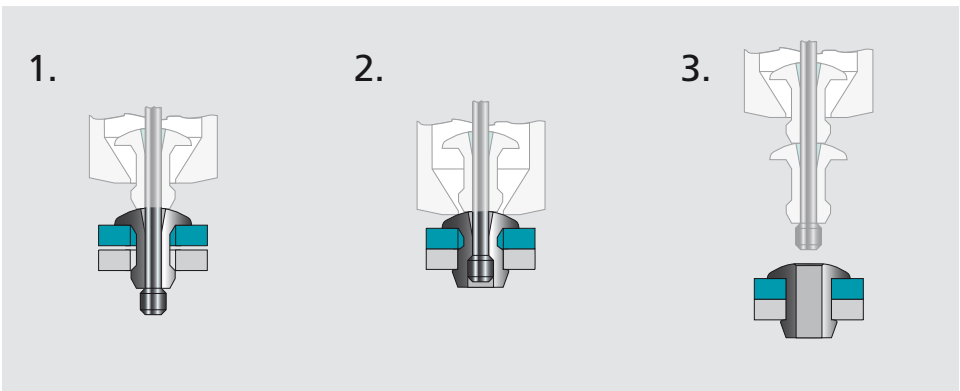
Cost effective terminal posts for printed circuit boards.

### Fastener Material & Surface Finish

Speed fasteners are available in Stainless Steel, Steel, Aluminium and Brass. The choice of material should be made on the basis of performance (shear and tensile strength), suitability for use with the parent material and corrosion resistance. For performance data please see the relevant technical data sheets.



# Typical placing sequence



1. The mandrel with pre-loaded fastener is located in the hole.

2. Tool activation pulls the mandrel through the fastener, expanding it within the hole to provide high clamp and secure joints.

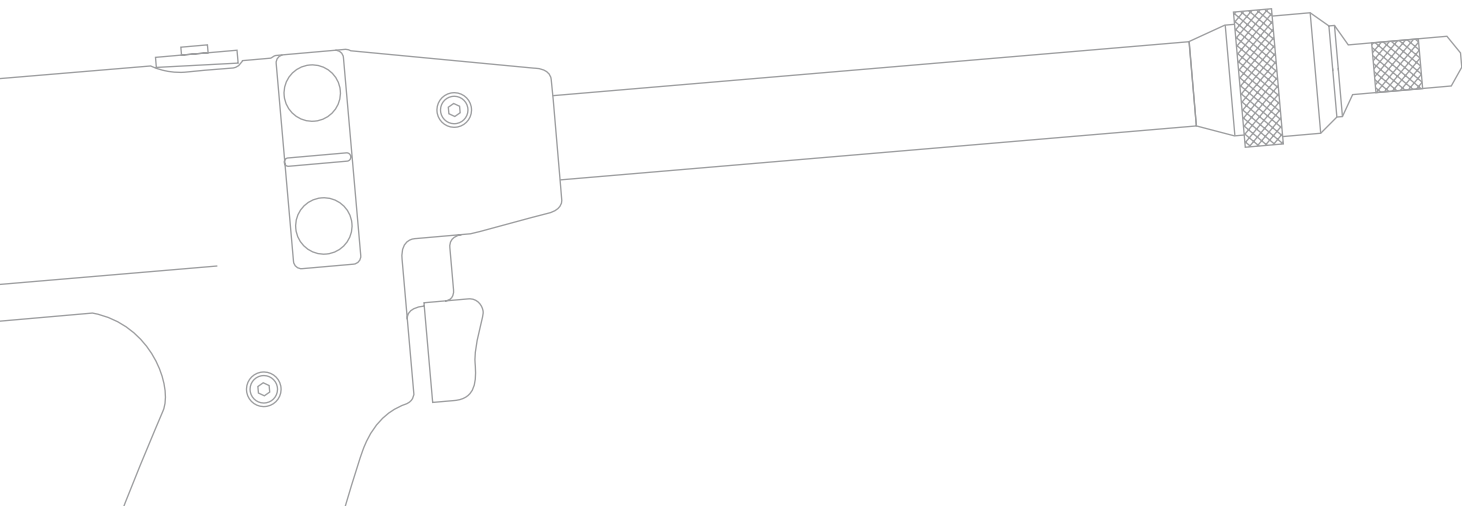
3. At the end of the installation cycle, the next fastener is automatically delivered to the nose of the tool, ready to repeat the assembly process.

