



Rivets & Inserts

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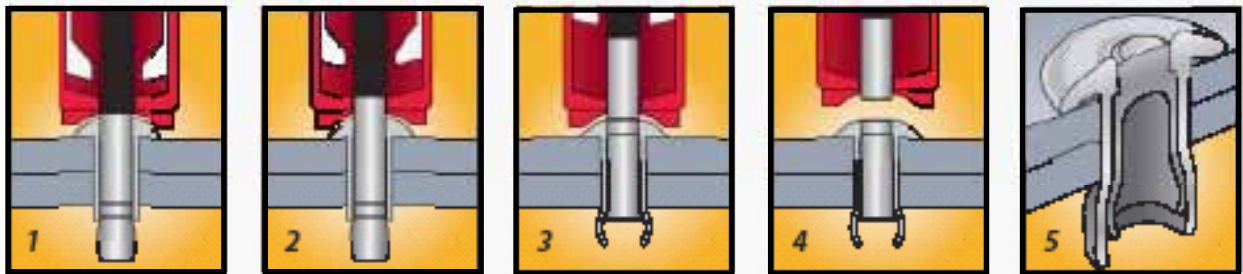


IBS, INCORPORATED Rivets W01

Low Profile Blind Rivets

- Strong, positive assembly, neat appearance.
- Quick and easy installation for low in-place cost.
- Vibration and tamper resistant.
- Will not mar painted work surface.
- Eliminates thread strip out.
- Quickly set by one person from one side of the assembly.
- Fasten metal to metal, wood and plastics to metal, all materials to fiberglass, and most other materials.
- Available in steel, stainless steel, and aluminum.
- Available in buttonhead and large flange designs.
- Large flange rivets are especially useful when fastening soft or brittle top panels where greater load bearing surface is needed.

Rivet Installation



1 After drilling hole to proper diameter, rivet is placed into hole and rivet setting tool is placed over mandrel.

2 Actuating tool starts mandrel into rivet body, pulling work material together and expanding body on the blind side.

3 A solid circle lock is created between the body and mandrel creating a weather resistant assembly that virtually eliminates pin push out

4 After the mandrel is broken, the mandrel is flush with the rivet body removing the need for grinding.

5 The expansion of the body tightly fills the hole creating a weather resistant joint, and the flush break eliminates the need for grinding.

Rivet Code Explanation

Example: ABL6-6A

A—First Letter Rivet Material (A-Aluminum, S-Steel, SS-Stainless Steel)

B—Second Letter Style of Head (B-Buttonhead)

L—Third Letter (if any) Large Flange Head

6—First Number Diameter in 32nd's

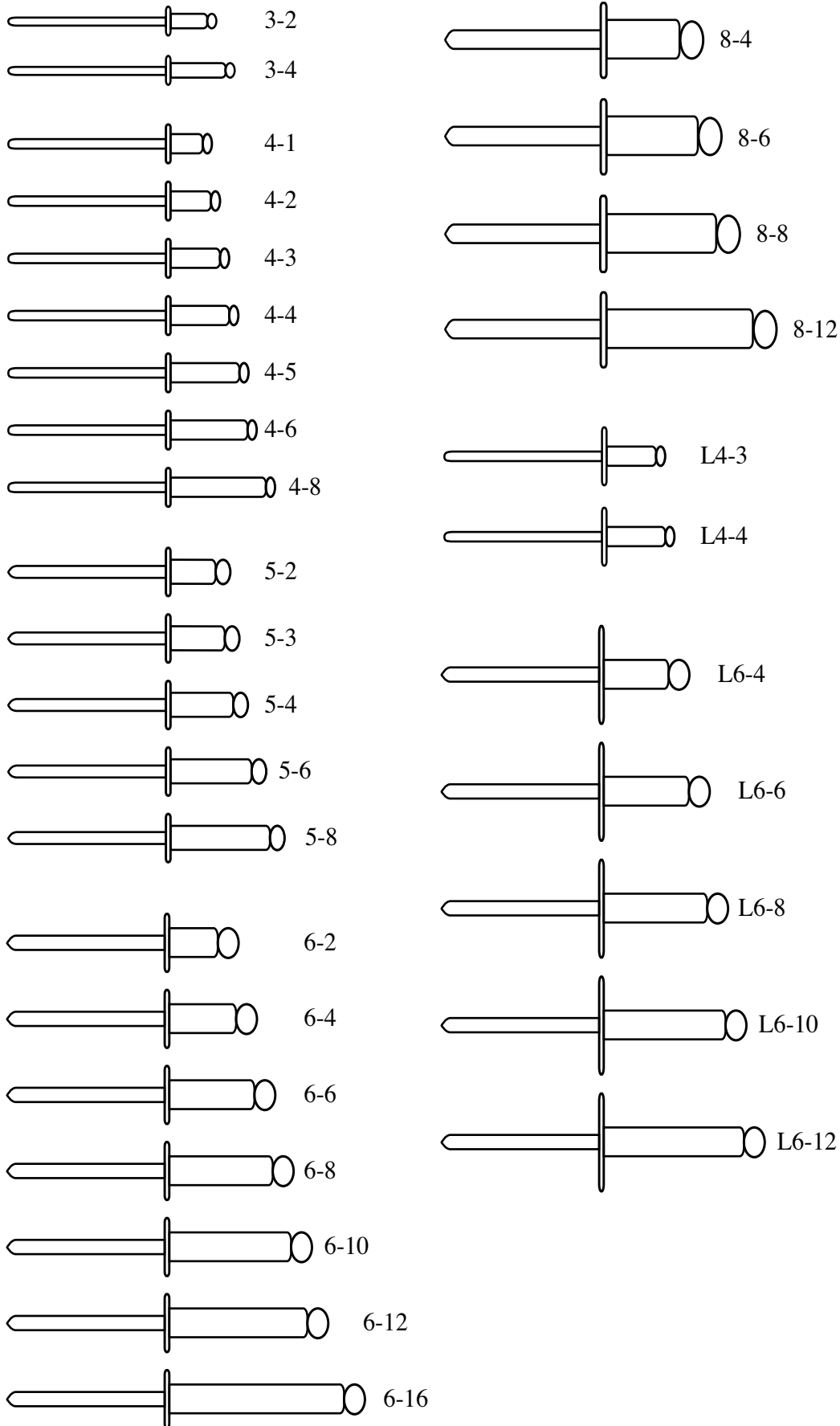
6—Second Number Maximum Grip Length in 16th's

A—Final Letter..... Mandrel Material (A-Aluminum, S-Stainless Steel). No letter indicates steel.

