



Declaration of Performance Nr 077/D7337AL/10.01.2018

1. Unique identification code of the product-type:

**Blind Rivets DIN7337
Aluminium AL / Carbon Steel AC Dome Head**

1a. Valid Hammerjack article numbers

**Standard AL/AC
65-73370101*, 80-B71AL*, 80-K71AL*, 89-B71AL3*, 89-K71AL*, H2K-*, H3K-***

**Painted AL/AC
65-73370103*, 80-B71RR*, 80-K71RR*, 85-B71RR*, 89-B71RR***

2. Type, batch or serial number or any other element allowing identification of the construction product as required under Article 11(4):

On the package

3. Intended use or uses of the construction product, in accordance with the applicable harmonised technical specification, as foreseen by the manufacturer:

A blind rivet is a fastener which can be operated to fasten the work pieces from one side only. Normally, when the operator cannot reach the other side for some reasons, and the other side of the work pieces is not visible – “blind”, the blind rivet is the best solution. As long as a blind rivet is used to fasten the work pieces, the rivet cannot be loosen unless it is damaged.

4. Name, registered trade name or registered trade mark and contact address of the manufacturer as required pursuant Article 11(5):

**Hammerjack OÜ
Tänassilma tee 15
Saku Vald 76406, Harjumaa
Tel: +372 6 729 515
Fax: +372 6 729 510
E-post: info@hammerjack.ee**

5. Where applicable, name and contact address of the authorised representative whose mandate covers the tasks specified in Article 12(2):

Not applicable

6. System or systems of assessment and verification of constancy of performance of the construction product as set out in Annex V:

System 3

7. In case of the declaration of performance concerning a construction product covered by a harmonised standard:



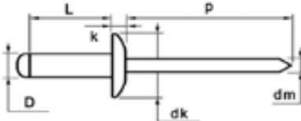
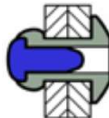
DIN7337/ISO15983

Deutsches Institut für Normung

8. In case of the declaration of performance concerning a construction product for which a European Technical Assessment has been issued:

Not applicable

9. Declared performance:

		MATERIALS	FINISH		
		aluminium alloy (AlMg 2,5)	polished		
		carbon steel	zinc plated		





AlMg 2,5 / STEEL DOME HEAD

dimensions in mm

D	L +0,9/-0	GRIP RANGE min. ~ max.	ARTICLE NUMBER	dk	k max.	dm ≈	p min.	TENSILE [N]	SHEAR [N]
2,4 [+0,08/-0,10]  2,5 mm	4,0	0,0 ~ 2,0	H2K-24040						
	6,0	1,5 ~ 3,5	H2K-24060	5,0	0,7				
	8,0	3,5 ~ 5,5	H2K-24080	[+0/- 0,7]	[+/- 0,15]	1,45	27	353	315
	10,0	5,5 ~ 7,5	H2K-24100						
3,0 [+0,08/-0,10]  3,1 mm	4,0	0,0 ~ 1,5	H2K-30040						
	6,0	1,5 ~ 3,5	H2K-30060						
	8,0	3,5 ~ 5,5	H2K-30080	6,5	0,8				
	10,0	5,5 ~ 7,5	H2K-30100	[+0/- 0,7]	[+/- 0,20]	1,75	27	810	620
	12,0	7,5 ~ 9,5	H2K-30120						
	14,0	9,0 ~ 11,0	H2K-30140						
16,0	11,0 ~ 13,0	H2K-30160							
3,2 [+0,08/-0,10]  3,3 mm	4,0	0,0 ~ 1,5	H2K-32040						
	6,0	1,5 ~ 3,0	H2K-32060						
	8,0	3,0 ~ 5,0	H2K-32080						
	10,0	5,0 ~ 7,0	H2K-32100	6,5	0,8				
	12,0	7,0 ~ 9,0	H2K-32120	[+0/- 0,7]	[+/- 0,20]	1,75	27	980	760
	14,0	9,0 ~ 11,0	H2K-32140						
	16,0	11,0 ~ 12,5	H2K-32160						
	18,0	12,5 ~ 14,5	H2K-32180						
20,0	14,5 ~ 16,5	H2K-32200							
4,0 [+0,08/-0,15]  4,1 mm	6,0	1,0 ~ 2,0	H3K-40060						
	8,0	2,0 ~ 4,0	H3K-40080						
	10,0	4,0 ~ 6,0	H3K-40100						
	12,0	6,0 ~ 8,0	H3K-40120						
	14,0	8,0 ~ 10,0	H3K-40140	8,0	1,0				
	16,0	10,0 ~ 12,0	H3K-40160	[+0/- 1,0]	[+/- 0,30]	2,10	27	1.600	1.200
	18,0	12,0 ~ 14,0	H3K-40180						
	20,0	14,0 ~ 15,5	H3K-40200						
	23,0	15,5 ~ 18,0	H3K-40230						
	25,0	18,0 ~ 20,0	H3K-40250						