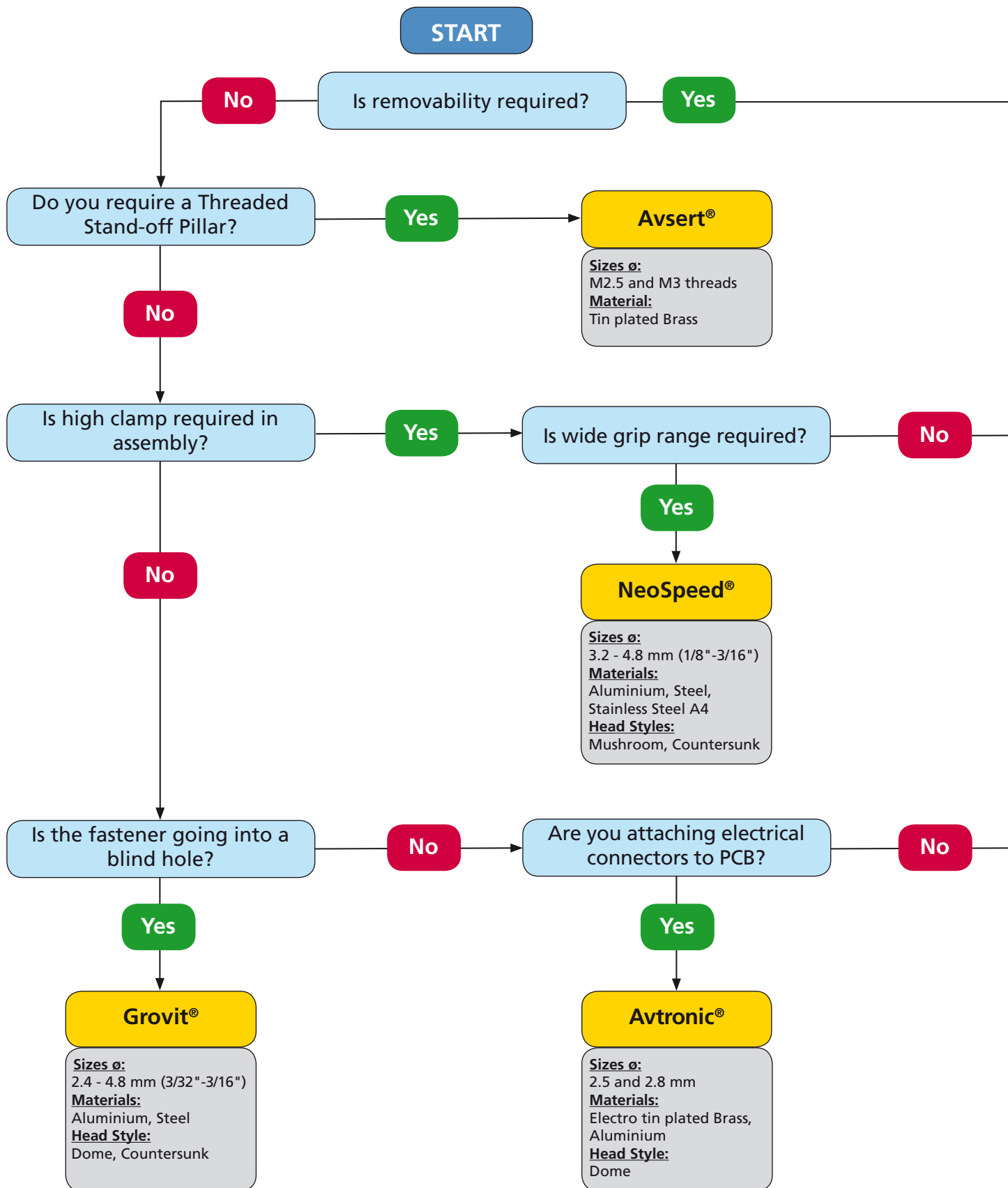
Please visit our website [www.StanleyEngineeredFastening.com](http://www.StanleyEngineeredFastening.com) for fastener placing animations.