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IBS, INCORPORATED

Rivets W01



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IBS, INCORPORATED

Rivets W01

Buttonhead Rivets Aluminum Rivet & Mandrel



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IBS No.	Rivet Dia. Inch (mm)	Drill No.	Head Dia. Inch (mm)	Head Height Inch (mm)	Rivet Length		Grip Range		Ultimate Strength lbs (N)		Pkg Qty
					In.	MM	Inch	MM	Shear	Tens.	
AB3-2A	3/32"	#41	.188 (4.78)	.032 (0.81)	.250	6.4	.032-.125	0.8-3.2	70 (310)	80 (360)	100
AB3-4A	(2.4)				.375	9.5	.126-.250	3.3-6.4			100
AB4-1A	1/8" (3.2)	#30	.250 (6.35)	.040 (1.02)	.212	5.4	.032-.062	0.8-1.6	120 (530)	150 (670)	100
AB4-2A					.275	7.0	.063-.125	1.7-3.2			100
AB4-3A					.337	8.6	.126-.187	3.3-4.8			100
AB4-4A					.400	10.2	.188-.250	4.9-6.4			100
AB4-5A					.462	11.7	.251-.312	6.5-7.9			100
AB4-6A					.525	13.4	.313-.375	8.0-9.5			100
AB4-7A					.587	14.9	.375-.437	9.5-11.0			100
AB4-8A					.650	16.5	.437-.500	11.0-12.7			100
AB5-2A	5/32" (4.0)	#20	.312 (7.92)	.045 (1.14)	.300	7.6	.062-.125	1.6-3.2	190 (850)	230 (1020)	100
AB5-3A					.362	9.2	.126-.187	3.3-4.8			100
AB5-4A					.425	10.8	.188-.250	4.9-6.4			100
AB5-5A					.487	12.4	.251-.312	6.5-7.9			100
AB5-6A					.550	14.0	.313-.375	8.0-9.5			100
AB5-7A	.612	15.6	.375-.437	9.5-11.0	100						
AB5-8A	.675	17.2	.437-.500	11.0-12.7	100						
AB6-2A	3/16" (4.8)	#11	.375 (9.53)	.055 (1.40)	.325	8.3	.062-.125	1.6-3.2	260 (1160)	320 (1420)	100
AB6-4A					.450	11.5	.126-.250	3.3-6.4			100
AB6-6A					.575	14.6	.251-.375	6.5-9.5			100
AB6-8A					.700	17.8	.376-.500	9.6-12.7			100
AB6-10A					.825	21.0	.501-.625	12.8-15.9			100
AB6-12A					.950	24.2	.626-.750	16.0-19.1			100
AB6-14A					1.075	27.3	.751-.875	19.2-22.4			100
AB6-16A					1.200	30.5	.876-1.000	22.4-25.4			100
AB8-4A	1/4" (6.4)	" F "	.500 (12.7)	.074 (1.88)	.500	12.7	.062-.250	1.6-6.4	580 (2580)	880 (3910)	100
AB8-6A					.625	15.9	.251-.375	6.5-9.5			100
AB8-8A					.750	19.1	.376-.500	9.6-12.7			100
AB8-12A					1.000	25.4	.501-.750	12.8-19.1			100
Large Flange											
ABL4-3A	1/8" (3.2)	#30	.375 (9.53)	.045 (1.14)	.337	8.6	.126-.187	3.3-4.8	120 (530)	150 (670)	100
ABL4-4A	(2.4)				.400	10.2	.188-.250	4.9-6.4			100
ABL6-4A	3/16" (4.8)	#11	.625 (15.9)	.082 (2.08)	.450	11.5	.062-.250	1.6-6.4	260 (1160)	320 (1420)	100
ABL6-6A					.575	14.6	.251-.375	6.5-9.5			100
ABL6-8A					.700	17.8	.376-.500	9.6-12.7			100
ABL6-10A					.825	21.0	.501-.625	12.8-15.9			100
ABL6-12A					.950	24.2	.626-.750	16.0-19.1			100



Buttonhead Rivets

Aluminum Rivet & Steel Mandrel



IBS No.	Rivet Dia. Inch (mm)	Drill No.	Head Dia. Inch (mm)	Head Height Inch (mm)	Rivet Length		Grip Range		Ultimate Strength lbs (N)		Pkg Qty
					In.	MM	Inch	MM	Shear	Tens.	
AB3-2	3/32"	#41	.188 (4.78)	.032 (0.81)	.250	6.4	.032-.125	0.8-3.2	70 (310)	80 (360)	100
AB3-4	(2.4)				.375	9.5	.126-.250	3.3-6.4			100
AB4-2	1/8" (3.2)	#30	.250 (6.35)	.040 1.02	.275	7.0	.063-.125	1.7-3.2	120 (530)	150 (670)	100
AB4-3					.337	8.6	.126-.187	3.3-4.8			100
AB4-4					.400	10.2	.188-.250	4.9-6.4			100
AB4-5					.462	11.7	.251-.312	6.5-7.9			100
AB4-6					.525	13.4	.313-.375	8.0-9.5			100
AB4-8					.650	16.5	.376-.500	9.6-12.7			100
AB5-2	5/32" (4.0)	#20	.312 (7.92)	.045 (1.14)	.300	7.6	.062-.125	1.6-3.2	190 (850)	230 (1020)	100
AB5-3					.362	9.2	.126-.187	3.3-4.8			100
AB5-4					.425	10.8	.188-.250	4.9-6.4			100
AB5-6					.550	14.0	.251-.375	6.5-9.5			100
AB5-8					.675	17.2	.376-.500	9.6-12.7			100
AB6-2	3/16" (4.8)	#11	.375 (9.53)	.055 (1.40)	.325	8.3	.062-.125	1.6-3.2	260 (1160)	320 (1420)	100
AB6-4					.450	11.5	.126-.250	3.3-6.4			100
AB6-6					.575	14.6	.251-.375	6.5-9.5			100
AB6-8					.700	17.8	.376-.500	9.6-12.7			100
AB6-10					.825	21.0	.501-.625	12.8-15.9			100
AB6-12					.950	24.2	.626-.750	16.0-19.1			100
AB8-4	1/4" (6.4)	" F "	.500 (12.7)	.074 (1.88)	.500	12.7	.062-.250	1.6-6.4	580 (2580)	880 (3910)	100
AB8-6					.625	15.9	.251-.375	6.5-9.5			100
AB8-8					.750	19.1	.376-.500	9.6-12.7			100
AB8-12					1.00	25.4	.501-.750	12.8-19.1			100
Large Flange											
ABL4-3	1/8"	#30	.375 (9.53)	.045 (1.14)	.337	8.6	.126-.187	3.3-4.8	120 (530)	150 (670)	100
ABL4-4	(3.2)				.400	10.2	.188-.250	4.9-6.4			100
ABL6-4	3/16" (4.8)	#11	.625 (15.9)	.082 (2.08)	.450	11.5	.062-.250	1.6-6.4	260 (1160)	320 (1420)	100
ABL6-6					.575	14.6	.251-.375	6.5-9.5			100
ABL6-8					.700	17.8	.376-.500	9.6-12.7			100
ABL6-10					.825	21.0	.501-.625	12.8-15.9			100
ABL6-12					.950	24.2	.626-.750	16.0-19.1			100

R I V E T S & I N S E R T S



IBS, INCORPORATED Rivets W01

Buttonhead Rivets Steel Rivet & Mandrel



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IBS No.	Rivet Dia. Inch (mm)	Drill No.	Head Dia. Inch (mm)	Head Height Inch (mm)	Rivet Length		Grip Range		Ultimate Strength lbs (N)		Pkg Qty
					In.	MM	Inch	MM	Shear	Tens.	
SB3-4	3/32" (2.4)	#41	.188 (4.78)	.032 (0.81)	.375	9.5	.126-.250	3.3-6.4	130 (580)	170 (760)	100
SB4-2	1/8" (3.2)	#30	.250 (6.35)	.040 1.02	.275	7.0	.063-.125	1.7-3.2	260 (1160)	310 (1380)	100
SB4-3					.337	8.6	.126-.187	3.3-4.8			100
SB4-4					.400	10.2	.188-.250	4.9-6.4			100
SB4-5					.462	11.7	.251-.312	6.5-7.9			100
SB4-6					.525	13.4	.313-.375	8.0-9.5			100
SB4-8					.650	16.5	.376-.500	9.6-12.7			100
SB5-2	5/32" (4.0)	#20	.312 (7.92)	.045 (1.14)	.300	7.6	.062-.125	1.6-3.2	370 (1650)	470 (2090)	100
SB5-4					.425	10.8	.188-.250	4.9-6.4			100
SB5-6					.550	14.0	.251-.375	6.5-9.5			100
SB5-8					.675	17.2	.376-.500	9.6-12.7			100
SB6-2	3/16" (4.8)	#11	.375 (9.53)	.055 (1.40)	.325	8.3	.062-.125	1.6-3.2	540 (2400)	680 (3020)	100
SB6-4					.450	11.5	.126-.250	3.3-6.4			100
SB6-6					.575	14.6	.251-.375	6.5-9.5			100
SB6-8					.700	17.8	.376-.500	9.6-12.7			100
SB6-10					.825	21.0	.501-.625	12.8-15.9			100
SB6-12					.950	24.2	.626-.750	16.0-19.1			100
SB8-4	1/4" (6.4)	" F "	.500 (12.7)	.074 (1.88)	.500	12.7	.062-.250	1.6-6.4	1150 (5110)	1500 (6670)	100
SB8-6					.625	15.9	.251-.375	6.5-9.5			100
SB8-8					.750	19.1	.376-.500	9.6-12.7			100
SB8-12					1.00	25.4	.501-.750	12.8-19.1			100
Large Flange											
SBL4-4	1/8" (3.2)	#30	.375 (9.53)	.045 (1.14)	.400	10.2	.188-.250	4.9-6.4	260 (1160)	310 (1380)	100
SBL6-4	3/16" (4.8)	#11	.625 (15.9)	.082 (2.08)	.450	11.5	.062-.250	1.6-6.4	540 (2400)	680 (3020)	100
SBL6-6					.575	14.6	.251-.375	6.5-9.5			100
SBL6-8					.700	17.8	.376-.500	9.6-12.7			100
SBL6-10					.825	21.0	.501-.625	12.8-15.9			100
SBL6-12					.950	24.2	.626-.750	16.0-19.1			100