AIMg 3,5 / STEEL DOME HEAD

dimensions in mm

D	L +0,9/-0	GRIP RANGE min. ~ max.	ARTICLE NUMBER	dk	k max.	dm ≈	p min.	TENSILE [N]	SHEAR [N]
4,8	6,0	1,0 ~ 2,0	H3K-48060						
[+0,08/-0,15]	8,0	2,0 ~ 3,5	H3K-48080						
	10,0	3,5 ~ 5,5	H3K-48100						
4,9 mm	12,0	5,5 ~ 7,5	H3K-48120						
	14,0	7,5 ~ 9,5	H3K-48140						
	16,0	9,0 ~ 11,0	H3K-48160	9,5	1,1				
	18,0	11,0 ~ 13,0	H3K-48180	[+0/-	[+/-	2,70	27	2.230	1.690
	20,0	13,0 ~ 15,0	H3K-48200	1,0]	0,30]				
	22,0	15,0 ~ 17,0	H3K-48220						
	25,0	17,0 ~ 20,0	H3K-48250						
	28,0	20,0 ~ 23,0	H3K-48280						
	30,0	23,0 ~ 24,5	H3K-48300						
	35,0	24,5 ~ 29,0	H3K-48350						
	40,0	29,0 ~ 33,0	H3K-48400						
5,0	6,0	1,0 ~ 2,0	H3K-50060						
[+0,08/-0,15]	8,0	2,0 ~ 3,5	H3K-50080						
	10,0	3,5 ~ 5,5	H3K-50100						
5,1 mm	12,0	5,5 ~ 7,5	H3K-50120						
	14,0	7,5 ~ 9,5	H3K-50140						
	16,0	9,0 ~ 11,0	H3K-50160	9,5	1,1				
	18,0	11,0 ~ 13,0	H3K-50180	[+0/-	[+/-	2,70	27	2.500	2.000
	20,0	13,0 ~ 15,0	H3K-50200	1,0]	0,30]				
	25,0	15,0 ~ 20,0	H3K-50250						
	28,0	20,0 ~ 23,0	H3K-50280						
	30,0	23,0 ~ 24,5	H3K-50300						
	35,0	24,5 ~ 29,0	H3K-50350						
	40,0	29,0 ~ 33,0	H3K-50400						
6,0	8,0	1,0 ~ 3,0	H3K-60080						
[+0,08/-0,15]	10,0	3,0 ~ 4,5	H3K-60100						
	12,0	4,5 ~ 6,0	H3K-60120						
6,1 mm	14,0	6,0 ~ 8,5	H3K-60140	12,0	1,5				
	16,0	8,5 ~ 10,5	H3K-60160	[+0/-	[+/-	3,60	31	3.900	2.500
	18,0	10,5 ~ 12,0	H3K-60180	1,5]	0,40]				
	22,0	12,0 ~ 16,0	H3K-60220						
	26,0	16,0 ~ 20,0	H3K-60260						
	30,0	20,0 ~ 23,0	H3K-60300						
6,4	10,0	1,0 ~ 3,5	H3K-64100						
[+0,08/-0,15]	12,0	3,5 ~ 5,5	H3K-64120						
	15,0	5,5 ~ 8,5	H3K-64150	13,0	1,8				
6,5 mm	18,0	8,5 ~ 11,5	H3K-64180	[+0/-	[+/-	3,85	31	4.090	3.120
	22,0	11,5 ~ 15,5	H3K-64220	1,5]	0,40]				
	26,0	15,5 ~ 19,0	H3K-64260						
	30,0	19,0 ~ 23,0	H3K-64300						

To choose the rivet diameter correctly as per the recommended hole size listed in this table, matching the diameter of the pre-drilled hole on the work pieces.

To measure the total thickness of the work pieces to be jointed, and find out the correct body length as per the "grip range" listed in this table.

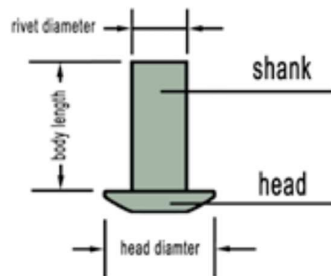
There is always a recommended thickness range (grip range) for each blind rivet, and correct choosing of the body length will consistently provide a good setting.

COMPONENTS & DIMENSIONS

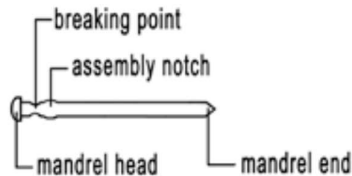
A blind rivet is composed of 2 parts: the body and the mandrel assembled:



Body and its dimensions:



Mandrel:



Setting blind rivets requires specially designed tools – riveting tools or specially designed machines on production lines. There are hydraulic riveting tools powered by air pressure, battery tools powered by Li-ion battery, and hand riveting tools operated manually. However, special hammer drive rivets are to be set only by simple hammers, as an exception.

To have a good understanding of the materials of the work pieces to be fastened, and determine the rivet material. While the rivet materials are referred, we refer to the materials of the rivet bodies. However, when different metals (work pieces and rivet bodies) come in contact with each other, contact corrosion will arise. In order to prevent the contact corrosion, a proper choice is important. The chart below tells you the way to choose.

rivet materials	work piece materials			
	aluminium	copper	steel	stainless steel
aluminium	✓	✗	○	○
copper	✗	✓	✗	○
steel	○	✗	✓	✓
stainless steel	○	○	✓	✓

✓ =GOOD ○ =ACCEPTABLE ✗ =BAD

10. The performance of the product identified in points 1 and 2 is in conformity with the declared performance in point 9.
This declaration of performance is issued under the sole responsibility of the manufacturer identified in point 4.

Signed for and on behalf of the manufacturer by:

A handwritten signature in blue ink, appearing to read 'Andrus Leppik', with a stylized flourish at the end.

Andrus Leppik, purchasing manager
10.01.2018