## The surface finishes for our speed fasteners are as follows:

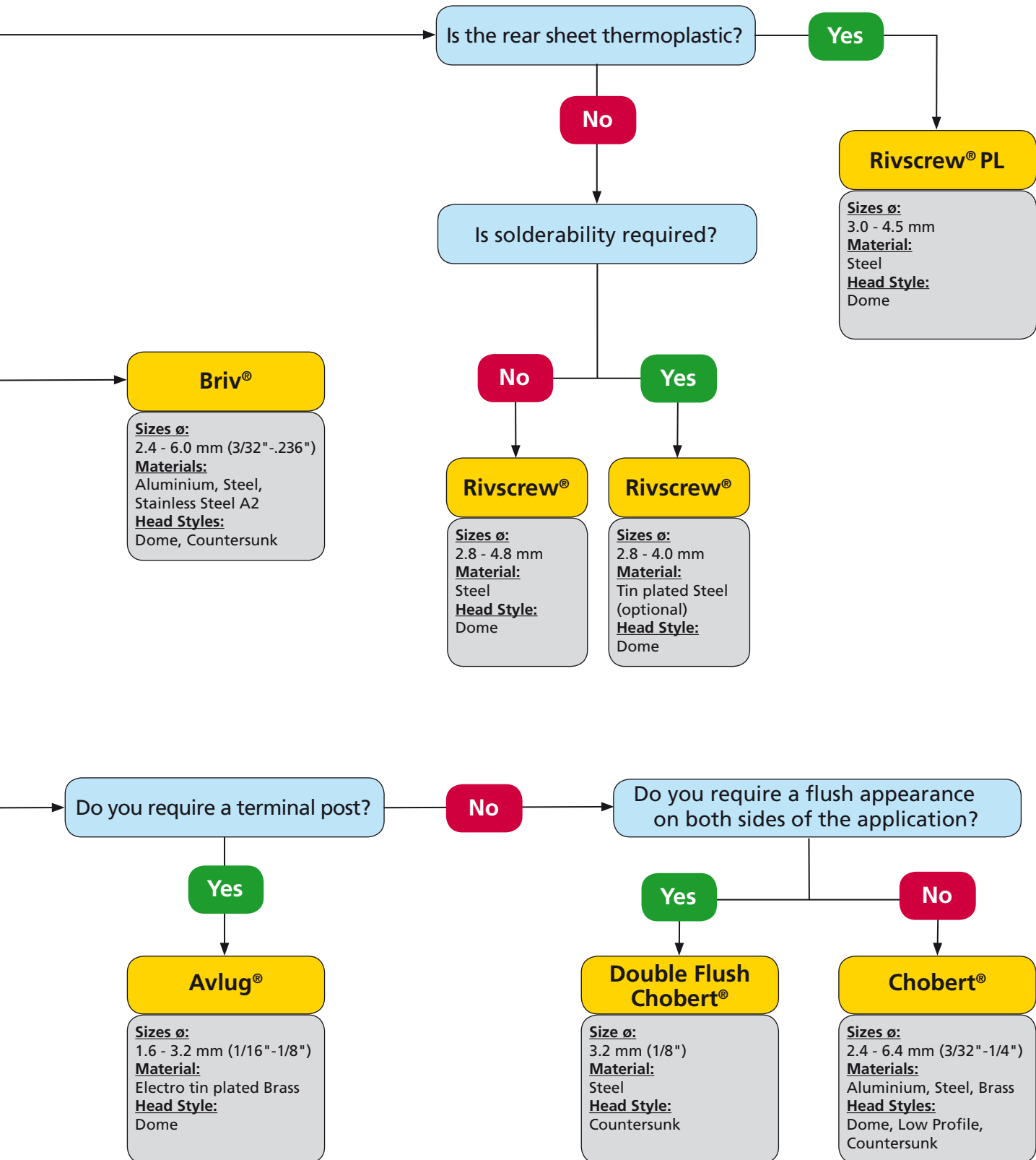
Steel	Zinc plate and clear passivation Option: Epoxy paint Zinc-nickel (with clear or black passivation) Organic coatings
Aluminium Alloy	Natural Option: Anodising (clear or colour dyed) Epoxy paint
Stainless Steel	Passivated
Brass	Brightened Tin plated (for solderability)

Almost all our fastener families may be specified with alternative surface finishes to provide increased corrosion resistance or a specific colour to suit your special application.





This selection guide is designed to illustrate which fasteners may be the most suitable for your application. This guide does not include the full range of POP Avdel products; our Applications Engineers are available to advise as to the best solution for your specific application needs.