Rivet Code Explanation

Example: ABL6-6A

- A**—First Letter Rivet Material (A-Aluminum, S-Steel, SS-Stainless Steel)
- B**—Second Letter Style of Head (B-Buttonhead)
- L**—Third Letter (if any) Large Flange Head
- 6**—First Number Diameter in 32nd's
- 6**—Second Number Maximum Grip Length in 16th's
- A**—Final Letter..... Mandrel Material (A-Aluminum, S-Stainless Steel). No letter indicates steel.


















IBS, INCORPORATED

Assortments Z02



















Aluminum Pop Rivet Assortment

IBS No. 156R • 16 Items • 1050 Pieces

 IBS, Inc. <small>SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR (800) 678-1906 • www.industrialbolt.com</small>		Aluminum Blind Rivets		
Assortment No. 156R				
AB3-2A 3/32 .032-.125 ALUM/ALUM RIVET 	AB3-4A 3/32 .126-.250 ALUM/ALUM RIVET 	AB4-2A 1/8 .063-.125 ALUM/ALUM RIVET 	AB4-3A 1/8 .126-.187 ALUM/ALUM RIVET 	AB4-4A 1/8 .188-.250 ALUM/ALUM RIVET 
			AB5-3A 5/32 .126-.187 ALUM/ALUM RIVET 	AB5-4A 5/32 .188-.250 ALUM/ALUM RIVET 
AB5-6A 5/32 .251-.375 ALUM/ALUM RIVET 	AB5-8A 5/32 .376-.500 ALUM/ALUM RIVET 	AB6-4A 3/16 .126-.250 ALUM/ALUM RIVET 	AB6-6A 3/16 .251-.375 ALUM/ALUM RIVET 	AB6-8A 3/16 .376-.500 ALUM/ALUM RIVET 
AB6-10A 3/16 .501-.625 ALUM/ALUM RIVET 		ABL6-6A 3/16 .251-.375 LRG FLGE 	ABL6-8A 3/16 .376-.500 LRG FLGE 	ABL6-10A 3/16 .501-.625 LRG FLNGE 

Steel Pop Rivet Assortment

IBS No. 174R • 15 Items • 975 Pieces

 IBS, Inc. <small>SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR (800) 678-1906 • www.industrialbolt.com</small>		Steel Blind Rivets		
Assortment No. 174R				
SB3-4 3/32 .126-.250 STEEL RIVET 		SB4-2 1/8 .063-.125 STEEL RIVET 	SB4-3 1/8 .126-.187 STEEL RIVET 	SB4-4 1/8 .188-.250 STEEL RIVET 
			SB5-2 5/32 .062-.125 STEEL RIVET 	SB5-4 5/32 .188-.250 STEEL RIVET 
SB5-6 5/32 .251-.375 STEEL RIVET 	SB5-8 5/32 .376-.500 STEEL RIVET 	SB6-4 3/16 .126-.250 STEEL RIVET 	SB6-6 3/16 .251-.375 STEEL RIVET 	SB6-8 3/16 .376-.500 STEEL RIVET 
SB6-10 3/16 .501-.625 STEEL RIVET 		SBL6-6 3/16 .251-.375 LRG FLGE STEEL 	SBL6-8 3/16 .376-.500 LRG FLGE STEEL 	SBL6-10 3/16 .501-.625 LRG FLGE STEEL 



IBS, INCORPORATED

Rivets W01

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Buttonhead Rivets

STAINLESS STEEL RIVET & STAINLESS MANDREL



IBS No.	Rivet Dia. Inch (mm)	Drill No.	Head Dia. Inch (mm)	Head Height Inch (mm)	Rivet Length		Grip Range		Ultimate Strength lbs (N)		Pkg Qty
					In.	MM	Inch	MM	Shear	Tens.	
SSB4-4S	1/8"	#30	.250	.040	.400	10.2	.188-.250	4.9-6.4	420 (1870)	530 (2360)	100
SSB4-6S	(3.2)		(6.35)	1.02	.525	13.4	.313-.375	8.0-9.5			
SSB5-4S	5/32"	#20	.312	.045	.425	10.8	.188-.250	4.9-6.4	650 (2890)	820 (3650)	100
SSB5-6S	(4.0)		(7.92)	(1.14)	.550	14.0	.251-.375	6.5-9.5			
SSB6-2S	3/16"	#11	.375	.055	.325	8.3	.062-.125	1.6-3.2	950 (4230)	1200 (5340)	100
SSB6-4S					.450	11.5	.126-.250	3.3-6.4			
SSB6-6S					.575	14.6	.251-.375	6.5-9.5			
SSB6-8S					.700	17.8	.376-.500	9.6-12.7			

Back-Up Washers

ALUMINUM ROUND

Back-Up Washers are .056" thick for use when fastening soft materials or to compensate for oversize holes where access to both sides of the work is possible.

IBS No.	Hole Size	Diameter	Pkg Qty
AS-8	1/8"	3/8"	100
AS-9	5/32"	7/16"	100
AS-10	3/16"	1/2"	100



Swivel Head Professional Rivet Tool (T03)

IBS No. HP-5



- Rivet head swivels 360° for riveting at any angle.
- Hardened steel construction
- Extended nosepiece for hard to reach locations.
- Comfortable non-slip handle grips.
- Not recommended for nylon rivets.
- Includes nosepieces: 3/32, 1/8, 5/32 & 3/16.

Rivet Diameter	3/32	1/8	5/32	3/16
Aluminum	YES	YES	YES	YES
Steel	YES	YES	YES	NO
Copper	NO	YES	NO	NO
Stainless Steel	NO	YES	NO	NO



Multi-Grip Blind Rivets

Aluminum Rivet • Steel Zinc Yellow Mandrel

Multi-Grip Rivets provide an effective and economical alternative to other, more costly methods of fastening, because one size handles the grip range capacity of up to 3 standard open end rivets. Multi-Grip rivets can be used in any application requiring open end rivets, while reducing inventory requirements. Use multi-grip rivets as a standard open-end rivet — no special tool is needed.



- Resists pull through on both thin and thick material.
- Greater holding power on areas with high vibration.
- Great for holes that are too large or have become elongated.

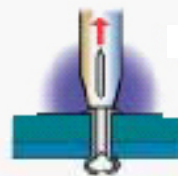
Large Flange Dome Head				Regular Dome Head			
ISB No.	Dia.	Grip Range	Pkg Qty	ISB No.	Dia.	Grip Range	Pkg Qty
170406	1/8"	1/32 – 3/16	100	171406	1/8"	1/32 – 3/16	100
170408	1/8"	1/8 – 5/16	100	171408	1/8"	1/8 – 5/16	100
170508	5/32"	3/64 – 1/4	100	171508	5/32"	3/64 – 1/4	100
170608	3/16"	1/4 – 1/2	100	171608	3/16"	1/16 – 1/4	100
170612	3/16"	1/2 – 25/32	100	171612	3/16"	3/16 – 7/16	100

Install

Insert rivet mandrel in the rivet setting tool



Using tool as a guide, insert rivet into prepared hole



Or insert rivet into prepared hole and then engage the mandrel with rivet setting tool. Squeeze trigger or handles to set rivet. Mandrel ejects after rivet is set.

Features, Benefits & Applications



One length handles both



Hollow extrusions & tubes



High Grip Strength
No Surface Distortion



Hard and Soft Materials



Vibration & Tamper Resistant



High Strength



No Marred Surfaces



Low Profile Heads



IBS, INCORPORATED Rivets W01

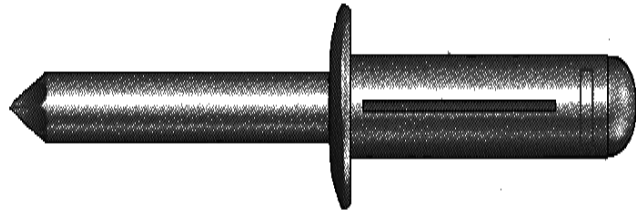
Tri-Fold Rivets

Tri-fold Rivets form three large folded wings which create excellent clamp-up and large blind side bearing surface.



- **Multi-Grip** - Adjusts to wide variation in application thickness.
- **Large Blindside Footprint** - Eliminates need for backup washer.
- **Distributed Clamping** - Helps prevent cracking of brittle materials.
- **Corrosion Resistant** - All aluminum construction.
- **High Pullout Resistance** - When used in thin or ductile materials.
- **Reduced Hole Sensitivity** - Works in oversized, misaligned or irregularly shaped holes.
- **Positive Mandrel Retention** - Rattle free fastener.

- D**- Body Diameter (Maximum)
B- Head Height (Nominal)
A- Head Diameter (Nominal)
L- Rivet Body Length (Nominal)



Head	Rivet	IBS	Grip	Hole Size	Dimensions					Typ. Strength lbs.	
Style	Dia.	No.	Range	Drill No.	D	B*	A	L*	F	Shear	Tensile
Dome	5/32	17254	.040-.250	.162-.167	.161	.055	.312	.770	.880	200	225
		17256	.040-.375	#20				.832	.942		
	3/16	17264	.062-.250	.209-.221 #4	.205	.075	.385	.750	.875	350	450
		17266	.187-.375					.875	1.000		
		17268	.312-.500					1.000	1.125		

Package Quantity = 50

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RiveDrill™ Riveter Drill Attachment

Standard IBS No. 140196
Heavy Duty IBS No. 140416



BOTTOM VIEW

A patented drill attachment that easily converts cordless, electric and pneumatic drills into a blind rivet gun. This innovative tool allows operators to set up to 14 rivets per minute - twice as many as can be set by standard hand tools. Ergonomically friendly, the RiveDrill™ requires just 6.6 pounds of pressure to operate, compared to 77.2 pounds required for hand operation.

The RiveDrill™ can be quickly inserted into a 3/8" or 1/2" reversible power drill as any standard drill bit would and is able to set any standard blind rivet up to 3/16" aluminum and the heavy duty up to 1/4". The shank of the rivet is expelled when the drill is operated in "reverse" mode. (For cordless electric power drills, a minimum 12V battery is recommended, 14V for Heavy Duty version). Nosepieces for 1/8", 5/32", and 3/16" sizes are included with IBS No. 140196 and 1/8", 5/32", 3/16", and 1/4" with IBS No. 140416.

APPLICATIONS:

- General Facility Maintenance & Repair
- Small Aircraft & Boat Repair
- Residential and Commercial Construction
- Automotive Aftermarket

RIVEDRILL for blind rivets SPECIFICATIONS

- Weight: .618 lbs (280) grams
- Length: 5.5 inches (141 mm)
- Diameter: 2.4 inches (60 mm)
- Battery for cordless drill: 12V
- Drill Types: Cordless
(12V recommended min for cordless), Electric, Pneumatic

RIVET CAPACITIES:

- 1/8", 5/32", 3/16" aluminum standard rivets;
- 1/8", 5/32", 3/16" aluminum/steel multi-grip rivets;
- 1/8" & 5/32" steel standard rivets;
- 1/8" stainless standard rivets



Heavy Duty Model
IBS No. 140416

RIVEDRILL for HEAVYDUTY blind rivets SPECIFICATIONS

- Weight: .132 lbs (600) grams
- Length: 7.09 inches (180 mm)
- Diameter: 2.4 inches (60 mm)
- Drill Types: Cordless
(14V recommended min for cordless), Electric, Pneumatic
- Rivet Capacities:
1/8", 5/32", 3/16", 1/4" alum standard rivets;
1/8", 5/32", 3/16", 1/4" alum/steel multi-grip rivets;
1/8" 5/32", 3/16" steel standard rivets;
1/8", 5/32", 3/16" stainless standard rivets

IBS No.	Description
140196	RiveDrill™ Riveter Drill Attachment
140416	RiveDrill™ HD Riveter Drill Attachment
140312	1/8" RiveDrill™ Nosepiece
140313	5/32" RiveDrill™ Nosepiece
140314	3/16" RiveDrill™ Nosepiece
140576	1/4" RiveDrill™ Nosepiece

R I V E T S & I N S E R T S



IBS, INCORPORATED

Assortments Z02

Multi-Grip Rivets Assortment

IBS No. 368R • 10 Items • 1,000 Pieces

Packaged in a locking steel drawer for storage & organization



IBS, Inc.
SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR
(800) 678-1906 • www.industrialbolt.com

Multi-Grip Rivets

Assortment No. 368R

<p>170406 1/8 LARGE FLG SHORT MULTIGRIP</p> 	<p>170408 1/8 LARGE FLG LONG MULTIGRIP</p> 	<p>170508 5/32 LARGE FLG MULTIGRIP</p> 
<p>170608 3/16 LARGE FLG SHORT MULTIGRIP</p> 	<p>170612 3/16 LARGE FLG LONG MULTIGRIP</p> 	
<p>171406 1/8 DOME HD SHORT MULTIGRIP</p> 	<p>171408 1/8 DOME HD LONG MULTIGRIP</p> 	<p>171508 5/32 DOME HD MULTIGRIP</p> 
<p>171608 3/16 DOME HD SHORT MULTIGRIP</p> 	<p>171612 3/16 DOME HD LONG MULTIGRIP</p> 	

Multi-Grip & Tri-Fold Rivets Assortment

IBS No. 369R • 12 Items • 800 Pieces

Packaged in a locking steel drawer for storage & organization



IBS, Inc.
SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR
(800) 678-1906 • www.industrialbolt.com

Multi-Grip & Tri-Fold Rivets

Assortment No. 369R

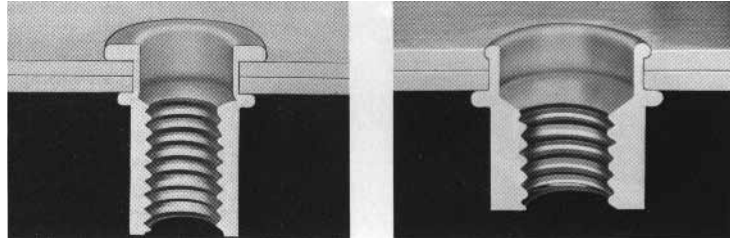
<p>170406 1/8 LARGE FLG SHORT MULTIGRIP</p> 	<p>170408 1/8 LARGE FLG LONG MULTIGRIP</p> 	<p>170508 5/32 LARGE FLG MULTIGRIP</p> 
<p>170608 3/16 LARGE FLG SHORT MULTIGRIP</p> 	<p>170612 3/16 LARGE FLG LONG MULTIGRIP</p> 	<p>171406 1/8 DOME HD SHORT MULTIGRIP</p> 
<p>171408 1/8 DOME HD LONG MULTIGRIP</p> 	<p>171608 3/16 DOME HD SHORT MULTIGRIP</p> 	<p>171612 3/16 DOME HD LONG MULTIGRIP</p> 
<p>17256 5/32 TRI-FOLD RIVET .040-.375</p> 	<p>17264 3/16 TRI-FOLD RIVET .062-.250</p> 	<p>17266 3/16 TRI-FOLD RIVET .187-.375</p> 

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Rivet Nut Systems & Installation

Flanged Rivet Nuts and "Thin Skin" Rivet Nuts enjoy a wide range of applications. They are especially useful where threaded holes are needed, but both sides of the material cannot be reached.