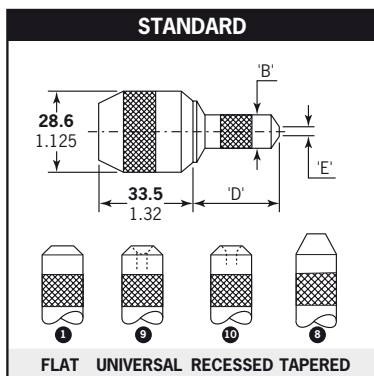




# Selection Guide

This table is designed as a guide to help you select the most suitable speed fastener for your particular application. Full technical and performance data for each speed fastener can also be found on our website or contact your local representative.

Product Range	Material						Finish						Head Style			Fastener Size (nom)											Series		Page				
	Aluminium 2.5 % Mg	Aluminium 3.5 % Mg	Aluminium 5 % Mg	Steel	Stainless Steel	Brass	Natural	Zinc plated	Polished/bright	Passivated	Tin plated	Nickel plated	Anodysed red	Dome	Low profile	Countersunk	1.6 mm (1/16")	2.4 mm (3/32")	2.5 mm	2.8 mm	3.0 mm	3.2 mm (1/8")	3.5 mm	4.0 mm (5/32")	4.5 mm	4.8 mm (3/16")	6.0 mm	6.4 mm (1/4")	M2.5	M3		Description	Data Sheet
NeoSpeed®			●				●							●																	57101	11	28
				●				●						●																	57121	11	30
					●				●					●																	57141	11	32
				●				●								●															57221	11	33
Briv®			●				●							●				●										●			1801	12	36
			●				●							●																	1802	12	38
			●										●	●				●									●				1804	12	36
				●				●						●													●				1821	12	39
				●				●		●				●				●									●				1822	12	41
						●			●					●				●													1831	12	42
						●					●			●				●													1833	12	42
	●				●				●					●				●													1841	12	44
						●							●				●													1861	12	36	
Chobert® Double Flush Chobert®				●				●						●														●			1121	13	45
				●				●								●												●			1122	13	47
	●						●							●				●										●			1124	13	51
	●						●							●				●													1125	13	49
		●					●							●				●									●				1131	13	49
			●				●							●				●									●				1132	13	51
				●			●							●				●								●					1135	13	49
			●				●							●				●								●					1136	13	51
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	●						●						●		●			●													1148	13	53
	●						●							●		●				●											1162	13	55
			●			●		●					●							●										1164	13	56	
Grovit®				●				●						●								●									1110	14	57
	●						●		●					●				●													1101	15	58
							●							●				●													1103	15	59
	●						●							●				●													1104	15	59
RivscREW® PL RivscREW® PL				●				●						●						●	●			●	●						1722	16	64
				●							●			●						●	●		●	●							1723	16	64
				●				●						●												●					1733	16	66
				●				●						●						●	●		●	●							1772	16	67
				●				●						●						●			●	●	●						1742	17	68
Avtronic®						●				●				●					●	●											1188	18	72
		●					●							●					●	●											1189	18	73
Avsert®						●				●																		●	●		1117	19	76
						●				●																		●	●		1118	19	77
Avlug®						●					●			●			●	●				●									1107	20	79



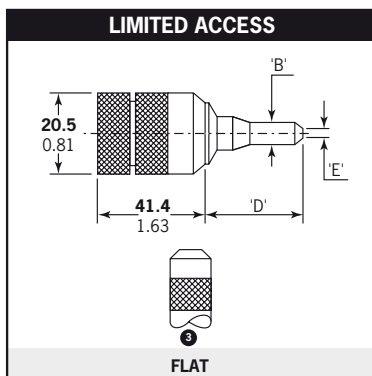
Applications with no or little access restrictions.

Pour applications ne présentant que peu ou pas de contraintes d'accès.

Für alle gut zugänglichen Nietpunkte.

Adatta per applicazioni senza restrizioni di accesso o con restrizioni di accesso limitate.

Apta para aquellas aplicaciones sin ninguna o pocas restricciones de acceso.