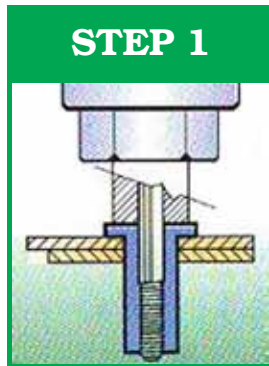
Flanged Rivet Nut

"Thin Skin" Rivet Nut

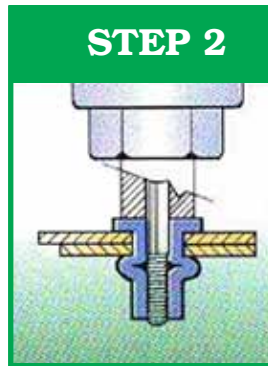
Flanged rivet nuts and "Thin Skin" rivet nuts can assure captive load bearing in materials too thin to independently provide efficient thread strength. They can easily be installed by one person from one side of the assembly using either air or hand powered tools.

Flanged Rivet Nuts, because of their large diameter head, can be used in soft materials which inherently offer little or no thread strength. "Thin Skin" Rivet Nuts allow for a nearly flush installation along with an excellent fit to mating materials.

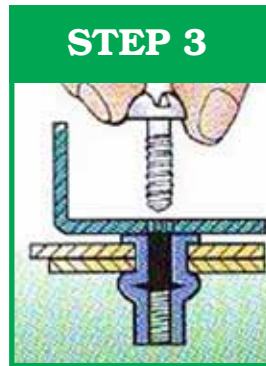
Easy Installation



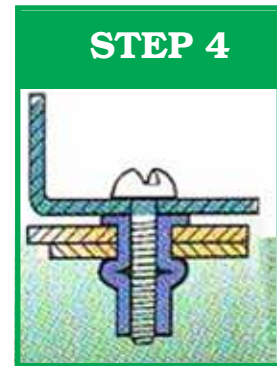
Drill hole to correct diameter, thread fastener onto tool mandrel and insert into hole.



Actuate tool to properly set fastener into material.



Complete your fastening operation with a bolt or screw with the proper thread.



The positive riveting action of both the Flanged and Thin Skin Rivet Nuts provide consistent firm fastening. Push out and shake loose are virtually eliminated

Product Strength - Flanged Rivet Nuts

Thread Size	Typical Sheer Strength		Typical Tensile Strength	
	Aluminum	Steel	Aluminum	Steel
6-32	215	365	225	525
8-32	280	525	285	575
10-24	300	650	415	815
10-32	300	650	415	815
1/4-20	525	700	650	1250
5/16-18	640	900	905	1400
3/8-16	1000	1370	1300	1500

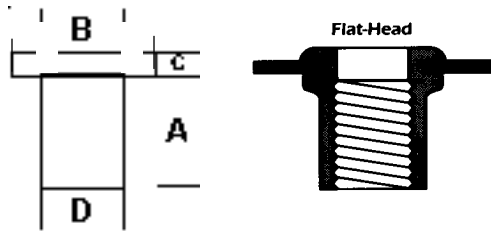


IBS, INCORPORATED

Thread Inserts W02

Flanged Rivet Nuts

ZINC PLATED STEEL OR ALUMINUM CLASS 2B THREADS



Flanged or Flathead Rivet Nuts can be used in a wide range of applications and are designed to provide a very efficient and cost-effective method of placing permanent threads in thin materials. Installed from one side, these rivet nuts are perfect for use in metal, fiberglass and rigid plastic previously too thin for tapped threads. Rivet nuts provide a neat appearance and once in place, the internal threads are ready for a screw or bolt.

Lightweight tooling assures easy installation and reduces costs compared to other methods. Provides permanent, captive threads that do not allow loosening under vibration and will not rotate when attached.

Rivet Nuts with **large diameter heads** can be used in soft materials which offer little, if any thread strength.

The **flathead design** provides the most bearing surface for higher torque applications. The larger flange extends above the material and provides a built in spacer.

Thread Size	IBS No.		Drill No. Hole size	B	C	A	Grip Range	Pkg Qty
	Steel	Alum.		Head Dia.	Head Ht.	Body Lgth.		
6-32	49110	49210	#12 .189/.193	.325	.032	.438	.010/.075	25
8-32	49120	49220	#2 .221/.226	.357	.032	.438	.010/.075	25
10-24	49130	49230	1/4" .250/.254	.406	.038	.531	.010/.080	25
10-32	49140	49240	1/4" .250/.254	.406	.038	.531	.010.080	25
1/4-20	49150	49250	'Q' .332/.338	.475	.058	.625	.020/.080	25
		49252				.687	.080/.140	25
5/16-18	49171	49271	'Z' .413/.423	.665	.062	.750	.030/.125	25
		49174				.875	.125/.200	25
3/8-16	49181	49281	1/2" .490/.500	.781	.088	.844	.030/.115	25

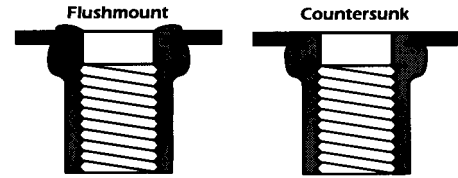
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“Thin Skin” Rivet Nuts

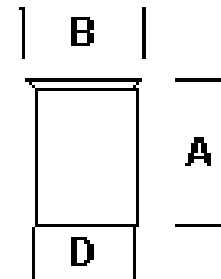
STEEL ZINC PLATED OR ALUMINUM CLASS 2B THREADS

“Thin Skin” Rivet Nuts feature a small flange which allows for two distinct finishes:



Flushmount - obtained by drilling a standard hole and offers a low profile to the surface of the application;

Countersunk - obtained by drilling a counter sunk hole and allows the rivet nut to be set below the surface. During installation of the “Thin Skin” Rivet Nuts the threaded body draws upward against the blind side of the application material, while the flange clamps onto the surface and lock the fastener into place. They are available in aluminum and low carbon steel in sizes from 6-32 to 3/8-16.



“Thin Skin” rivet nuts can be used in a wide range of applications to place permanent threads in thin materials. They are ideal for use in metal, fiberglass, and rigid plastics. These rivet nuts provide a nearly flush appearance and provide permanent, captive threads that do not allow loosening under vibration and will not rotate when attached to the mating material.

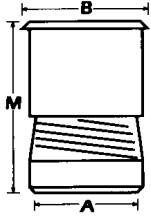
NOTE: HOLE SIZE IS CRITICAL FOR PROPER INSTALLATION.