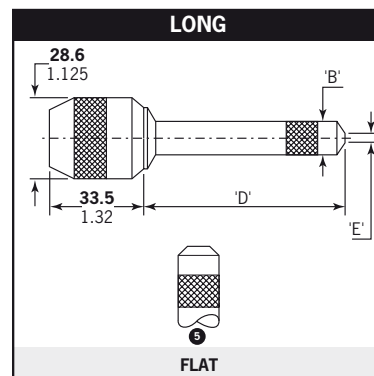
Allows access into very restrictive applications.

Permet d'accéder à des applications à accès très limité.

Für eng an den Bauteilseiten anliegende Nietpunkte.

Consente l'accesso ad applicazioni con serie restrizioni di accesso.

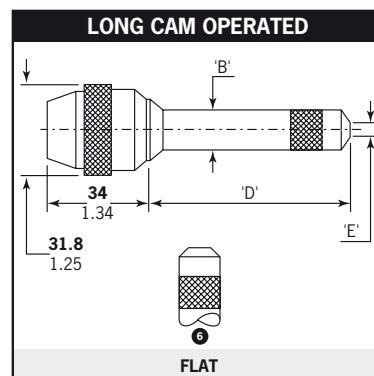
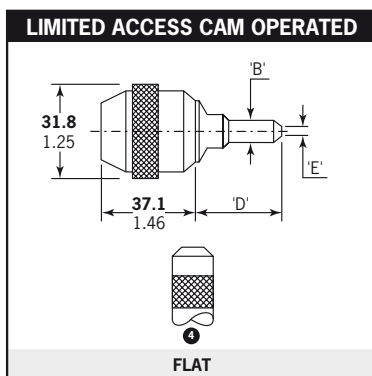
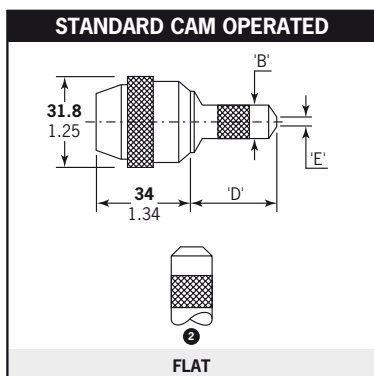
Permite el acceso en aplicaciones de acceso extremadamente limitado.



Allows more penetration into applications. Permet une pénétration supérieure dans les applications sans autres contraintes d'accès. Für tiefsitzende und eng an den Bauteilseiten anliegende Nietpunkte.

Consente una penetrazione maggiore nell'applicazione senza altre restrizioni di accesso.

Permite una mayor profundidad de acceso en aquellas aplicaciones sin restricción de acceso en anchura.



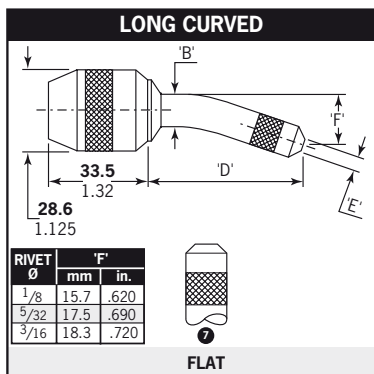
Nose equipment with addition of a twist cam to ease and speed up the nose jaw opening thus the pod reloading procedure.

Ensembles de nez avec, en plus, une came facilitant et accélérant l'ouverture du nez de pose, et donc le rechargement en fixations.

Zum leichteren Magazinieren haben diese Mundstücke durch einen Drehring zu öffnende Mundstückschnäbel.

Equipaggiamento con l'aggiunta di una camma per facilitare e rendere più veloce l'apertura della testata e pertanto la procedura di ricarica dell'astuccio portarivetti.

Boquillas que incorporan una leva para facilitar y hacer más rápida la apertura de la boquilla y el procedimiento de carga.



Type

- 1 - 7 Flat / Plat / Flach / Piatta / Plana
- 8 Tapered / Biseauté / Spitz / A punta / Conica
- 9 Universal / Universel / Für erhöhte Klammerkraft / Universale / concava
- 10 Recessed / En retrait / Spezial / Incassata / Apriete

Allows more penetration into applications.

Permet une pénétration supérieure dans les applications à accès limité.

Für tiefsitzende und eng an den Bauteilseiten anliegende Nietpunkte.

Consente una penetrazione maggiore nelle applicazioni con restrizioni di accesso.

Permite una mayor penetración en las aplicaciones con acceso limitado.