Thread Size	IBS No.	Mat'l	Drill No. Hole Size	B	A	Grip Range	Pkg Qty
				Head Dia.	Body Length		
6-32	49415	Steel	1/4"	.287	.41	.020/.080	25
6-32	17500	Alum.	.250/.254				
8-32	49425	Steel	1/4"	.287	.41	.020/.080	25
8-32	17501	Alum.	.250/.254				
10-24	49435	Steel	9/32"	.32	.465	.020/.130	25
10-24	17502	Alum.	.281/.285				
10-32	49445	Steel	9/32"	.32	.465	.020/.130	25
10-32	17503	Alum.	.281/.285				
1/4-20	49455	Steel	3/8"	.415	.61	.030/.165	25
1/4-20	17504	Alum.	.375/.379				
5/16-18	49475	Steel	1/2"	.54	.720	.030/.165	25
5/16-18	17505	Alum.	.500/.504				
3/8-16	17506	Alum.	1/2"	.658	.535	.020/.125	25



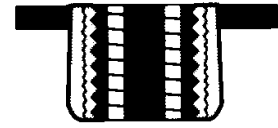
IBS, INCORPORATED Thread Inserts W02

“Nutsert” Type Thread Inserts



“Nutserts” are a versatile threaded fastener that can be used in a variety of applications. Use in any thickness of metal or rigid material of at least 3/32" (.0937). Eliminate the need for tapping, welding, and brazing. "Nutserts" design consists of an upper sleeve and a base which

Completed Application



has both internal and external threads. During installation, the base is drawn upwards inside the upper sleeve forcing a 360° contact between the sleeve and application material. No special preparation is needed; a drilled or punched hole is all that is required. Because of its unique setting ability, "nutserts" can be used in almost any thickness of material. Installation is made quite easy with a variety of tools and kits.

Thread Size	IBS No.		Material Thickness .0937 - .1562		Material Thickness .1562 - Infinity		A	B	Pkg Qty
	Steel	Alum	Hole	Drill	Hole	Drill			
1/4-20	17510	17516	.391	25/64	.391	25/64	.510	.408	25
5/16-18	17511	17517	.500	1/2	.516	33/64	.615	.537	25
3/8-16	17512	17518	.562	9/16	.578	37/64	.740	.600	25

Heavy Duty Nutsert Tool

IBS No. 49550

Ideal for installing larger size steel inserts. This heavy-duty tool installs 1/4-20 through 3/8-16, and 5mm through 10mm threaded inserts in aluminum or steel. Quick changing mandrels, easily adjustable stroke. 1/4-20 mandrel and nosepiece included.



Heavy Duty Nutsert Tool (49550)
Mandrels & Nosepieces

IBS No.	Description
49551	1/4-20 Mandrel & Nosepiece
49552	5/16-18 Mandrel & Nosepiece
49553	3/8-16 Mandrel & Nosepiece

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Knurled Nutserts

STEEL ZINC PLATED • CLASS 2B THREADS

These new blind threaded inserts with a large head are ideal for applications where large or irregular holes are a problem. Installed from one side, these knurled nutserts work in sheet metal, structural foam, fiberglass, and some plastics. They provide a neat appearance, and once in place the internal threads are ready for a screw or bolt. Additional features of the Knurled Nut Sert include:

- Increased torque or strength over conventional style nutserts.
- 360° knurled expansion after setting
- Vibration resistant
- Large flanged head increases push-out strength

After installation, Knurled Nutserts provide permanent, captive threads that do not allow loosening under vibration and will not rotate when attached to the mating material. Nutserts with large diameter heads can be used in soft materials which inherently offer little, if any thread strength. The flathead design provides the most bearing surface for higher torque applications. The large flange extends above the material in which it is installed and provides a built-in spacer.



IBS No.	Thread Size	Grip Range	Hole Size	Drill Size	Min. Flange	Max. Length	Pkg Qty
49509	6-32	.080 - .130	.264	17/64	.390	.470	25
49501	8-32	.080 - .130	.264	17/64	.390	.470	25
49502	10-24	.020 - .130	.295	19/64	.415	.475	25
49503	10-32	.020 - .130	.295	19/64	.415	.475	25
49504*	1/4-20	.027 - .165	.390	25/64	.500	.580	25
49505*	5/16-18	.027 - .150	.530	17/32	.690	.685	25
49506*	3/8-16	.027 - .150	.530	17/32	.690	.685	25
NS-47360	M4 X .07	.5 - 2.0 mm	6.75+.15 mm	6.75 mm	9.91 mm	10.67 mm	100
NS-47385	M5 X 0.8	.5 - 3.3 mm	7.6+.15 mm	7.6 mm	10.54 mm	12.07 mm	100
NS-47386	M6 X 1.0	.7 - 4.2 mm	10.0+.15 mm	10.0 mm	12.7 mm	14.73 mm	50
NS-47388	M8 X 1.25	.7 - 3.8 mm	13.5+.15 mm	13.5 mm	17.4 mm	17.53 mm	25
NS-47390	M10 X 1.5	.7 - 3.8 mm	13.5+.15 mm	13.5 mm	17.4 mm	17.53 mm	25

* Recommend using Heavy Duty Nutsert Tool (IBS No. 49550) for installation

















IBS, INCORPORATED

Assortments Z08

Knurled Nutsert Assortment













IBS No. 431P • 13 items • 127 pieces

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 IBS, Inc. <small>SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR (800) 678-1906 • www.industrialbolt.com</small>			Knurled Nutserts with Tool Assortment No. 431P	
49514 3/8-16 MANDREL & NOSEPIECE 	49503 10-32 KNURLED GRIP SERT 	49506 3/8-16 KNURLED GRIP SERT 		
49513 5/16-18 MANDREL & NOSEPIECE 		<i>NOTE: This size should be installed with Heavy Duty Nutsert Tool P/N 49550</i>		
49512 1/4-20 MANDREL & NOSEPIECE 	49502 10-24 KNURLED GRIP SERT 	49505 5/16-18 KNURLED GRIP SERT 		
49511 10-32 MANDREL & NOSEPIECE 		<i>NOTE: This size should be installed with Heavy Duty Nutsert Tool P/N 49550</i>		
49510 10-24 MANDREL & NOSEPIECE 	49501 8-32 KNURLED GRIP SERT 	49504 1/4-20 KNURLED GRIP SERT 		
49508 8-32 MANDREL & NOSEPIECE 		<i>NOTE: This size should be installed with Heavy Duty Nutsert Tool P/N 49550</i>		

Aluminum Nutsert Assortment

IBS No. 432P • 14 items • 152 pieces

 IBS, Inc. <small>SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR (800) 678-1906 • www.industrialbolt.com</small>			Aluminum Nutserts Assortment No. 432P	
49514 3/8-16 MANDREL & NOSEPIECE 	17503 10-32 ALUM RIVET NUT 	17506 3/8-16 ALUM RIVET NUT 		
49513 5/16-18 MANDREL & NOSEPIECE 	17502 10-24 ALUM RIVET NUT 	17505 5/16-18 ALUM RIVET NUT 		
49512 1/4-20 MANDREL & NOSEPIECE 	17501 8-32 ALUM RIVET NUT 	17504 1/4-20 ALUM RIVET NUT 		
49511 10-32 MANDREL & NOSEPIECE 	17500 6-32 ALUM RIVET NUT 			
49510 10-24 MANDREL & NOSEPIECE 	49507 6-32 MANDREL & NOSEPIECE 			
49508 8-32 MANDREL & NOSEPIECE 				



Rivet Nut Gun
IBS No. 49500

This thin sheet setting tool has been designed to enable threaded nut inserts to be threaded easily by hand. Invaluable to maintenance engineers for on the spot repairs.

- Designed for the quick manual insertion of permanent load bearing threads in materials from 0.20" to 0.128."
- Simple set up and easy uniform stroke allows a nutsert to be set in thin sheet materials without causing surface damage.
- A comprehensive range of mandrels and nosepieces are available.

Ideal for:

- One side application
- Flush mounting
- Permanent thread
- Moisture resistant
- Cost effective
- Strong
- Rapid
- Vibration resistant
- Portable

**RIVET NUT GUN
 MANDRELS & NOSEPIECES**

IBS No.	Description
49500	Rivet Nut Gun Tool Only No Mandrels or Nosepieces
49507	6-32 Mandrel & Nosepiece
49508	8-32 Mandrel & Nosepiece
49510	10-24 Mandrel & Nosepiece
49511	10-32 Mandrel & Nosepiece
49512	1/4-20 Mandrel & Nosepiece
49513	5/16-18 Mandrel & Nosepiece
49514	3/8-16 Mandrel & Nosepiece
NS-49520*	4mm Mandrel & Nosepiece
NS-49521*	5mm Mandrel & Nosepiece
NS-49522*	6mm Mandrel & Nosepiece
NS-49523*	8mm Mandrel & Nosepiece
NS-49524*	10mm Mandrel & Nosepiece

* Order as non-stock item



IBS, INCORPORATED

Thread Inserts W02

Self-Tapping Threaded Inserts

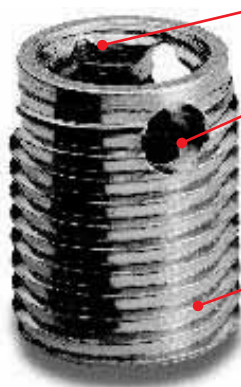
FOR USE IN ALUMINUM, ALUMINUM ALLOY, MAGNESIUM AND MILD STEEL



Our self-tapping thread inserts features both internal and external threads and cutting bores. These inserts have a thick wall and the cutting force is distributed over three cutting edges, making them ideal for materials with difficult cutting properties: aluminum, aluminum alloy, magnesium and mild steel.

FEATURES & BENEFITS:

- Taps and installs in one easy step, saving time, money and labor.
- Provides maximum pull-out strength and wear resistant threads in aluminum, aluminum alloy, magnesium and mild steel.
- Three lateral cutting bores make for an easy self-tapping installation, providing a connection that is highly resistant to vibration.



Internal threads are wear-resistant standard class 2B

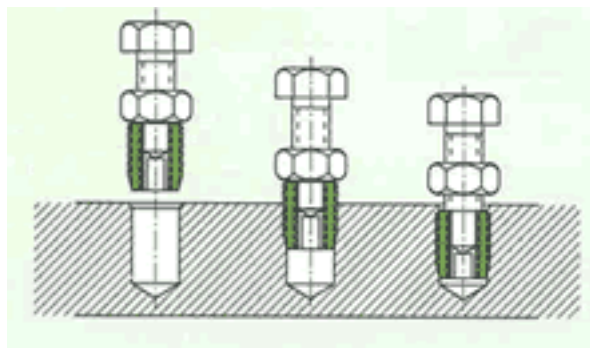
Circular cutting bores self-tap and lock into the base material. Resists extreme vibration with no loss in performance.

Superior pull-out resistance in softer metals and plastics from the external v-form thread.

INSTALLATION INSTRUCTIONS:

(Using a hex head cap screw & nut)

1. Drill to recommended hole size.
2. Thread hex nut onto capscrew. Screw insert onto capscrew with holes away from nut. Tighten the nut snugly to the top of the insert.
3. Using the appropriate wrench or socket, carefully align insert perpendicular to the hole and turn clockwise until flush with the surface. To remove capscrew, hold nut and loosen capscrew.



SELF-TAPPING THREADED INSERTS

IBS No.	Size	Length	Drill # & Hole Size	Hole Depth	Pkg Qty	IBS No.	Size	Length	Drill # & Hole Size	Hole Depth	Pkg Qty
65935	1/4-20	.472	V (.366)	.591	20	65945	M6-1.0	.472	V (.377)	.591	20
65936	5/16-18	.551	29/64 (.453)	.669	20	65946	M8-1.25	.551	29/64 (.453)	.669	20
65937	3/8-16	.709	17/32 (.531)	.866	10	65947	M10-1.5	.709	17/32 (.531)	.866	10
65939	1/2-13	.945	11/16 (.68)	1.102	10	65948	M12-1.75	.866	39/64 (.609)	1.023	10

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Self-Tapping Threaded Inserts Assortment

IBS No. 696R • 8 Items • 60 Pieces
Packaged in a locking steel drawer for storage & organization



Self-Tapping Threaded Inserts

Assortment No. 696R

<p>65935 1/4-20 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: V</p>	<p>65936 5/16-18 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 29/64</p>	<p>65937 3/8-16 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 17/32</p>	<p>65939 1/2-13 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 11/16</p>
<p>65945 M6-1.0 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: V</p>	<p>65946 M8-1.25 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 29/64</p>	<p>65947 M10-1.5 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 17/32</p>	<p>65948 M12-1.75 SELF-TAPPING THREAD INSERT</p>  <p style="text-align: center;">Use Drill: 39/64</p>

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IBS, INCORPORATED

Thread Inserts W02

Helical Thread Inserts



Thread inserts are used to replace stripped out or damaged threads in most metals including aluminum. They are made from high quality stainless steel wire, with diamond-shaped cross section, wound to the shape of a spring thread. The insert, which is larger in diameter than the tapped hole, is allowed to spring back, permanently anchoring it into place. Because it is bigger, the insert has greater area to hold in and is stronger than the original threads. The inserts compensatory action shares the load over the entire bolt and hole, thus reducing stud feature, and increasing holding or pull out strength. The Industrial Bolt insert system consists of stainless steel helically wound precision inserts, high quality HSS taps and metal installation tools. Inserts are available in both individual and kit form.

- Creates superior threads with greater holding power
- Quick and easy to use
- Suitable for new applications requiring strong threads
- Simplifies change-over from metric to U.S. threads
- Provides stronger and more efficient threads than other inserts.



**SAFER ON HEAVY DUTY APPLICATIONS
LESS DOWN TIME DUE TO REPLACEMENT**

**KITS INCLUDE TAP,
INSTALLATION TOOL,
& INSERTS**

Helical Thread Installation



STEP 1: DRILL
Drill out old threads, including any broken bolts or studs.



STEP 2: TAP
Tap hole for insert with tap provided in the kit.



STEP 3: INSTALL
Install the helical thread insert and the job is done!

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Helical Thread Inserts

Coarse Thread					Fine Thread				
Size	IBS No.		Rec. Drill Size	Inserts Per Pkg	Size	IBS No.		Rec. Drill Size	Inserts Per Pkg
	Kit	Inserts				Kit	Inserts		
6-32	16000	16020	25	12	10-32	16012	16032	13/64	12
8-32	16001	16021	11/64	12	1/4-28	16013	16033	17/64	12
10-24	16002	16022	13/64	12	5/16-24	16014	16034	21/64	10
12-24	16003	16023	15/64	12	3/8-24	16015	16035	25/64	10
1/4-20	16004	16024	17/64	12	7/16-20	16016	16036	29/64	6
5/16-18	16005	16025	21/64	10	1/2-20	16017	16037	33/64	6
3/8-16	16006	16026	25/64	10	9/16-18	16017A	16041	37/64	6
7/16-14	16007	16027	29/64	6	5/8-18	16018	16038	41/64	6
1/2-13	16008	16028	17/32	6	3/4-16	16019	16039	49/64	4
9/16-12	16009	16029	19/32	6					
5/8-11	16010	16030	21/32	6					
3/4-10	16011	16031	25/32	4					

ALL KITS & INSERTS SOLD AS PACKAGES ONLY!

Metric Helical Inserts				
Size	IBS No.		Rec. Drill Size	Inserts Per Pkg
	Kits	Inserts		
M6 x 1.0	16042	16051	1/4"	12
M8 x 1.25	16043	16052	21/64"	10
M10 x 1.5	16044	16053	13/32"	10
M12 x 1.75	16045	16054	31/64"	6
M14 x 1.25*	16049	16050		12**
*For Spark Plugs		** includes 6 ea. 3/4 & 3/8		

FOR EXAMPLE:
1 KIT (16000) = 1 PKG
F
INCLUDES (12) INSERTS,
(1) INSTALLATION TOOL,
& (1) TAP
1 PKG (16032) = 12 INSERTS
ORDER QTY = 1

R I V E T S & I N S E R T S



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Thread Inserts W02

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Thread Repair Inserts Installation & Removal



1. Drill out old threads with a standard drill. Countersink with a standard (82° - 100°) countersink.



2. Tap new threads with a standard tap. See charts for proper size and depth.



3. Screw in the insert until slightly below the surface.



4. Drive keys down with several hammer taps on the proper installation tool.

NOTE: Drill is oversized, see charts for proper dimensions.