ø nom.	Fastener Rivets / Niettyp / Rivetti / Remaches	Nose Equipment Nez de pose / Mundstück / Testata / Boquilla	Type	Part No/ref	Dimensions Dimension / Abmessungen / Dimensioni / Dimensiones		
					B	D	E
2.4 (3/32")	Briv® / Chobert® / Grovit®	Standard	①	07150-03003	9.14	33.02	4.06
		Standard cam operated	②	07170-04500	9.14	33.02	
		Limited access	③	07274-01000	5.59	27.18	
		Limited access cam operated	④	07177-03003	5.08	29.97	
		Standard tapered	⑤	07170-03103	9.14	33.02	
3.2 (1/8")	Briv® / Chobert® / Grovit®	Standard	①	07150-03004	10.41	29.97	5.08
		Standard cam operated	②	07170-04600		29.97	
		Long	⑤	07150-04004		55.37	
		Long cam operated	⑥	07170-05000		55.37	
		Long curved	⑦	07150-05004		53.85	
		Standard tapered	⑧	07170-03104		30.23	
	Double Flush Chobert®	Standard cam operated	②	07537-03100		29.07	5.95
		Standard	①	07150-03005	12.19	33.02	6.10
4.0 (5/32")	Briv® / Chobert® / Grovit®	Standard cam operated	②	07170-04700		33.02	
		Long	⑤	07150-04005		58.42	
		Long cam operated	⑥	07170-05100		58.42	
		Long curved	⑦	07150-05005		56.64	
		Standard tapered	⑧	07150-03105		33.02	
	Chobert® / Grovit®	Standard tapered	⑧	07150-03106	11.18	33.02	
4.8 (3/16")	Briv® / Chobert® / Grovit®	Standard	①	07150-03006	14.22	29.97	8.38
		Standard cam operated	②	07170-04800		29.97	
		Long	⑤	07150-04006		58.42	
		Long cam operated	⑥	07170-05200		58.42	
		Long curved	⑦	07150-05006		56.13	
	Chobert® / Grovit®	Standard tapered	⑧	07150-03106		29.97	
		Standard	①	07170-05800	16.33	30.65	13.14
6.0	Briv®	Standard cam operated	②	07170-05600		30.65	
		Long	⑤	07170-05900		55.65	
		Long cam operated	⑥	07170-05700		55.65	
		Standard	①	07150-03008	16.26	29.97	9.91
6.4 (1/4")	Chobert®	Standard cam operated	②	07170-04900		29.97	
		Long	⑤	07150-04008		55.37	
		Long cam operated	⑥	07170-05300		55.37	
		Standard	①	07170-05300		55.37	

## Head forming Nose Equipment / a formage de tête / kopfformend / a formatura di testa / tipo de boquilla

2.4 (3/32")	Briv® 1)	Standard	⑨	07150-03203	9.14	33.78	6.60
3.2 (1/8")			⑩	07170-03004	10.41	30.48	7.62
4.0 (5/32")			⑨	07150-03204		30.99	7.69
4.8 (3/16")			⑩	07170-03005	12.19	33.53	10.41
			⑨	07150-03205		34.29	
			⑩	07170-03006	14.22	30.48	12.01
			⑨	07150-03206		31.50	

all dimensions in mm / en millimètres / alle Maße in mm / in millimetri / en milímetros

1) except stainless steel and countersunk / sauf inox et tête fraisée / außer Edelstahl und Senkkopf / eccetto acciaio inox e testa svasata / excepto acero inoxidable y cabeza avellanada

⑨ maximises clench but reduces grip range by approx. 0.4 mm / obtenir le plus fort serrage possible, mais la prise maximum se trouve réduite d'environ 0,4 mm / maximierte Klammerkraft bei Verringerung des Klemmbereiches um ca. 0,4 mm / ottiene la ribaditura più alta possibile, ma la distanza massima tra i centri dei rivetti viene ridotta di circa 0,4 mm / se alcanza un máximo apriete en la fijación, pero el espesor máximo se reduce en aproximadamente 0,4 mm

⑩ increases clench without affecting grip range / Augmente le serrissage sans influencer l'épaisseur / erhöhte Klammerkraft bei gleichem Klemmbereich / aumenta la ribaditura (la presa di rivettatura) senza compromettere lo spessore / incrementa el apriete sin afectar al rango de espesores a remachar