IBS THREAD REPAIR INSERTS CAN BE REMOVED WITHOUT DAMAGE TO THE PARENT MATERIAL



1. Drill out material between keys and internal thread with standard drill to specified depth (refer to chart for proper dimensions).
2. Bend the keys inward and break off.
3. Remove the old insert using an E-Z Out or similar tool
4. Install the replacement insert into the original tapped hole.

TECHNICAL NOTES:

Material: Carbon Steel Inserts - C1215 or equivalent

Finish: Carbon Steel Insert - Parkerized

Tolerances: ± 0.10 inch or $+ .25$ mm unless specified otherwise

Dimensions: All dimensions are listed in inches.

IBS, INCORPORATED

Thread Inserts W02



Thread Repair Inserts Heavy Wall

IBS No.	INSERT			INSTALLATION				REMOVAL			
	Carbon Steel	Internal Thread Class 2A	External Thread Mod. Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Dia. +.010 - .000	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
65900	8-32	5/16-18	.31	65999	I 16143	.32	5/16-18 17637	.37	7/32	1/8	
65901	10-24	3/8-16	.31	65999	Q 16151	.38	3/8-16 17639	.37	9/32	1/8	
66101	10-32										
65902	1/4-20	7/16-14	.37	65999	X 16158	.44	7/16-14 17641	.48	11/32	3/16	
66102	1/4-28										
65903	5/16-18	1/2-13	.43	65999	29/64 17425	.51	1/2-13 17643	.50	13/32	3/16	
66103	5/16-24										
65904	3/8-16	9/16-12	.50	65999	33/64 16833	.57	9/16-12 17645	.56	15/32	3/16	
66104	3/8-24										
65905	7/16-14	5/8-11	.62	65999	37/64 16837	.63	5/8-11 17647	.68	17/32	3/16	
66105	7/16-20										
65906	1/2-13	3/4-16	.62	65999	45/64 16845	.76	3/4-16 17650	.68	21/32	3/16	
66106	1/2-20										
65907	9/16-12	3/4-16	.81	65999	45/64 16845	.76	3/4-16 17650	.94	21/32	3/16	
65908	5/8-11	7/8-14	.87	65999	53/64 16853	.88	7/8-14 17652	1.00	25/32	5/16	
66108	5/8-18										
65909	3/4-10	1-1/8-12	1.12	65999	1-1/16 NS-29880	1.14	1-1/8-12 NS	1.31	31/32	5/16	
66109	3/4-16										

R I V E T S & I N S E R T S



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Thread Inserts W02



Thread Repair Inserts Thin Wall

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IBS No.	INSERT			INSTALLATION					REMOVAL		
	Carbon Steel	Internal Thread Class 2A	External Thread Mod. Class 2A	Length	Installation Tool Part No.	Tap Drill Size	C'Sink Dia. +.010 - .000	Thread Tap		Drill	
								Size Class 2B	Min. Depth	Size	Depth
65921	10-24	5/16-18	.31	65999	I 16143	.32	5/16-18 17637	.37	7/32	1/8	
66121	10-32										
65922	1/4-20	3/8-16	.37	65999	Q 16151	.38	3/8-16 17639	.43	9/32	3/16	
66122	1/4-28										
65923	5/16-18	7/16-14	.43	65999	X 16158	.44	7/16-14 17641	.50	11/32	3/16	
66123	5/16-24										
65924	3/8-16	1/2-13	.50	65999	29/64 17425	.51	1/2-13 17643	.56	13/32	3/16	
66124	3/8-24										
65925	7/16-14	9/16-12	.56	65999	33/64 16833	.57	9/16-12 17645	.62	15/32	3/16	
66125	7/16-20										
65926	1/2-13	5/8-11	.62	65999	37/64 16837	.63	5/8-11 17647	.68	17/32	3/16	
66126	1/2-20										



Thread Repair Insert Assortments

Assortments with Cabinets

212R • USS Heavy Wall 214R • USS Thin Wall
 213R • SAE Heavy Wall 215R • USS Thin Wall

 IBS, Inc. <small>SPECIALTY PRODUCTS FOR MAINTENANCE & REPAIR (800) 878-1906 • www.IndustrialBolt.com</small>		Thread Repair Insert Assortments <small>1/4-1/2 NC USS Heavy Wall (212R - Row #4 only) 1/4-1/2 NF SAE Heavy Wall (213R Row #2 only) 1/4-1/2 NC USS Thin Wall (214R Row #3 only) 1/4-1/2 NF SAE Thin Wall (215R Row #1 only)</small>			
66122 1/4-28 THIN WALL THD INSERT  Use With P/N 16151 "Q" Drill P/N 17639 3/8-16 Tap	66123 5/16-24 THIN WALL THD INSERT  Use With P/N 16158 "X" Drill P/N 17641 7/16-14 Tap	66124 3/8-24 THIN WALL THD INSERT  Use With P/N 17425 29/64 Drill P/N 17643 1/2-13 Tap	66125 7/16-20 THIN WALL THD INSERT  Use With P/N 16833 33/64 Drill P/N 17645 9/16-12 Tap	66126 1/2-20 THIN WALL THD INSERT  Use With P/N 16837 37/64 Drill P/N 17647 5/8-11 Tap	
66102 1/4-28 HVY WALL THD INSERT  Use With P/N 16158 "X" Drill P/N 17641 7/16-14 Tap	66103 5/16-24 HVY WALL THD INSERT  Use With P/N 17425 29/64 Drill P/N 17643 1/2-13 Tap	66104 3/8-24 HVY WALL THD INSERT  Use With P/N 16833 33/64 Drill P/N 17645 9/16-12 Tap	66105 7/16-20 HVY WALL THD INSERT  Use With P/N 16837 37/64 Drill P/N 17647 5/8-11 Tap	66106 1/2-20 HVY WALL THD INSERT  Use With P/N 16845 45/64 Drill P/N 17650 3/4-16 Tap	66108 5/8-18 HVY WALL THD INSERT  Use With P/N 16853 53/64 Drill P/N 17652 7/8-14 Tap
65922 1/4-20 THIN WALL THD INSERTS  Use With P/N 16151 "Q" Drill P/N 17639 3/8-16 Tap	65923 5/16-18 THIN WALL THD INSERTS  Use With P/N 16158 "X" Drill P/N 17641 7/16-14 Tap	65924 3/8-16 THIN WALL THD INSERTS  Use With P/N 17425 29/64 Drill P/N 17643 1/2-13 Tap	65925 7/16-14 THIN WALL THD INSERTS  Use With P/N 16833 33/64 Drill P/N 17645 9/16-12 Tap	65926 1/2-13 THIN WALL THD INSERTS  Use With P/N 16837 37/64 Drill P/N 17647 5/8-11 Tap	65999 INSERT TOOL FOR THD INSERTS 
65902 1/4-20 HVY WALL THD INSERT  Use With P/N 16158 "X" Drill P/N 17641 7/16-14 Tap	65903 5/16-18 HVY WALL THD INSERT  Use With P/N 17425 29/64 Drill P/N 17643 1/2-13 Tap	65904 3/8-16 HVY WALL THD INSERT  Use With P/N 16833 33/64 Drill P/N 17645 9/16-12 Tap	65905 7/16-14 HVY WALL THD INSERT  Use With P/N 16845 37/64 Drill P/N 17647 5/8-11 Tap	65906 1/2-13 HVY WALL THD INSERT  Use With: P/N 16845 45/64 Drill P/N 17650 3/4-16 Tap	

Thread Repair Insert Assortments

Fill-In Assortment Segments

221R • USS Heavy Wall 223R • USS Thin Wall
 222R • SAE Heavy Wall 224R • USS Thin Wall



Insert Tool
IBS No. 65999

Use for tapping down locking keys

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